



Designation: **D4688 – 99 (Reapproved 2013) D4688/D4688M – 14**

Standard Test Method for Evaluating Structural Adhesives for Finger Jointing Lumber¹

This standard is issued under the fixed designation **D4688/D4688M**; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method is designed to evaluate adhesives for finger jointing lumber used in the manufacture of ~~structural~~ a variety of bonded structural wood products such as structural glued laminated timber. It tests the tensile strength of joints under the following ~~treatments~~; treatments: dry with no treatment, wet after one vacuum-pressure soak treatment, and wet after cyclic boil-dry treatment.

1.2 This test method is intended neither for quality control as the test assemblies are selected for the absence of defects usually found in run-of-the-mill finger joints nor as a substitute for in-plant qualification of end joints, including full-scale joint tests.

NOTE 1—This test method is specifically designed to evaluate adhesives for use in finger jointing lumber using small scale test specimens cut from carefully selected finger joint assemblies. In contrast, plant qualification and quality control require tests of full scale end joints selected randomly from production, designed to evaluate parameters beyond adhesive performance which affect the performance of the end use product.

1.3 The values stated in either SI units or inch-pound units are to be regarded separately as the standard. The values given in parentheses are for information only. ~~stated in each system may not be exact equivalents; therefore, each system shall be used independently of the other. Combining values from the two systems may result in non-conformance with the standard.~~

1.4 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety and health practices and determine the applicability of regulatory limitations prior to use.*

2. Referenced Documents

2.1 *ASTM Standards*:²

[D907 Terminology of Adhesives](#)

[D2559 Specification for Adhesives for Bonded Structural Wood Products for Use Under Exterior Exposure Conditions](#)

[D5266 Practice for Estimating the Percentage of Wood Failure in Adhesive Bonded Joints](#)

[E4 Practices for Force Verification of Testing Machines](#)

3. Terminology

3.1 *Definitions*—Many terms in this test method are defined in Terminology [D907](#).

3.2 *Definitions of Terms Specific to This Standard*:

3.2.1 *billet, n*—a piece cut from a vertical finger joint assembly as an intermediate step in making specimens.

3.2.2 *horizontal finger joint, n*—a joint formed by bonding two precut members shaped like fingers where the profile is visible on the edge of the lumber (see [Fig. 1a](#)).

3.2.3 *vertical finger joint, n*—a joint formed by bonding two precut members shaped like fingers where the profile is on the wide face of the lumber (see [Fig. 1b](#)).

3.2.4 *finger joint assembly, n*—a short portion of two boards joined at their ends by ~~a~~ an adhesively bonded finger joint ~~obtained from a finger joint production line for testing, to create a longer piece,~~ frequently referred to as an *assembly*.

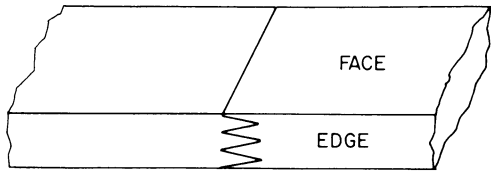
3.2.5 *sample, n*—a group of finger joint assemblies obtained from a finger joint production line or laboratory prepared finger joints selected for statistical purposes.

¹ This test method is under the jurisdiction of ASTM Committee [D14](#) on Adhesives and is the direct responsibility of Subcommittee [D14.30](#) on Wood Adhesives. Current edition approved Oct. 1, 2013. Published November 1, 2014. Originally approved in 1987. Last previous edition approved in 2005 (2013) as D4688 – 99 (2005) (2013). DOI: [10.1520/D4688-99R13](#); [10.1520/D4688_D4688M-14](#).

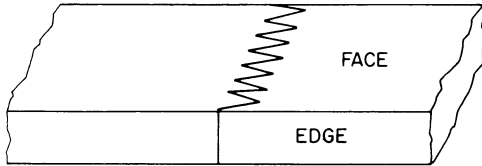
² For referenced ASTM standards, visit the ASTM website, [www.astm.org](#), or contact ASTM Customer Service at [service@astm.org](#). For *Annual Book of ASTM Standards* volume information, refer to the ~~standard's~~ Document Summary page on the ASTM website.



