

## Quality description for glulam GL24 in spruce

produced according ONORM EN 14080  
 stress graded according to ONORM EN 14081, finger jointed according to EN 385  
 lamellas are glued together to glulam of variable height  
 higher strength classes are available: GL28, GL32, GL36 (on request)



characteristics	visual quality	industrial quality
<b>black knots</b>	allowed as long as they don't drop out	allowed
<b>dropped out knots</b>	allowed up to a diameter of 10 mm	allowed
<b>wane</b>	not allowed	not allowed
<b>rotten parts</b>	not allowed	not allowed
<b>pith</b>	allowed	allowed
<b>resin pocket</b>	allowed up to approx. 5 x 50 mm, larger once needs to be patched	allowed
<b>insect attack</b>	not allowed	sporadically occurring is allowed
<b>blue stain</b>	up to approx. 5 % of the surface	allowed
<b>red strips</b>	up to approx. 5 % of the surface	allowed
<b>quality of planing</b>	row spots not allowed; planing stroke till 10 mm length & 1 mm deepness allowed	row spots and planing stroke are allowed
<b>cracks</b>	up to deepness from 1/6 of the component part width (per side) is allowed; the required statical load-bearing capacity should not be affected.	up to deepness from 1/6 of the component part width (per side) is allowed; the required statical load-bearing capacity should not be affected.
<b>type of wood</b>	spruce	spruce
<b>strength</b>	GL24 acc. standard EN 14080 higher strength classes on request	GL24 acc. standard EN 14080 higher strength classes on request
<b>raw material</b>	L25 acc. to DIN 4074 & EN 14081	L25 acc. to DIN 4074 & EN 14081
<b>production</b>	acc. standards & attached certificate	acc. standards & attached certificate
<b>glueing</b>	Melamine urea formaldehyde polymer adhesive with high-frequency technology	Melamine urea formaldehyde polymer adhesive with high-frequency technology
<b>width</b>	from mm 80 up to 280, in 20 mm steps	from mm 80 up to 280, in 20 mm steps
<b>height</b>	from mm 80 to 1280 mm, in 40 mm steps (intermediate height with one small/splitted edged laths)	from mm 80 to 1280 mm, in 40 mm steps (intermediate height with one small/splitted edged laths)
<b>length</b>	4 to 27 m; standard length 13.50 m (<4,00 m trimmed with Hundegger)	4 to 27 m; standard length 13.50 m (<4,00 m trimmed with Hundegger)
<b>thickness of lamellas</b>	up to 40 mm	up to 40 mm
<b>moisture content</b>	12-14 %	12-14 %
<b>surface</b>	4-side planed, edges chamfered	4-side planed, edges chamfered
<b>tolerance of dimension</b>	<400 mm ± 2 mm; >400 mm: height ± 0,5% of the beam cross section	<400 mm ± 2 mm; >400 mm: height ± 0,5% of the beam cross section

