



Designation: D3535 – 07a (Reapproved 2021)

Standard Test Method for Resistance to Creep Under Static Loading for Structural Wood Laminating Adhesives Used Under Exterior Exposure Conditions¹

This standard is issued under the fixed designation D3535; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 This test method covers adhesives suitable for the bonding of wood, including treated wood, into structural laminated wood products for general construction, for marine use, or for other uses where a high-strength general construction, creep-resistant, waterproof adhesive bond is required.

1.2 The values stated in SI units are to be regarded as the standard. The values given in parentheses are for information only.

1.3 *This standard does not purport to address all of the safety concerns, if any, associated with its use. It is the responsibility of the user of this standard to establish appropriate safety, health, and environmental practices and determine the applicability of regulatory limitations prior to use.*

1.4 *This international standard was developed in accordance with internationally recognized principles on standardization established in the Decision on Principles for the Development of International Standards, Guides and Recommendations issued by the World Trade Organization Technical Barriers to Trade (TBT) Committee.*

2. Referenced Documents

2.1 *ASTM Standards:*²

[A125 Specification for Steel Springs, Helical, Heat-Treated](#)

¹ This test method is under the jurisdiction of ASTM Committee D14 on Adhesives and is the direct responsibility of Subcommittee D14.30 on Wood Adhesives.

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² For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For *Annual Book of ASTM Standards* volume information, refer to the standard's Document Summary page on the ASTM website.

[D907 Terminology of Adhesives](#)

[D2559 Specification for Adhesives for Bonded Structural Wood Products for Use Under Exterior Exposure Conditions](#)

3. Terminology

3.1 *Definitions:*

3.1.1 *glulam, n*—synonym for structural-glued-laminated timber.

3.1.2 *structural-glued-laminated timber, n*—an engineered, stress-rated product of a timber laminating plant comprising assemblies of specially selected and prepared wood laminations securely bonded together with adhesives, with the following characteristics: (1) the grain of all laminations is approximately parallel longitudinally; and (2) the laminations may be comprised of pieces end-joined to form any length, of pieces placed or glued edge-to-edge to make wider ones or of pieces bent to curved form during gluing. (Synonym *glulam*) ANSI/AITC A190.1 – 2002, American National Standard for Wood Products—Structural Glued Laminated Timber (Edited to conform with ASTM format).

3.1.3 For other terms used in this test method, refer to Terminology [D907](#).

4. Summary of Test Method

4.1 Glued laminations are subjected to a constant load under various combinations of temperature and relative humidity. The amount of creep is measured.

5. Significance and Use

5.1 This test method rates the performance of the adhesive in laminated wood as measured by resistance to creep under static load.

5.2 This test method will normally be used in conjunction with Specification [D2559](#).

6. Apparatus

6.1 *Compression-Type Creep Tester*, as shown in [Fig. 1](#),³ required for testing the specimens under the static load. This tester consists of:

- 6.1.1 *Base Plate*,
- 6.1.2 *Four Tension Rods*,
- 6.1.3 *Spacer Plate*,
- 6.1.4 *Center Rod*,
- 6.1.5 *Spring*,
- 6.1.6 *Top Plate*, and
- 6.1.7 *Nuts*.

6.2 *Metal Spacers*, coated with an effective mold-release agent. Seven are needed for each laminate. Dimensions are 69.8 mm (2¾ in.) long by 15.9 mm (5⁄8 in.) wide by 6.4 mm (¼ in.) thick. Spacers made of other materials may also be used provided it does not react with the adhesive and can be removed without disturbing the specimen.

6.3 *Oven*, capable of maintaining $71 \pm 2^\circ\text{C}$ ($160 \pm 3.6^\circ\text{F}$) and humidity chamber capable of maintaining $26.7 \pm 2^\circ\text{C}$ ($80 \pm 3.6^\circ\text{F}$) and $90 \pm 5\%$ relative humidity.

NOTE 1—Some ovens may not be able to accommodate a full length creep tester. Since the test specimen is 276 mm in length, it is permissible to reduce the “filler pieces” and angles to a length of 267 mm each allowing pressure to be exerted directly on the test specimen without the use of filler blocks. [Fig. 2](#) shows an optional creep tester. The changes are to the lengths of the 4-tension rods, center rod, angles and filler pieces. Use of this tester requires special care when choosing a spring (see footnote 3 in [Fig. 1](#) and [10.1](#)) that will fit the reduced space. All other measurements will be the same as [Fig. 1](#).