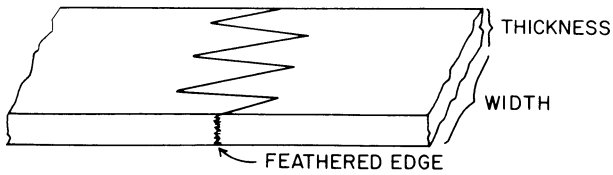
3.2.3.1 Discussion



(a) Horizontal Joint



(b) Vertical Joint



(c) Test Specimen

FIG. 21 Finger Joint Assembly and Specimen Descriptions

In the laminating industry the term *sample* is used for an individual finger joint assembly.

3.2.6 *specimen, n*—an individual strip, test piece prepared to $\frac{3}{8}$ (approximately) by 12 in. (6.4 by 35 by 305 mm), cut from a finger joint assembly for the tension tests specific dimensions for the purpose of determining the adhesive performance in accordance with the tension tests described in this test method.

4. Significance and Use

4.1 This test method is specifically designed to measure the performance of adhesives in finger joints manufactured under production line conditions.

4.1.1 The test method can be adapted to evaluate the adhesive performance of laboratory produced finger joints using commercial finger joint cutting heads with finger joints produced following the adhesive manufacturers recommendations. The conditions under which the finger joints were produced, including any limitations, are to be reported in 9.1.2.2 (see Note 2).

NOTE 2—If laboratory prepared finger joints are to be produced, record details related to adhesive used, its preparation, application to the cut finger joint, appropriate bonding parameters and limitations in the production of the finger joint assemblies.

4.2 The results of the test method may be used to certify an adhesive as suitable for finger jointing lumber under production-line conditions where the intended end use of the finger jointed lumber will may be in a structural glued laminated timber. When the test results are to be used for certification of an adhesive for this purpose, use a standard wood species and a standard finger profile. Standard species may be found in Table 1 of Specification variety of bonded D2559. Two standard finger profiles commonly used in the manufacture of structural glued laminated timber industry are shown in structural wood products Fig. 1.

4.2.1 When the test results are to be used for certification of an adhesive a standard wood species shall be used.

4.2.1.1 Standard species may be found in Table 1 of Specification D2559.

4.3 This test method is not intended for quality control as the test assemblies are selected for their absence of defects usually found in run-of-the-mill lumber and finger joints.

5. Apparatus

5.1 *Test Machine*, capable of applying a calibrated tensile force, up to 23 kN (5000 lbf), having an accuracy of $\pm 1\%$ when calibrated in accordance with Practice E4, and equipped with Templin (wedge-action) grips with grip area of 38 by 75 mm (1½ by 3 in.) in.

5.2 *Vacuum Pressure Vessel*, capable of drawing and holding a vacuum of at least 635 mm (25 in.) [25 in.] of mercury (sea level) for 30 min, holding a pressure of 620 ± 35 kPa (75 ± 2 psi) for 30 min, and capacity to ensure that all of the specimens are at least 5150 mm (2 in.) [2 in.] below the water level during the complete vacuum-pressure cycle.

5.3 *Tank for Boiling*, capacity such that all specimens are at least 51 mm (2 in.) [2 in.] below the water level for the duration of the boil cycles.

5.4 *Oven*, capable of operating continuously for 20 h at $63 \pm 2^\circ\text{C}$ ($145 \pm 5^\circ\text{F}$) [5°F] with sufficient air circulation to lower the moisture content of the group of specimens to from saturation to no more than 8 % within 20 h.

