

**Determination of the maximum open time for
thermoplastic wood adhesives for non-structural
applications**

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN 16556:2014 sisaldab Euroopa standardi EN 16556:2014 inglisekeelset teksti.	This Estonian standard EVS-EN 16556:2014 consists of the English text of the European standard EN 16556:2014.
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English Version

Determination of the maximum open time for thermoplastic wood adhesives for non-structural applications

Détermination du temps ouvert maximal des adhésifs
thermoplastiques pour bois pour applications non
structurales

Bestimmung der maximalen offenen Wartezeit bei
thermoplastischen Holzklebstoffen für nicht tragende
Anwendungen

This European Standard was approved by CEN on 20 September 2014.

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Foreword

This document (EN 16556:2014) 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of an identical text or by endorsement, at the latest by May 2015 and conflicting national standards shall be withdrawn at the latest by May 2015.

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.

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Environmental statement

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

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1 Scope

This European Standard defines the test method for the determination of the maximum open time for thermoplastic wood adhesives for non-structural applications by tensile shear strength. It is carried out on standardized test pieces glued with increasing open times.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 923, *Adhesives - Terms and definitions*

EN 1067, *Adhesives - Examination and preparation of samples for testing*

EN ISO 15605, *Adhesives - Sampling (ISO 15605)*

ISO 5893, *Rubber and plastics test equipment — Tensile, flexural and compression types (constant rate of traverse) — Specification*

3 Terms and definitions

For the purposes of this document, the terms and definitions given in EN 923 and the following apply.

3.1
maximum open time
 the longest time within which two wooden adherends, where the adhesive is applied, can remain decoupled ensuring a tensile force value $\geq 10 \text{ N/mm}^2$ and a wood failure $> 0 \%$

Note 1 to entry: The open time is expressed in minutes (min).

4 Symbols and abbreviations

A	bonded test surface, in square millimetres (mm^2);
a	thickness of bond-line, in millimetres (mm);
α	angle between growth ring and surfaces to be bonded, in grades ($^\circ$);
b	width of test piece, in millimetres (mm);
F_{max}	the applied load at failure, in Newton (N);
l_1	length of test piece, in millimetres (mm);
l_2	length of overlap (length of tested surface), in millimetres (mm);
s	thickness of the panels, in millimetres (mm);
τ	shear strength, in Newton (N).

5 Sampling

Samples of the adhesive shall be taken according to EN ISO 15605 and prepared for testing according to EN 1067.