7. Selection and Preparation of Wood

7.1 Use any softwood or hardwood planned for gluing. Only one species is required, even if several will be glued. Flat-grained wood is most desirable, however experience has shown that flat-grained specimens may break in the wood when loaded. (This test measures only creep. Use Specification [D2559](#) to measure bondability to all species considered.)

7.2 The wood shall have a slope of grain not steeper than 1 in 15 on any face or any edge. The wood shall contain no knots larger than 3.18 mm (1⁄8 in.) in diameter and shall be free of decay, machining defects (such as chipped grain, dubbed ends, feed roll polish, coarse knife marks, and feed roll compression), and any drying defects such as case hardening, collapse, splits, or checks.

7.3 Condition the wood at $23 \pm 2^\circ\text{C}$ ($73.4 \pm 3.6^\circ\text{F}$) and a relative humidity of 50 to 70 % (preferably 65 %) until a moisture content of 8 to 14 % or, preferably, 9 to 12 % has been obtained.

³ Springs selected must fit within the space provided [approximately 110-mm (4.3-in.) maximum outside diameter and 300-mm (11.8-in.) maximum overall height] and should be of corrosion-resistant material (for example, stainless steel, cadmium, or zinc-plated steel), should have a spring constant of $35\,000 \pm 7000$ N/m (200 ± 40 lbf/in.) and a load when fully compressed (that is at solid height) of about 4500 N (approximately 1000 lbf). For additional information, refer to Specification [A125](#) for Steel Springs, Helical, Heat Treated.

7.4 Freshly knife plane each lamination before applying the test adhesive. The machining tolerances for each lamination used in preparing the test specimen shall be no greater than ± 0.25 mm (0.01 in.) between laminations and ± 0.20 mm (0.008 in.) within laminations. Observe the most severe of the above tolerances.

8. Test Specimens

8.1 The laminated wood members shall be prepared from boards 15.9 mm (5⁄8 in.) thick by 63.5 mm (2½ in.) wide by 304.9 mm (12 in.) along the grain for each test condition. Each test lamination shall be made from two outer laminations as above and alternate metal spacers and wood sections for the inner lamination ([Fig. 3](#)). The wood sections shall be sliced from a third board identical to that above. The wood sections shall be 28.5 mm (1⅛ in.) along the grain by 15.9 mm (5⁄8 in.) thick by 63.5 mm wide. The laminated wood members shall be prepared by alternately laying seven metal spacers on edge tightly adjacent to eight wood center sections. The wood sections should be slightly thicker than the metal spacers to obtain adequate pressure on the gluelines. It has been found that running a 13-mm (½-in.) piece of tape completely around the 16 loose pieces holds them together as a unit while gluing. Glue should be applied to the outer laminations and not the center ply. The outer laminations shall then be applied overlapping about 13 mm on each end and the entire assembly carefully clamped and the adhesive cured as recommended. After curing and clamp removal, the metal spacers shall be pushed gently (not impact driven) out. Then each three-ply laminated wood member shall be trimmed along the sides to leave a width of 50.8 ± 0.8 mm ($2 \pm 1/32$ in.) and the outer overlapping boards at one end trimmed to 3.2 mm (1⁄8 in.) longer than the inner section. A center line perpendicular to the grain shall be marked across all of the 28.6-mm center sections and running to the specimen edge. The specimen shall then be notched as in [Fig. 3](#), the 3.2-mm notches being visually centered on the above lines. Notching should be to, but not beyond, the adhesive line. The specimen shall then be trimmed at the untrimmed end to 276.2 mm (10⅞ in.). This dressed member, 47.6 by 50.8 by 276.2 mm (1⅞ by 2 by 10⅞ in.) appears in [Fig. 3](#). When the specimen is loaded axially, shear loads shall be applied to the 15 overlap areas which are 50.8 by 12.7 mm (2 by 0.5 in.), giving double leg joints with glueline area of 1290 mm² (2 in.²).