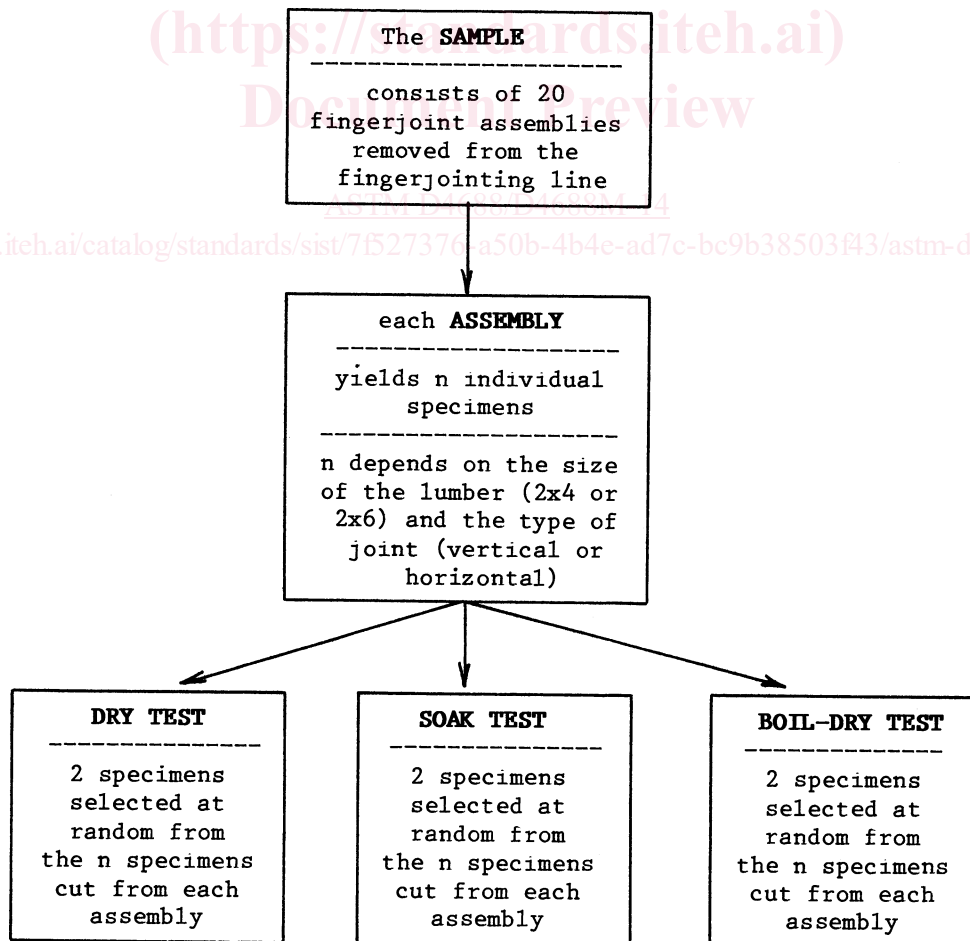


FIG. 32 Flowchart of the Source and Allocation of Individual Test Specimens



5.4.1 *Timer*; to shut the oven off automatically is desirable.

6. Specimen Preparation

6.1 Obtain a sample consisting of either 20 horizontal or vertical finger joint assemblies from a finger joint production line or, when evaluating laboratory prepared finger joints, from a population of laboratory prepared finger joints. The boards must be nominal 2 by 4-in. or 2 by 6-in. ~~Reject any assembly with obvious defects in the lumber or joint.~~

6.1.1 Identify and record the wood species, joint configuration, average specific gravity and moisture content.

6.2 *Horizontal Joint* (Fig. 21(a)):

6.2.1 Joint one face of each assembly until the finger on the surface is feathered as shown in Fig. 21(c).

NOTE 3—In the context of this test method, feathering is described as a process where the surface containing the respective vertical or horizontal joint is planed to approximately center of the visible edge of the joint (see Fig. 1(c)).

6.2.2 Joint one edge of the assembly for end cutting and ripping at a later stage.

6.2.3 Plane the second face of the assembly until the finger on the surface is feathered while maintaining 35-mm (1 3/8-in.) assembly thickness or nearly so of about 35-mm [1 3/8-in.].

NOTE 4—It is more important to feather the finger than to maintain the 35-mm (1 3/8-in.) thickness.

6.2.4 Cut the assembly to a 305-mm (12-in.) [12-in.] length with the finger jointed area joint at the center.

6.2.5 Rip individual specimens 6.4-mm (1/4-in.)-in.] thick (Fig. 1) from the assembly starting with the jointed edge of the assembly (see 6.2.2) against the saw guide. A thin hollow-ground rip saw blade is preferred but the important criterion is the straightness of the cut. Check cut specimens for uniform thickness throughout. Thickness shall not vary by more than 0.5 mm (0.02 in.). Number the specimens in order from one side of the assembly to the other.

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6.2.5.2 Number the specimens in order from one side of the assembly to the other.

