



BSI Standards Publication

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

Part 5: Determination of minimum pressing
time under referenced conditions

National foreword

This British Standard is the UK implementation of EN 15416-5:2017. It supersedes BS EN 15416-5:2006 which is withdrawn.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 secretary.

This publication does not purport to include all the necessary provisions of a contract. Users are responsible for its correct application.

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Published by BSI Standards Limited 2017

ISBN 978 0 580 85711 9

ICS 83.180

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This British Standard was published under the authority of the Standards Policy and Strategy Committee on 31 January 2017.

Amendments/Corrigenda issued since publication

Date	Text affected
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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN 15416-5

January 2017

ICS 83.180

Supersedes EN 15416-5:2006

English Version

Adhesives for load bearing timber structures other than phenolic and aminoplastic - Test methods - Part 5: Determination of minimum pressing time under referenced conditions

Adhésifs pour structures portantes en bois de type autre que phénolique et aminoplaste - Méthodes d'essais - Partie 5 : Détermination du temps de pressage minimal dans des conditions de référence

Klebstoffe für tragende Holzbauteile ausgenommen Phenolharzklebstoffe und Aminoplaste - Prüfverfahren - Teil 5: Bestimmung der Mindestpresszeit bei Referenzbedingungen

This European Standard was approved by CEN on 30 October 2016.

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Ref. No. EN 15416-5:2017 E

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European foreword

This document (EN 15416-5:2017) 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of an identical text or by endorsement, at the latest by July 2017, and conflicting national standards shall be withdrawn at the latest by July 2017.

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 15416-5:2006.

Compared to EN 15416-5:2006, the following main modifications have been made:

- a) title has been changed;
- b) application for EPI adhesives according to EN 16254 has been added;
- c) the pressing times are determined for both close contact glue line and 0,3 mm thick glue line when testing PUR adhesives (EN 15425) and EPI adhesives in category “General purpose” (EN 16254), and close contact glue line and 0,2 mm thick glue for EPI adhesives designed for category “Small dimensions” (EN 16254);
- d) some parts of this European Standard are made in line with EN 302-6:2013;
- e) some of the wording in EN 302-1:2013 have been used to describe how to evaluate and report % wood failure (fibre failure) in the tested test pieces;
- f) it is stated that the glue application shall be done at the temperature used for conditioning and pressing of the material. When screening tests are performed, the material may, however, be removed from the test temperature for glue application;
- g) measurement and reporting of glue line thickness has been deleted.

This document is one of a series dealing with adhesives for use with timber structures, and is published in support of product standards for bonded load-bearing timber structures.

The series consists of three classification and performance requirements for adhesives for load-bearing timber structures, phenolic and aminoplastic adhesives (EN 301), one component polyurethane adhesives (EN 15425) and emulsion polymerized isocyanate adhesives (EN 16254), together with 12 test methods (EN 302 Parts 1 to 8 and EN 15416 Parts 1 and 3 to 5).

These European Standards have the following titles:

- EN 301, *Adhesives — phenolic and aminoplastic, for load-bearing timber structures — Classification and performance requirements*
- EN 15425, *Adhesives — One component polyurethane (PUR) for load-bearing timber structures - Classification and performance requirements*