

natureplus e.V.

Award Guideline 0211

Adhesive-Bonded Wood Products for Construction Purposes

Issued: June 2015

For the Awardance of the Eco-Label





Award Guideline 0211
Adhesive-Bonded Wood Products
for Construction Purposes
Version: June 2015

Page 2 of 10

1. Application Areas

The following criteria contain the requirements for the awardance of the natureplus eco-label for untreated, adhesive-bonded wood battens, slats, beading, posts and sheets and boards (bonded over their whole surface area) for use in structural construction purposes. These especially include solid construction timber, glued laminated beams (Glulam), glued laminated boards/sheets and so called I-beams and for those elements which are bonded over their whole surface area, in particular, glued laminated boards/sheets, plywood sheeting, cross-laminated sheets and multilayer solid timber boards/sheeting. The products must be dry, free of wood preservatives and surface treatment substances.

This guideline does not include adhesive-free timber according to DIN 68365, Sawn wood according to DIN 4074 (Sawn-wood assortments 1 and 2). These are covered in Award Guideline RL0210. Untreated solid timber sheets/boards and other building elements for non-structural purposes are covered in Award Guideline RL0205. Elements for wooden flooring are covered in Award Guideline RL0209 and untreated solid timber such as wood battens, slats, beading, (tongue and groove-) planks and scantlings (joists and beams) for non-structural use are regulated in Award Guideline RL0210.

The award guideline is to be applied exclusively to the named products. Treated timber and wood for use in window construction, bonded systems which incorporate materials not mentioned in this guideline and thermally modified timbers are outside the scope of this guideline.

2. Award Criteria

The prerequisite for the awardance of the natureplus eco-label is the fulfilment of the basic criteria GL-0000 and of the chemicals directive GL-5001.

2.1 Suitability of Application

The product meets the requirements for the suitability of application by holding the state-specific or the European technical approval or the building inspectorate approval. If none of the approvals apply, the manufacturer has to provide evidence that all standards relevant for the product are met (DIN 1052:2004-08, or DIN 4074-1 combined with DIN 68140-1 or an equivalent standard).



Award Guideline 0211
Adhesive-Bonded Wood Products
for Construction Purposes
Version: June 2015

Page 3 of 10

The amount of moisture contained in the wood must not exceed 15% and for products to be used for interior (dry environment) applications according to DIN 1052:2004-08 Usage Class 1 not more than 12%.

2.2 Composition, Forbidden Substances, Substance Restrictions

The proportion of wood (including moisture) in the products must be at least 97 % of the mass of the end product. Polyurethane/Polyurea adhesives and mixed resins based upon aminoplasts and phenol are permitted. Only the use of low-emission UF (urea-formaldehyde) compounds is permitted.

The application of biozides are not permitted.

The product is subject to laboratory analyses as laid down in section 3 and has to comply with the limit values stated therein.

2.3 Raw Material Sourcing, Production of Preliminary Products, Production

The requirements of the guideline GL-5002 for the origins of wood and wood production must be met for wood as a raw material.

The manufacturer has to state and to place his suppliers under the obligation that no synthetic plant protecting product with agents included on the list of banned pesticides of the chemicals directive GL-5001 are used during growing, harvest, storage or transport of the materials used. Compounds based on arsenic or mercury must not be employed. Implementing the obligation and the supplier's declarations are a part of the certification procedures.

If less than 80% of the energy required to dry the products is from renewable sources, then the efficiency level of the drying plant must be above 0.5. The proportion of renewable energy in electricity will be taken into account.

The manufacturer must demonstrate that a hazardous substance management according to national standards and regulations is available at the production facility for employee protection. Information on dust release and compliance with general dust limit values must be included therein. Where compliance with the general dust limit values or other occupational limit values cannot be guaranteed despite technical and organisational measures, personal protection equipment must be available. It must be aimed for a minimisation of avoidable burdens of the employees.



Award Guideline 0211
Adhesive-Bonded Wood Products
for Construction Purposes
Version: June 2015

2.4 Usage

The product must not exhibit any unpleasant or foreign smells or odours.

The emissions during use have to be in compliance with the limit values according to section 3. In order to ensure that the results can be replicated, emissions analyses are undertaken on a mixed sample from 4 individual samples taken from various product batches.

In the case of resin-rich softwoods (e.g. pine, Douglas fir, larch), the producer must provide evidence of suitable measures to minimise the levels of VOC's (e.g. the selection of raw materials, periodic VOC-measurements, storage/drying).

2.5 Recycling/Disposal

The product must be suitable for safe disposal in a waste incineration facility.

2.6 Ecological Parameters

The manufacturing of all products of this product group must be in compliance with the ecological parameters listed below.

