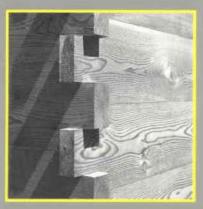
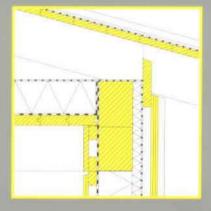
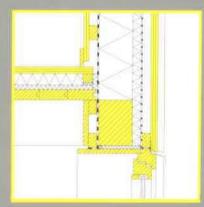
# **DETAIL** Praxis

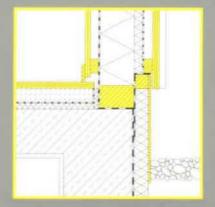


# **Timber Construction**

Details Products Case studies







Theodor Hugues Ludwig Steiger Johann Weber

Birkhäuser Edition Detail

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Theodor Hugues Ludwig Steiger Johann Weber

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### **DETAIL** Praxis Timber Construction

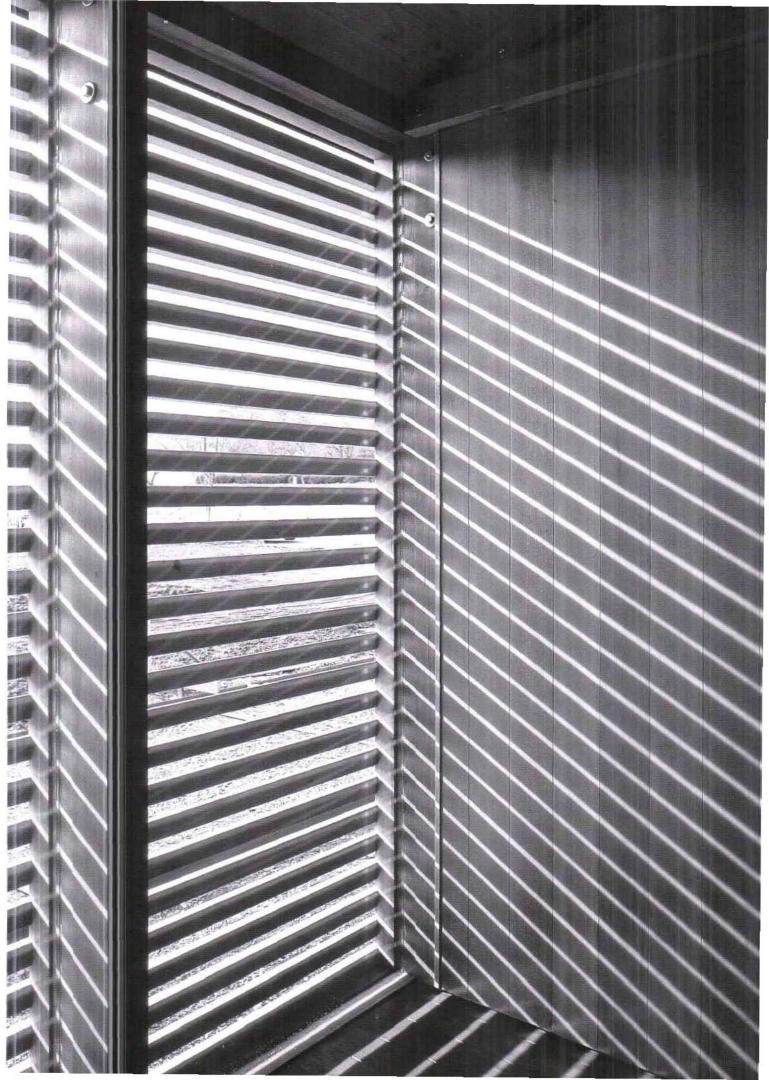
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### Contents

- 9 Introduction
- 11 House A
- 12 Exterior wall, plinth
- 13 Interior wall, floor above basement
- 14 Exterior wall, floor/ceiling, window
- 15 Interior wall, floor/ceiling, door
- 16 Exterior wall, ceiling, eaves
- 17 Exterior wall, ceiling, verge
- 18 Exterior wall, services installation shaft
- 19 Party wall
- 21 House B
- 22 Exterior wall, plinth
- 23 Interior wall, sole plate
- 24 Exterior wall, foundation
- 25 Interior wall, foundation
- 26 Exterior wall, floor/ceiling, window
- 27 Interior wall, floor/ceiling, door
- 28 Exterior wall, eaves
- 29 Exterior wall, verge
- 30 Exterior wall, corner
- 31 Party wall
- 33 Product overview
- 34 Timber
- 40 Manufactured Wood Products
- 50 Building boards
- 53 Insulating materials
- 66 Sheathing paper
- 70 Joints and fasteners
- 76 Wood preservation
- 78 Joint sealing tapes
- 80 Overview of exemplary constructions
- 81 Exemplary constructions
- 97 Technical information
- 100 Standards
- 101 Literature
- 102 References
- 107 Subject index
- 109 Index of projects
- 110 Picture credits

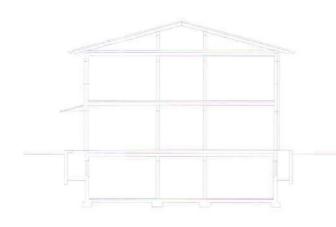
The Arbeitsheft Holzbau, the precursor of this book, arose at the suggestion of the Bayerisches Zimmerer- und Holzbaugewerbe and was sponsored by the Stiftung des Bayerischen Zimmerer- und Holzbaugewerbes Donat Müller.

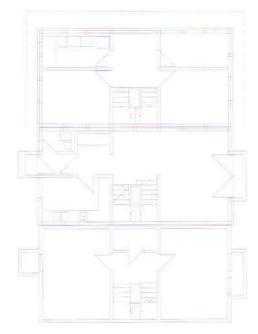
The authors should like to extend their special thanks to Univ.-Prof. Dr.-Ing Heinrich Kreuzinger (load-bearing structure) and Dipl.-Ing. (FH) Georg Wust and Dipl.-Ing. (FH) Wolfgang Hallinger (construction and materials).

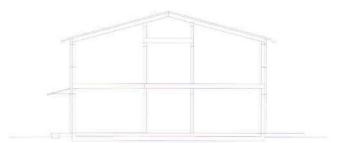


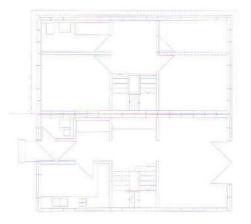












### Introduction

The Arbeitsheft Holzbau is intended as an aid to all those working in the field of construction. However, it is neither a construction manual nor an encyclopaedia of materials, It aims to show the relationship between design, detail work and the built product. What has emerged is a very handy book which summarises, in a userfriendly manner, all the material found in offices and enterprises that deals with building with wood. To avoid the selection presenting here failing prey to rapid obsolescence and, above all, premature obsolescence, it has been limited to basic designs and proven materials.

### Part 1

The first part provides an overview of the exemplary use of building components, component layers and building materials and their integration into the overall structure of two prototypical timber houses of different design. Questions concerning building physics, such as heat, and sound insulation, vapour and fire protection, draught proofing and jointing are briefly explained and presented in graphic examples of details and joints typical of wooden construction. Two simple, common types of terraced house have been designed and constructed to illustrate the interconnections and the problems. Common to both types is the relatively low roof pitch permitting the use of light roofing materials. Both houses can be heated with gas.

House A is a craft-built timber-framework house standing on a cellar. Its latticework walls rest on the cellar walls and the floor above the cellar and bear a wooden joist ceiling as well as a doubly supported roof structure which has not been fitted out. The distance between the post axes and the ceiling joists is 125 cm, making it a multiple of the module of 62.5 cm, which many of the building materials observe. The disadvantage of using thicker boarding on the visible joists has to be weighed up against the spatial (hall width, cubic measure) and the design advantages (door and window openings without trimming). It could be reduced to 83.33 cm (250 cm: 3).

To improve the dimensions of the roof overhang at the eaves and the verge, the rafter spacing between was halved to 62.5 cm. The greater part of *House B* is designed to be produced in the workshop and assembled from prefabricated wall elements, floors and a roof on a floating foundation, assuming that the subsoil is suitable. The roof has been fitted out and integrated into the interior.

The design is based on a dimensional coordination of 62.5 cm, corresponding to the basic elements of panel construction such as the panel dimensions of the plywood, chipboard and, above all, plasterboard / gypsum-fibre board. This dimensional co-ordination has proven to be a useful standard for partial and full prefabrication.

The development of the skin and its material implementation has been executed in accordance with the different goals of the two projects.

### Part 2

The generic terms of building materials and joints and fasteners have been italicised in the commentary on the details. In part 2 they are listed in the subject index under the marked generic term along with products, specifications and manufacturers,

### Part 3

The brief illustrated documentation of the nine completed projects is intended to convey an impression of the diverse types of wooden buildings, showing the designs chosen, the specific ways in which the details have been elaborated, and the materials used.

### Part 4

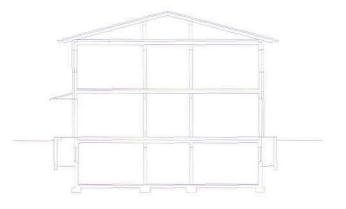
The appendix contains technical information, a summary of the pertinent guidelines and standards together with a bibliography and a list of manufacturers, also includes cross-references that allow readers to follow the path from the manufacturer to the product and its use and vice versa, as well as a subject index and list of names. House A

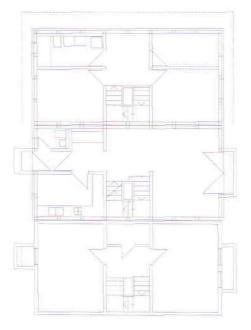
All of the detail drawings are drawn to a scale of 1:10.

The yellow squares refer to specific texts. The diverse building components have been developed as variations and represent exemplary solutions that must be adapted to specific marginal conditions, prevailing legislation, standards and manufacturers' recommendations. The authors shall not be liable for any claims made against them on the basis of the material presented here.

### House A

- 12 Exterior wall, plinth
- 13 Interior wall, floor above basement
- 14 Exterior wall, floor/ceiling, window
- 15 Interior wall, floor/ceiling, door
- 16 Exterior wall, ceiling, eaves
- Exterior wall, ceiling, verge
   Exterior wall, services installation shaft
- 19 Party wall





### a

Under DIN 18195, and to ensure that the wood is protected, a plinth height of 30 cm must be observed. Although a plinth can be lower in principle, special measures must be taken where this is the case, for example: a roof overhang, offsets, weather-protected sides, and coarse gravel strips to reduce water splashing.

The *perimeter insulation* of the exterior basement wall is covered on the outside for aesthetic reasons and to offer protection against any mechanical damage, for instance, with a fibre-cement slab.

### 🗌 b

The *perimeter insulation* and the wall structure must be made to harmonise with one another at the transition of the *perimeter insulation* to the facade. The crosssection for the *ventilation* must not be obstructed in any way. If banked-up coarse gravel is used to push the lower panel edge against the *insulating board*, the *fibre-cement slab* need only be fastened with a batten along its upper edge. The vertical panel joint must be executed in a way that prevents moisture from seeping behind the panel.

