NORDIC
STRUCTURES

Adhesives used in Nordic Products

This technical note provides information on the adhesives used in Nordic Lam+ and Nordic X-Lam products.

Nordic Lam+

Nordic Lam+ structural glued laminated timber (glulam) is made from Spruce-Pine-Fir species (mainly Black Spruce), and is certified to the ANSI A190.1 Standard. The surfaces are bonded with an emulsion polymer isocyanate (EPI) adhesive, a one-component polyurethane (PU-1K) adhesive used with a primer, or a two-component polyurethane (PU-2K) adhesive. The finger joints are bonded with a polyurethane emulsion polymer (PEP) adhesive or a two-component polyurethane (PU-2K) adhesive. The adhesives conform to the requirements of ANSI 405 and CSA O112.9, which include durability requirements for exterior exposure conditions. These formaldehyde-free adhesives do not pose a health hazard and the quantities of glues are in a very low proportion of about 3% (mass-based).

Adhesives used:

- Face bonding, hot presses:
  - Bostik Isoset WD3-A322/CX-47 (EPI)
  - Henkel Loctite/Purbond GT20/GT205 (PU-2K)
- Face bonding, cold presses:
  - Bostik Isoset MAX (PU-1K) with MAX300 Primer
  - Henkel Loctite/Purbond HB-X (PU-1K) with PR 3105 Primer
- Finger jointing:
  - Bostik Isoset UX-100/WD3-A322 (PEP)
  - Henkel Loctite/Purbond GT20/GT205 (PU-2K)

Nordic X-Lam

Nordic X-Lam cross-laminated timber (CLT) is made from Spruce-Pine-Fir species, and is certified to the ANSI/APA PRG 320 Standard. The surfaces are bonded with a one-component polyurethane (PU-1K) adhesive used with a primer. The finger joints are bonded with a polyurethane emulsion polymer (PEP) adhesive. These formaldehyde-free adhesives do not pose a health hazard and the quantities of glues are in a very low proportion of about 1% (mass-based).

Adhesives used:

- Face bonding: Henkel Loctite/Purbond HB-X (PU-1K) with PR 3105 Primer
- Finger jointing: Bostik Isoset UX-160/WD3-A322 (PEP)

For environmental certifications: https://www.nordic.ca/en/documentation/technical-documents#greencertification
For the adhesive technical data sheets: https://www.nordic.ca/en/documentation/technical-documents/ns-nt204-tds
For the adhesive safety data sheets: https://www.nordic.ca/en/documentation/technical-documents/ns-nt204-sds

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Technical Data Sheets:

- Technical Data Sheet, Bostik Isoset CX-47
- Technical Data Sheet, Bostik Isoset MAX1017
- Technical Data Sheet, Bostik Isoset MAX1020
- Technical Data Sheet, Bostik Isoset MAX1060
- Technical Data Sheet, Bostik Isoset MAX300
- Technical Data Sheet, Bostik Isoset UX-100
- Technical Data Sheet, Bostik Isoset UX-160
- Technical Data Sheet, Bostik Isoset WD3-A322
- Technical Data Sheet, Henkel Loctite/Purbond GT20
- Technical Data Sheet, Henkel Loctite/Purbond GT205
- Technical Data Sheet, Henkel Loctite/Purbond HB-X122
- Technical Data Sheet, Henkel Loctite/Purbond HB-X152
- Technical Data Sheet, Henkel Loctite/Purbond HB-X202
- Technical Data Sheet, Henkel Loctite/Purbond HB-X602
- Technical Data Sheet, Henkel Loctite/Purbond PR 3105
- GREENGUARD Certificate of Compliance, Loctite/Purbond GT20
- GREENGUARD Certificate of Compliance, Loctite/Purbond HB-X

Safety Data Sheets:

- Safety Data Sheet, Bostik Isoset CX-47
- Safety Data Sheet, Bostik Isoset MAX1017
- Safety Data Sheet, Bostik Isoset MAX1020
- Safety Data Sheet, Bostik Isoset MAX1060
- Safety Data Sheet, Bostik Isoset MAX300
- Safety Data Sheet, Bostik Isoset UX-100
- Safety Data Sheet, Bostik Isoset UX-160
- Safety Data Sheet, Bostik Isoset WD3-A322
- Safety Data Sheet, Henkel Loctite/Purbond GT20
- Safety Data Sheet, Henkel Loctite/Purbond GT205
- Safety Data Sheet, Henkel Loctite/Purbond HB-X122
- Safety Data Sheet, Henkel Loctite/Purbond HB-X152
- Safety Data Sheet, Henkel Loctite/Purbond HB-X202
- Safety Data Sheet, Henkel Loctite/Purbond HB-X602
- Safety Data Sheet, Henkel Loctite/Purbond PR 3105