6.3 *Vertical Joint* (Fig. 21(b)):

6.3.1 Joint one edge of the finger joint assembly.

6.3.2 Joint one face of the finger joint assembly.

6.3.3 With the jointed edge against the saw guide, rip billets 40 mm (1 1/16 in.)-in.] wide from the assembly.

NOTE 5—The 40-mm (1 1/16-in.)-in.] dimension is not critical but this dimension must be enough to allow feathering the fingers in following subsequent steps.

6.3.4 Joint and plane the sides of each billet so the exposed sides of the fingers are feathered as described in 6.2.1 and 6.2.3.

6.3.5 Rip four individual specimens of 6.4-mm (1/4-in.)-in.] thickness from each billet of the assembly as in 6.2.5. Number the specimens in order from one side of the assembly to the other. Use the same order for each assembly.

6.3.5.1 Number the specimens in order from one side of the assembly to the other. Use the same order for each assembly.

6.4 Inspect specimens for defects. Assemblies yielding specimens that have obvious strength-reducing characteristics such as: low visual density, knots, steep slope of grain, compression wood, compression failures, decay, pitch pockets, or stress risers due to errors in specimen preparation, may be rejected. If specimens with questionable strength characteristics are tested they shall be identified by appropriate notes on the report form prior to exposure and testing. ~~preparation shall be rejected.~~

6.5 Condition all specimens to equilibrium moisture content (EMC) at $23 \pm 2^\circ\text{C}$ ($73[68 \pm 4^\circ\text{F}]3^\circ\text{F}$) and $50 \pm 5\%$ relative humidity. Monitor the weight of randomly selected specimens periodically to determine when equilibrium is reached.

6.6 Weigh all specimens to the nearest 0.01 g and record the weight. Measure the width and thickness of the specimens to the nearest 0.25 mm (0.010 in.) [0.010 in.] and record the measurements.

6.7 Randomly assign two specimens from each of the 20 finger joint assemblies in the sample to each test (that is, dry, soak, and boil). (Note this requires only six specimens from each assembly, the other specimens are extra.) Fig. 32 shows the source and distribution of the specimens.

NOTE 6—Thus: 20 assemblies \times 2 specimens/assembly = 40 specimens/test.

7. Procedure

7.1 *Dry Test* (No Treatment):

7.1.1 As described in 6.7, assign 40 specimens to this test. Test each specimen in tension to failure by loading at a rate of 5 mm/min (0.20 in./min) [(0.20 in./min)]. Maintain a space of 240 ± 6 mm ($6[6 \pm 0.25 \text{ in.}]$ in.) between the ends of the jaws of the grips. Record the load at failure.



NOTE 7—Be very careful to align the specimen with the principal axis of the test grip. Failure to do this will increase the variability of the results. ~~Markings or~~ Markings, spacers on the grips, or some other device is recommended to ensure proper front-to-rear alignment, and a plumb bob or other device is recommended to ensure the vertical alignment.

7.1.2 Determine ~~the failure and~~ record the percentage of wood failure and the failure mode using the criteria given in **Annex A1** independent of any knowledge of the strength test result.

7.2 *Cold Water Vacuum-Pressure Soak Test:*

7.2.1 As described in 6.7, assign 40 specimens to this test. Place ~~all 40~~ specimens in a vacuum-pressure vessel with spacers between them so that water has free access to all surfaces. Fill the vessel with tap water at 18.5 to 27.5°C (~~65~~ 65 to 80)°F] so that all specimens are at least 51 mm (~~2 in.~~) 2 in.] below the surface of the water. After filling, seal the vessel and draw a vacuum of at least 635 mm (~~25 in.~~) 25 in.] of mercury (sea level). Hold the vacuum for 30 min, then release the vacuum and apply pressure of 620 ± 35 kPa (75 ± 2 psi). Hold this pressure for 2 h, then release. Remove the specimens from the pressure vessel and place them submerged in water at room ~~temperature until tested.~~ temperature. Remove the specimens individually from the water, and test while wet within 1 h.

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7.2.2 Wipe the surface of each specimen with a dry cotton cloth or paper towel and test wet. Test wet in tension as described in 7.1.1. Record the load at failure.

