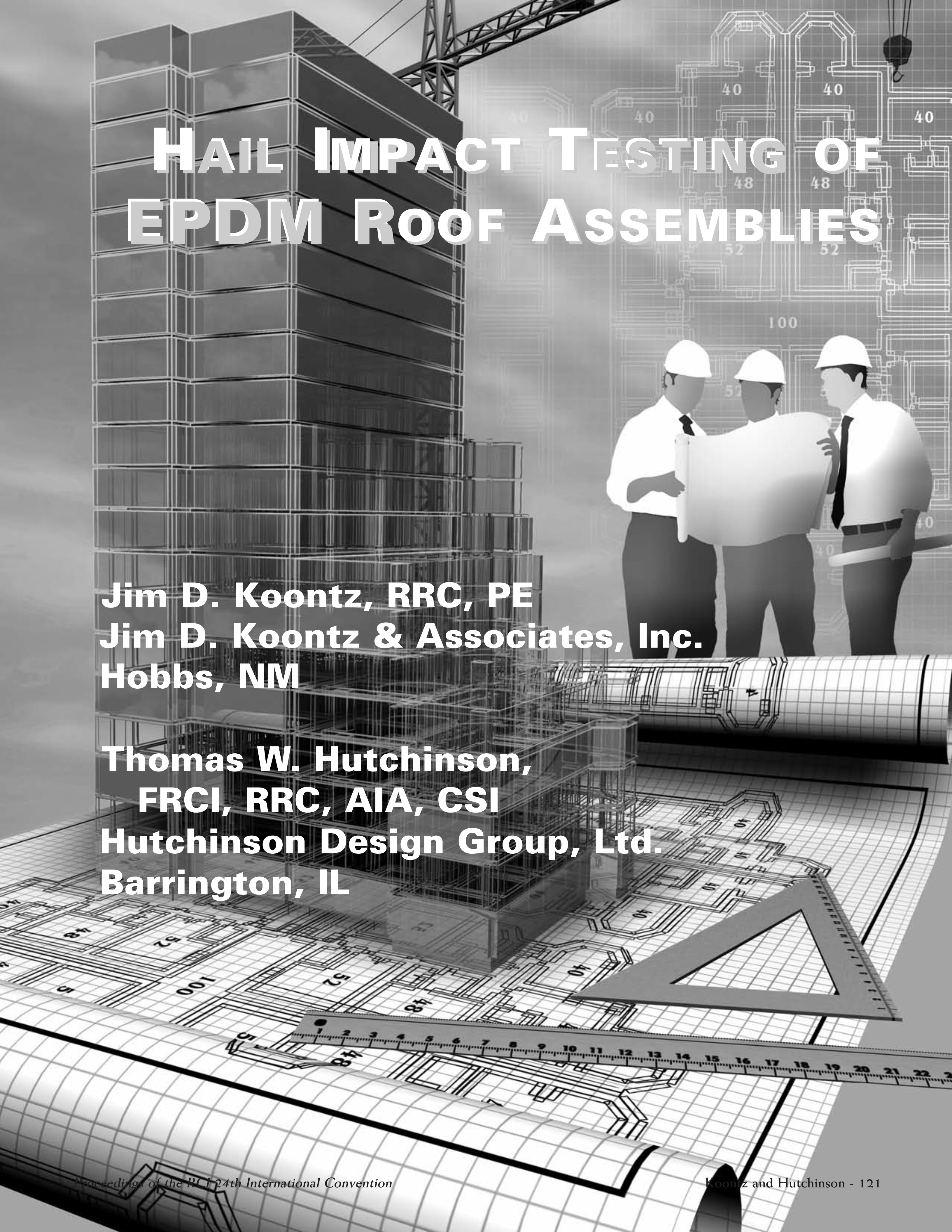

Hail Impact Testing of EPDM Roof Assemblies

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ABSTRACT

The EPDM Roofing Association retained the services of Jim D. Koontz & Associates, Inc. to perform laboratory testing on 81 test targets provided by the association. The targets varied in age and substrate. The samples were impacted with ice spheres ranging in size from 1 to 3 inches utilizing National Bureau of Standards Procedure 23. Impact points were analyzed for relative damage.