### С

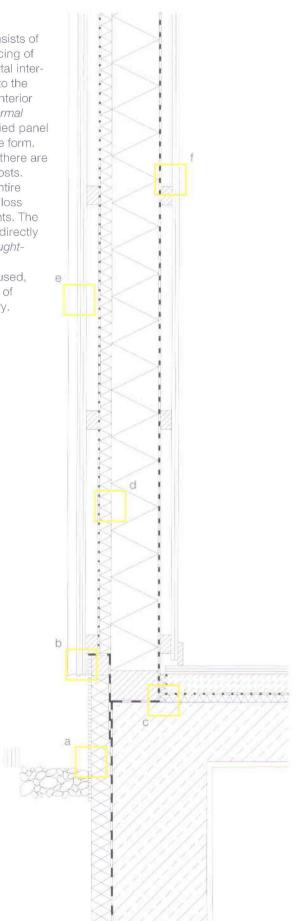
The wooden sill plate must take up the tolerances of the concrete floor above the basement. The joint is sealed with high-expansion cement mortar. The *wooden sill* plate must be impregnated both to protect it and insulate it from the concrete floor. *Chemical wood preservative* is not necessary if timber species with a high *resistance class* are used. To attach the bar-reinforced sill plate to the floor, the plate is drilled through and then anchored with a heavy-duty bolt, taking care that a safe distance is maintained to the edge of the concrete.

(Alternatively, the sill plate can be fixed with an angle attached to the side or with a ragbolt cast in concrete.)

### d

The exterior wall construction consists of 12 x 12 cm posts with a unit spacing of 125 cm, and a vertical or horizontal intermediate structure adapted both to the substructure of the exterior and interior lining and to the format of the thermal insulation. Insulation can be applied panel or roll form, or sprayed on in flake form. Flakes should only be injected if there are sealed chambers between the posts. A softboard is fixed across the entire bearing structure to reduce heat loss through the structure and the joints. The panels, to which battens can be directly fixed, are rebated to provide draughtproofina.

If a fibrous insulating material is used, vertical battening and some kind of draughtproofing will be necessary.



# h g

### e

The ventilation cross-section between the weatherboarding and the inner board is sufficient to ensure *ventilation* of the exterior skin.

If more resistant and well-patinated wood species such as larch, cedar and Douglas fir are used, the surface *boarding* need not be treated. However, this will not prevent the wood from greying, which is harmless in any case. If other woods are used, a weather-protective layer, such as a glaze or a coat of paint, will be necessary – depending on the resistance class.

### 🔲 f

The interior lining comprises vertical matchboards attached to a horizontal batten substructure. If the post spacing is 125 cm, the substructure should have a cross-section of at least 30 x 50 mm or – better still – 40 x 60 mm.

In this area, dimensional tolerances can be compensated for and electrical cables laid. However, there is too little space to fit electric sockets here without piercing the vapour retarding layer inside the thermal insulation. As it is difficult to mount connections on the vapour retarding layer, electric sockets and switches should be installed on the Interior walls whenever possible.

### 🗖 g

The load-bearing interior walls also consist of 12 x 12-cm post with horizontal rails. The *sill* plate must be anchored in the same way as the exterior wall to the floor above the basement. It is not necessary to observe minimum distances (the *stainwell* being an exception) between the heavy-duty bolt and the concrete edge here.

When constructing the floor, care must be taken that the *sill* plate is high enough to ensure that the floating screed terminates at an edge insulating strip. Although flush skirting boards offer a more elegant solution, they are also more expensive.

### h

The electrical installations are routed through the cavity in the interior wall, which is soundproofed with a *mineral-* or *coconut-fibre* panel. If stable load-bearing structures are used (for example, solid structural timber with additional horizontal rails), the *boarding* can be mounted directly. Alternatively, plywood or OSB panelling can be used.

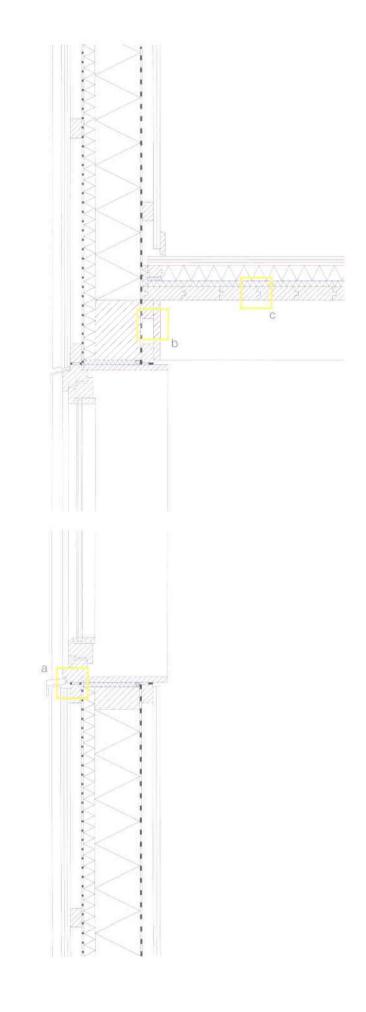
### 🔲 a

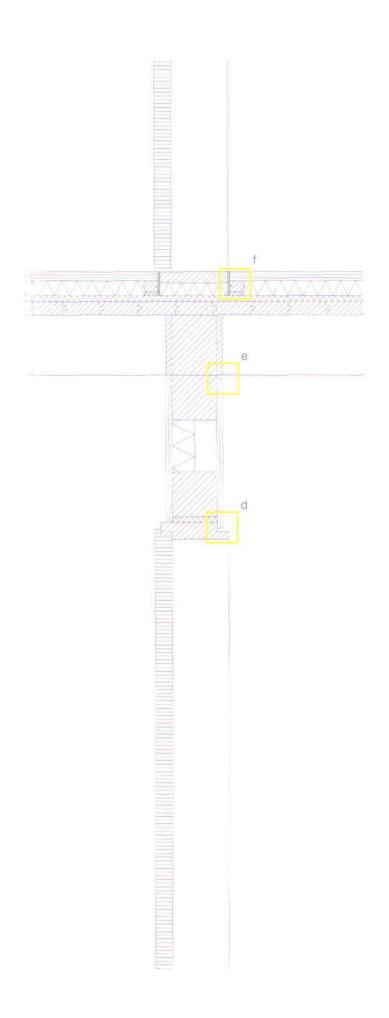
The window, which is mounted flush with the wall and fixed to the rail at sill level with a metal angle, provides a simple transition to the overlapping vertical weatherboards. Care must be taken that the angle is mounted on the bearing structure in front of the soft particleboard. The draughtproofing can be fixed to a batten beneath the outer window frame. A similar procedure is adopted on the inside when connecting the vapour retarding layer to the prefabricated window frame, which is fixed to the outer frame. Before the vapour retarding layer is mounted, the joint between the window frame and the bearing structure must be carefully filled out or foam-filled with insulating material.

Joint sealing tape must also be applied to ensure that the window is airtight. In January 2002, the Ordinance on Energy Saving came into effect, which tightened up the requirements for *exterior walls*. Under the ordinance, these walls must be constructed and verified as totally draught-proof enclosures. This applies, in fact, to all junctions, especially for those at the window surrounds.

### b

The exposed transverse joists in the floors are fixed to the posts with galvanised steel sheet joist hangers. To ensure that vapour is fully retarded, a section of foil to which the vapour retarding layer is subsequently attached - is attached to the bearing structure when the beam is fixed. A board is fitted between the beams to a batten substructure to create a flush connection to the interior wall cladding and cover the underside of the joint between the panelling and the bearing structure. This step is necessary as swelling may cause movement in the panelling. To prevent airborne noise entering at the edge of the ceiling, the joint between the floor and the wall must be carefully filled in with insulating material.





### С

As a structural grid of 125 cm has been chosen for the building, tongued-andgrooved floor covering is required. A floor comprising plain floorboards on timber bearing strips laid loose and filled with insulating material will suffice for a detached house. If prefabricated parquet or sheet flooring is preferred, it is advisable to lay the flooring on a load-bearing surface of ready mixed dry screed. Airborne-sound insulation can be optimised by putting loose fill beneath the impactsound insulation or by ballasting the floor structure with, for example, paving flags attached with adhesive to give a shearresistant bond.

### d

The joint between the lintel beam and the doorframe is filled in with insulating material to improve the *sound insulation* of the interior wall. The rebate in the solid door frame not only seals the joint with the interior-wall lining, but also creates a harmonious transition between the door and window flashing on the one hand, and the interior boarding on the other.

### e

The floor joists rest on the head of the interior load-bearing wall. The space between the joists is sealed with an additional rail at the same level as the joists. This area can now be covered with a board, as was the case with the *exterior wall*.

🔲 f

The solid door frame is connected to the floor by a *threshold*, a measure which not only ensures greater stability when transporting the door frame, but also makes it possible to lay the flooring without having to fit it into the door reveal.

To provide adequate *impact-sound insulation* here too, an insulating strip is fitted between the *threshold* and the flooring. The joint between the *threshold* and the planks is filled with a cork strip to absorb any movements in the materials.

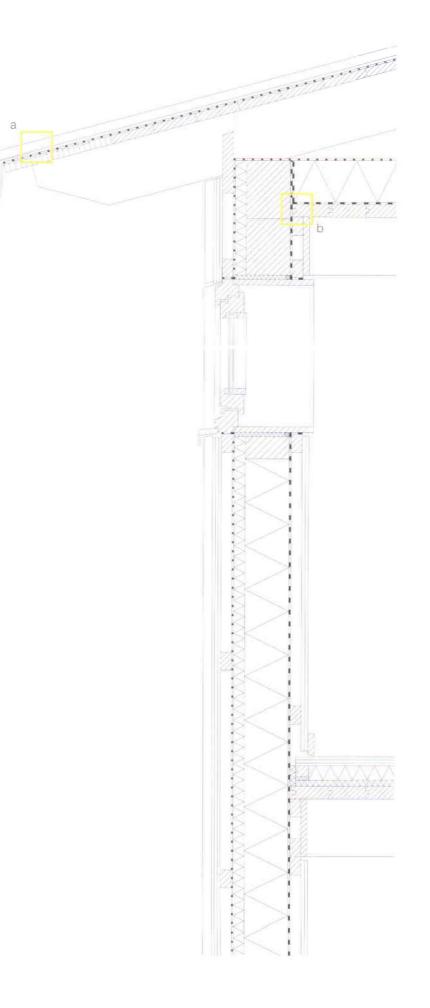
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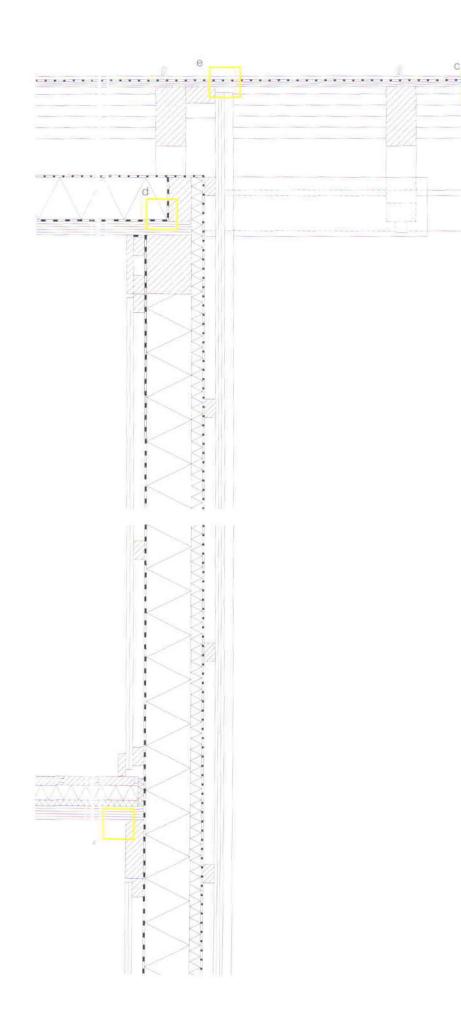
A sheet-metal covering joined with locked double-welt standing seams and laid on a *separation layer* has been chosen for the roof covering. If the *separation layer* is to serve as sheathing, a more resistant material, appropriately laid, should be used. The rafter spacing of 62.5 cm corresponds to the support-grid of 125 cm. Instead of planed boarding, a panel of watertight adhesive bonded *plywood* has been used, which allows the roof-skin overhang to be extended over the ends of the rafters at the eaves. A *chemical wood preservative*, as required under DIN 68 800, is unnecessary.

