



BSI Standards Publication

Adhesives for load bearing timber structures other than phenolic and aminoplastic — Test methods

Part 4: Determination of open assembly time under referenced conditions

National foreword

This British Standard is the UK implementation of EN 15416-4:2025. It supersedes BS EN 15416-4:2017, which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee PRI/52, Adhesives.

A list of organizations represented on this committee can be obtained on request to its committee manager.

Contractual and legal considerations

This publication has been prepared in good faith, however no representation, warranty, assurance or undertaking (express or implied) is or will be made, and no responsibility or liability is or will be accepted by BSI in relation to the adequacy, accuracy, completeness or reasonableness of this publication. All and any such responsibility and liability is expressly disclaimed to the full extent permitted by the law.

This publication is provided as is, and is to be used at the recipient's own risk.

The recipient is advised to consider seeking professional guidance with respect to its use of this publication.

This publication is not intended to constitute a contract. Users are responsible for its correct application.

© The British Standards Institution 2025
Published by BSI Standards Limited 2025

ISBN 978 0 539 31730 5

ICS 83.180

Compliance with a British Standard cannot confer immunity from legal obligations.

This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 October 2025.

Amendments/corrigenda issued since publication

Date	Text affected

English Version

Adhesives for load bearing timber structures other than
phenolic and aminoplastic - Test methods - Part 4:
Determination of open assembly time under referenced
conditions

Adhésifs pour structures portantes en bois de type
autre que phénolique et aminoplaste - Méthodes
d'essais - Partie 4 : Détermination du temps
d'assemblage ouvert dans des conditions de référence

Klebstoffe für tragende Holzbauteile ausgenommen
Phenolharzklebstoffe und Aminoplaste - Prüfverfahren
- Teil 4: Bestimmung der offenen Wartezeit bei
Referenzbedingungen

This European Standard was approved by CEN on 11 August 2025.

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 CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists 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 CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

Contents

Page

European foreword	3
Introduction	4
1 Scope.....	6
2 Normative references.....	6
3 Terms and definitions	6
4 Principle	7
5 Apparatus	7
6 Procedure	7
6.1 General.....	7
6.2 Preparation of bonded assemblies.....	7
6.3 Preparation of samples for testing.....	8
6.4 Test procedure.....	8
7 Expression of results	8
7.1 Tensile shear strength	8
7.2 Failure mode.....	8
7.3 Glue line thickness	9
8 Requirement.....	9
9 Test report.....	9
9.1 General information	9
9.2 Information about the adhesive	9
9.3 Preparation of test pieces and testing procedure.....	9
9.4 Test results.....	10

European foreword

This document (EN 15416-4:2025) 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 April 2026, and conflicting national standards shall be withdrawn at the latest by April 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 supersedes EN 15416-4:2017.

EN 15416-4:2025 includes the following significant technical changes with respect to EN 15416-4:2017:

- a) terms and definitions for glue line added;
- b) determination of glue line thickness in 6.3 described in more detail;
- c) expression of glue line thickness added as 7.3;
- d) different spread rates and glue line thicknesses considered in the requirement in Clause 8.

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.

According to the CEN-CENELEC Internal Regulations, the national standards organisations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Republic of North Macedonia, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Türkiye and the United Kingdom.