
Plywood — Bonding quality —
Part 1:
Test methods

Contreplaqué — Qualité du collage —
Partie 1: Méthodes d'essai



PDF disclaimer

This PDF file may contain embedded typefaces. In accordance with Adobe's licensing policy, this file may be printed or viewed but shall not be edited unless the typefaces which are embedded are licensed to and installed on the computer performing the editing. In downloading this file, parties accept therein the responsibility of not infringing Adobe's licensing policy. The ISO Central Secretariat accepts no liability in this area.

Adobe is a trademark of Adobe Systems Incorporated.

Details of the software products used to create this PDF file can be found in the General Info relative to the file; the PDF-creation parameters were optimized for printing. Every care has been taken to ensure that the file is suitable for use by ISO member bodies. In the unlikely event that a problem relating to it is found, please inform the Central Secretariat at the address given below.

This document is a preview generated by EVS



COPYRIGHT PROTECTED DOCUMENT

© ISO 2007

All rights reserved. Unless otherwise specified, no part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from either ISO at the address below or ISO's member body in the country of the requester.

ISO copyright office
Case postale 56 • CH-1211 Geneva 20
Tel. + 41 22 749 01 11
Fax + 41 22 749 09 47
E-mail copyright@iso.org
Web www.iso.org

Published in Switzerland

Contents

Page

Foreword.....	iv
1 Scope	1
2 Normative references	1
3 Test pieces	1
3.1 Sampling.....	1
3.2 Shape and size.....	1
4 Apparatus	5
4.1 Pre-treatment.....	5
4.2 Shear test.....	5
5 Pre-treatment.....	5
5.1 Sequence of pre-treatment	5
5.2 Positioning of test pieces	5
6 Procedure	6
6.1 Determination of behaviour of ply bonding by shear test.....	6
6.2 Determination of percentage of apparent cohesive wood failure	6
6.3 Alternative procedure.....	6
7 Expression of results	6
8 Test report	7
Annex A (normative) Determination of percentage of apparent cohesive wood failure by comparison with reference illustrations.....	8
Annex B (normative) Bond testing and evaluation using the chisel/knife testing procedures (suitable for quality control purposes only)	12
Bibliography	16

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

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

ISO 12466-1 was prepared by Technical Committee ISO/TC 89, *Wood-based panels*, Subcommittee SC 3, *Plywood*.

This second edition cancels and replaces the first edition (ISO 12466-1:1999), which has been technically revised.

ISO 12466 consists of the following parts, under the general title *Plywood — Bonding quality*:

- *Part 1: Test methods*
- *Part 2: Requirements*

Plywood — Bonding quality —

Part 1: Test methods

1 Scope

This part of ISO 12466 specifies methods for determining the bonding quality of plywood, blockboard, battenboard, and laminboard, bonded with thermosetting resin, by shear testing.

NOTE If it is possible to demonstrate a correlation between the methods defined in this part of ISO 12466 and other methods, these may be used.

2 Normative references

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

ISO 12466-2, *Plywood — Bonding quality — Part 2 Requirements*

ISO 16999, *Wood-based panels — Sampling and cutting of test pieces*

3 Test pieces

3.1 Sampling

Sampling shall be in accordance with ISO 16999.

Test pieces shall be without any visible defect in the testing area.

3.2 Shape and size

The test pieces shall be prepared as shown in Figures 1, 2 and 3.

Each test piece shall be cut so that the grain direction of the layer (ply) between the glue lines under test is perpendicular to the length of the test piece.

The test pieces shall be prepared and nicking (saw cuts) made to allow the examination of each glue line of the panel. The saw cuts shall extend inside the layer.

Test pieces of full-panel thickness may be used for panels with three to nine layers (plies). For panels of more than nine layers, excess layers shall be removed by planing, cutting or sanding.