As the overhang is to be fixed to the rafters, its size must be adapted to the length of the gutter bracket. The panel widths are obtained by dividing a standard panel in equal parts to avoid waste, for example by quartering a 125 cm-wide panel.

### b

The floor beneath the roof void is designed in the same way as the upper floor, whose *joists* are connected to the posts by beams. A carpenter fits the *vapour retarding layer* and the *thermal insulation* in sections, connecting them with the ceiling boarding to the roof boarding of the profiled planks, They are then covered with a water-repellent *draughtproofing* designed to allow diffusion. The roof overhang on the gable side calls for a relatively large cross-section for the projecting eaves purlins, The *draughtproofing* is attached to the eaves purlin.





### С

To ensure that the roof edge is kept as narrow as possible, the seam at the verge is bent over and bonded to the overhanging roof boarding to form a drip batten. The building's low height allows for a sheet bay width of 62.5 cm and thereby harmonises the locked double-welt standing seams with the rafter arrangement, which corresponds to half the structural grid.

### 🔲 d

In the gable area, the *exterior wall* structure only extends as far as the floor beneath the roof void. The roof void is not insulated to the outside. In order to fit the insulation, the *draughtproofing* and the *vapour retarding layer* at the transition from the wall to the ceiling, an edge beam has been fitted to the roof boarding so that the individual insulating layers can be attached to both its long sides.

### e

The vertical exterior boarding extends as far as the lower edge of the roof boarding; it is screwed to a plank running along the edge rafter on the lower side of the roof boarding. At this edge, air from both the ventilated roof and the wall construction can escape through the ventilation cross-section of the overlapping vertical *weatherboarding*.

🔲 f

A vertical plank, fixed to the side of the posts, will provide sufficient support for the load-bearing roof boarding at the gable wall.

### a

The exterior corner of the overlapping vertical *weatherboarding* is easily made by connecting the window boards to create a butt joint. The boards are fixed to the horizontal battens with *nails* or *screws* of stainless steel (they may be galvanised only in exceptional cases) to avoid corrosion stains on the boarding. Each board is fixed separately to avoid tension due to swelling and shrinkage.

The joint can be made *airtight* by overlapping or bonding the boards at the corner.

### 🔲 b

Normally, boards of equal width are used for the overlapping vertical *weatherboarding*. As the outer boards overlap those beneath them – approx. 25 mm on each side – the boards appear to be of different widths. This system allows for differences in spacing between the boards, obviating the need to use door and window flashings of special widths. It is essential that the façade be planned carefully and all measurements be precisely attuned to the positioning of the boards.

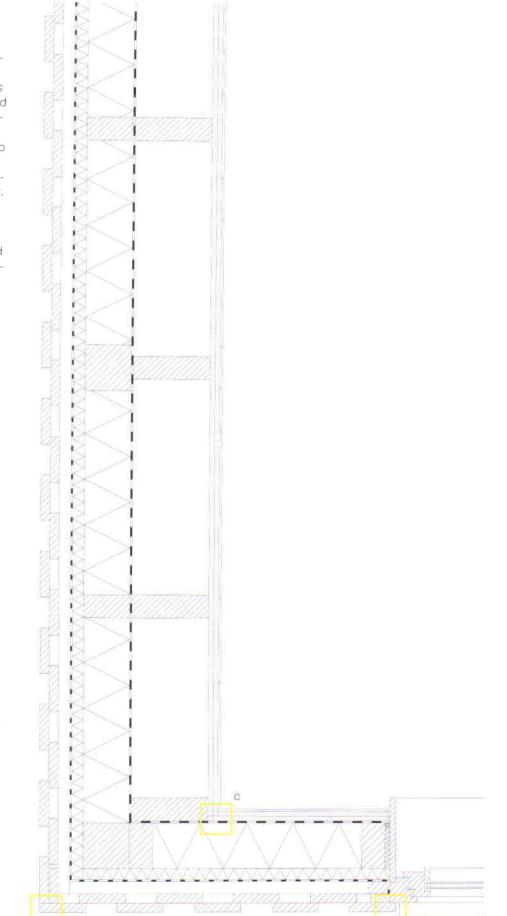
When windows are installed flush, they must be attached to the side of the outer frame in such a way that the overlapping *weatherboard* seals the joint between the outer frame and the wall. There is no need for the casement to be rebated at the side. The *draughtproofing*, insulation and the *vapour retarding layer* are connected to the wall structure in precisely the same way as the window to the lintel and the parapet beam.

### С

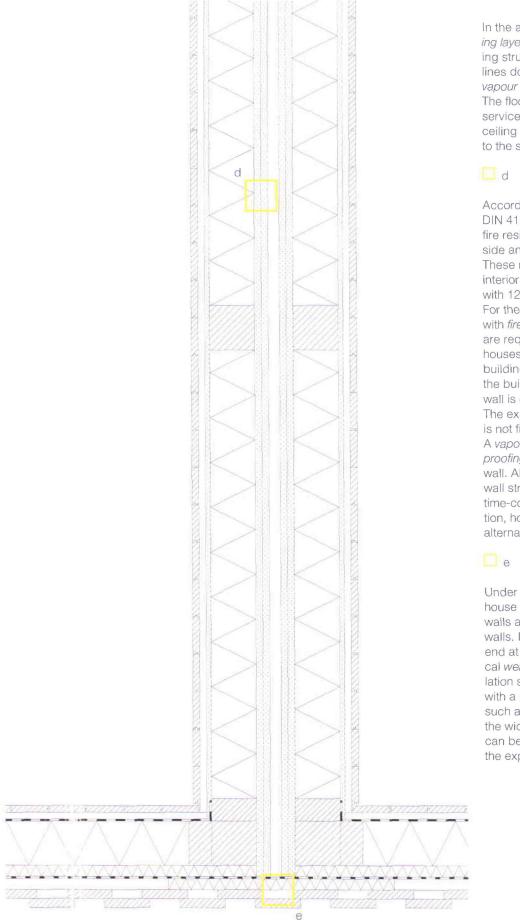
For the services shaft, a substructure comprising 6 x 20 or 8 x 20 cm posts is necessary. Optimally, it is constructed half a grid space in the *exterior wall* to reduce the span of the *planking*. Ceramic tiles are bonded to the *gypsum fibreboard* or impregnated *plasterboard* (identification colour: green).

When connecting the sanitary fittings, the location and dimensions of the posts and rails must be taken into consideration. If the rib spacing exceeds 40 cm, two layers of *plasterboard* will be necessary.

a



b



In the area of the shaft, the vapour retarding layer is fixed to the inside of the bearing structure to ensure that the service lines do not unnecessarily penetrate the vapour retarding layer.

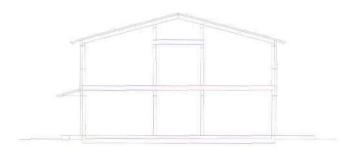
The floor structure continues through the services shaft. If lines run vertically, the ceiling boarding must be drilled or cut out to the size of the conduits.

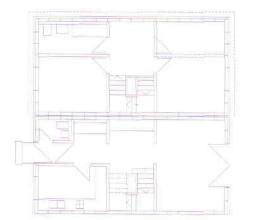
According to the building regulations and DIN 4102, a party wall must comply with fire resistance class F 30 B on the room side and F 90 B in the cavity. These requirements are fulfilled on the interior by using a single layer of *planking* with 12.5 mm *fire-resistant plasterboard*. For the exterior, two-layers of *planking* with *fire-resistant plasterboard* ( $2 \times 18$  mm) are required. In the case of terraced houses, this requirement applies to both buildings. During construction, the side of the building must be planked before the wall is erected.

The expansion joint between the houses is not filled for reasons of sound insulation. A vapour retarding layer and draughtproofing are not necessary in the party wall. All things considered, this type of wall structure is a relatively costly and time-consuming affair. In timber construction, however, there is no recognised alternative to this approach.

Under the building regulations, a terraced house is a low-rise building whose party walls are constructed like compartment walls. In the cavity, the F 90 *planking* can end at the inside of the overlapping vertical *weatherboarding*. The boarding ventilation space must, however, be sealed with a non-flammable insulating material such as *mineral fibre* extending at least the width of the party wall. The boarding can be continued uninterrupted across the expansion joint. House B

- 22 Exterior wall, plinth
- 23 Interior wall, sole plate
- 24 Exterior wall, foundation
- 25 Interior wall, foundation
- 26 Exterior wall, floor/ceiling, window
- 27 Interior wall, floor/ceiling, door
- 28 Exterior wall, eaves
- 29 Exterior wall, verge
- 30 Exterior wall, corner
- 31 Party wall





### 🔲 a

Before constructing a floating foundation with a load-bearing reinforced concrete slab on frost blanket gravel, it is first necessary to carry out preliminary investigations to determine the soil type and establish its bearing capacity. A rapidly draining, concentrated soil with a good bearing capacity is absolutely essential. The top layer of soil must be replaced by a layer of clean gravel approx. 40 cm deep, which is then carefully compressed and covered with a sub-base of 5–10 cmthick grade B5 concrete on which the reinforced floor slab is cast.

### 🗌 b

On the interior, the floor slab must be thermally insulated beneath the screed. The transition to the *exterior wall* is a weak point. This problem can be overcome (and the planned insulation standard maintained) by fitting impervious *thermal insulation* to the front side of the sole plate and covering the insulation either with a flat *fibre-cement slab* or concrete roofing tiles.

### С

Prior to installing the prefabricated exterior wall elements, a *sill* is put in place, aligned, underlaid and fixed to the concrete slab with either lug angles and *dowels* or anchor bolts. The space between the *sill* and the floor slab is filled with highexpansion cement mortar. Since it is particularly exposed to hazards, the *sill* must be protected to meet *hazard* class 2 requirements. Alternately, a very resistant wood species can be used, which will eliminate the need for chemical wood protection.

The *damp-proof course* on the floor slab is first bonded or welded to the seal beneath the sill. Then the plasterboard lining is attached to the elements, which are initially left unclad on the interior.