The speakers will review the results of these tests. This presentation will be offered at an advanced level and will provide detailed technical data based on the results of the tests. These tests will confirm the results of previous anecdotal studies that have shown that EPDM has an outstanding performance record against hail damage and will also show that these results continue throughout the life of the membrane.

SPEAKERS

Mr. Jim D. Koontz is a graduate of Tulane University with master's degrees in business and engineering. Mr. Koontz is a licensed professional engineer and a registered roof consultant specializing in roof design, inspection, laboratory analysis, and failure investigation of roof systems. Mr. Koontz has authored a number of technical papers involving impact damage to various roofing systems, including built-up roofing, single ply, and residential roofing projects. He has been involved in the roofing industry for 48 years as a roofing contractor and engineer. Koontz has provided consulting/engineering services in over 40 states, Canada, Mexico, and the Caribbean.

Mr. Tom Hutchinson is a graduate of the University of Illinois with master's degrees in both architecture and civil engineering. He is a licensed architect and registered roof consultant. He has made numerous presentations in Europe, South America, North America and Asia. Mr. Hutchinson is a principal in Hutchinson Design Group, Ltd., and a past president of RCI, and currently serves as technical consultant for ERA (EPDM Roofing Association). He is a Certified Energy Professional in the city of Chicago and secretary CIB/RILEM International Joint Committee on "Roof Materials and Systems." Tom is a member of AIA; CSI; RCI; NRCA; ASTM Committee D-8 on Roofing, Waterproofing & Bituminous Materials; and past president of the Barrington Rotary and a past region director of RCI.

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Hail Impact Testing of EPDM Roof Assemblies

INTRODUCTION

Hail damage to roof assemblies within the United States and worldwide results in millions of dollars of economic loss each year. At least one state insurance agency allows insurance companies to provide a reduction in insurance rates if a hail-resistant type roofing material is installed. Owners of properties that are largely self-insured are beginning to realize the importance of installing hail-resistant roofing systems.

Terminal velocities and energies of hailstones

Diameter		Terminal Velocity			Approximate Impact Energy	
Inches	*cm*	*ft/s*	*mi/hr*	*m/sec*	*ft lbs*	*Joules*
1	(2.5)	73	50	(22.3)	<1	(<1.36)
1¼	(3.2)	82	56	(25.0)	4	(5.42)
1½	(3.8)	90	61	(27.4)	6	(10.85)
1¾	(4.5)	97	66	(29.6)	14	(18.96)
2	(5.1)	105	72	(32.0)	22	(29.80)
2¼	(6.4)	117	80	(35.7)	53	(71.9)
2¾	(7.0)	124	85	(37.8)	81	(109.8)
3	(7.6)	130	88	(39.6)	120	(162.7)

Table A

The EPDM Roofing Association (ERA) members knew from empirical experience that EPDM roof systems fared very well in hailstorm events, but desired scientific validation. In the fall of 2007, ERA decided to embark on a hail testing program. The technical committee decided that in addition to new material, the real question in the design, insurance, and contractor communities is, "how do aged, *in-situ* roof covers perform?" Thus it was determined that the EPDM test sample pool would include new EPDM membrane material, new EPDM membrane material that would be heat-aged, and existing in-situ EPDM roof membrane materials that would be procured from existing roofs with five to 20 years of actual exposure. Carlisle Syntec and Firestone Building Products each provided 4-ft x 4-ft new 60-mil EPDM material samples, had new 60-mil EPDM material heat-aged, and procured 60-mil samples from roof covers that have been exposed between five and 20 years.

Prior to sending the EPDM samples for testing, the EPDM material was fully adhered to various 4-ft x 4-ft substrates: mechanically fastened polyiso insulation, mechanically fastened wood fiber board, and ½-in plywood. Between 20 and 35 samples of each roof cover category were sent for testing.

Field experience from the examination of thousands of roofs has clearly shown that hail damage to a roofing system can be the result of several factors:

- Diameter of the hail
- Type of roofing system
- Age of the roof cover
- Substrate beneath the primary roof system
- Surface temperature at the point of impact

To evaluate a roofing system's resistance to hail damage, these reference points have to be considered as part of a research project.

