

**Norsk Treteknisk Institutt (Treteknisk) Sveriges Tekniska  
Forskningsinstitut (SP), Statens Tekniska Forskningscentral  
(VTT), Dansk Teknologisk Institut (DTI)**

*Adhesives tested and approved for production of structural glulam and finger jointed structural timber in Norway, Sweden, Finland and Denmark*

**Norsk Treteknisk Institutt  
Blindern, 2011-06-20**

Replaces edition dated 2010-11-16

Approval has been given for a period of 5 years. At expiration of each 5 year period, confirmation is needed from the adhesives producer that the composition of the glue has not been changed since the adhesive system was approved the first time. Adhesives approved for hardwood are tested on European Oak (Pedunculate Oak), and will also apply to European Ash. For other hardwood species separate approval is needed.

### Footnotes

- 1) The adhesive can be used in separate string dispersion of glue and hardener for gluing of lamellae (the production line must be approved separately).
- 2) The adhesive is approved for finger jointing with 5 % water additive and/or with 0,005 % of the colorant "Basonyl Red".
- 3) The adhesive is approved for finger jointing of spruce and pine, as well as pine pressure impregnated with CCA-salts, with 5 % water additive.
- 4) The adhesive is approved for finger jointing of spruce and unimpregnated pine with 5 % water additive.
- 5) The adhesive system is approved for finger jointing of Nordic softwood where glue and hardener is applied in mixed form.
- 6) The adhesive system is approved for separate application of glue and hardener when finger jointing of Nordic softwood. The equipment for glue application must be approved separately, both regarding coverage, amount and mixture/mixing ratio. The national control organs must through testing make sure that sufficient dry strength is achieved, and that the glue lines' final water durability are as assumed.
- 7) The adhesive is approved for finger jointing with 5 % water additive and/or 2,2 % of colorant (2,0 % Pintosol E-WL 41 + 0,2 % Colanyl Schwarz PR 130).
- 8) The adhesive is suited for "Contactless" application (strings across the finger front). System for application and safety must be approved separately by the national control organs.
- 9) The adhesive is also tested according to EN 392 (shear strength) and EN 302-2 (delamination) with glue line thickness 2 mm. The system is thus suited for certain types of gluing, where a thicker glue line than normal must be expected.

Note 1: *The term finger jointing includes both glulam lamellae and finger jointed structural timber.*

### Remarks

Most of the adhesives are accepted as CE approved according to the intention of EN 14080. Such an acceptance is given in a separate column.

### Adhesives approved only for indoor use

#### Casein

The adhesives are tested according to existing procedures for casein adhesives.

Adhesive	Approved for	Supplier	Last approved
Prefere 9800	Nordic softwood	Dynea AS	2009





## Adhesive given separate approval for finger jointing of structural timber

For use in service class 1, 2 and 3.

### Emulsion Polymerised Isocyanate (EPI)

Casco Adhesives	1989	1993	Casco Adhesives AB	15	2006
Kestokol	WR11	WR	Kiilto OY	15	2009
Prefere	6150	6650	Dynea AS	15	2009

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### Melamine-Urea-Formaldehyde (MUF)

Kauramin	683	688	BASF	30 - 100	2006
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### 1 component Polyurethane (PUR)

Jowapur	686.20	-	Jowat AG	-	2010
"	680.20	-	"	-	2011

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Note 5 : Approved for Norway Spruce