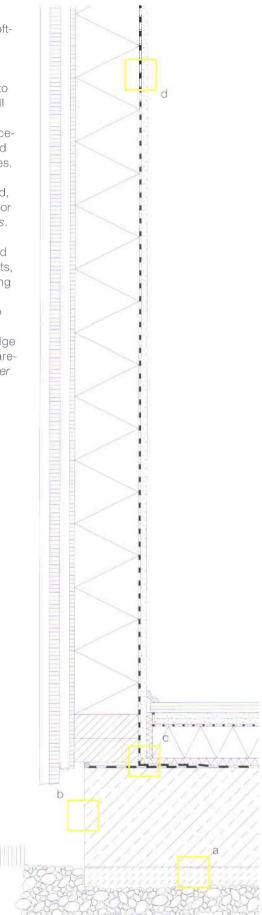
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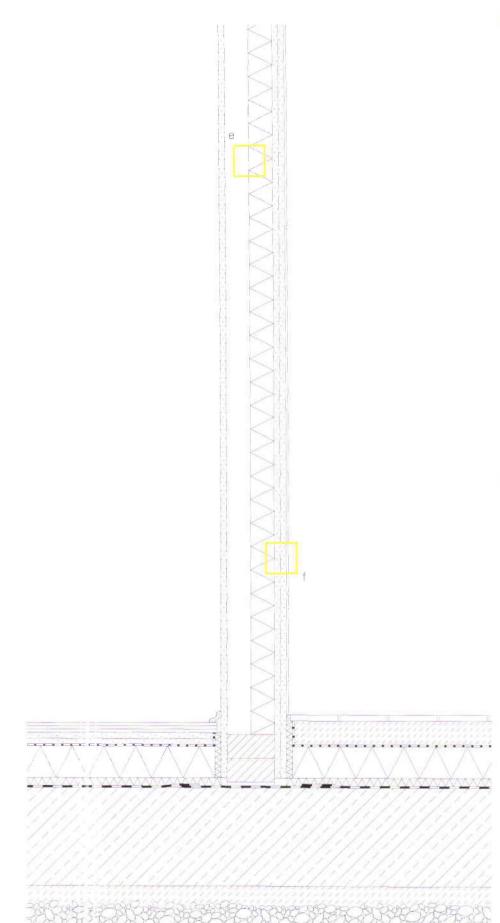
A permit must be obtained from the building supervisory authorities before the prefabricated insulated wall elements can be erected. Although these elements are subsequently panelled on both sides (clad elements), with most wooden constructions it is customary to panel them with *plywood sheeting* or *plasterboard* on the outside only at first, and to leave them unclad on the room side until they have been fitted to the structural timbers (softwood timbers measuring  $6 \times 12$  to  $6 \times 16$  cm, depending on the insulation standard).

The above procedure makes it easier to fix the *sill* to the floor and install the wall elements.

If the *panelling* is to be used for reinforcement, permission must first be obtained from the building supervisory authorities. The elements are screwed to the construction, which is then sound insulated, vapour retarded and lined on the interior with *plasterboard* or *wood-based panels*.

If the interior panelling is to be attached directly to the structural timber elements, great care must be taken when planning the services, particularly the electric installations. If there is no alternative to connecting sockets to the *exterior wall*, protected sockets with an adhesive edge must be used. The sockets must be carefully bonded to the *vapour retarding layer* and provided with external insulation.





### e e

The height of the elements corresponds to that of the room(s), which, in turn, must comply with standard board dimensions. The element lengths partly depend on the method of transport and assembly used. Elements can extend the entire width of the house.

The interior wall elements, which must comply with the standard dimensions of board materials and construction timbers, comprise structural timbers made of softwood and measure 6/12 cm (centre distance = 62.5 cm). Like the exterior wall elements, they should initially be panelled on one side only. Once they have been constructed and installed, they should be clad with plasterboard or wooden panels. If the cavity between the structural timber elements has not been completely filled with expanded mica, cellulose flakes, etc., it should be filled with mineral or coconutfibre sound insulation at least 30-40 mm or - preferably - 60 mm thick. Higher sound-insulation values can be obtained by applying double panelling or fitting additional "floating" panel cladding with flexible wall connections.

### 🔲 f

Appropriately bonded wooden panels or impregnated *plasterboard* (identification colour green) must be used in the humid rooms, *Gypsum fibreboard* has the advantage of not requiring additional treatment. Two layers of gypsum fibreboard will be necessary if humid rooms are to be tiled or the spacing between the structural timbers exceeds approx, 42 cm.

The shrinkage ratio of the noggings must be taken into account when attaching the *panelling*. Owing to their cross-section, this ratio is small and can be reduced still further by using pre-dried wood.

### 🔲 a

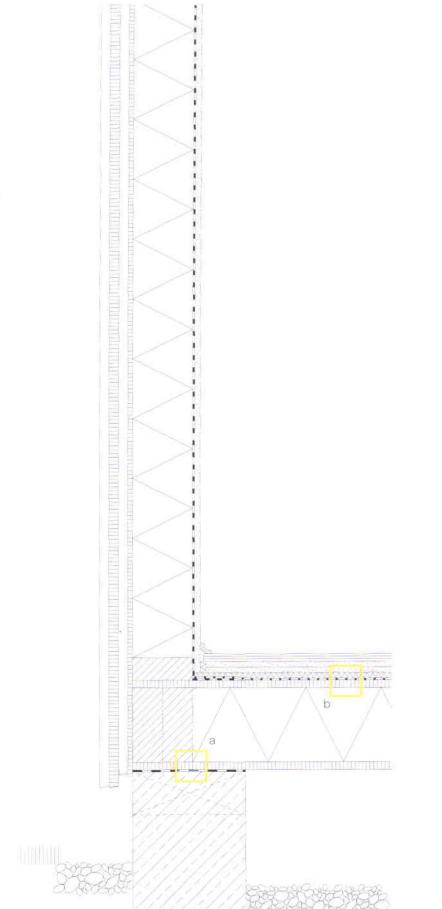
A different and perhaps more consistent approach to wood construction as a "dry" construction method is to use a *floor construction* comprising structural timber elements and with excellent thermal insulation, and to panel them on both sides. (These elements have dimensions of approx.  $6 \times 20$  cm, determined statically and in accordance with insulation standards.) The rising walls are connected to the aligned and fixed floor elements. *Cemented chipboard* and *fibrated concrete slabs* make suitable underside *panels*.

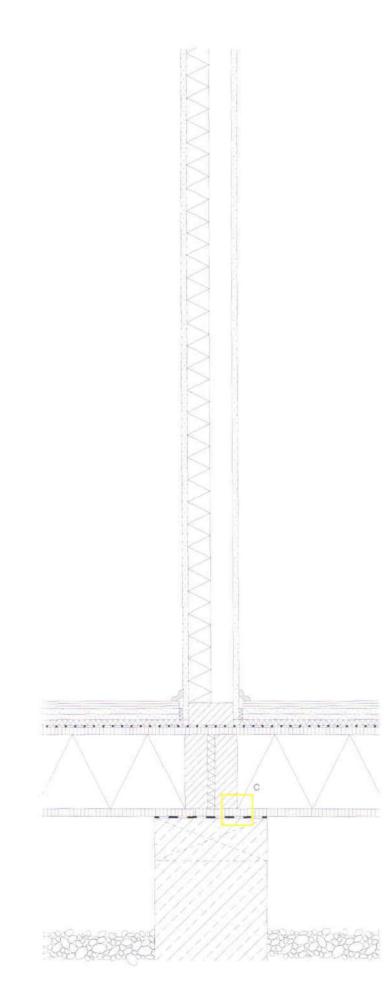
The cavity between the infilling and the underside of the elements must be permanently ventilated. This can be done by installing correspondingly large grated openings on both sides of the terraced house.

### b

Floating dry screed composed of wood, plasterboard, or *gypsum fibreboard* panels should be installed as a dry construction.

The *PE-foil* under the impact-sound insulation serves as a *vapour retarding layer* and simultaneously provides draught insulation.





### С

Beneath the interior walls, there is no need for frost-proof foundations or for continuous footing concreted to the soil or planked. The position of the footing is determined by that of the floor elements and the load-bearing interior walls. The floor elements should be formed as a plate and anchored to the foundation with authorised dowels or connection angles and stone bolts. AW 100 plywood strips or high-expansion cement mortar can be used to equalise out any unevenness. A vapour barrier of, say, polymeric bitumen or *plastic sheet* is fitted between the floor elements and the foundations to prevent any damage through moisture. The abutting joint between the elements must be sealed with insulating strips and sealing tape.

### 🔲 a

The wall elements are held together by, and aligned with, the upper headpiece. The floor, which is composed of *glued laminated beams* or *glued laminated timbers*, is fitted and bolted in element widths of between 60 and 250 cm (beams) or 62.5 and 100 cm (timbers). Mounting and shrinkage must be taken into account when choosing the width. During the construction phase, the wood – especially the solid elements – must be protected from the weather at all times to prevent damage through moisture and swelling.

If necessary, diaphragm action can be ensured by joining the elements to make them shear-resistant.

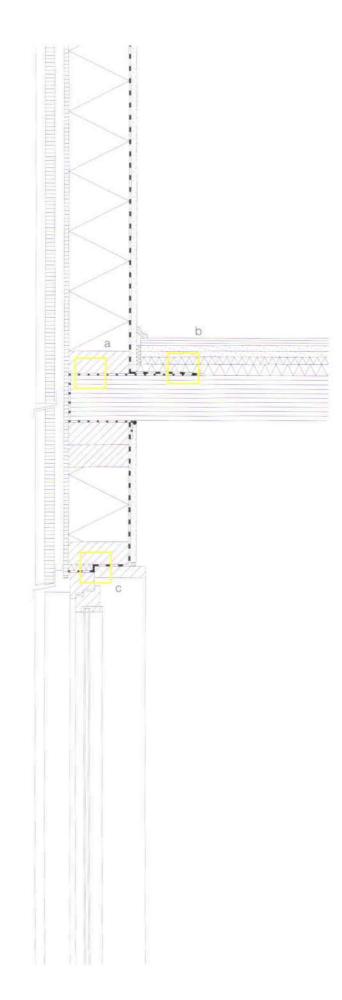
### 🔲 b

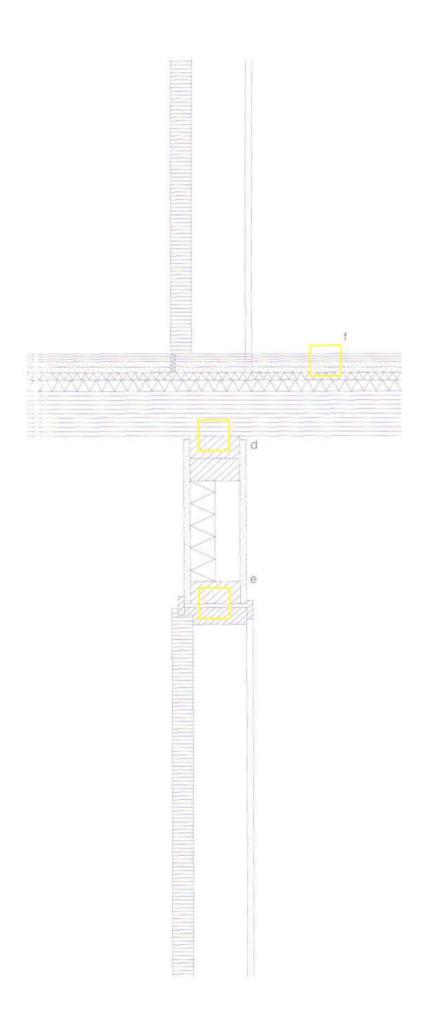
To ensure that the light, effectively insulated wooden wall fulfils its function, the vapour retarding layer must be connected to the wall at the floor edge in a way that allows for subsequent inspection. Correspondingly long sections of flexible *plastic sheeting* that allow for diffusion must be wrapped round the end of the floor and fixed on the upper side of the floor to the vapour retarding layer sheeting of the installed wall elements.

