

DIN EN 16254:2014-02 (E)

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

| Contents | | Page |
|---|--|-------------|
| 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 |

