

TECHNICAL NOTE NUMBER 142  
FOREST PRODUCTS LABORATORY - U. S. FOREST SERVICE - MADISON, WISCONSIN

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WHEN TO MACHINE CASEIN GLUE JOINTS

Casein glue sets very quickly and produces a joint strong enough to machine in a few hours. In tests at the Forest Products Laboratory casein glue joints in spruce proved as strong as the wood after 4 hours and in hard maple after 6 hours. When maximum speed of production is essential, such woods may be machined at the end of the periods stated, without sacrificing the strength of the joint. In some kinds of work, however, machining so soon after gluing is not advisable, because of the danger of warping or the production of sunken joints as the moisture content of the glued wood equalizes.

Another important fact brought out by the tests on joint strength is that joints released from pressure at the end of 2 hours and then allowed to season for 22 hours proved as strong as those that had been pressed for 24 hours. Joints pressed for only  $\frac{1}{2}$  hour and seasoned, although of good strength, on the average, were somewhat erratic in this respect and probably would not be dependable where maximum strength is important.