

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

