

DIN EN 385:2007-11 (E)

Finger jointed structural timber - Performance requirements and minimum production requirements

Contents		Page
Foreword		3
Introduction		4
1	Scope	4
2	Normative references	4
3	Terms and definitions	4
4	Symbols	6
5	Requirements	6
5.1	General	6
5.2	Timber	7
5.2.1	Species	7
5.2.2	Knots and fissures	7
5.2.3	Wane or edge damage	7
5.3	Adhesives	8
5.4	Bending strength	9
6	Manufacturing requirements	9
6.1	Production conditions	9
6.2	Timber	9
6.3	Adhesive application	9
6.3.1	Adhesive application by machine	9
6.3.2	Manual adhesive application	10
6.4	Assembly and end pressure	10
6.4.1	Assembly	10
6.4.2	End pressure	10
7	Quality control	11
7.1	Factory production control	11
7.1.1	General	11
7.1.2	Sampling of finger joints	11
7.1.3	Testing of finger joints	11
7.1.4	Compliance	12
7.2	Organization of factory production control	13
7.2.1	Responsibility and authority	13
7.2.2	Delegated by the manufacturer for factory production control	13
7.2.3	Inspection by the manufacturer	14
7.3	Documentation of the quality control system	14
7.4	Inspection and testing	14
7.4.1	General	14
7.4.2	Action in case of non-conformity	14
7.4.3	Quality surveillance of non-conforming finger joints	14
8	Type testing, initial determination of joint strength	15
8.1	General	15
8.2	Materials	15
8.3	Preparation of specimens	15

8.4	Procedure	15
8.5	Test report	15
8.6	Classification of joints	15
Annex A (informative) The tasks of the third party certification body		16