

DIN EN 16254:2016-12 (E)

Adhesives - Emulsion polymerized isocyanate (EPI) for load-bearing timber structures - Classification and performance requirements (includes Amendment :2016)

Contents		Page
European foreword		3
Introduction		4
1	Scope	5
2	Normative references	5
3	Terms and definitions	6
4	Classification	7
5	Requirements	9
5.1	General	9
5.2	Bond strength in longitudinal tensile shear test	9
5.3	Resistance to delamination	10
5.4	Tensile strength perpendicular to the glue line after climatic treatment (acid damage test)	11
5.5	Effect of wood shrinkage on the shear strength	11
5.6	Static load test of multiple glue line specimens in compression shear	11
5.7	Creep deformation test at cyclic climate conditions with specimens loaded in bending shear	12
5.8	Long term sustained load test at cyclic climate conditions with specimens loaded perpendicular to the glue line ("Glass house test")	12
6	Test methods	12
6.1	General	12
6.2	Determination of bond strength in longitudinal tensile shear test	12
6.3	Determination of resistance to delamination	12
6.4	Determination of tensile strength perpendicular to the glue line after climatic treatment (acid damaged test)	12
6.5	Determination of the effect of wood shrinkage on the shear strength	13
6.6	Static load test of multiple glue line specimens in compression shear	13
6.7	Creep deformation test with specimens loaded in bending shear	14
6.8	Long term sustained load test at cyclic climate conditions with specimens loaded perpendicular to the glue line ("Glass house test")	14
7	Working properties of the adhesive	14
7.1	General	14
7.2	Determination of working life under reference conditions	14
7.3	Determination of open assembly time under reference conditions	14
7.4	Determination of pressing time under reference conditions	14
Annex A (normative)	Climatic treatment prior to shear test	15
Annex B (normative)	Glass house test	16
Annex C (informative)	Product limitations and glulam production control for beams produced with Small Dimension adhesives	19
Bibliography		20