NATIONAL BUREAU OF STANDARDS IMPACT RESEARCH

In the early 1960s, the National Bureau of Standards (NBS) in Washington, DC, conducted research by impacting roof systems with ice spheres. Sydney H. Greenfield of the NBS performed this initial research and generated technical article NBS 23, Hail Resistance of Roofing Products.[1] Mr. Greenfield, referring to research by Laurie,[2] initially determined the freefall or terminal velocity of hail (refer to *Table A*).

The technical data indicates that the free-fall velocity of the hail increases with hailstones of larger diameters. A key factor is the amount of "impact energy" that is imparted to a target or roof surface. Simply stated:

Impact Energy = Kinetic Energy = ½ Mass * Velocity²

$$\text{Impact Energy} = \text{Kinetic Energy} = \tfrac{1}{2}\,\text{Mass} \times \text{Velocity}^2$$

The mass of a hailstone obviously is dependent upon the volume of the ice sphere and density of the ice. The density of hailstones is typically valued at .91.

Diameter Inches	Volume Inches^3	Mass Lbs.	Free Fall Velocity Ft/Sec	Impact Energy Ft. Lbs.
1.0	.52	.0005	73	1.41
1.5	1.77	.0018	90	7.29
2.0	4.18	.0043	105	23.7

Table B

$$\text{Volume of a sphere} = 1.33 * \Pi * \text{Radius}^3$$

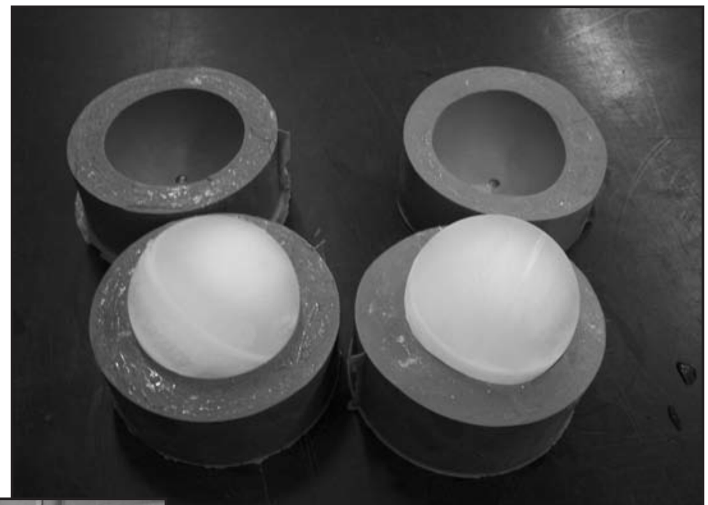
$$\text{Mass} = \frac{\text{Volume*Density}}{32.2}$$

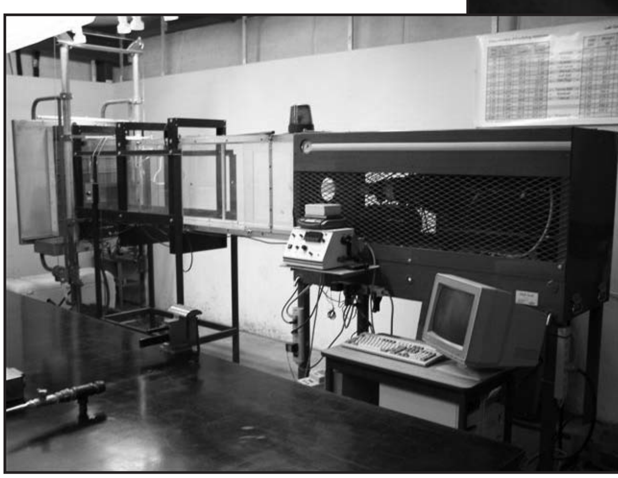
A substantial difference in impact energy occurs with only slight changes in diameter. Note the impact energy between 1-in, 1½-in and 2-in hail. Increasing hail size from 1-in to 2-in hail only represents a 100% change in diameter. The impact energy, however, increases by percentage 1,580% (refer to *Table B*).

