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1 **Feasibility of glued laminated timber beams**  
2 **with tropical hardwoods**

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10

11 **Abstract:**

12 A feasibility study of glulam was carried out in French Guiana using local wood species. The aim  
13 was to determine gluing parameters affording satisfactory behaviour to manufactured glulam in  
14 a tropical climate.

15 Three abundant wood species, with special properties, were selected for the study and  
16 Resorcinol-Phenol-Formaldehyde resin was used for bonding. Three industrial parameters were  
17 considered: adhesive spread rate, closed assembly time and gluing pressure. Delamination and  
18 shearing tests were carried out in accordance with European Standards.

19 The tests revealed the influence of wood properties and manufacturing parameters on joint  
20 resistance. In fact, the results showed that specific gravity and the shrinkage coefficient greatly  
21 influenced the gluing step. Indeed, wood with a medium specific gravity needed more adhesive  
22 and more pressure than wood with a high specific gravity. In addition, planing and lamella  
23 thickness were found to affect glue joint resistance.

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25 **Keywords:** *tropical hardwoods, glulam, delamination, shear strength*

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# 1 Introduction

2 Nowadays, glued laminated timber is acknowledged to be a high-performance  
3 composite material used in construction. Indeed, this wood product enjoys high  
4 mechanical properties, compared to solid wood (Guitard 1994). It is also an  
5 economical and ecological material, comparing to concrete or steel, using a  
6 renewable resource provided by a sustainable forest management. Despite  
7 increasing glulam imports into French Guiana, these wood products need to meet  
8 some specific requirements for use in a tropical climate. However, some local  
9 wood species from the Amazon forest could be used for glulam manufacturing,  
10 avoiding risks of degradation due to the abundance of fungi and termites.

11 The assembling of wood products by gluing depends on many interlinked factors  
12 to achieve a single glued assembly. While glulam manufacturing in temperate  
13 countries has been mastered, the adhesive bonding of wood components in a  
14 tropical climate raises numerous problems. One of the main problems is high  
15 temperatures and humidity, which weaken the adhesive and its adhesion (EN 301  
16 2006). Consequently, the gluing process is a critical step that can greatly affect  
17 adhesion and the mechanical properties of glulam beams manufactured in French  
18 Guiana. This step can be defined by various industrial parameters: glue basis  
19 weight which is related to the glue spread rate, assembly time which indicates  
20 glue polymerization status and the pressure applied to hold lamellae together  
21 (Elbez and Bentz 1991). Moreover, tropical hardwood properties, such as a high  
22 specific gravity, high shrinkage coefficient, or the presence of resins, are another  
23 major bonding problem (Gérard 1999). In order to avoid these problems, the right  
24 match has to be established between the gluing parameters, appropriate wood  
25 properties and moisture content under tropical conditions (Guiscafre and Sales  
26 1980 intern report). Based on the glulam manufacturing of African hardwoods,  
27 past studies (Bedel and Gautier 1972; Guiscafre and Sales 1975, 1980 intern  
28 report; Gérard 1999) have shown that closed assembly times need to be shorter  
29 than those recommended by the adhesive manufacturer, due to high temperatures  
30 in the tropics, which increase resin curing (Bedel and Gautier 1972). A high  
31 pressure is not beneficial when gluing wood with a high specific gravity  
32 (Guiscafre and Sales 1975, 1980 intern report). Furthermore, careful surface  
33 preparation of the lamellae before gluing and a uniform glue joint thickness are  
34 required to manufacture a timber beam. Moreover, it appears that a sanded surface  
35 does not increase delamination results (Guiscafre and Sales 1980 intern report;  
36 Gérard 1999). Lastly, working on hardwoods, Hwang et al. (1993) showed that  
37 bonding-strength (evaluated by shearing tests) increases with an increase in the  
38 specific gravity of the wood, whereas retention of Resorcinol Phenol  
39 Formaldehyde (RPF) adhesive in the wood decreases (Hwang et al. 1993).

40 As there is no standard on the use of hardwood glulam for structural purposes, this  
41 innovative structural wood gluing assembly has to be validated by two  
42 standardized tests designed for softwood species. The delamination test assesses  
43 the resistance of the assembly to shearing and tension perpendicular to the grain

1 induced by cyclical variations in wood moisture content. It is defined as an ageing  
2 test. The block shear test characterizes mechanical resistance of the joint to  
3 shearing.

4  
5 In this study, the bondability of hardwoods for glued laminated timber beams was  
6 assessed in French Guiana using local wood species. The aim was to establish  
7 gluing parameters affording good mechanical properties to glued laminated beams  
8 manufactured in a tropical climate.

## 10 **2 Materials and methods**

11 The study of the feasibility of glulam with new wood species needs to choose the  
12 adequate wood species and adhesive producing the best association wood-  
13 adhesive-preservation. The present study focused mostly on the analysis of the  
14 combination specie-adhesive. To avoid risks of degradation due to the virulence  
15 of fungi and termites, species with natural durability were considered and  
16 recommendations in use were provided to enhance the preservation (Bourreau  
17 2011).

### 18 **2.1 Wood and adhesive properties**

19 In French Guiana there are almost 1,500 species listed, but wood properties and  
20 industrial constraints impose a strict choice of species for glulam manufacture.  
21 The most important physical wood properties are specific gravity, wood  
22 shrinkage, anisotropy and satisfactory natural durability. The chosen species were  
23 logged according to a sustainable forest management provided by the French  
24 Forestry Organisation (ONF) pending PEFC and FSC certifications for French-  
25 Guiana area.

