

DIN EN 15425:2026-08 (E)

Adhesives - One component polyurethane (PUR) for load-bearing timber structures - Classification and performance requirements (includes Amendment :2026)

Contents		Page
European foreword		4
Introduction		5
1	Scope	6
2	Normative references	6
3	Terms and definitions	7
4	Classification	8
5	Requirements	11
5.1	General	11
5.2	Bond strength in longitudinal tensile shear test	12
5.3	Resistance to delamination	13
5.4	Tensile strength perpendicular to the bond line after climatic treatment (acid damage test)	13
5.5	Effect of wood shrinkage on the shear strength	13
5.6	Static load test of multiple bond line specimens in compression shear	13
5.7	Creep deformation test at cyclic climate conditions with specimens loaded in bending shear	14
5.7.1	Application area "Finger-jointing" - close contact glue line in test	14
5.7.2	Application area "General purpose" - 0,3 mm glue line thickness in test	14
5.7.3	Application area "Special purpose" - 0,5 mm glue line thickness in test	14
5.8	Long-term sustained load test at cyclic climate conditions with specimens loaded perpendicular to the bond line ("Glass house test")	14
5.9	Delamination test on finger-jointed test pieces	14
6	Test methods	15
6.1	General	15
6.2	Determination of longitudinal tensile shear strength	15
6.3	Determination of resistance to delamination	15
6.4	Determination of tensile strength perpendicular to the bond line after climatic treatment (acid damage test)	15
6.5	Determination of the effect of wood shrinkage on the shear strength	15
6.6	Static load test of multiple bond line specimens in compression shear	15
6.7	Creep deformation test with specimens loaded in bending shear	16
6.8	Long-term sustained load test at cyclic climate conditions with specimens loaded perpendicular to the bond line ("Glass house test")	16
6.9	Delamination test on finger-jointed test pieces	16
7	Working properties of the adhesive	16
7.1	General	16
7.2	Determination of initial viscosity under reference conditions	16
7.3	Determination of open assembly time under reference conditions	16
7.4	Determination of pressing time under reference conditions	17
8	Marking and labelling	17
Annex A (normative) Climatic treatment prior to shear test		18

Annex B (normative) Delamination test for bonding of finger-joints	19
B.1 Production of the specimens	19
B.2 Testing	20
B.3 Expression of results	21
B.4 Test report	21
B.4.1 Adhesive	21
B.4.2 Preparation of test pieces and testing procedure	21
B.4.3 Test results	22
Annex C (informative) Information on bonding operations with one-component polyurethane adhesives in combination with water-spraying	23
Bibliography	24