INDUSTRY IMPACT RESEARCH

Historically, the hail resistance of roofing products has been tested by dropping steel balls or darts onto the roofing product. The procedures used to impact roofing products have varied among the United States, Canada, and European organizations. Two primary U.S. entities that perform impact testing for code approval have been Underwriters Laboratory (UL)[3] and Factory Mutual Global (FMG).[4] The Canadian groups utilize impact procedure CGSB 37-GP-52M.[5]

The Canadians, UL, and FMG use steel darts to impact targets, typically at room temperature. Other organizations, such as ASTM, have developed impact tests that use steel darts: ASTM D 3746.[6] Within the last few years, greater consideration has been given to impacting targets with ice spheres. Prior research by Jim Koontz and Associates, Inc. (JKA)[7] has also reviewed the issue of ice spheres versus steel darts. The use of ice spheres, obviously, comes closer to replicating what occurs during a real hailstorm event.





HAIL GUN

A key factor in performing the test is to have reproducible impact energies with each shot of "hail." The hail gun propels ice spheres by utilizing the quick release of compressed air from a tank to a barrel. In order to achieve reproducibility, several factors have to be taken into consideration. Consistent "air pressure" is required for each shot. This necessitates controlling the air pressure to 0.01 psi.

Molds for ice spheres are fabricated using precise diameter steel spheres. Each ice sphere of a given diameter is then weighed to .01 grams prior to each shot. Laboratory-grade barrels or tubes with precise internal diameters are also necessary to develop consistent impact energies. Basically, the charge, (i.e., air pressure), the quick release valve, and the bullets (ice spheres) require precise fabrication in order to achieve reproducible impact energies.

The ice spheres are initially weighed to 0.01 gram and then placed in the barrel, similar to a lead shot for a muzzle loader. As the ice sphere is pneumatically launched towards the target, the velocity is measured with a ballistics timer. The kinetic or "impact energy" is then calculated for each hail shot. The minimum kinetic energies listed by the NBS are maintained within a tolerance of plus zero plus ten percent.

EPDM TARGETS

Carlisle and Firestone provided a total of 81 test targets constructed with 60-mil nonreinforced EPDM for impact testing. The new, heat-aged and field-aged targets listed in *Table C* included:

Material Age	Test Targets
New	25
Heat Aged	20
Field Aged	36

Table C

The field-aged and exposed EPDM samples were collected from six states across the country and ranged in age from five to 20 years. The field aged samples are listed in *Table D*.

The artificially heat-aged samples were prepared at Cascade Technical Services of Hillsboro, Oregon. The samples were heat-aged for 1,440 hours at a temperature of 240 degrees Fahrenheit.

The 4-ft by 4-ft EPDM "targets" were installed over a variety of substrates that included polyiso and wood fiber insulation, plywood, and OSB board. Fully adhered EPDM was utilized in the target construction (refer to *Table E*). *Table E* indicates the material age, substrate, and number of samples of each prepared.

IMPACT PROCEDURES

Each target with substrate was mounted vertically. Hailstones measuring 1.5-in, 2.0-in, 2.5-in, and 3.0-in impacted the targets at a 90-degree angle at velocities listed by the NBS. In order to replicate severe weather conditions and cold rain during a hailstorm, the test targets were sprayed with water at forty degrees Fahrenheit. Prior research and experience has shown that roof assemblies exhibit different levels of impact resistance depending upon surface temperature.

The various targets were impacted both in the "field area" and also directly over fasteners and plates utilized to secure the substrate below the EPDM. Failure was defined as a visible split or cut in the surface of the EPDM.

Field Aged & EPDM Membrane		
Deck #	**Location**	**Age**
1	Des Moines, IA	5 - 10 years
2	Des Moines, IA	5 - 10 years
3	Des Moines, IA	5 - 10 years
4	Lawrence, KS	10 - 15 years
5	Wichita, KS	10 - 15 years
6	Denver, CO	15 - 20 years
7	Lakewood, CO	15 - 20 years
8	Kansas City, KS	10 -15 years
9	Lawrence, KS	10 -15 years
10	Holcomb, KS	10 -15 years
11	Omaha, NE	10-15 years
12	Omaha, NE	10-15 years
13	Littleton, CO	10-15 years
14	Wheatridge, CO	10-15 years
15	Farmington, UT	5-10 years
16	Farmington, UT	5-10 years
17	Indianapolis, IN	15-20 years
18	Indianapolis, IN	15-20 years

Table D

IMPACT RESULTS

Of the 25 "new" EPDM test targets tested, 24 targets were not damaged by 3-in hail balls. None of the 20 "heat-aged" targets failed when impacted with 3-in hail balls.