26 Three abundant wood species were selected: *Qualea rosea*, *Dicorynia guianensis*  
27 and *Peltogyne venosa*. *P. venosa* and *D. guianensis* have both sufficient natural  
28 durability when not used in ground contact, whereas the *Q. rosea* needs a soak  
29 treatment when used in exterior condition. However, working on the gluing of  
30 treated hardwoods, Janowiack et al (1992) and Paes et al (2009) show good  
31 bonding results between RPF adhesive and CCA treatment. In this study, a  
32 softwood specie, *Larix decidua*, commonly used in temperate countries was  
33 considered as a reference species (CIRAD 2008).

34 Some wood properties can be found in technical documents for Guianese wood  
35 species (CTFT 1999, EN 335-2 2006) and they are summed up in table 1.

36 A wide variety of adhesives is available on the market, but depending on  
37 end-uses, requirements are different and are regulated by European standards.  
38 Thus, given the structural purposes under tropical conditions, the choice of  
39 adhesives is limited to two types, a Melamine-Urea-Formaldehyde (MUF) and a  
40 Resorcinol Phenol Formaldehyde (RPF) (EN 301 2006). However, bonding tests  
41 on the selected tropical species (Bourreau 2011) showed that the MUF is sensitive

1 to the surrounding environmental conditions of high temperatures and high  
2 humidity and is not recommended to be used in a manufacturing process under  
3 tropical conditions. This observation was also reported by Custodio et al.(2008).

## 4 **2.2 Bonding durability tests**

5 To assess bonding efficiency, delamination and block shear tests were used in this  
6 study in accordance with European standards EN 391: 2002 and EN 392: 1995  
7 respectively.

### 8 *2.2.1 Delamination*

9 The delamination test is used to assess the resistance of the glue joint after ageing  
10 cycles including strong variations in wood moisture content. As wood dimensions  
11 vary during use depending on changes in ambient humidity, delamination assesses  
12 the resistance of the glued assembly under those variations. Depending on the  
13 service classes for which the end-product is to be used, different delamination test  
14 procedures exist relative to the risk levels assessed for the wood product (EN 391  
15 2002). Thus, for glulams used in service class 3, outdoor conditions, delamination  
16 tests were carried out according to procedure A, described in EN 391: 2002  
17 standard. This involved three cycles of water immersion with a pressure of 6 bars,  
18 then drying between 60 and 70 degrees Celsius until the specimen reached its  
19 initial weight (around 22 hours).

20  
21 Measurements were taken along the glue lines on each cross-section of the  
22 specimen. The total delamination of a specimen ( $D_s$ ) was calculated, which  
23 expresses the proportion of the delamination length of all glue lines ( $l_{DS}$ )  
24 compared to the total length of all the glue lines of a specimen ( $l_s$ ), as illustrated in  
25 the next equation.

26

$$D_s(\%) = \frac{l_{DS}}{l_s} \times 100$$

27 Delamination was measured to an accuracy of 0.1 mm. This value was compared  
28 to the upper limit allowed by the European standards, i.e. 10% for tropical  
29 hardwoods.

30

### 31 *2.2.2 Block shear strength and wood failure.*

32 The block shear test is used to assess the shear mechanical resistance parallel to  
33 the grain of the glued assembly (EN 392 1995). Indeed during glulam beams  
34 loading, the shear is a major failure mode of the interfaces of the lamellae. At the  
35 end of the shearing test, the adherence of the glue joint is also assessed on the  
36 faces of the sheared samples in order to determine the weakened part of the  
37 composite, either the adhesive or the wood.

1 Shear tests were carried out on specimens with square areas in accordance with  
2 EN 392: 1995. Shear-strength testing was conducted using an MTS machine with  
3 a constant crosshead displacement rate. During the tests, most failures occurred  
4 within 20seconds. The wood failure percentage was estimated to the nearest 5 %  
5 of explored shear area. The requirement, according to EN 386: 2002 is a  
6 combination between maximum shear strength ( $f_v$ ) and wood failure percentage  
7 (WFP), which is the percentage of wood on the sheared surface. Requirements for  
8 individual and average values are given in table 2. However, past studies on the  
9 bondability of African hardwoods considered that block shear testing is successful  
10 when glue line shear-strength reaches at least 80% of solid wood shear resistance  
11 (Guiscafre and Sales 1975).

12

13

## 14 **2.3 Experimental data plan**

15 In order to evaluate the effect of bonding conditions on glued assembly durability  
16 for glulam manufacturing under the climatic conditions in French Guiana (average  
17 temperature: 30°C, relative humidity: 85%), three industrial parameters were  
18 considered: spread rate (g/m<sup>2</sup>), Closed Assembly Time (CAT in min), defined as  
19 the time from assembly until the application of pressure, and clamping pressure  
20 (MPa).

### 21 *2.3.1 Experimental procedure*

22 In this study, 92 glulam beams composed from three wooden slats were  
23 manufactured and tested. Depending on the lamellae thickness ( $e$ ), the size of the  
24 beams was 3x100x700 mm<sup>3</sup>. Beams were manufactured from boards, air-dried in  
25 the local atmosphere until they had reached a balanced moisture content MC. The  
26 balanced MC observed on the guianensis species was 14, 16 and 17% ( $\pm 2\%$ ) for  
27 *P. venosa*, *D. guianensis* and *Q. rosea* respectively. This difference could be  
28 explained by an experimental fluctuation induced by the season when the test, and  
29 so the MC measures, were done. Because boards were air-stabilized, moisture  
30 content recorded during the dry season will be lower than the MC recorded at the  
31 wet season.

