



**NSAI**  
Standards

Irish Standard  
I.S. EN 15274:2015

# General purpose adhesives for structural assembly - Requirements and test methods

**I.S. EN 15274:2015**

*Incorporating amendments/corrigenda/National Annexes issued since publication:*

The National Standards Authority of Ireland (NSAI) produces the following categories of formal documents:

I.S. xxx: Irish Standard — national specification based on the consensus of an expert panel and subject to public consultation.

S.R. xxx: Standard Recommendation — recommendation based on the consensus of an expert panel and subject to public consultation.

SWiFT xxx: A rapidly developed recommendatory document based on the consensus of the participants of an NSAI workshop.

*This document replaces/revises/consolidates the NSAI adoption of the document(s) indicated on the CEN/CENELEC cover/Foreword and the following National document(s):*

*NOTE: The date of any NSAI previous adoption may not match the date of its original CEN/CENELEC document.*

*This document is based on:*

EN 15274:2015

*Published:*

2015-04-15

*This document was published  
under the authority of the NSAI  
and comes into effect on:*

2015-05-02

ICS number:

83.180

NOTE: If blank see CEN/CENELEC cover page

NSAI  
1 Swift Square,  
Northwood, Santry  
Dublin 9

T +353 1 807 3800  
F +353 1 807 3838  
E standards@nsai.ie  
W NSAI.ie

Sales:  
T +353 1 857 6730  
F +353 1 857 6729  
W standards.ie

Údarás um Chaighdeáin Náisiúnta na hÉireann

EUROPEAN STANDARD

**EN 15274**

NORME EUROPÉENNE

EUROPÄISCHE NORM

April 2015

ICS 83.180

Supersedes EN 15274:2007

English Version

## General purpose adhesives for structural assembly - Requirements and test methods

Adhésifs structuraux pour applications générales -  
Exigences et méthodes d'essai

Klebstoffe für allgemeine Anwendungen in strukturellen  
Klebverbunden - Anforderungen und Prüfverfahren

This European Standard was approved by CEN on 25 January 2015.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and United Kingdom.



EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**CEN-CENELEC Management Centre: Avenue Marnix 17, B-1000 Brussels**

## Contents

Page

Foreword.....	3
1 Scope .....	4
2 Normative references .....	4
3 Terms and definitions .....	5
4 Performance characteristics for intended uses .....	6
4.1 General.....	6
4.2 Sampling.....	7
5 Requirements .....	7
5.1 Production control requirements.....	7
5.2 Performance requirements .....	7
5.3 Sampling .....	8
6 Assessment and verification of constancy of performance (AVCP).....	8
6.1 General.....	8
6.2 Type testing.....	8
6.2.1 General.....	8
6.2.2 Test samples, testing and compliance criteria.....	9
6.2.3 Test reports .....	9
6.2.4 Shared other party results .....	10
6.2.5 Cascading determination of the product type results .....	10
6.3 Factory production control (FPC) .....	11
6.3.1 General.....	11
6.3.2 Requirements .....	12
6.3.3 Product specific requirements .....	14
6.3.4 Initial inspection of factory and of FPC .....	14
6.3.5 Continuous surveillance of FPC .....	15
6.3.6 Procedure for modifications.....	15
6.3.7 One-off products, pre-production products (e.g. prototypes) and products produced in very low quantity.....	15
Annex ZA (informative) Clauses of this European Standard addressing the provisions of the EU Construction Products Regulation .....	17
ZA.1 Scope and relevant characteristics .....	17
ZA.2 Procedure for AVCP of general purpose adhesives .....	18
ZA.2.1 System of AVCP .....	18
ZA.2.2 Declaration of performance (DoP) .....	19
ZA.2.2.1 General .....	19
ZA.2.2.2 Content.....	19
ZA.2.2.3 Example of DoP .....	20
ZA.3 CE marking and labelling .....	21
Bibliography .....	24

## **Foreword**

This document (EN 15274:2015) has been prepared by Technical Committee CEN/TC 193 “Adhesives”, the secretariat of which is held by AENOR.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by October 2015, and conflicting national standards shall be withdrawn at the latest by January 2017.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN [and/or CENELEC] shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN 15274:2007.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association.

For relationship with EU Regulation see informative Annex ZA, which is an integral part of this document.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

**EN 15274:2015 (E)****1 Scope**

This European Standard specifies requirements for adhesives intended for use in the creation and general assembly of load-bearing, structural elements used in civil engineering works and the construction of buildings. Other than the exceptions stated, it embraces all combinations of bonded materials, used to create or repair load-bearing elements.

It covers individual adhesives and special purpose kits comprising various combinations of adhesive types and components.

It includes test methods and methods of assessment.

The performance requirements in this standard may not be applicable to highly specialized applications in extreme environmental conditions, e.g. cryogenic use, nor do they cover specialized circumstances such as accidental impact, e.g. due to traffic or ice, or earthquake loading where specific performance requirements will apply.

The intended use is for internal and external construction elements and those cladding and covering elements (excluding ceramic tiles) specifically required, by regulatory authorities, to provide protection from fire in identified building zones, including escape routes.

This European Standard does not cover:

- prefabricated, bonded structural components;
- concrete bonded either to itself or steel or a material based on carbon fibre;
- wood, when bonded to itself to form a timber based, laminated beam [of the type known as a 'Glulam' beam] intended for use as a major structural, load bearing element;
- thermoplastics [e.g. polyethylene, polypropylene, polyamide and fluorinated polymers in general] unless they have been specifically prepared [usually through a specialized oxidative process] for bonded assembly on site;
- co-axial metallic assemblies comprising fasteners- threaded and otherwise, pipes and tubes;
- glass assemblies in structural glazing applications made using silicone adhesives;
- those structural elements that are permanently immersed in water.

**2 Normative references**

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 923:2005+A1:2008, *Adhesives — Terms and definitions*

EN 1067, *Adhesives — Examination and preparation of samples for testing*

EN 1242, *Adhesives — Determination of isocyanate content*

EN 1465, *Adhesives — Determination of tensile lap-shear strength of bonded assemblies*

EN 1877-1, *Products and systems for the protection and repair of concrete structures — Test methods — Reactive functions related to epoxy resins — Part 1: Determination of epoxy equivalent*

This is a free preview. Purchase the entire publication at the link below:

[Product Page](#)

- 
- Looking for additional Standards? Visit Intertek Inform Infostore
  - Learn about LexConnect, All Jurisdictions, Standards referenced in Australian legislation
-