



# SLOVENSKI STANDARD

## SIST EN 302-2:2013

01-maj-2013

Nadomešča:  
SIST EN 302-2:2004

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**Lepila za nosilne lesene konstrukcije - Preskusne metode - 2. del: Ugotavljanje  
odpornosti lepljenega stika proti razslojevanju (delaminaciji)**

Adhesives for load-bearing timber structures - Test methods - Part 2: Determination of  
resistance to delamination

Klebstoffe für tragende Holzbauteile - Prüfverfahren - Teil 2: Bestimmung der  
Delaminierungsbeständigkeit

Adhésifs pour structures portantes en bois - Méthodes d'essai - Partie 2: Détermination  
de la résistance à la délamination

**Ta slovenski standard je istoveten z: EN 302-2:2013**

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**ICS:**

83.180	Lepila	Adhesives
91.080.20	Lesene konstrukcije	Timber structures

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN 302-2**

March 2013

ICS 83.180

Supersedes EN 302-2:2004

English Version

## Adhesives for load-bearing timber structures - Test methods - Part 2: Determination of resistance to delamination

Adhésifs pour structures portantes en bois - Méthodes  
d'essai - Partie 2: Détermination de la résistance à la  
délamination

Klebstoffe für tragende Holzbauteile - Prüfverfahren - Teil 2:  
Bestimmung der Delaminierungsbeständigkeit

This European Standard was approved by CEN on 5 February 2013.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.

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## Foreword

This document (EN 302-2:2013) has been prepared by Technical Committee CEN/TC 193 “Adhesives”, the secretariat of which is held by AENOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by September 2013 and conflicting national standards shall be withdrawn at the latest by September 2013.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 302-2:2004.

The following modifications have been made:

- The glue spread for minimum and maximum assembly time is now given for aminoplastic and phenolic adhesives;
- The standard is now used for assessing the compliance for adhesives with EN 301, EN 15425 and prEN 16254.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

**EN 302-2:2013 (E)****Introduction**

This document is one of a series dealing with adhesives for use with timber structures, and is published in support of EN, 1995 *Eurocode 5: Design of timber structures*. The series consists of three classification and performance requirements for adhesives for load-bearing timber structures, phenolic and aminoplastic adhesives (EN 301), one component polyurethane adhesives (EN 15425) and emulsion polymerised isocyanate adhesives (prEN 16254), and all together eleven test methods (EN 302 Parts 1 to 7 and EN 15416 Parts 2 to 5).

These European Standards have the following titles:

EN 301, *Adhesives, phenolic and aminoplastic, for load-bearing timber structures — Classification and performance requirements*

EN 15425, *Adhesives — One component polyurethane for load bearing timber structures — Classification and performance requirements*

prEN 16254, *Adhesives — Emulsion polymerized isocyanate (EPI), for load-bearing timber structures — Classification and performance requirements*

EN 302, *Adhesives for load-bearing timber structures — Test methods*

— *Part 1: Determination of longitudinal tensile shear strength*

— *Part 2: Determination of resistance to delamination*

— *Part 3: Determination of the effect of acid damage to wood fibres by temperature and humidity cycling on the transverse tensile strength*

— *Part 4: Determination of the effects of wood shrinkage on the shear strength*

— *Part 5: Determination of maximum assembly time under referenced conditions*

— *Part 6: Determination of the minimum pressing time under referenced conditions*

— *Part 7: Determination of the working life under referenced conditions*

EN 15416, *Adhesives for load bearing timber structures other than phenolic and aminoplastic — Test methods*

— *Part 2: Static load test of multiple bondline specimens in compression shear*

— *Part 3: Creep deformation test at cyclic climate conditions with specimens loaded in bending shear*

— *Part 4: Determination of open assembly time for one component polyurethane adhesives*

— *Part 5: Determination of conventional pressing time*

**Safety statement**

Persons using this document should be familiar with the normal laboratory practice, if applicable. This document cannot address all of the safety problems, if any, associated with its use. It is the responsibility of the user to establish appropriate safety and health practices and to ensure compliance with any regulatory conditions.

**Environmental statement**

It is understood that some of the material permitted in this standard can have a negative environmental impact. As technological advantages lead to better alternatives for these materials, they will be eliminated from this standard to the greatest extent possible.

At the end of the test, it is recommended that the user of the standard take care to carry out an appropriate disposal of the wastes, according to local regulations.