32

33 The clamping pressure was applied by a traditional screw press. The pressure was  
34 controlled by a torque wrench. After at least 8 hours' pressurization to ensure  
35 almost full bonding strength, all the glulam beams were conditioned in the  
36 ambient climate for at least 2 weeks before any handling. Afterwards, beams are  
37 planned and full cross-sectional slats were cut from each beam, alternating one  
38 specimen for the delamination test and one for the shear test. A total of 5 samples  
39 of dimension 3x90x75mm<sup>3</sup> for the delamination test and 4 samples of dimension  
40 3x45x45 mm<sup>3</sup> for the shear tests were produced per beam to ensure good

1 representativeness of bonding. No loading (bending, etc.) has been applied on the  
2 beams before delamination or shear tests.  
3 Before testing, the joint thickness of each beam was measured under an electronic  
4 microscope on samples reserved for the shear test, in order to determine the actual  
5 amount of glue present at the bonding interface. In fact, the actual glue spread rate  
6 depends on the squeeze-out of adhesive during the pressing steps, table 3 and the  
7 part of the adhesive absorbed by lamellae(Bourreau2011). According to the  
8 standards, the samples used for shear tests are stabilized around a moisture  
9 content (MC) of 12% and cut in standard dimensions just before performing the  
10 tests. This avoids sample shrinkage.

11

### 12 2.3.2 Bonding tests

13 To conduct this study, 3 sets of experiments were carried out. They are  
14 summarized in table 3. The 1<sup>st</sup> set examined the influence of surface preparation  
15 before bonding. The 2<sup>nd</sup> set, the main one in this study, focused on the effect of  
16 the industrial parameters described previously on the bonding of each wood  
17 species studied (*Q. rosea*, *P. venosa*, *D. guianensis* and *L. decidua*). In this set of  
18 tests, the glue was spread on both sides of the boards. The values of the tested  
19 gluing parameters used in the first two sets were selected on the basis of the  
20 adhesive manufacturer recommendations, that advised to glue with 750g/m<sup>2</sup> per  
21 face with a clamping pressure of the 1 MPa and a CAT of 20 minutes at 30°C.  
22 Finally, a set of validation tests was carried out on the species with good  
23 delamination results established in the 2<sup>nd</sup> set of tests. In addition, the effect of  
24 lamella thickness on delamination was investigated, in order to improve bonding.

## 25 3 Results and discussion

26 In this part, the results of the delamination and the block shear tests are presented.  
27 They are followed by a discussion that explains the influence of the considered  
28 parameters (Glue spread rate, CAT and Pressure) on the bonding of the glulam.

### 29 3.1 Delamination results

#### 30 3.1.1 Planning influence

31 Firstly, the influence of surface preparation was examined by means of the 1<sup>st</sup> set  
32 of delamination tests. Table 4 shows the delamination results for 3 gluing  
33 conditions obtained on specimens planned more than a day before gluing and  
34 glued a maximum of 8h after planning.

35 This table shows that the delamination factor was greatly affected by surface  
36 preparation. The results show that a surface glued more than 24hours after  
37 planning interfered with the adhesion of the resin. It appears that the wood surface  
38 needed to be refreshed just before the gluing step to avoid contamination of the  
39 surface by wood chemicals, which are very present in hardwoods and migrate to

1 the surface (Nussbaum and Sterley 2002). This step therefore prepares the wood  
2 support, to give good anchorage of the adhesive to its surface and also enhances  
3 the physical and chemical links between its surface and the glue (Nussbaum and  
4 Sterley 2002; Gindl et al. 2004). In temperate countries, when gluing softwood  
5 species, it is recommended to spread the adhesive within a day (Nussbaum and  
6 Sterley 2002). In our case it seemed that gluing within 8 hours after planning was  
7 very beneficial.

8

### 9 3.1.2 Glue spread rate influence

10 The effect of the glue spread rate on delamination was examined in the 2<sup>nd</sup> set of  
11 tests. The results are given in figure 1 for the three wood species used. In this  
12 figure, one point represents the average delamination recorded on the 5 samples  
13 obtained from the same beam.

14 On this graph, the first observation is that the amount of adhesive measured on the  
15 glue joint of the samples was much lower than the quantity applied. Despite some  
16 good results for samples with a thin glue joint, delamination results greatly varied  
17 and were well over the 10% limit allowed by the European standard. Moreover,  
18 the reference softwood species, *L. Decidua*, gave very good results. In fact, when  
19 glued under the same conditions, the samples of the reference species had a  
20 significantly greater glue joint thickness and therefore resisted cracking and joint  
21 opening during the severe moisture variations.

22 We also found that higher delamination results ( $D_s = 80\%$ ) were achieved with  
23 wood species displaying higher swelling coefficients (*Q. rosea*:  $R_B = 14.44\%$ ),  
24 whereas the wood displaying lower swelling coefficients (*P. venosa*) showed less  
25 delamination ( $D_s = 40\%$ ) and low variability in the results. Indeed, the higher the  
26 swelling coefficient of the bonded wood, the higher was the delamination risk,  
27 due to greater tensile and shearing stresses at the gluing interface, induced by the  
28 moisture variations.

29 Lastly, figure 1 illustrates that, for *P. venosa* and *D. guianensis*, the specimens  
30 with a glue spread rate over  $180 \text{ g/m}^2$  at the joint interface had delamination results  
31 under the standard limit of 10%.

32 In order to analyse the effect of the glue spread rate on delamination resistance for  
33 the three species, a generalized additive model (GAM) was used (figure 2).

