
Lepila - Enokomponentni poliuretani (PUR) za nosilne lesene konstrukcije - Razvrstitev in zahtevane lastnosti (vključno z dopolnilom A1)

Adhesives - One component polyurethane (PUR) for load-bearing timber structures - Classification and performance requirements

Klebstoffe - Einkomponenten-Klebstoffe auf Polyurethanbasis (PUR) für tragende Holzbauteile - Klassifizierung und Leistungsanforderungen

Adhésifs - Adhésifs polyuréthane monocomposants (PUR) pour structures portantes en bois - Classification et exigences de performance

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This European Standard was approved by CEN on 18 December 2022 and includes Amendment 1 approved by CEN on 3 April 2026.

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EN 15425:2023+A1:2026 (E)

European foreword

This document (EN 15425:2023+A1:2026) has been prepared by Technical Committee CEN/TC 193 “Adhesives”, the secretariat of which is held by UNE.

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of an identical text or by endorsement, at the latest by December 2026, and conflicting national standards shall be withdrawn at the latest by December 2026.

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

This document includes Amendment 1 approved by CEN on 3 April 2026.

This document supersedes A1 EN 15425:2023 A1.

The start and finish of text introduced or altered by amendment is indicated in the text by tags A1 A1.

EN 15425:2023 includes the following significant technical changes with respect to EN 15425:2017:

- a) for adhesive type “Special purpose”, the test according to EN 302-8 is performed with a bond line thickness of 0,5 mm;
- b) an additional adhesive subtype I-SP-70-0,5 has been added in Table 1;
- c) for adhesive type FJ, the test according to EN 302-2 is required only with short closed assembly time, and the test according to EN 15416-5 is only required with thin glue line;
- d) for finger joint delamination tests on additional wood species, the reference to EN 301 has been replaced by a new Annex B;
- e) for the delamination test according to EN 302-2 with preservative treated wood, a test with Scots pine (*Pinus sylvestris*) and silver fir (*Abies alba*) covers also Norway spruce (*Picea abies* L.);
- f) the description of the test procedure for an “adhesive line” has been modified;
- g) the description of a test procedure when a primer is used in all bonding operations has been added in Clause 4;
- h) provisions and maximum tolerance for testing and application of a primer have been added in 5.1;
- i) information on water spraying has been included in the scope and as a new Annex C.

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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Introduction

This document is one of a series dealing with one component polyurethane adhesives for use with timber structures, and is published in support of product standards for load-bearing timber structures in connection with EN 1995-1-1, *Eurocode 5: Design of timber structures — Part 1-1: General — Common rules and rules for buildings*.

The series consists of:

- one standard for classification and performance requirements (EN 15425);
- eight test methods (EN 302-1, EN 302-2, EN 302-3, EN 302-4, EN 302-8, EN 15416-1 (“Glass house test”), EN 15416-3 and Annex B of this document) used to assess the performance of adhesives after specified heat and humidity treatments; and
- three test methods (EN ISO 2555 (reference in EN 302-7), EN 15416-4, and EN 15416-5) to characterize the working properties of the adhesives.

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 document may have negative environmental impact. As technological advantages lead to better alternatives for these materials, they will be eliminated from this European Standard to the extent possible.

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