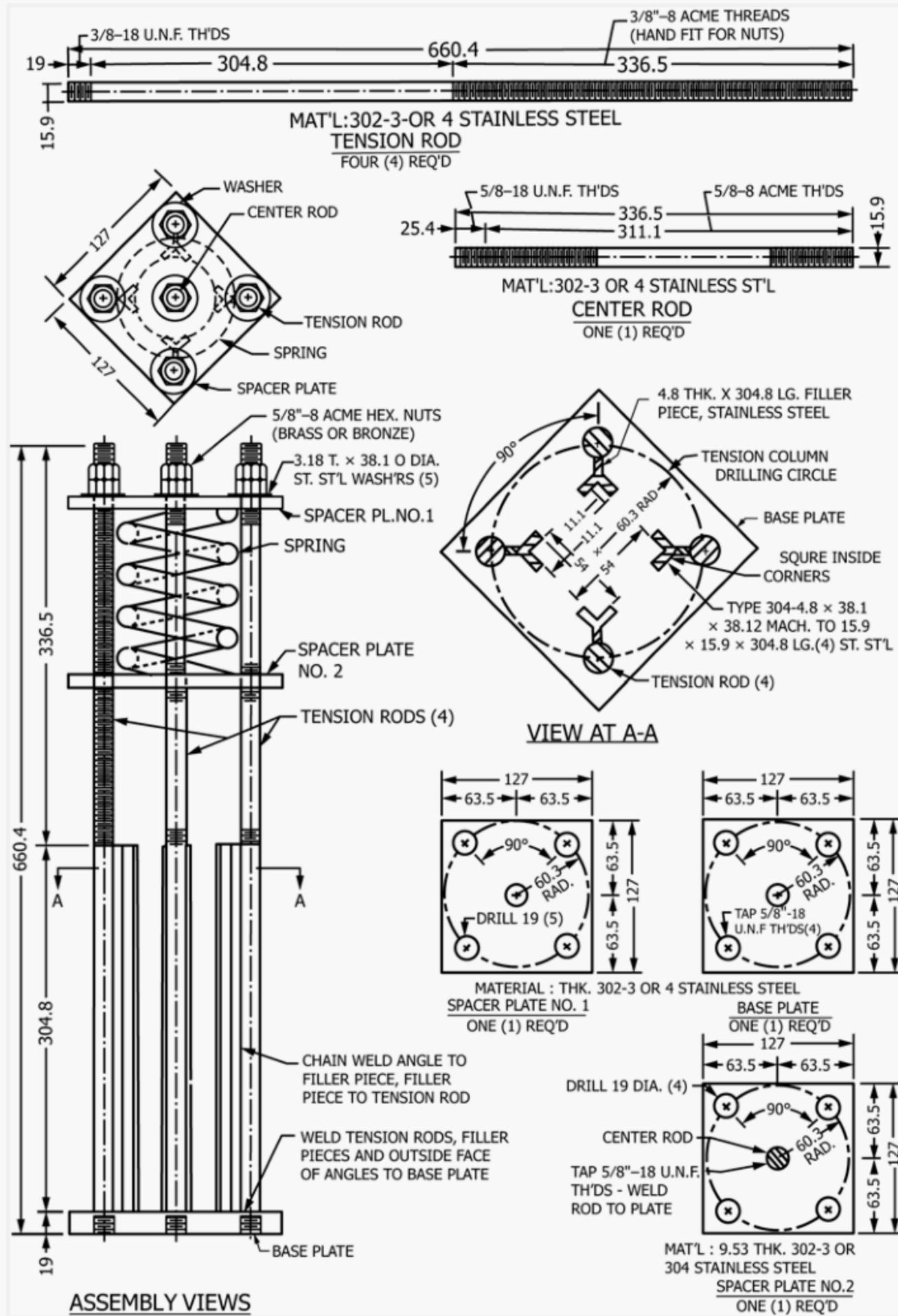
8.2 Two specimens for each variable combination to be investigated are prepared.

9. Assembly Time

9.1 Only one combination of open and closed assembly time is required. The open and closed assembly times are to be the optimum recommended with the adhesive manufacturer’s instructions.

10. Procedure

10.1 Preparatory to testing, use a square and razor blade to scribe a line perpendicular to the exposed gluelines across each of the lapped areas. Then insert the stack of test specimens



Metric Equivalents

mm	in.	mm	in.
3.18	1/8	127	5
4.77	3/16	139.7	5 1/2
9.53	3/8	148	5 3/4
11.1	7/16	165.1	6 1/2
15.9	5/8	267	10 1/2
19.1	3/4	304.8	12
25.4	1	311.1	12 1/4
38.1	1 1/2	336.5	13 1/4
54.0	2 1/8	415	16 3/8
60.3	2 3/8	660.4	26
63.5	2 1/2		