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**EN 302-2:2013 (E)****1 Scope**

This European Standard specifies a method for determining the resistance to delamination in glue lines.

It is suitable for the following applications:

- a) for assessing the compliance of adhesives with EN 301, EN 15425 and prEN 16254;
- b) for assessing the suitability and quality of adhesives for load-bearing timber structures;
- c) for comparing the effects on the bond strength resulting from the choice of bonding conditions, from different climatic conditioning and from the treatment of the test pieces before and after bonding.

This test is not applicable for modified and stabilised wood with strongly reduced swelling and shrinkage properties, such as acetylated wood, heat-treated wood and polymer impregnated wood.

This test is intended primarily to obtain performance data for the classification of adhesives for load-bearing timber structures according to their suitability for use in defined climatic environments.

This method is not intended to provide data for structural design, and does not necessarily represent the performance of the bonded member in service.

**2 Normative references**

Not applicable.

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**3 Principle**

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Bonded, laminated specimens are subjected to an impregnation-drying procedure. The specimens are impregnated with water by immersing them and applying alternating high and low (vacuum) pressure. They are then dried rapidly in a specified air stream at low humidity (see 4.4). The extent of open glue lines, delamination, as a result of these treatments is measured and compared with the total length of glue lines on both end-grain faces of the specimen.

**4 Apparatus**

**4.1 Autoclave or similar pressure vessel**, designed to safely withstand a pressure of at least 625 kPa absolute (525 kPa above nominal atmospheric pressure).

**4.2 Vacuum pump or similar device**, capable of reducing the pressure in the vessel (4.1) to below 20 kPa absolute (80 kPa below nominal atmospheric pressure).

**4.3 Pump or similar device**, for obtaining a pressure of at least 600 kPa absolute (500 kPa above nominal atmospheric pressure).

**4.4 Air-circulating oven(s) or chamber(s)**, capable of drying the test pieces (see 5.4) in the following climate condition:

- a) for low temperature procedure (type II adhesive) a temperature of  $(27,5 \pm 2,5)$  °C, circulating the air within the chamber, maintaining a constant relative humidity of  $(30 \pm 5)$  %; and
- b) for high temperature procedure (type I adhesive) a temperature of  $(65 \pm 3)$  °C, circulating the air within the chamber, maintaining a relative humidity of  $(12,5 \pm 2,5)$  %.



NOTE Air speed velocity of 2 m/s to 3 m/s in empty chamber has shown to be suitable to achieve drying times according to 5.4.2 and 5.4.3.

**4.5 Balance**, allowing measurements with an accuracy of  $\pm 1$  g.

**4.6 Wood chisel and hammer**, or similar devices capable of opening the glue lines.

## 5 Method

### 5.1 Selection of timber

Use flat-sawn, straight-grained Norway spruce (*Picea abies* L.), free of reaction wood, with a density of  $(450 \pm 25)$  kg/m<sup>3</sup> at  $(12 \pm 1)$  % moisture content. Preferably, knot-free wood should be used, but allowances are made for boards with knots up to a maximum of 20 mm in diameter, but splay (spike) knot is not allowed. The test with Norway spruce also covers approval of silver fir (*Abies alba*) and Scots pine (*Pinus sylvestris*).

If the adhesive is to be used on wood from other conifer species like larch (*Larix decidua*), Douglas fir (*Pseudotsuga menziesii*) and pines with coloured heartwood (other than Scots pine (*Pinus sylvestris*)), from hardwood species and/or on preservative treated wood, also prepare four laminated members using representative samples using wood with mean density.

Condition the timber in the standard climate [20/65] ( $(20 \pm 2)$  °C and a relative humidity of  $(65 \pm 5)$  %) for at least 7 days prior to bonding, ensuring that the timber has a moisture content of  $(12 \pm 1)$  %.

### 5.2 Preparation of the bonded members

Make four laminated members, two with short assembly time and two with long assembly time. For each laminated member, prepare six lamellae at least  $(150 \pm 5)$  mm wide,  $(30 \pm 1)$  mm thick and approximately 500 mm long from six different boards. The desired thickness is achieved by planing 38 mm thick lamellae. Store the lamellae in standard climate [20/65] before planing and gluing. Bond the lamellae in accordance with Table 1, within 8 h of planing. Within each assembly, ensure that the six lamellae present the same growth ring symmetry.