

## **Classification of thermosetting wood adhesives for non-structural applications**

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## EESTI STANDARDI EESSÕNA

## NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 12765:2002 sisaldab Euroopa standardi EN 12765:2001 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 16.01.2002 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN 12765:2002 consists of the English text of the European standard EN 12765:2001.</p> <p>This document is endorsed on 16.01.2002 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p><b>Käsitlusala:</b> This European Standard classifies thermosetting resin based wood adhesives for non-structural applications into durability classes C1 to C4 based on the wet and dry strengths of bond-lines measured under specified conditions after various conditioning treatments.</p>	<p><b>Scope:</b> This European Standard classifies thermosetting resin based wood adhesives for non-structural applications into durability classes C1 to C4 based on the wet and dry strengths of bond-lines measured under specified conditions after various conditioning treatments.</p>
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ICS 83.180

**Võtmesõnad:** adhesive-bonded joints, adhesives, bonding agents, classification, loading classes, non-load bearing, strength of materials, stress, stress group, testing, thermosetting polymers, thermosetting resins, wood, wood glue, woodbased sheet materials, wooden boards

**English version**

**Classification of thermosetting wood adhesives for  
non-structural applications**

Classification des colles à bois à  
résine thermodurcissable à usages  
non structuraux

Klassifizierung von duroplastischen  
Holzklebstoffen für nichttragende  
Anwendungen

This European Standard was approved by CEN on 2001-04-16.

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 Management Centre or to any CEN member.

The European Standards exist 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 Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

**CEN**

European Committee for Standardization  
Comité Européen de Normalisation  
Europäisches Komitee für Normung

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## Foreword

This European Standard 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, and conflicting national standards withdrawn, by November 2001 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

Austria, Belgium, the Czech Republic, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, the Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

## Introduction

European Standards giving a common classification with respect to durability classes for wood adhesives will allow considerable improvement in consumer protection in any future product liability system with regard to properties guaranteed by the adhesive manufacturer.

## 1 Scope

This European Standard classifies thermosetting resin based wood adhesives for non-structural applications into durability classes C1 to C4 based on the dry and wet strengths of bond-lines measured under specified conditions after various conditioning treatments.

For special applications, further tests, which do not fall within the scope of this standard, could be applicable.

The adhesives described in this standard are suitable for the bonding of furniture and interior structures, panelling, doors, windows, stairs etc made of wood or derived timber products.

NOTE Thermosetting resin is defined in EN 923 as: monomer, polymer or copolymer, which when cured, changes into a substantially infusible and insoluble product.

## 2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies (including amendments).

EN 205	Test methods for wood adhesives for non-structural applications — Determination of tensile shear strength of lap joints
EN 923	Adhesives — Terms and definitions.

## 3 Terms and definitions

For the purposes of this European standard the terms and definitions given in EN 923 and the following terms and definitions apply.

### 3.1

#### **thermosetting wood adhesive**

adhesive whose main constituent is a thermosetting resin and which has been formulated for bonding wood

## 4 Classification

An adhesive shall be classified in accordance with Table 1, which gives examples of climatic conditions and fields of application in which the bonded member is to be used. The classification shall be based on tests on thin bond-lines except when gap-filling properties are claimed, in which case it shall be based on tests using both thin and thick bond-lines as defined in EN 205.