

# TECHNICAL NOTES

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FOREST PRODUCTS LABORATORY

U. S. FOREST SERVICE

MADISON, WISCONSIN

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## WHEN TO HEAT WOOD BEFORE GLUING

Whether a hide glue joint will be strengthened or weakened by heating the wood before gluing depends on the size of the joint. It is assumed, of course, that the work is being done in a glue room that is warm and not draughty, and that the wood itself is at room temperature. Under these conditions, if the joint to be made is of small area, heating the wood is unnecessary. In fact it may be detrimental, for the warmth of the wood will keep the glue thin; and, when pressure is applied, too much glue may squeeze out, leaving a starved joint. It is very easy to apply too much pressure to a small area.

In making glue joints of large size (several inches each way), heating the wood before gluing is of distinct advantage. Many experiments at the Forest Products Laboratory, Madison, Wis., have proved that when the wood in large joint work is not heated, the joints develop full strength only in spots. Weak spots and even open joints are too frequently discovered.

Uniform high strength in joints of large size may be secured by heating the wood in a hot-box for 10 or 15 minutes at 120 to 130 degrees Fahrenheit just before gluing. The heat from the wood prevents the glue from chilling and keeps it liquid until pressure is applied.

It should be remembered that heating the wood retards the setting of the glue to some extent. In heavy woods, from which the heat escapes slowly, this retarding effect is more marked than in lighter woods. In all species glued cold at the laboratory the time under pressure required to develop full joint strength was less than 8 hours. When heated wood was used, at least 10 hours were required to develop full joint strength in mahogany, and more than 12 hours in red oak and maple.