FIG. 1 Compression-Type Creep Tester³

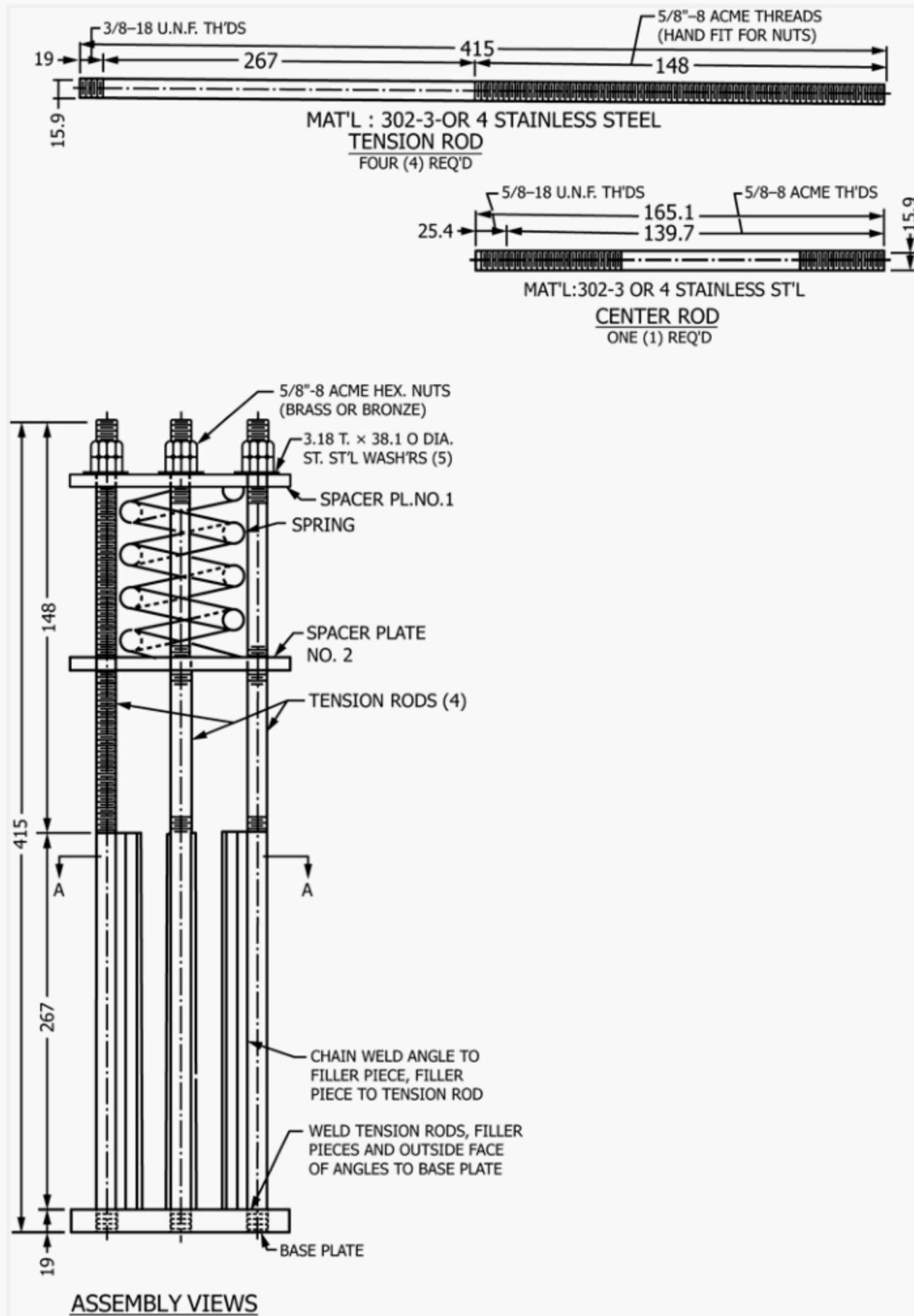


FIG. 2 Optional Compression-Type Creep Tester

within the guides of the compression-type creep tester described in 6.1 and shown in Fig. 1 and position spacer plate No. 2 on top. (In case the stack of specimens does not come to or slightly above the guides, use filler blocks on top of the stack.) Insert the spring and position spacer plate No. 1 on top of the spring. Exert a gentle compression and position the corner nuts. Load the entire unit in any type of compression testing machine such as that described in 6.1 to 218.2 kg (480 lb) total load 1655 kPa (240 psi) and tighten the corner nuts by hand to maintain spring compression. Position the keeper nut on center

rod and tighten to within 9.5 mm ($\frac{3}{8}$ in.) on the top plate, thus retaining the spring in case one or two specimens fail.