Ecological parameters per m ³	Guide values ¹
Primary energy input of non renewable total resources (PENRE ²) [MJ]	4000
Primary energy input of non renewable and renewable total resources (PET ³) [MJ]	6000
Photochemical ozone creation potential (POCP) [kg ethylen-equiv.]	0,4
Acidification potential (AP) [kg SO ₂ -equiv.]	1,6
Eutrophication potential (EP) [kg PO ₄ ³⁻ -equiv.]	0,6
Global-warming potential (GWP) [kg CO ₂ equiv.]	250
Abiotic depletion potential (ADP) [kg Sb equiv.]	0,0002



Award Guideline 0211

Adhesive-Bonded Wood Products for Construction Purposes

Version: June 2015

Page 5 of 10

If a single guide value is exceeded, it will be decided on a case by case basis whether this is permissible for the purpose of optimising the complete product manufacturing process.

¹Testing method: Calculation of the ecological parameters according to natureplus® implementing provisions for life cycle assessments; inventory analysis analogous to ISO 14040ff; efficiency categories according to CML-IA version 4.1 from October 2012 and characterised as baseline; primary energy requirement according to Frischknecht 1996; global-warming potential 1994/100 years; system limits: raw material sourcing to products ready for shipment

² PENRE: **p**rimary **e**nergy input of **n**on renewable **e**nergy resources

³ PET: **p**rimary **e**nergy inputs of renewable and non renewable **t**otal resources

2.7 Declaration

The product packaging should display a full declaration of the input materials listed, analogue to the EU-Cosmetic Regulations, according to the declining mass percentage. If it is not possible to display this information directly on the product packing, it should be provided with the product in a technical datasheet or sales leaflet (in English or in the national language). If intermediate/preliminary products or formulations are used as input substances and the proportion present in the final product is >0.1 M-%, then all the substances used within these must also be taken into account for the declaration.

For naming the input materials as part of the declaration the following applies:

- More than 1 M-% - designation of the substance in question
- Less than 1 M-% - at least a functional designation (e.g. "moth proofing agent")

Furthermore, it is obligatory to provide the following information in a suitable form to the consumer or user (eg. online):

- Instructions for use and safety precautions
- Indications for storage and disposal
- Batch numbers
- City/town and country of production
- Indication of geographical origin of the key input material

When employing components with a potential for environmental hazard, the manufacturer has to suitably indicate measures to be taken to ensure environmental protection during removal and demolition (i.e. controlled deconstruction).



Award Guideline 0211

Adhesive-Bonded Wood Products for Construction Purposes

Version: June 2015

Page 6 of 10

Additionally, the following product-specific information must be made available to the consumer or user.

- Labelling according to the guidelines of the European Community (Communauté Européenne, CE marking) or the respective general technical approval, including a scope specification
- General data (designation, type, name, etc.)
- Surface weight [kg/m^2] or density [kg/m^3]
- Thickness, length and width in mm
- Wood type and origin
- Moisture content of the wood
- The suitability for the usage class according to DIN 1052:2004-08
- The grade indication according to DIN 4074-1:2003-06 or
- Strength class according to DIN 1052:2004-8
- Euro class according to EN 13501-1

Information about the avoidance of chemical wood preservation and special construction measures being a requirement for classifying wood materials as hazard class 0 (according to DIN 68800-2 or an equivalent standard) is to be provided in the form of a leaflet. The manufacturer has to give indications regarding sufficient wood conditioning before installation.

2.8 Processing/Installation

The manufacturer must demonstrate whether working procedures avoiding dust release are available for the processing of the product. If this is the case, these procedures are to be recommended and suitably presented within the processing guidelines. If compliance with the general dust limit values might not be guaranteed, wearing personal protection equipment must be recommended.

2.9 Packaging

The packaging used must be recyclable. The manufacturer must participate in a recycling system if there is one for the corresponding material.

Paper and cardboard packaging must be made from recycled paper. Alternatively, paper from sources as per GL-5002 is permitted.

Plastic packaging must be comprised from polyolefins. PET, polystyrene or polycarbonates are allowed exceptionally in reasonable cases. Packaging made from PVC is generally not permitted. Packaging must not contain biocides.



Award Guideline 0211
Adhesive-Bonded Wood Products
for Construction Purposes
 Version: June 2015

The natureplus certification mark has to be printed on the packaging after the awardance of the product.

3. Laboratory Tests

The products are subject to laboratory analyses to test for harmful substances and undesirable ancillary ingredients. A representative sample is collected during the site inspection. If the sample collection can not be conducted by a natureplus examiner, an independent person designated by natureplus can collect the sample. For products with different sizes but the same composition, a single sample is sufficient.

3.1 VOC - TVOC

The product is subject to a test-chamber examination to survey the emissions of VOC, SVOC and other volatile compounds and to check compliance with the limit values. Measurements usually occur after 3 and 28 days. When low VOC emissions are to be expected, the emissions test can be terminated early, if a measurement 7 days after loading of the test chamber does not object to this. The test-chamber examination is performed according to the current version of the test method TM-01 VOC.