34 Figure 2 shows the general trends of dependence of the bonding of the three  
35 species on the glue spread-rate. The black line represents the mean effect of glue  
36 spread rate on delamination and the dotted lines represent its 95% confidence  
37 interval. When these three lines become positive or negative, it means that the  
38 influence of glue spread rate parameter is meaningful. Thus, Figure 2 shows no  
39 significant dependence for *Q. rosea* (a) within the range of  $80 \text{ g/m}^2 - 135 \text{ g/m}^2$ . In  
40 fact, the recorded quantity of glue on the bonding interface was very small, and  
41 cannot identify any dependence. For *P. venosa* (b) and *D. guianensis* (c), the plot



1 shows a high dependence and give a general trend. It appeared that the larger the  
2 amount of adhesive was on the bond, the lower was the delamination factor.  
3 Lastly, this analysis identified the lower limit needed to obtain acceptable  
4 delamination results for structural bonding. The amounts were respectively  
5 175g/m<sup>2</sup> and 220g/m<sup>2</sup> for *P. venosa* and *D. guianensis* determined graphically  
6 when the mean effect and its confidence interval become negative on the figure.

7

### 8 3.1.3 CAT and Pressure influences

9 In order to analyse the effect of the other gluing parameters on delamination  
10 resistance, statistical analyses of variance (ANOVA) were performed using the  
11 CAT and the pressure level P as variables and the interaction between them (table  
12 5). And figure 3 presents graphically the influence of pressure (1) and CAT (2) on  
13 delamination results of the three Guianese wood species. Black lines on this figure  
14 represent the maximal delamination according to the standard.

15 Table 5 shows the effect of gluing parameters on the delamination resistance of  
16 the three Guianese wood species used. The results showed that the CAT greatly  
17 affected *D. guianensis* but not *Q. rosea* and *P. venosa*. On figure 3 (a2 and c2), it  
18 appeared that best results were obtained when the CAT was shortest (5 minutes),  
19 and maximum delamination occurred when the CAT was 10 minutes long.  
20 Likewise, the pressure level was only significant for *P. venosa*. Indeed, the results  
21 showed that a low pressure level was needed to prevent delamination (figure 3b1).  
22 For *Q. rosea*, table 5 reveals a significant effect of the coupling agent P and CAT.  
23 For this species, it appeared that the higher the applied pressure level was, the  
24 longer the CAT needed to be in order to obtain sufficient bonding.

### 25 3.2 Block shear results

26 As well as the delamination tests, the 27 gluing conditions given for the 2<sup>nd</sup> set of  
27 tests (table 3) were also tested, in accordance with the European standard, to  
28 assess glue joint shear resistance. Figure 4 gives the block shear results for the 2<sup>nd</sup>  
29 set of tests, as a function of the maximum shear resistance,  $f_v$ , and the wood failure  
30 percentage (WFP) of the assembly. Figure 4a shows all individual values and  
31 Figure 4b the mean values of the 54 beams tested per species. On each graph,  
32 black line represents the WFP minimum value to reach according to EN386:  
33 2002. Dotted lines represent the requirements proposals made by Aicher and  
34 Ohnesorge(2011) when tested beech glulam.

35 The block shear test gave an average strength  $f_{v, mean}$  per species of around 13.5,  
36 14.7 and 13.5MPa for *Q. rosea*, *P. venosa* and *D. guianensis* respectively.  
37 Despite some minor differences between wood species, the block shear strength of  
38 the individual specimens ranged between 4.3 and 21.7 MPa and the wood failure  
39 percentage from 15 to 100%. It appeared that 4% of all the specimens tested  
40 displayed low shear strength (from 4 to 6 MPa), 11% had medium shear strength  
41 (from 6 to 11 MPa) and 85% showed high shear resistance (over 11 MPa). This

1 last resistance class presents results close to the shear strength recorded for solid  
2 wood samples ( $f_{v,mean-solid} = 13.3, 15.0$  and  $13.8$  MPa for *Q. rosea*, *P. venosa* and *D.*  
3 *guianensis* respectively). Indeed, the shear resistance ratios between glulam, at its  
4 glue joint, and solid wood, recorded on each specimen, were from 80% to 125%.  
5 Moreover, each specimen with a low shear strength  $f_v$  presented a major lack of  
6 adherence, characterized by low wood failure percentages. Thus, 16 specimens  
7 and 1 beam failed the block shear test. It is important to note that the beams which  
8 failed the shearing test also failed the delamination test, whereas the beams that  
9 failed the delamination test could pass the block shear one. In accordance with  
10 Aicher and Ohnesorge (2011), requirements made on the block shear test standard  
11 (EN 386: 2002) is set too low when using hardwoods. And requirements proposed  
12 by these authors (dotted lines) are rather rigorous and permit to identify more  
13 beams which failed the delamination test (30 specimens and 8 beams here).  
14  
15 Lastly, these results on tropical hardwoods did not show any specific gravity  
16 effects on bond shear strength, as reported by Hwang et al. (1993).

17

### 18 **3.3 General Discussion**

19

20 The above delamination and shearing results showed that gluing parameters were  
21 interdependent and needed to be matched to each wood species. Indeed, dense  
22 wood was greatly affected by the pressure level (case of *P. venosa*). On the other  
23 hand, the relation between CAT and pressure had a major effect on glue joint  
24 resistance for a softer wood (*Q. rosea*). Obviously, the amount of glue spread on  
25 the surface needs to be sufficient to ensure good adhesion and to be resistant to  
26 lamella swelling and shrinkage during delamination tests, especially in the case of  
27 wood with a high shrinkage coefficient. High pressure can squeeze out the  
28 adhesive from the interface or lead to excessive penetration into the substrate,  
29 especially when the glue has not already hardened. In the case of *D. guianensis*,  
30 the CAT greatly influenced the delamination resistance of the bonds, especially  
31 due to the tropical climatic conditions observed during the gluing step despite the  
32 good wettability of this species (Bourreau 2011). When the assembly time was  
33 very long, the ambient temperature increased resin cure, preventing its penetration  
34 into vessel and cell walls, leading to weak joint anchorage.