7.2.3 ~~After the specimens have dried, determine~~ Dry tested specimens to less than 8 % moisture content, then determine and record the percentage of wood failure and the failure mode as described in 7.1.2. Record the failure mode.

7.3 Cyclic Boil Test:

7.3.1 As described in 6.7, assign 40 specimens to this test. Place all 40 specimens in the boil tank with spacers so that water has free access to all surfaces. Fill with water such that the specimens are at least 51 mm (2 in.) [2 in.] below the water level. Boil specimens for 4 h, then dry them in an oven at 63 ± 2°C (145 [145 ± 5°F] 5°F) with sufficient air circulation to lower the moisture content to 8 % (oven-dry basis) ± 3 % of their conditioned weight recorded in 6.6 in no more than 20 h.

NOTE 8—The rate of air circulation, the size of the load of specimens in the oven, and the spacing of the specimens greatly affect drying time and the steepness of the moisture gradient in the specimen. Variation of these factors strongly affects the repeatability of the test method. ~~If~~ In order to obtain acceptable repeatability (within-laboratory variability) and reproducibility (between laboratories) is important, the drying variables must be maintained as constant as possible from one series of tests to the next. If this is not possible, the drying laboratories), the drying should be conducted so that the specimens reach 8 % moisture content ± 3 % of their original weight within the same drying period in every test. One way to do this is to monitor the weight of the specimens and adjust the oven vents so the specimens reach the target 8 % moisture weight in 15 to 20 h. As an aid in following moisture content, the weight of specimens at 8 % moisture content is about 96 % of their weight at 12 % moisture content. The drying time aid, the drying time and airflow required can be established with some of the extra specimens cut from the 20 assemblies.

7.3.2 Repeat the boil-dry cycle five more times; except during the final cycle do not dry the specimens. ~~Cool the specimens to room temperature submerged in water and keep them there until they are tested. Remove the specimens from the boiling vessel and cool in running water at 18 to 27°C [65 to 80°F] for 1 h. Remove the specimens individually from the water, and test while wet within 1 h.~~

7.3.3 Test wet in tension as described in 7.2.27.1.1. Record the load at failure.

7.3.4 ~~After the specimens have dried, determine~~ Dry tested specimens to less than 8 % moisture content, then determine and record the percentage of wood failure and the failure mode as described in 7.1.2. Record the failure mode.

NOTE 9—Nonmandatory guidelines for joint performance follow:

Mode 1 —
Modes 2 and 3 —
Modes 4, 5, and 6 —

An unacceptable failure.
Unconditionally acceptable failure.
Conditionally acceptable failure if strength is acceptable.

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8. Calculation of Results

8.1 Calculate the tensile stress at failure in megapascals (pounds-force per square inch) as the load at failure in newtons (pounds-force) divided by the cross-sectional area of the specimen expressed to the nearest mm provided by the measurements of 6.6 (0.01 in.²).

8.2 Estimate the 25th, 50th, and 75th percentiles for the group of specimens in the following manner:

- 8.2.1 Arrange the specimens in order of increasing strength.
- 8.2.2 Estimate the 25th percentile as the average of the 10th and 11th lowest strength values.
- 8.2.3 Estimate the 50th percentile as the average of the 20th and 21st values.
- 8.2.4 Estimate the 75th percentile as the average of the 30th and 31st strength values.

8.3 Determine the upper and lower adjacent values (see definition below) for the group of specimens. Determine the outliers (test values outside the range expressed by the upper and lower adjacent values).

25th percentile =	Q1	= the value below which 25 % of the observations fall.
50th percentile =	Q2	= the value below which 50 % of the observations fall.
75th percentile =	Q3	= the value below which 75 % of the observations fall.
Upper adjacent value	=	the largest observation equal to or less than the quantity $Q3 + 1.5(Q3 - Q1)$.
Lower adjacent value	=	the smallest observation greater than or equal to the quantity $Q1 - 1.5(Q3 - Q1)$.
Outliers	=	observations greater than the upper adjacent value or less than the lower adjacent value.

8.4 Calculate the mean and standard deviation. Specimens exhibiting failure mode 6 may be excluded from the calculation. Include specimens with failure modes 1, 2, 3, 4, and 5 in the calculation unless the strength value is an outlier or the wood is of poor quality (such as compression wood, etc.).