Emission measurement after 3 days

Test parameters	Limits	Unit
VOC (VOC, VVOC, SVOC) classified in: Regulations (EC) No. 1272/2008: categories Carc. 1A und 1B, Muta 1A und 1B, Repr. 1A und 1B; TRGS 905: K1, K2, M1, M2, R1, R2; IARC groups 1 u. 2A; DFG MAK-list III1, III2	< 1	$\mu\text{g}/\text{m}^3$
Total volatile organic compounds (TVOC)	≤ 3000	$\mu\text{g}/\text{m}^3$

Emission measurement after 28 days

Test parameters	Limits	Unit
Total volatile organic compounds (TVOC)	≤ 300	$\mu\text{g}/\text{m}^3$
of which:		



Award Guideline 0211
Adhesive-Bonded Wood Products
for Construction Purposes
 Version: June 2015

Total bicyclic terpenes	≤ 200	µg/m ³
Total sensitising substances per MAK IV, BgVV-list cat. A, TRGS 907	≤ 100	µg/m ³
Total VOC (VOC, VVOC, SVOC) classified in: Regulation (EC) No. 1272/2008: Categorie Carc. 2, Muta 2, Repr. 2; TRGS 905: K3, M3, R3; IARC: group 2B; DFG MAK-list: III3	≤ 50	µg/m ³
Total aldehyde, C4-C11, acyclic, aliphatic	≤ 100	µg/m ³
Styrene	≤ 10	µg/m ³
Methylisothiazolinone (MIT)	< 1	µg/m ³
Benzaldehyde	≤ 20	µg/m ³
Total (VOC) without non-identified compounds	≤ 100	µg/m ³

A calculation of the r-value is performed. The limit value is ≤ 1.

Other emission measurements

Test parameters	Limit values	Unit
after 24 hours		
Monomeric isocyanates TDI, HDI	≤ 1	µg/m ³
Monomeric isocyanates MDI ⁽²⁾	≤ 2	µg/m ³
after 28 days		
Total semi-volatile organic compounds (TSVOC)	≤ 100	µg/m ³
Formaldehyde	≤ 36 ⁽¹⁾	µg/m ³
Acetaldehyde	≤ 36 ⁽¹⁾	µg/m ³

⁽¹⁾ 36 µg/m³ ≈ 0,03 ppm

⁽²⁾ if binding agents based on polymeric MDI are used

Termination criteria:

The emissions test can be terminated 7 days after loading the test chamber, if the values measured at this time are lower than 50% of the 28-day threshold limits.



Award Guideline 0211
Adhesive-Bonded Wood Products
for Construction Purposes
 Version: June 2015

3.2 Element Analyses

The product is subject to an element analysis to determine the content of harmful elements and to check for undesirable contaminations. The measurements have to be in compliance with the limit values. The analysis is performed according to the current version of the test method TM-02 metals.

Element	Limit value	Unit
Boron (B)	25	mg/kg
Chromium (Cr)	5	mg/kg
Copper (Cu)	10	mg/kg
Mercury (Hg)	0,1	mg/kg

3.3 Other Analyses

Test parameters	Limit values	Unit	Method
Halogenic organic compounds: AOX/EOX	≤ 1	mg/kg	TM-03 Halo
Odour	≤ 3	Odour intensity	TM-04 Odour
Total pesticides	≤ 1	mg/kg	TM-05 Pesticides
Individual pesticides Organochlorine pesticides: Aldrin, Chlordane, DDD, DDE, DDT, Dichlofluanid, Dieldrin, Endrin, Heptachlor, Hexachlorobenzene, Lindane, Pentachlorophenol Organophosphate pesticides: Dimethoat, Fenthion, Parathion-methyl, Parathion-ethyl, Phosalon	≤ 0,5	mg/kg	TM-05 Pesticides



Award Guideline 0211
Adhesive-Bonded Wood Products
for Construction Purposes
Version: June 2015

Pyrethroids: Cypermethrin, Lambda-Cyhalothrin, Permethrin			
Other: Benomyl, Carbendazim, Prochloraz			

Test Methods

TM-01 VOC: Volatile Organic Compounds VOC/TVOC, formaldehyde, acetaldehyde and TSVOC: DIN EN ISO 16000 series expanded by the natureplus implementation rules.

TM-02 Metals: ICP-MS measurements according to DIN EN ISO 17294-2, supplemented with the natureplus implementation rules and a sample preparation adjusted to the issue analysed.

TM-03 Halo: Halogenic organic compounds after combustion, determined by microcoulometry according to the natureplus implementation rules "AOX/EOX".

TM-04 Odour: natureplus implementation rules "odour intensity", 6-degree grading scale 24h after loading the test chamber

TM-05 Pesticides: DFG S 19 supplemented with the natureplus implementation rules.