The "field-aged" EPDM target samples included 18 over a 2-in-thick polyiso insulation substrate and 18 over a ½-in-thick OSB substrate, supported by 1½-thick polyiso roof insulation. Fourteen of the EPDM targets that were adhered directly over the polyiso did not fail when impacted with 3.0-in hail balls. (One sample failed with a 3-in hail ball; a second sample failed with a 2.5-in hail ball; and the two other samples failed with a 2-in diameter hail ball.) None of the 18 EPDM "field-aged" targets over OSB were

Roof Targets		
Material Age	**Substrate**	**No. of Samples Prepared**
New	1.75" Polysio	3
New	2" Polysio	4
New	½" OSB 2.0" Polysio	7
New	2.0" Polysio Neoprene cover at fastener head	5
New	½ " Wood Fiber 2.0" Polysio	6
Heat Aged	½" Wood Fiber 2.0" Polysio	6
Heat Aged	½ " Plywood 2.0" Polysio	3
Heat Aged	½" OSB 2.0" Polysio	3
Heat Aged	2.0" Polysio	8
Field Aged	2.0" Polysio	18
Field Aged	½ " OSB 1.5" Polysio	18

Table E

damaged by 3-in-diameter hail balls (refer to *Table F*).

COMMENTARY

Some geographical areas of the United States are clearly more prone to severe hail events. Roof assemblies should be capable of resisting impact from reasonably expected hail storms for a given geographical area. Just as roofs are required to perform in various meteorological events such as wind, snow, and rain, a roof should be able to withstand some degree of hail impact over its expected service life.

The International Building Code 2006,[8] paragraph 1504.7, states: roof coverings shall resist impact damage based on tests conducted in accordance with ASTM D 3746, ASTM D 4272, CGSB 37-GP-52M. These procedures are conducted with steel darts versus ice spheres at room temperature. The testing is for new products and does not address the long-term effects of UV exposure. The results of testing following these protocols may provide false positive results.

Jim D. Koontz & Associates, Inc. has examined hundreds of EPDM roofs that have been impacted by hail. Two noteworthy projects include a telephone building in Fort Worth, Texas, that was impacted by softball-sized hail in 1995. The nonreinforced EPDM over polyiso did not fail. A second project was at a University-of-Nebraska-in-Kearney campus building covered with nonreinforced EPDM, which survived softball-sized hail. The manufacturer of the roof was notified of the performance of the aged EPDM assembly. The roofs on 65 other buildings failed.

During the examination of hundreds of roofs, direct impacts over fasteners and plates used to secure underlayment have been extremely rare. Damage observed of that kind has not constituted a failure of the entire roof and has been repairable. Increasing use of adhesives to fasten insulation and coverboards is eliminating the already unlikely chance of damage caused by nail-ball impact and mechanical fastener plates.

Roof Samples' Results		
Material Age	**Substrate**	**Samples Passed**
New	1.75" Polyiso	3
New	2" Polyiso	4
New	½" OSB 2.0" Polyiso	6 of 7
New	2.0" Polysio Neoprene cover at fastener head below the EPDM target	5
New	½" Wood Fiber 2.0" Polysio	6
Heat Aged	½" Wood Fiber 2.0" Polysio	6
Heat Aged	½" Plywood 2.0" Polysio	3
Heat Aged	½" OSB 2.0" Polysio	3
Heat Aged	2.0" Polysio	8
Field Aged	2.0" Polysio	14 of 18
Field Aged	½" OSB 1.5" Polysio	18

Table F

CONCLUSIONS

The new, heat-aged and aged nonreinforced EPDM tested within this study provided excellent resistance to large hail. Of the 81 targets installed over polyiso, wood fiber, plywood, and OSB board, 76 did not fail when impacted with hail ice balls up to three inches in diameter.

The overall results of this research clearly indicate that nonreinforced EPDM roof assemblies offer a high degree of hail resistance over a variety of substrates. The impact resistance of both the field-aged and heat-aged membrane also clearly demonstrates that EPDM retains the bulk of its impact resistance as it ages.

Owners of critical facilities, such as hospitals, schools, computer centers, airports, and sensitive government buildings have come to realize the importance of installing a hail-resistant roof assembly over critical facilities. The use of nonreinforced EPDM can provide an additional level of long-term protection.

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