10.2 Place the entire unit in the test apparatus described in 6.3 and condition at one of the following conditions. Prepare two units for each test condition and adhesive-wood combination.

Temperature		Relative Humidity, %	Time, days
°F	°C		
160	71	ambient	7
80	26.7	90	7

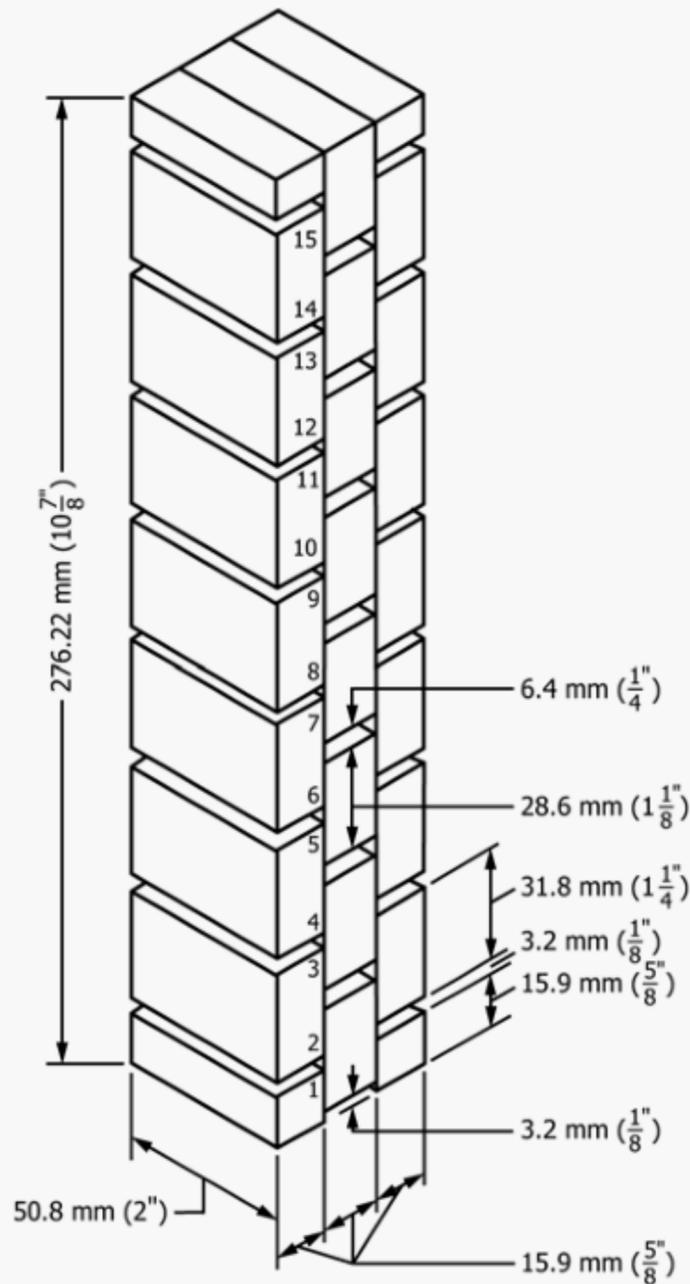


FIG. 3 View of Assembled Test Blocks

10.3 *Measurements*—At the end of the 7 days remove the four test jigs from the oven and humidity chamber. Measure the

total length slippage (creep) in all gluelines to the nearest 0.127 mm (0.005 in.). Add the total length of creep for both test specimens and each variable combination report in millimetres (inches).

11. Report

11.1 The report shall include the following:

11.1.1 Identification of the adhesive used by class, number, or manufacturer's mark,

11.1.2 Application and bonding conditions used for the specimen,

11.1.3 Wood preparation and conditioning including specific gravity and moisture content at time of bonding,

11.1.4 Temperature and relative humidity at time of bonding,

11.1.5 Number of specimens tested, and

11.1.6 The creep values obtained.

12. Precision and Bias

12.1 At the present time, there is no basis for a statement of precision or bias concerning the reproducibility of results among laboratories. Such information may be available in the future following round-robin testing among laboratories.

12.2 The precision and bias of this test method is a function of the properties of the cured bondline; if wood failure occurs, it is a function of the wood's variability. Precision shall be reported in terms of the standard deviation of the data and the standard error of the mean.

13. Keywords

13.1 creep; exterior exposure; glulam; structural-glued-laminated timber

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