### C c

The selected assembly system and point in time when the exterior wall cladding is installed determine whether the surfacefinished windows are assembled in the workshop or on site, and whether they are installed with or without glazing. The windows must be fitted to the structure with a section of vapour-resistant, flexible plastic that is fixed to the window frame.

The joint between the lintel and the window frame performs a vital function during installation in absorbing tolerances and movements. It should be filled with an insulating material (*mineral fibres, mineral wool, sheep's wool, etc.*) and sealed with a pre-compressed *sealing tape* or permanently elastic sealing material. The stringent requirements of the energy conservation regulations must be observed (see also p. 14a).





### 🔲 d

The ceiling's structural connection to the interior walls corresponds to that of the exterior walls. The problems related to fitting the *vapour retarding layer* and *draughtproofing* do not apply here.

### e

The joint between the lintel and the doorframe is constructed in the same way as that of the window (see item c). The requirements of building physics concerning heat, vapour and draughts, which present considerable practical problems, do not apply here.

🔲 f

The floor structure, which is composed of parquet, *dry screed* and *impact insulation*, has been made 3 cm thicker than usual to include a services shaft which, in turn, accommodates the larger number of lines laid along the floor/ceiling. The problem of power-supply lines crossing one another can only be surmounted by careful planning.

Even with such a relatively "complex" ceiling structure, additional measures can be taken to improve airborne-sound insulation by, for example, using "sand honeycombs".

### a

The roof floor of *glued laminated beams* or *glued laminated timbers* is fitted to the support and screwed to the *sill*. As with the floor, a section of *plastic sheet* that allows diffusion is guided around the headpiece of the roof floor and fixed to the floor *vapour retarding layer*. The sheet ends must be either bonded together or well overlapped and fastened.

### b b

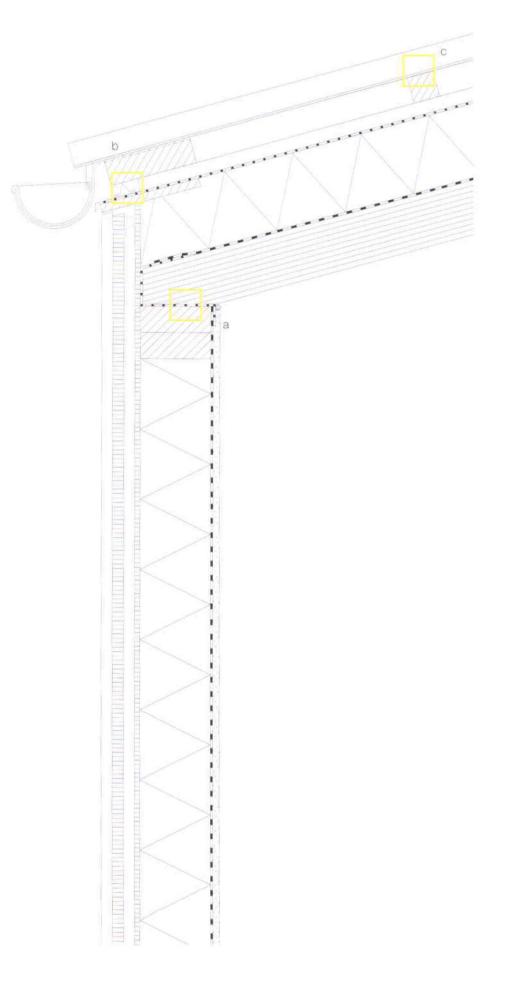
The height of the cross rafters is determined by the thickness of the *thermal insulation*.

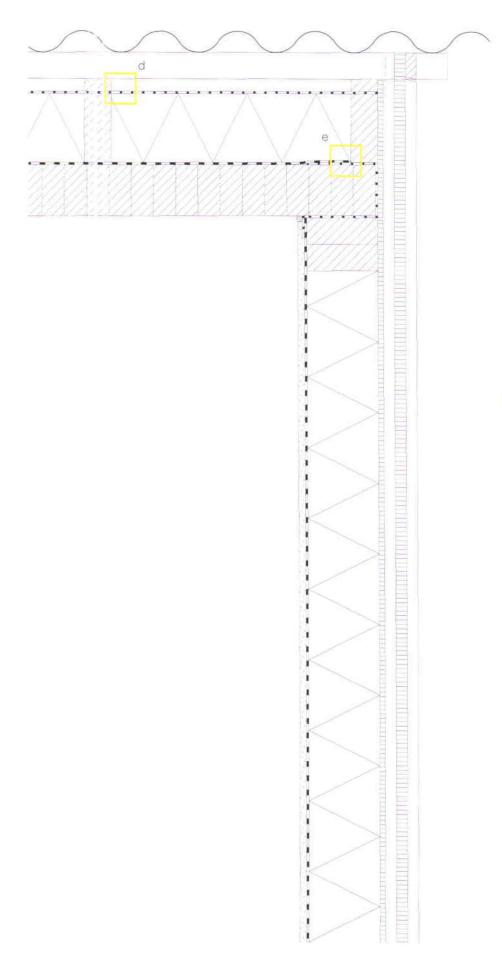
Covering the insulation with vapour permeable, water-repellent paper, or with *plastic sheeting* displaying the same qualities, ensures that any precipitation (rain, drifting snow...) or "secondary" meltwater (changes in weather or cold night air that cools the underside of the non-sucking roofing material) can drain off, and that there is no reduction in insulation value. Ventilation and drainage are ensured by counter battens and a triangular cleat of perforated plate, which is fixed to the eaves flashing with tingles.

The eaves flashing rests on a plywood strip, for which the cross-rafters are cut out. It is advisable to bolt the flush countersunk gutter hanger onto a continuous fascia.

### С

The dimensions and spacing chosen for the rafter-supporting purlins depend on the corrugated sheet roofing used.





### d

The width of the insulating panels must be greater than the clear spacing of the cross rafters to accommodate the slightly compacted *thermal insulation* installed between them, which has to compensate for any wood shrinkage.

The division of the substructure into cross-rafters and counter battens ensures that the vapour-permeable protective layer is level and remains securely fixed.

The main goal here (depending on the thermal-insulation requirements for the roof) is to ensure that the continuous rafters do not create a thermal bridge. This can be avoided by installing a second insulating layer, as shown in the example here. Another solution is to place insulation beneath the foil between the horizontal counter battens, or to install continuous bituminous *fibreboard* decking, which simultaneously acts as a protective layer.

### C e

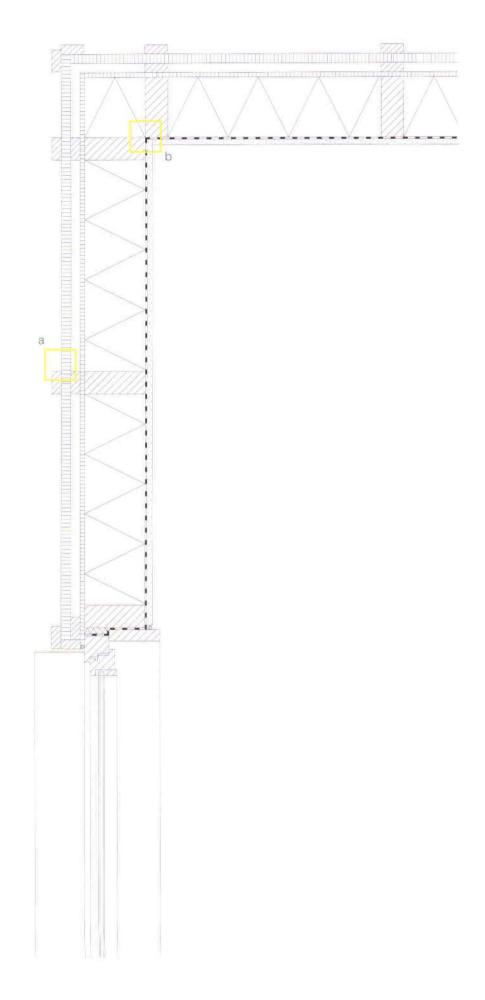
The efficiency of the various insulating measures and the utility of a house largely depends on whether the protective layers, which take the diverse loads imposed on a building (thermal, moisture, air), can be applied consistently and safely to all connections. They must also be open to inspection.

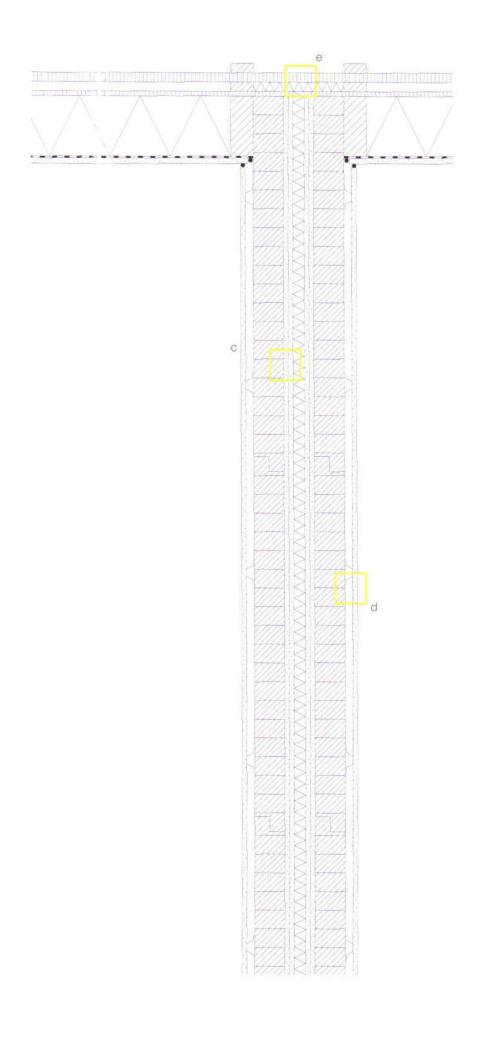
The storage capacity of the heavy roof members improves thermal protection during the summer.

### 🔲 a

If the substructure unit spacing of 62.5 cm is observed, the plywood panels (which are generally 125 cm wide) can be screwed in the centre of the panels and at their edges. The width of the cover strips has to be calculated accurately to ensure that the edge spacing of the *screws* is sufficient, and to fully cover the screw heads. Narrower cover strips should not be used unless an alternative way is found of fixing the facing panels (e.g. by screwing them onto more closely spaced substructure elements) and the panel edges only has to be cramped by the screwed-down cover strips.

Although the absence of a visible bolted connection (with a shadow gap, sealing tape and a correspondingly wide substructure) on a smooth large plywood cladding panel does justice to the material, it nevertheless exposes the panel edges. This, in turn, makes it almost impossible to prevent water absorption and heightens the risk of damage or movement from swelling and shrinkage. The following protective measures can be taken here: reduce the weather loads, e.g. by circumspect alignment of the building, use large roof overhangs or cantilevered balcony slabs, and give all edges water-repellent treatment. As these precautions were not taken in the example presented here, a more resistant joint was chosen and secured with cover strips.