35

36 As regards block shear resistance, the results arising from this study showed that  
37 86% of the samples passed the block shear test, despite the unsatisfactory  
38 delamination results on the samples with the same gluing conditions. This tallies  
39 with the results reported by Aicher and Ohnesorge (2011) on beech glulam,  
40 highlighting that the standard shear test requirements are set too low to validate a  
41 structural glued assembly made from hardwoods. It appears that the block shear  
42 test identifies glue joints displaying a major lack of adherence and can easily  
43 assess if the strength of the glued assembly is similar to that of solid wood.

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Lastly, these two standard tests complement each other, but the delamination test is the strictest, involving joint opening by both tension and shearing perpendicular to the grain due to rapid and severe humidity variations.

**3.4 Validation of gluing parameters**

The above results seemed to qualify *D. guianensis* for glulam manufacturing in French Guiana, other species need more investigations. Consequently, the 3<sup>rd</sup> set of tests was carried out on this species with the gluing parameters fixed in table 3. For industrial purposes, the time to assemble beams before applying pressure needed to be longer than 20 minutes, so the CAT was extended to 40 minutes. In this set of tests, glue was spread on one face. The delamination results for these tests were in accordance with the European standard, with an average delamination of 5.9%. However, 12% of the samples recorded delamination over 10% (a maximum of 12.7%).

The results for the block shear test are given in table 6. Based on the European standards, all the samples successfully passed the block shear test and the strength ratio between glulam joints and the solid wood exceeded 80%.

In order to improve the resistance of the samples to delamination, the effect of lamella thickness on delamination risks was investigated in this set of tests, making it possible to determine an adequate thickness that reconciles the cost of glulam production with the resistance of the bond to severe moisture variations. Figure 4 shows delamination results for each lamella thickness group considered in table 3.

The results show that the thinner the bonded lamella thickness was, the better was the glulam resistance to delamination. It appeared that at around 28 mm, average delamination was below the limit set by the European standard. However, the thinner the lamella thickness was, the higher was the cost of glulam production. This was mostly due to more adhesive use and also to greater wood wastage during manufacturing. Consequently, a thickness of 28 mm appears to be the optimum lamella thickness for manufacturing *D. guianensis* glued laminated timber in French Guiana (Bourreau 2011).

The effect of lamella thickness is in keeping with the results reported by Ohnesorge et al. (2010) who analysed beech wood beams with lamella thicknesses of 29, 35 and 38 mm. The high delamination rates observed may have been related to the increase in wood swelling under moisture variation. This was also observed when using a wood species with a high shrinkage coefficient (*Q. rosea*). In order to prevent high swelling stress during the delamination test, the lamella thickness could be reduced and the same sawing pattern needs to be used for the beam assembly.

## 1    **4    Conclusions and recommendations**

2    Depending on the wood species used, the delamination results showed significant  
3    gluing parameter effects. Prior to being bonded, the board needed to be planned  
4    just before adhesive application and it appeared that the glue joint needed a  
5    minimum thickness to provide a satisfactory assembly that could resist severe  
6    moisture variations. Consequently, gluing parameters need to be adjusted to the  
7    wood species, especially in a tropical climate. Moreover, the current delamination  
8    test seemed to be too strict and may not be easy to use or adapt to validate a  
9    structural glued assembly using tropical hardwoods.

10   Lastly, to prevent cracks along the glue joint, due to moisture variations, the board  
11   thickness can be decreased. An optimum of 28 cm was adopted for *D. guianensis*  
12   glulam manufacturing in French Guiana. As regards the block shear test, it was  
13   successfully passed by almost all the glulam specimens despite a lack of adhesive  
14   observed in a large number of samples.

15   Despite some gluing conditions validated by European standards for *D. guianensis*  
16   glulam manufacturing more research is needed to determine gluing conditions for  
17   the other two wood species. In the case of *Q. rosea*, the amount of glue needs to  
18   be increased and, in order to avoid high shrinkage constraints, the lamella  
19   thickness should be decreased. For the densest wood, *P. venosa*, the pressure level  
20   needs to be decreased in order to prevent glue from being squeezed out of the  
21   joint. The validation of some gluing conditions needs to focus on the delamination  
22   test, and the block shear test should be used to characterize joint resistance.

23   In the future, prior to industrializing Guianese glulam, the resistance of finger  
24   jointing assembly has to be tested in order to validate the use of these tropical  
25   species for glulam industry.

