



SLOVENSKI STANDARD
oSIST prEN 15416-4:2024
01-junij-2024

Lepila (razen fenolnih ali aminskih) za nosilne lesene konstrukcije - Preskusne metode - 4. del: Ugotavljanje odprtega časa pri referenčnih pogojih

Adhesives for load bearing timber structures other than phenolic and aminoplastic - Test methods - Part 4: Determination of open assembly time under referenced conditions

Klebstoffe für tragende Holzbauteile ausgenommen Phenolharzklebstoffe und Aminoplaste - Prüfverfahren - Teil 4: Bestimmung der offenen Wartezeit bei Referenzbedingungen

Adhésifs pour structures portantes en bois de type autre que phénolique et aminoplaste - Méthodes d'essais - Partie 4 : Détermination du temps d'assemblage ouvert dans des conditions de référence

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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

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prEN 15416-4

May 2024

ICS 83.180

Will supersede EN 15416-4:2017

English Version

Adhesives for load bearing timber structures other than phenolic and aminoplastic - Test methods - Part 4: Determination of open assembly time under referenced conditions

Adhésifs pour structures portantes en bois de type autre que phénolique et aminoplaste - Méthodes d'essais - Partie 4 : Détermination du temps d'assemblage ouvert dans des conditions de référence

Klebstoffe für tragende Holzbauteile ausgenommen Phenolharzklebstoffe und Aminoplaste - Prüfverfahren - Teil 4: Bestimmung der offenen Wartezeit bei Referenzbedingungen

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 193.

If this draft becomes a European Standard, 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.

This draft European Standard was established by CEN 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.

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Recipients of this draft are invited to submit, with their comments, notification of any relevant patent rights of which they are aware and to provide supporting documentation.

Warning : This document is not a European Standard. It is distributed for review and comments. It is subject to change without notice and shall not be referred to as a European Standard.



EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

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European foreword

This document (prEN 15416-4:2024) has been prepared by Technical Committee CEN/TC 193 “Adhesives”, the secretariat of which is held by UNE.

This document is currently submitted to the CEN enquiry.

This document will supersede EN 15416-4:2017.

This document includes the following significant technical changes with respect to EN 15416-4:2017:

- a) terms and definitions for glue line added;
- b) determination of glue line thickness in 6.3 described in more detail;
- c) expression of glue line thickness added as 7.3;
- d) different spread rates and glue line thicknesses considered in the requirement in Clause 8.

Any feedback and questions on this document should be directed to the users’ national standards body. A complete listing of these bodies can be found on the CEN website.

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prEN 15416-4:2024 (E)**Introduction**

This document is one of a series dealing with adhesives for use with timber structures, and is published in support of the EN 1995 series, Eurocode 5: Design of timber structures. The series consists of five classification and performance requirements for adhesives for load-bearing timber structures, phenolic and aminoplastic adhesives (EN 301), one component polyurethane adhesives (EN 15425), emulsion polymer isocyanate adhesives (EN 16254), two component epoxy and polyurethane adhesives for glued in rods (EN 17334) and for on-site repair of cracked timber structures (EN 17418) and all together twelve test methods (EN 302-1, EN 302-2, EN 302-3, EN 302-4, EN 302-5, EN 302-6, EN 302-7 and EN 302-8 and EN 15416-1, EN 15416-3, EN 15416-4 and EN 15416-5).

These European Standards have the following titles:

EN 301, *Adhesives, phenolic and aminoplastic, 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*
- *Part 8: Static load test of multiple bond line specimens in compression shear*

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

- *Part 1: Long-term tension load test perpendicular to the bond line at varying climate conditions with specimens perpendicular to the glue line (Glass house test)*
- *Part 3: Creep deformation test at cyclic climate conditions with specimens loaded in bending shear*
- *Part 4: Determination of open assembly time under referenced conditions*
- *Part 5: Determination of minimum pressing time under referenced conditions*

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

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

EN 17334, *Glued-in rods in glued structural timber products — Testing, requirements and bond shear strength classification*

EN 17418, *Two-component epoxy and polyurethane adhesives for on-site repair of cracked timber structures — Testing, requirements and repair strength verification*