### 🔲 b

The elements are jointed at the corner. Although the corner design shown here is atypical for wooden frame constructions, it does make it easier to connect the elements in an open corner joint. After it has been screwed together, the corner must be sealed on the outside with a prefabricated, thermally insulated metal angle.

The greater requirements (regarding building physics) placed on the exposed outside corner mean that considerable care must be taken when installing the *thermal insulation* and the *vapour retarding layer*. The joint must be completely packed with insulating material (filling, injecting) and the angle sealed with tape (buthyl, for instance) beneath the overlapping joint of the *vapour retarding layer* (nailed/clamped and bonded).

### C c

According to the Building Regulations and DIN 4102 T-4, party walls must have a fire-resistance class of F 30-B (interior) and F 90-B (exterior). These requirements can be met using *glued laminated beams* or *glued laminated timber* elements which are panelled accordingly on the outside (in contrast to the procedure adopted for House A). If this method is chosen, the construction must be inspected and a permit may have to be obtained. As an alternative to leaving an air space between the party walls, an elastic *insulating material* could be used here (e.g. building class A, melting point > 1000 °C).

🗌 d

It is necessary to establish the required acoustic reduction (required Rw = 57 dB or 67 dB for greater sound insulation). Sound insulation can be improved even more with an interior facing shell of *plasterboard panels* on spring shackles.

e

The expansion joint must extend to the outer edge of the *exterior wall*. The width of the non-flammable backfill insulation must be established in co-operation with the responsible authority. Products

### Products

### Timber

- 34 Solid wood
- 35 Structural solid wood
- 36 Glued laminated timber
- 37 Glued laminated beams
- 38 Boards/planks
- 39 Profile boards

### Manufactured Wood Products

- 40 Blockboard and laminated board
- 41 Three- and five-ply panels42 Laminated construction board
- 43 Parallel laminated veneer
- 44 Parallel strand lumber
- 45 Laminated strand lumber
- 46 Oriented strand board
- 47 Fibreboard
- 48 Flat-pressed boards
- 49 Extruded particle boards
- 50 Fibre-Reinforced cement boards

### **Building Boards**

- 51 Fibre cement boards
- 52 Plasterboard
- 53 Gypsum fibreboard

### Insulating Materials

- 54 Wood fibre
- 55 Bituminated fibreboard
- 56 Cork
- 57 Expandable polystyrene
- 58 Extruded polystyrene
- 59 Polyurethane
- 60 Mineral wool
- 61 Sheep's wool/cotton wool
- 62 Flax/hemp
- 63 Coconut fibre
- 64 Cellulose
- 65 Perlite/swelling clay

### Sheathing paper

- 66 Vapour retarding layer/vapour barrier
- 67 Damp-proofing
- 68 Product overview

### Joints and Fasteners

- 70 Dowels
- 71 Anchors/bolts
- 72 Screws/staples
- 73 Nails/Nail Plates
- 74 Sheet steel brackets
- 76 Wood preservation
- 78 Joint sealing tapes

### Timber Solid Wood



### Solid Wood

DIN 1052-1 DIN 4074-1 DIN 68365 **DIN EN 350-2** Thermal conductivity:  $\lambda_{\rm p} = 0.13$  W/mK Vapour diffusion resistance factor:  $\mu = 40$ Raw density: dependent on timber species  $\rho = 450 - 800 \text{ kg/m}^3$ Computation weight in accordance with DIN 1055-1:  $4 - 6 \, \text{kN/m^3}$ Building material classification: B 2 Thermal capacity:  $C = 350 \text{ kJ/m}^3\text{K}$ Wood moisture content: as dry structural wood < 20 % Amount of swelling and shrinkage per % change in wood moisture 0.24 % across the grain

Commonly used timber species

- spruce
- firpine
- larch
- Douglas fir

### Dimensions

Cross-section dimensions for square timber stock [cm]: 6/6, 6/8, 6/12, 8/8, 8/10, 8/12, 8/16 10/10, 10/12,10,20, 10/22 12/12, 12/14, 12/16, 12/20, 12/24 14/14, 14/16, 16/16, 16/18, 16/20, 18/22 20/20, 20/24 Length: depending on the sawing facilities of the sawmill: up to 16 m.

### Material

- Solid wood is debarked round timber and converted building timber (squared timber, planks, boards and laths) of softwood (coniferous wood) and hardwood (wood from deciduous trees).
- Structural timber is round wood or sawn timber. The cross-sections of load-bearing building elements are dimensioned in relation to the load-bearing capacity of the wood species in question.
- Converted building timbers are laths, planks and squared (softwood) timber. The following types of sawn timber are distinguished according to their thickness-to-width ratio:

	Thickness d	
	Height h [mm]	
Lath	d ≤ 40	b < 80
Board	d ≤ 40	b ≥ 80
Plank	d > 40	b > 3d
Squared timber	$b \le h \le 3b$	b > 40

### Use

Sawn softwood may be used in all areas of construction. When load-bearing timbers are used for external building elements, appropriate measures must be taken to preserve the wood (treatment with chemicals or structural reinforcement). In order to minimise fluctuations in wood moisture as well as the related negative consequences brought about by shrinkage and swelling, the moisture content of the wood used should correspond to its moisture content in service.

In-service moisture content:

Heated buildings enclosed on all sides  $9 \pm 3 \%$ Without heating  $12 \pm 3 \%$ Covered, open buildings  $15 \pm 3 \%$ Constructions exposed to the weather on all sides  $18 \pm 6 \%$  For invitations to tender and orders:

- Sawn wood species
- DIN
- Grade
- Wood species
- Sawn wood grade
- Wood moisture
- Thickness/height
- Width
- Length
- Calculated per m/m<sup>3</sup>

### Grading

Structural wood, which is dimensioned in relation to its load-bearing capacity, must be graded mechanically, in relation to its load-bearing capacity, prior to use.

- Depending on the grading procedure, the moduli of elasticity, raw density, knottiness and grain deviation are recorded and the sawn timbers graded. The mechanical grades are: MS 7, MS 10, MS 13, MS 17 (see appendix)
- When wood is graded visually, the following characteristics have to be considered: the wane, knots, annual-ring width, slope of grain, cracks, stains, compression wood, insect damage, mistletoe attack and warp. The visual grades are: S 7, S 10, S 13 (see appendix). The DIN standards S 7, S 10, S 13 correspond to the old quality classes I, II, III.

There is no difference between visual and mechanical grades with respect to loadbearing capacity.

### Sawn timber grades:

Sawn-wood grade	Grading	Permissible wane
S	-	-
A	S 13	1/8
В	S 10	1/3
С	S7	Saw-marked sides

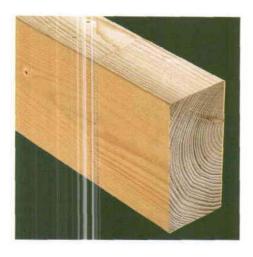
### Manufacturer(s)

Converted building timber is available directly from sawmills as dimensional timber (square timber stock) and can be ordered in a wide variety of cross-section dimensions and lengths.

### Information

Bundesverband Deutscher Holzhandel e.V.

Bund Deutscher Zimmermeister e.V. Lignum Proholz



### Structural Solid Wood

- DIN 1052-1 DIN 1052-1/41 DIN 4074-1 Thermal conductivity:  $\lambda_{\rm p} = 0.13$  W mK Vapour diffusion resistance factor:  $\mu = 40$ Raw density:  $p = 470 - 530 \text{ kg/m}^3$ Computation weight according to DIN 1055-1: 4-6 kN/m3 Building mater al classification: B 2 Wood moisture content:  $15 \pm 3\%$ Amount of sv elling and shrinkage per % change in wood moisture 0.24 % across the grain Wood species:
- spruce
- fir
- pine
- larch

Dimensions [n:rn]  $60 \times 120/140/160/180$   $60 \times 200/240$   $80 \times 120/140/160/200/240$   $100 \times 120/200$   $120 \times 120/200/240$ Length: with finger jointing any number of lengths is possible

### Material

Structural solid wood is a converted building pinewood which, due to its field of application, is subject to very stringent requirements. Its load-bearing capacity (S 10) and appearance are graded according to the DIN 4044-1 hardwood standard.

Additional requirements apply which go beyond DIN 4074-1 with respect to wood moisture content, dimensional stability/ size consistency, sawing method, limitation of crack width, and – in the case of visible building elements – surface quality.

### Identification

The product must display a kite mark. In addition, it must bear the kite mark of the Überwachungsgemeinschaft Konstruktionsvollholz aus deutscher Produktion e.V. (accreditation body for German solid structural wood products).

### Use

Structural solid wood is primarily used when the wood used has to fulfil strict requirements concerning its load-bearing capacity, appearance, dimensional accuracy and shape retention. In wooden house construction, structural solid wood is used primarily in the construction of fully insulated structures,

As the wood has a moisture content of  $15 \pm 3$  %, it need not be treated with chemical preservatives,

- For invitations to tender and orders:
- · Structural solid wood
- Identification
- Wood species
- Thickness/height
- Width
- Length
- Surface
- Calculated per m/m<sup>3</sup>

### Manufacture

Wood finishes are categorised according to use:

- structural solid timber for visible structures (planed and chamfered)
- structural solid timber for concealed structures (levelled and chamfered, with the heart plank removed)

In both cases, finger jointing is permissible as spring-actuated longitudinal jointing. This type of jointing does not weaken the cross section of the wood and need not be taken into account during stress detection,

In the case of visible structural solid timber, a heart-free cut is obligatory for cross sections of up to 100 mm. This is made by removing a 40 mm-thick heart plank. A heart-free cut is obligatory for all other cross-sectional thicknesses and for the entire range of visible structural solid woods.

### Manufacturer(s) (selection)

Ante-Holz GmbH Eugen Decker Holzindustrie Ambros Fichtner Holzwerk Anton Heggenstaller AG Anton Hess GmbH+Co KG Hülster-Holz GmbH & Co.KG Johann Kirchhoff GmbH Merkle Holz GmbH Rettenmeier GmbH & Co.KG Holz Schmidt GmbH Schollmayer Holz GmbH Matthäus Sturm GmbH Holzwerke Wimmer GmbH

### Information

Überwachungsgemeinschaft Konstruktionsvollholz aus deutscher Produktion e.V. Bund Deutscher Zimmermeister e.V. Bundesverband Deutscher Holzhandel e.V.



### **Glued Laminated Timber**

DIN 1052-1/A1 EC 5 DIN 4074-1 Thermal conductivity:  $\lambda_{\rm p} = 0.13$  W/mK Vapour diffusion resistance factor:  $\mu = 40$ Raw density - depending on the wood species:  $\rho = 450 - 800 \text{ kg/m}^3$ Building material classification: B 2 Computation weight in accordance with DIN 1055-1: 4 to 5 kN/m<sup>3</sup> Wood moisture content: 8-12 % Amount of swelling and shrinkage per % change in wood moisture: 0.24 % across the grain

### Wood species:

- spruce, fir, larch
- Douglas fir, Western hemlock,
- Southern pine, Yellow cedar

### Types of glue:

Urea-formaldehyde resin (UF) Melamine modified urea-formaldehyde resin (MUF) Phenol resorcinol resin (PRF) Polyurethane (PU)

### Dimensions

Recommended width [cm]: 8–22 Height [cm]: up to 200 The height-to-width (h/w) ratio of 1/10 must not be exceeded Length [m]: up to 30. Overlengths or up to 50 m are possible (check for transportability)

### Material

Glue-laminated timber is a modified solid wood in which the weakening influence of growth-related defects has been largely cancelled out.