26

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- 1 **Table legends:**  
2 **Table 1** Properties of selected wood species  
3 **Table 2** Normalized values for a successful block shear test (EN 386: 2002)  
4 **Table 3** Recap of the bonding tests  
5 **Table 4** Effect of planning on delamination for 3 different gluing conditions  
6 **Table 5** Effects of the CAT and P parameters on the delamination factor Ds  
7 **Table 6** Block shear test results for *D. guianensis* (3<sup>rd</sup> set of tests)  
8  
9 **Table 1** Properties of selected wood species

Wood species	S <sub>G</sub>	R <sub>B</sub>	R <sub>t</sub>	R <sub>r</sub>	R <sub>t</sub> /R <sub>r</sub>	HC
<i>Qualea Rosea</i>	0.70	14.44	9.74	5.80	1.68	2
<i>Dicorynia guianensis</i>	0.79	13.50	8.24	5.13	1.61	3
<i>Peltogyne venosa</i>	0.84	11.47	6.80	4.83	1.41	3
<i>Larix decidua</i>	0.60	11.92	8.20	4.20	1.95	3

- 10 S<sub>G</sub>: Mean specific gravity  
11 R<sub>B</sub>, R<sub>t</sub> and R<sub>r</sub>: total, tangential and radial shrinkage coefficients respectively (%).  
12 HC: Hazard Class (EN 350-2: 2007)  
13

- 14 **Table 2** Normalized values for a successful block shear test (EN 386: 2002)

	Average			Individual Values		
Shear strength f <sub>v</sub> , in MPa	6	8	f <sub>v</sub> >11	4< f <sub>v</sub> <6	6	f <sub>v</sub> >10
Minimum WFP, in%	90	72	45	100	74	20
For values in between linear interpolation shall be used.						

15

- 16 **Table 3** Recapitulation of the bonding tests

Specifications	1 <sup>st</sup> Set	2 <sup>nd</sup> Set	3 <sup>rd</sup> Set
Wood species	<i>Q. rosea</i>	<i>Q. rosea</i> <i>D. guianensis</i> <i>P. venosa</i> <i>L. decidua</i>	<i>D. guianensis</i>
Adhesive type	RPF		
Adhesive/hardener(ratio)	100/20		
Lamella thickness	28 mm		16 /22 /28 /34 mm
Maximum time between planning and bonding	>24h / ≤ 8h	≤ 8h	
Adhesive spreading	2 faces		1 face
Adhesive spread rate (g/m <sup>2</sup> )	750 / 1500	250 / 750 / 1500	300
CAT (min)	10 / 20	5 / 10 / 20	40
Pressure (MPa)	0.7 / 1	0.4 / 0.7 / 1	1
Total beams/delamination specimens/shear specimens (per species)	6/60/0	54/270/216	32/160/0

1

2 **Table4** Effect of planning on delamination for 3 different gluing conditions

Maximum time between planning and gluing	Delamination results (%) depending on gluing parameters					
	Spread rate (g/m <sup>2</sup> )/CAT (min)/Pressure (MPa)					
	1500/10/0.7		750/10/0.7		750/20/1.0	
	Mean	Stdv	Mean	Stdv	Mean	Stdv
>24h	61.4	9.5	35.2	13.0	12.3	6.3
≤ 8h	19.5	11.2	14.6	8.4	6.0	5.3

3 Stdv: Standard deviation

4

5 **Table5** Effects of the CAT and P parameters on the delamination factor Ds

Wood species	Source	DOF	Sum of squares	Mean of squares	F-value	P
<i>Q. rosea</i>	P	5	0.033	0.007	0.197	0.964
	CAT	0	0.000			
	P*CAT	12	1.015	0.085	2.543	0.004**
<i>D. guianensis</i>	P	0	0.000			
	CAT	2	3.484	1.742	44.887	<0.0001**
	P*CAT	15	1.278	0.085	2.196	0.007
<i>P. venosa</i>	P	5	0.223	0.045	3.522	0.004**
	CAT	0	0.000			
	P*CAT	12	0.105	0.009	0.694	0.757

6 DOF: Degrees of freedom

7 \* Coupling agent

8 \*\* Significant for p &lt; 0.005. The smaller p, the more significant the effect

9

10 **Table6** Block shear test results for *D. guianensis* (3<sup>rd</sup> set of tests)

	$f_v$ (MPa)	WFP (%)
Min	11.67	40
Mean	15.48	79
Max	19.57	100

11

12

1 All figures were provided by R software except for figure 1 which was realized by Excel  
2 2007.

3 **Figure legends:**

4 **Fig.1** Influence of measured glue spread rate on delamination results

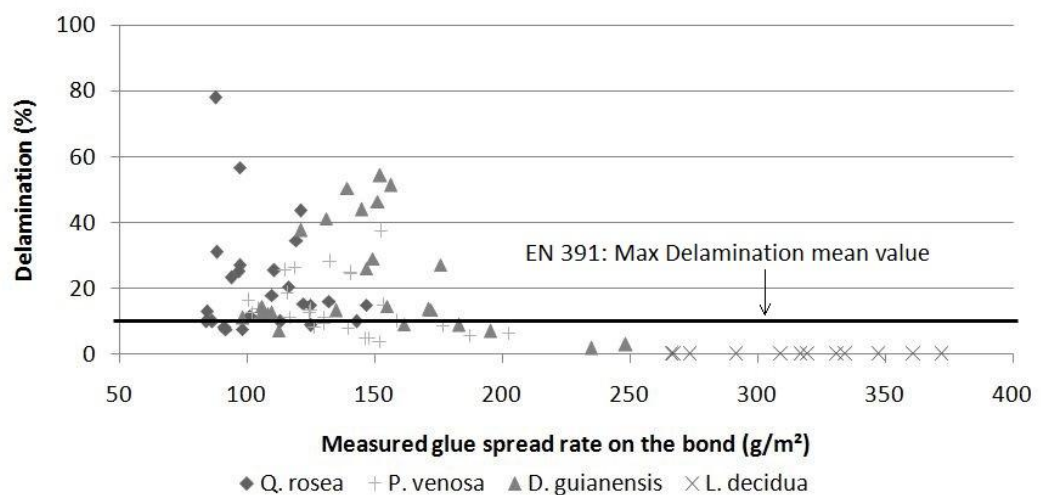
5 **Fig.2** Influence of glue amount on delamination resistance for *Q. rosea*(a), *P. venosa* (b) and *D.*  
6 *guianensis* (c)

7 **Fig. 3** Influence of Pressure (1) and CAT(2) on delamination resistance for *Q. rosea*(a), *P. venosa*  
8 (b) and *D. guianensis* (c).

