

ICS 79.080

English Version

**Laminated and finger jointed timber blanks and semi-finished
profiles for non-structural uses - Part 2: Production control**

Ebauches et profilés semi-finis en bois lamellé-collés et
assemblés par enture multiples pour usages non
structurels - Partie 2: Contrôle de production

Holzkanteln und Halbfertigprofile für nicht tragende
Anwendungen - Teil 2: Produktionskontrolle

This Technical Specification (CEN/TS) was approved by CEN on 1 September 2009 for provisional application.

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Foreword

This document (CEN/TS 13307-2:2009) has been prepared by Technical Committee CEN/TC 175 “Round and sawn timber”, the secretariat of which is held by AFNOR.

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Introduction

The production requirements and control described in this Technical Specification are designed so as to obtain a reliable and durable bond between the lamellae, in order that the bonds in the glued laminated blanks will maintain their integrity throughout their intended service life. Such blanks are not intended to be used as load-bearing members.

1 Scope

This Technical Specification specifies the method of control and tests for glue bond performance of lamination and finger jointing processes employed in the production of timber blanks and semi-finished profiles (products) for joinery applications.

The methods of control are set out to ensure the durability of the glue line according to the service class.

The specific requirements for dimensions, stability and moisture content are given in EN 13307-1.

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.

EN 204, *Classification of thermoplastic wood adhesives for non-structural applications*

EN 301, *Adhesives, phenolic and aminoplastic, for load-bearing timber structures — Classification and performance requirements*

EN 392, *Glued laminated timber — Shear test of glue lines*

EN 408, *Timber structures — Structural timber and glued laminated timber — Determination of some physical and mechanical properties*

EN 12765, *Classification of thermosetting wood adhesives for non-structural applications*

EN 13183-1, *Moisture content of a piece of sawn timber — Part 1: Determination by oven dry method*

EN 13183-2, *Moisture content of a piece of sawn timber — Part 2: Estimation by electrical resistance method*

EN 13183-3, *Moisture content of a piece of sawn timber — Part 3: Estimation by capacitance method*

EN 13307-1, *Timber blanks and semi-finished profiles for non-structural uses — Part 1 : Requirements*

EN 13354, *Solid wood panels (SWP) — Bonding quality — Test method*

EN 14220, *Timber and wood-based materials in external windows, external door leaves and external doorframes — Requirements and specifications*

EN 14221, *Timber and wood-based materials in internal windows, internal door leaves and internal doorframes — Requirements and specifications*

EN 14257, *Adhesives — Wood adhesives — Determination of tensile strength of lap joints at elevated temperature (WATT '91)*

EN 14298, *Sawn timber — Assessment of drying quality*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1

adhesive failure

failure of the glue bond, where an adhesive film, free of wood particles, may be detected on the opposing sheared wood surfaces