Glued laminated timber is composed of at least three sheets of softwood timber glued under pressure, parallel to the grain, to create stable building elements.

Glued laminated timber grades

Glued laminated	Grade of
timber grade	laminates
BS 11	S 10, MS 10
BS 14	S 13
BS 16	MS 13
BS 18	MS 17

### Use

Synthetic resin glues with a urea-formaldehyde resin basis may be used for nonwater-resistant gluing. The glued joint is light in colour and barely distinguishable from the wood.

If water-resistant gluing is required, synthetic resin glues with a phenol, resorcin, melamine or polyurethane basis must be used. Phenol and resorcin resins are identifiable by the dark-brown glued joints they make, whereas modified melamine resins are light to chocolate-brown in colour. Polyurethane joints are light and transparent.

Glued laminated timber that is exposed directly to the vicissitudes of the weather requires additional chemical treatment with oleaginous wood preservatives. For invitations to tender and orders:

- Wood species
- Glued laminated timber grade
- Width, height, length
- Gluing
- Surface
- Wood preservation measures
   Calculated per m<sup>3</sup>

### Manufacture

The individual laminates used to make glued laminated timber must be at least 6mm thick and not exceed 33 mm. Straight building components may be 42 mm thick provided that they are not subject to extreme, climatically induced load changes.

The laminates are dried and planed. All natural defects such as excessively large knots and pieces of bark are removed mechanically. Abutments are staggered and glued as finger joints and clamp pressed.

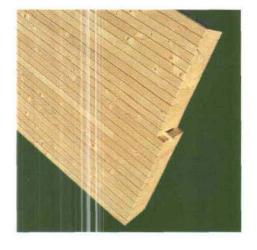
Load-bearing components may only be manufactured by authorised enterprises. These components must be clearly identified with kite marks.

Manufacturer(s) (selection) Achberger Ingenieur Holzbau GmbH Grossmann Bau GmbH Haas Fertigbau GmbH Härle Karl GmbH Kaufmann Holzbauwerk Maier Holzbau GmbH Merk Holzbau GmbH Zeh Ulrich GmbH&Co.KG

### Information

Deutsche Gesellschaft für Holzforschung e.V. DGfH Studiengemeinschaft Holzleimbau e.V. Gütegemeinschaft BS-Holz e.V. Otto-Graf-Institut

### Timber Glued Laminated Beams



### **Glued Laminated Beams**

### Non-standarcised

They may only be used if permission is granted on the basis of the local Building Regulations in each individual case.

Thermal concluctivity:  $\lambda_{\rm p} = 0.13$  W/mK Vapour diffus cn resistance factor: u = 40 Raw density:  $\rho = 450 - 800$  kg/m<sup>3</sup> depending on the wood species used Computation weight in accordance with DIN 1055-1:  $4-5 \text{ kN/m}^{3}$ Building material classification: B 2 Thermal capacity:  $C = 350 \text{ kJ/r}^3 \text{K}$ Wood moisture content:  $15 \pm 3\%$ Amount of swelling and shrinkage per percentage change in wood moisture 0.24 % across the grain

Dimensions Beam height [cm]: Walls 6.8~12 Floors/ceilings 12-24

### Material

Glued laminated beams are solid, flat, building elements. They are composed of layers of boards or planks connected to each other with nails or hardwood drift bolts. The quality of the original material is not subject to particularly high minimal requirements. Laminations of grades S7/S10 are sufficient. Side boards can be used. Although there are no obligatory lamination thicknesses, the customary sawmill thicknesses of 24–32 mm, or up to 60 mm in special cases, are recommended. Boards and planks with thicknesses between 32 mm and 45 mm are often used for visible structures.

### Use

Floors, ceilings, roofs, (both bearing and non-bearing) can be constructed with glued laminated beams. The individual beams are used vertically in the wall elements.

Additional measures can be taken if diaphragm action is desired.

Solid wooden elements have a far higher storage capacity and therefore provide better thermal insulation during the summer months than wooden framework wall constructions.

The individual elements are connected with groove-and-tongue joints, rebates or flat steel connections. Swelling and shrinkage must be taken into consideration when selecting element widths. In order to avoid swelling, the wood must be effectively weatherproofed to protect it during transport, storage and installation.

This system, which has a high load-bearing capacity, allows for extremely slender cross sections. A variety of composite construction systems involving the use of concrete are available on the market. For invitations to tender and orders:

- Manufacturer
- Wood species
- Thickness/width/length
- Surface
- Calculated per m/m<sup>2</sup>

### Manufacture

Glued laminated beams are generally prefabricated. After the laminations have been dried to a wood moisture content of  $15 \pm 3$  % they are levelled, arranged close together lengthways, and glued with staggered joints in a continuous process. Laminations of the same thickness and width are used. The coupling force can be transferred to the lamination joints by using more nails, or by gluing or finger jointing. The joint can be strengthened by using profiled boards on the faces.

Floor/ceiling openings and other openings must be taken into consideration when manufacturing glued laminated beams.

The elements can be prefabricated in lengths of up to 2.40 m, depending on transportability. Lengths should not exceed 12 m.

Manufacturer(s) (selection) Bau-Barth-Holzbauelemente Holzbau Becke & Sohn GmbH Hiwo Holzindustrie Waldburg zu Wolfegg GmbH & Co. KG Rudolf Janssen GmbH & Co. KG Kaufmann Holzbauwerke Kaufmann Massivholz GmbH Kobus

*Information* Fachagentur Holz Bund Deutscher Zimmermeister



## **Boards/Planks**

DIN 4071-1 DIN 4071-1 Thermal conductivity:  $\lambda_{_{\rm R}}=0.13~W/mK$ Vapour diffusion resistance factor: u = 40Raw density:  $\rho = 350-500 \text{ kg/m}^3$  depending on the wood species used Computation weight in accordance with DIN 1055-1: 4-6 kN/m3 Building material classification: B2 Thermal capacity:  $C = 350 \text{ kJ/m}^{3}\text{K}$ Wood moisture content: Equivalent to equilibrium moisture content < 20 % Amount of swelling and shrinkage per % change in wood moisture 0.24 % across the grain Wood species: · spruce, fire, pine · larch, Douglas fir · Northern softwood species for planed assortments

#### Dimensions

Thickness, unplaned [mm]: 16, 18, 22, 24, 28, 38, 44, 48, 50, 63, 70, 75 Thickness, planed [mm]: 13.5, 15.5, 19.5, 25.5, 35.5, 41.5, 45.5 Thickness, northern woods, planed [mm]: 9.5, 11, 12.5, 14, 16, 22.5, 25.5, 28.5, 40, 45 Width [mm]: 75, 80, 100, 115, 120, 125, 140, 150, 160, 175 Length [mm]: 1,500-6,000 Gradations [mm]: 250, 300

#### Material

Unplaned softwood boards and planks are parallel square-edged materials. Planed softwood boards and planks are planed smooth on one side and processed to an even thickness on the back. The edges are neither planed nor profiled.

## Use

Unplaned and planed boards and planks are used for shuttering, external cladding and the most diverse areas of construction. When boards and planks are used for structures that have to be dimensioned in relation to load-bearing capacity, they must meet the requirements of DIN 1052 and be graded in accordance with DIN 4074-1. If the boards do not have to perform a loadbearing or reinforcing function, there is no necessity under German building regulations to take preventive measures to preserve the wood.

It is advisable to use load-bearing lathing with a cross section of  $30 \times 50$  mm (minimum cross section  $24 \times 48$  mm) to affix the cladding. These cross sections are available as dry wood from trade stores; cross sections with an average moisture content of  $15 \pm 3$  % can also be obtained by invitation to tender.

Visible joints and fastenings for external use must be made of galvanised steel or – better still – chromium-nickel stainless steel.

The spacing of the load-bearing lathing depends on board thickness:

Board thickness [mm]	Lathing spacing
18.0	400-550
19.5	500-700
22.0	550-800
24.0	600-900
25.5	700-950
28.0	800-1,050

## For invitations to tender and orders:

- Classification
- DIN
- Grading
- Wood species
- Thickness
- Width
- Length
- Calculated per m²/m³

#### Manufacture

Boards and planks are sawn from round timber in sawmills or milled in planing mills and then planed, if necessary. Their dimensions and thickness-to-width ration are their distinguishing features.

	Thickness (t)	Width (w)		
	[mm]	[mm]		
Board	t ≤ 40	w ≥ 80		
Plank	t > 40	w > 3t		

If boards are to be used externally, they must be treated with a preventive structural wood preservative. Careful planning and execution are essential.

If boards are exposed to weather, they should not be made of pine as it invariably has sap rot and blue stain. Their sap is particularly susceptible to wood-decaying and wood-staining fungi, which not only damage the wood but also cause paint failure.

To avoid changes in form in internal areas, the wood moisture content must be stated when placing orders. It is advisable to ventilate the wood cladding.

#### Manufacturer(s)

Boards and planks, both planed and unplaned, can be obtained from a variety of sawmills and planing mills.

*Information* Lignum



## **Profile Boards**

DIN 4072 (matched boards) DIN 68122 (matched fibreboards) DIN68123 (metatherboards) DIN 68126-1+3 (profile boards with broad root and chamfer)

# Dimensions

Matched boards: Thickness (European) [mm]: 15.5, 19.5, 22.5, 35.5 Width [mm]: 95, 115, 135, 155 Thickness (northern) [mm]: 19.5, 22.5, 25.5 Width [mm]: 96, 111, 121

## Matched fibreboards: Thickness (European) [mm]: 15.5, 19.5 Width [mm]: 95, 115 Thickness (northern) [mm]: 12.5 Width [mm]: 96, 111

Weatherboards: Thickness (European) [mm]: 19.5 Width [mm]: 115, 135, 155 Thickness (northern) [mm]: 19.5 Width [mm]: 111, 121, 146

Profile boards with broad root and chamfer Thickness (European) [mm]: 12.5, 15.5, 19.5 Width [mm]: 93, 115 Thickness (northern) [mm]: 12.5, 14, 19.5 Width [mm]: 1,2.5, 14, 19.5

Length (European) [mm]: 1,500-4,500 gradations 250 (increments) 4,500-6,000 gradations 500 Length (northern) [mm]: 1,800-6,000 gradations 300

#### Material

Matched boards are boards with grooves and planed tongues.

Softwood matched boards are boards with planed tongues and grooves, chamfered to an angle of less than 45° on the upper side.

Softwood weatherboards are boards with planed tongues and grooves, and a concave-rounded edge on the tongue side.

Softwood profile boards with broad root and chamfer are boards with tongues, planed grooves and chamfered edges on the visible face and a wide tongue on the face side.

#### Use

Matched and profile boards are used to panel both interiors and exteriors. Any building boards that have to be dimensioned in relation to their load-bearing capacity must meet the requirements of DIN 1052 and be graded in accordance with DIN 4074-1.

#### Manufacture

Designation
DIN
Grade
Wood species
Thickness
Width
Length

Calculated per m<sup>2</sup>

Planed and profile woods are sawn from round timber in sawmills and then milled and planed in planing mills.

For invitations to tender and orders:

In addition to the forms and dimensions covered by DIN, other profiles and dimensions can be obtained from the manufacturer – depending on the tools and equipment at the manufacturer's disposal. Planing mills make profile boards on request and sell them through trade stores.