9 **Fig.4** Block shear test results (2<sup>nd</sup> set of tests) for individual values (a) and mean values (b) -  
10 current minimum requirements for production control (black lines) and Aicher and Ohnesorge  
11 proposals (dotted lines).

12 **Fig.5** Influence of *D. guianensis* lamellae thickness on delamination

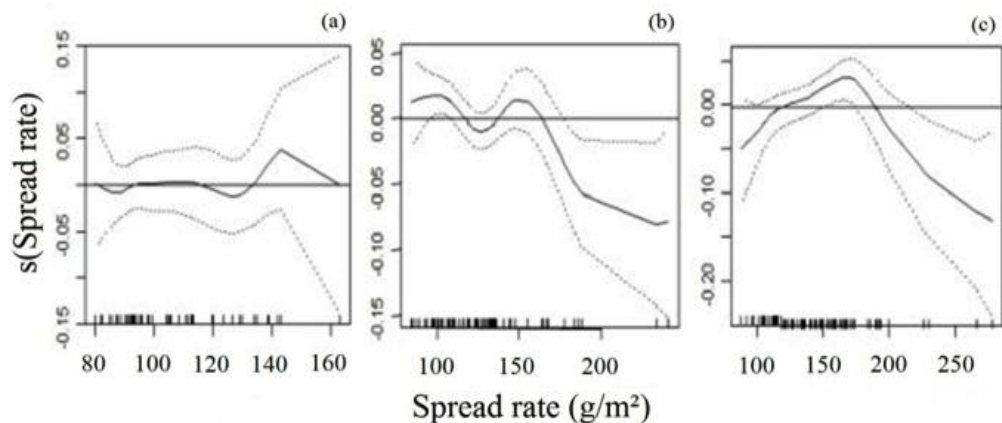
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15 **Fig.1** Influence of measured glue spread rate on delamination results

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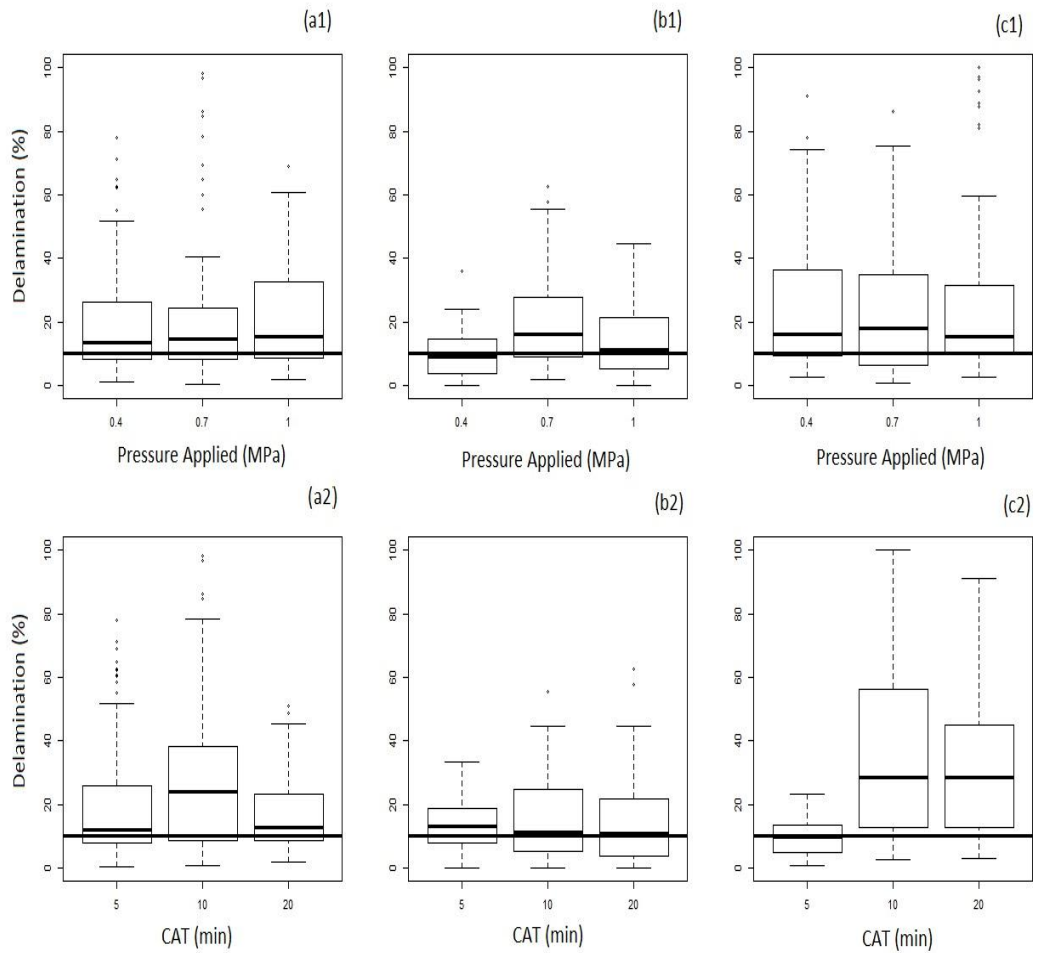


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1 **Fig.2** Influence of glue amount on delamination resistance for *Q. rosea*(a), *P. venosa* (b) and *D.*  
2 *guianensis* (c)

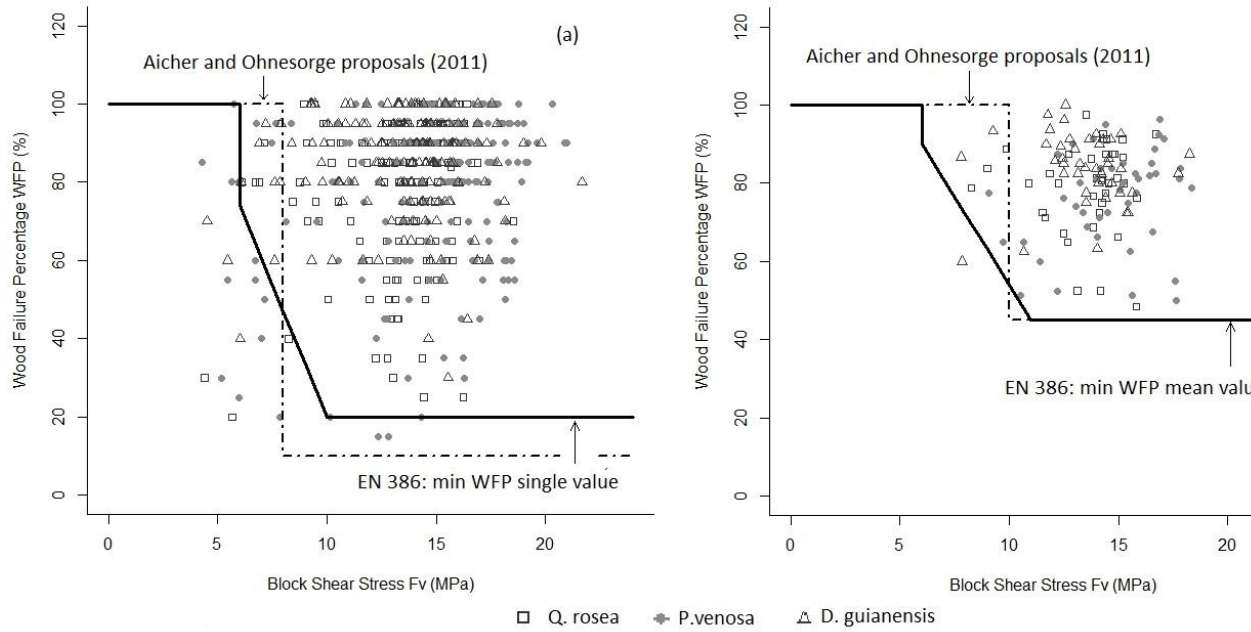
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5 **Fig.3** Influence of Pressure (1) and CAT (2) on delamination resistance for *Q. rosea*(a), *P.*  
6 *venosa* (b) and *D. guianensis* (c)

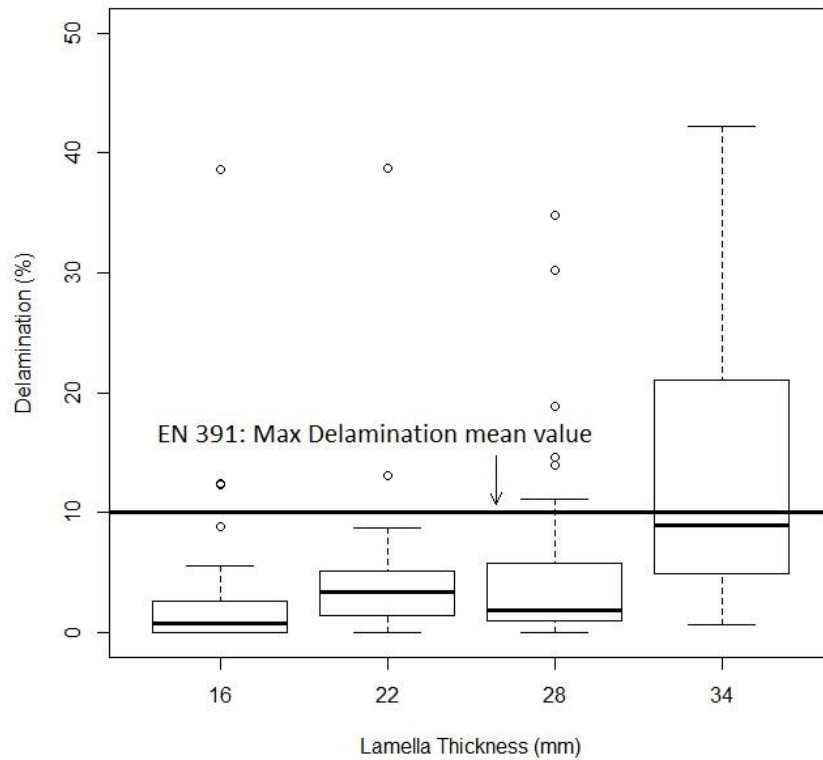
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2 **Fig.4** Block shear test results (2<sup>nd</sup> set of tests) for individual values (a) and mean values (b) -  
 3 current minimum requirements for production control (black lines) and Aicher and Ohnesorge  
 4 proposals (dotted lines).

5



6

7 **Fig.5** Influence of *D. guianensis* lamellae thickness on delamination

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