# Manufacturer(s) (selection)

The assortment of profile boards available from trade stores varies considerably due to the great range of types and shapes.

Information Bundesverband Deutscher Holzhandel e.V.

## Manufactured Wood Products Blockboard and Laminated Board



#### Blockboard and laminated board

DIN 68705-2 Thermal conductivity:  $\lambda_{\rm p} = 0.15$  W/mK Vapour diffusion resistance factor:  $\mu = 50/400$ Raw density:  $\rho = 400 - 800 \text{ kg/m}^3$ Computation weight in accordance with DIN 1055-1: 4.5-6.5 kN/m3 Building material classification: R2 Material class: 20.100 Emission class: E 1 Wood moisture content: 5 < 15 % Amount of swelling and shrinkage per % change in wood moisture content: 0.020 %

Wood species:

- spruce
- fir
- pine

# Dimensions Thickness [mm]: 13, 16, 19, 22, 25, 28, 30, 38 Length [mm]: 1,220, 1,530, 1,830, 2,050, 2,500, 4,100 Width [mm]: 2,440, 2,500, 3,500, 5,100, 5,200, 5,400

## Material

Formerly known as core plywood, blockboard consists of a core layer of solid wood board-shaped strips that are glued together. The width of the strips varies from approx. 24 mm to a maximum of 30 mm. A face veneer (three-ply board) or a cross-band veneer and a face veneer (five-ply board) is fixed to each side, with the grain running perpendicular to that of the adjacent layer.

Laminated boards are composed of a middle core of perpendicular rotary-cut veneers (strips) that are glued together. The veneers are 5–8 mm thick. A face veneer, or a cross-band veneer and a face veneer, are fixed to each side. The grain of each sheet runs perpendicular to that of the adjacent one. All glues with an assured adhesive strength are permissible.

In the case of blockboard, the glued wooden core is composed of softwoods (primarily spruce) to ensure a more stable form, whereas softer or harder hardwoods are generally chosen for cross-band veneers and face veneers. The same wood species can be used for both wooden core and veneer plywood, alongside the customary indigenous softwoods and hardwoods. A number of tropical woods are also used for the cores and for cross-band and face veneers, rounding off the customary indigenous softwoods and hardwoods available.

## Use

Blockboards and laminated boards are primarily used in the manufacture of furniture, as well as in laboratory and stair construction. However, they are rarely used in timber engineering.

## For invitations to tender and orders:

- Manufacturer
- DIN
- Panel type
- Wood species
- Emission class
- Thickness
- Width
- Length
- Surface
- Calculated by m<sup>2</sup>

#### Manufacture

In general, 24 mm-thick softwood boards that have been carefully dried to a wood moisture content of approx. 6–8 per cent are considered suitable for the manufacture of block cores. These boards are cut into laths with multi-blade circular saws so that the lath width corresponds to the thickness of the inner core. The laths are then glued together with casein, polyvinylacetate or urea-formaldehyde resins to form boards and pressed.

DIN 68705-4 refers to structural blockboard and core-stripe blockboard as plywoods with defined, monitored elastomechanical properties. They are used in building construction (e.g. for reinforcement),

In the manufacture of the core, rotary cut veneers 5–8 mm thick are glued in layers parallel to the grain to create blocks. These are then sawn at right angles to the level of the single plies to make boards. In both manufacturing processes, the cross-band and face veneers are glued to the inner plies with the same glues and pressed.

Manufacturer(s) (selection) Pfleiderer



## Three- and Five-Ply Panels

German building authority certification: Z-9.1-242 Z-9.1-258 Z-9.1-376 Z-9.1-404 Z-9.1-477 Thermal conductivity:  $\lambda_{\rm B}=0.14~{\rm W}\,{\rm rnK}$ Vapour diffusion resistance factor:  $\mu = 50/400$ Raw density:  $\rho = 400 - 500 \text{ kg/m}^3$ Building material classification: B2 Material class: 20, 100, 100 G Emission class: F 1 Wood moisture content:  $12 \pm 2\%$ Amount of svielling and shrinkage per % change in wood moisture content: 0.020 %

Wood species

- spruce
- larch
- Douglas fir

Material

The panels consist of three or five layers of softwood, each glued at right angles to the adjacent ply. Melamine modified urea-formaldehyde and phenolic resin are used as glues.

Since the thicknesses of the single plies vary according to type and manufacturer, the elasto-mechanical properties of panels of equal thickness can also differ considerably.

#### Application(s)

Depending on glue type and the wood preservative (if any), the panels can be employed wherever panels of wood classes 20, 100 and 100 G are allowed under both the German Building Regulations and DIN 68800-2.

Once permission has been granted, the multi-ply panels can be used as effective and as reinforcing planking in manufacturing wall, ceiling and roof panels for wooden houses that are erected as panel construction systems in accordance with DIN 1052-3.

Depending on the type of permit granted, these panels can sometimes be used in place of laminated construction board as per DIN 1052-1,

If the edges are carefully covered or sealed for protection, they can also be used for large ventilated facades. Invitations to tender and orders:

- Manufacturer
- Certification number
- Panel type
- Wood species
- Wood preservation measures
- Thickness
- Width
- Length
- Surface
- Calculated per m<sup>2</sup>

# Manufacture

In the case of softwood plies glued at right angles to one another, at least 90 per cent of the single sheets must be grade S10 (DIN 4074-1) and the remaining sheets at least grade S7.

The surface veneers must be at least 4-9 mm thick, and those of the inner plies 4-50 mm.

Dimensions Thickness (three-ply) [mm]: 12–75 Thickness (thre-ply) [mm]: 33–80 Length [mm] 2,500–6,000 Width [mm]: 1,000–4,750

Manufacturer(s) (selection) Dold Süddeutsche Sperrholzwerke Gmach Holzbauwerke Haas Fertigbau GmbH Kaufmann Holzbauwerk Pröbstel Holzwerke

## Manufactured Wood Products Laminated Construction Board



## Laminated Construction Board

DIN 68705-3 German building authority certification: Z-9.1-43 Z-9.1-6 Z-9.1-7 Thermal conductivity:  $\lambda_{\rm p} = 0.15$  W/mK Vapour diffusion resistance factor:  $\mu = 50/400$ Raw density:  $\rho = 450 - 800 \text{ kg/m}^3$ Building material classification: B2 Wood moisture content: 5-15% Amount of swelling and shrinkage per % change in wood moisture content: Thickness: 0.25-0.35 % Length/width: 0.01-0.02 %

Wood species (selection):

- spruce
- pine
- Clear pine
- · Douglas fir
- Hemlock
- Southern pine
- mahogany
- Cherry mahogany

## Panel types:

Laminated construction board 20 Laminated construction board 100 Laminated construction board 100 G

Dimensions

Thickness [mm]: 8, 9, 10, 12, 15, 18, 20, 21, 24, 25, 40 Formats [mm]: 2,500/3,000 × 1,250/1,500 2,400/3,050 × 1,200/1,525

#### Material

Laminated construction board is made by arranging and gluing alternate veneers perpendicular to one another. Urea resin is used to glue the veneers of laminated construction board 20, whereas waterresistant, alkaline hardening / phenolic resin, phenol-formaldehyde resin, and resorcinol resin are used for laminated construction board 100 and 100 G. All other glues must be certified by the building authorities.

#### Application(s)

Laminated construction board is mostly used as effective, reinforcing panelling for walls, ceilings and roofs. For the required panel type, which depends on the panel's position in the building component, please refer to DIN 68800-2.

Panel typePanel moisture<br/>in serviceLaminated construction board 20 $\leq 15 \%$ Laminated construction board 100 $\leq 18 \%$ Laminated construction board 100G $\leq 21 \%$ 

#### Manufacture

Laminated construction board is made from the same wood species as normal plywood. However, light species of tropical wood such as limba and obeche may not be used.

Beech laminated construction board, as per DIN 68705-5, consists of three to nine veneers, each 1.5–3.2 mm thick (from wood classes 100 and 100 G). It is used, in particular, for building elements subjected to great static loads.

Beech laminated construction board (100 G) panels are either made of sapclear wood corresponding to at least resistance class 2 as specified in DIN 68364 (e.g. oak, mahogany, cherry mahogany) or from another wood species Invitations to tender and orders:

- Laminated construction board
- DIN 68705
- Certification number
- Panel type
- Emission class
- Thickness, width, length
- Surface finish
- Calculated by m<sup>2</sup>

bonded with a glue liquor to which a wood preservative has been added. If a chemical wood preservative is required because the species used has a low resistance class, a wood preservative designed to eliminate destructive fungi (basidiomycetes) must be added to the glue liquor when the panels are being manufactured.

The panels must bear the following permanent identification:

- Kite mark
- DIN certification number
- External quality control stamp
- Panel type
- Emission class
- Thickness

Manufacturer(s) (selection) Blomberger Holzindustrie Bruynzeel Multipanel GmbH Dold Süddeutsche Sperrholzwerke Finnforest Oy Glunz AG Hess & Co. AGT ROHOL Rosenauer R.O.L. Rougier Océan Landex Schaumann Wood Oy Teuteburger Sperrholzwerk Westag & Getalit AG

#### Information

American Plywood Ass. (APA) Cofi Canadian Plywood Association Council of Forest Industries of British Columbia Finnish Plywood International Güteschutzgemeinschaft Sperrholz e.V. Lignum Proholz Verband der Deutschen Holzwerkstoffindustrie e.V.



## Parallel Laminated Veneer

German building authority certification: Z-9,1-100 Z-9,1-291 Z-9,1-245 Thermal conductivity:  $\lambda_{\rm H} = 0.15$  W/mK Vapour diffusion resistance factor:  $\mu = 50/400$ Raw density  $\rho = 400-80$  C kg/m<sup>3</sup> Building material classification: B 2 Emission class: E 1

Wood species:

- spruce
- pine (kerto
- · Douglas fir
- Southern pre (microlam)

## Dimensions: Kerto-S vericers are used for load-bearing, rod-shaped structural members. Thickness [mm]: 21-69Max, dimensions [mm]: $1,820 \times 26,000$ Kerto-Q veneers are used for panels and plates. $h \le 1,800$ Thickness [mm]: 21-75Max, sizes [mm]: $1,820 \times 23,000$

## Material

Parallel laminated veneer is a multi-ply wood-based material. In contrast to plywood, its veneers are generally arranged parallel to the grain and glued watertight with phenol-formaldehyde resin. If broad widths are required, plies are also arranged crosswise to increase stability. When wood class 100 G veneers are glued together, the single sheets are impregnated with a wood preservative to for protection against destructive fungi.

#### Application(s)

Parallel laminated veneer may be used in all areas of work in which glued laminated timber is permitted. Owing to the high loads it is permitted to

bear, parallel laminated veneer can also be used for reinforcing the following structural elements: purlins and other girders subject to bend-

ing, girders at the point of support, loadbearing plates, connecting plates, etc.

The presence of cup shakes in the veneers makes it relatively easy to impregnate parallel laminated veneer with aqueous wood preservatives across its entire cross-sectional area. As a result, it can be used in areas exposed to the weather (e.g. external use for roof panels).

Invitations to tender and orders:

- Manufacturer
- Certification number
- Type of parallel laminated veneer
- Thickness, width, length
- Wood preservation measures
   Calculated by m<sup>s</sup>

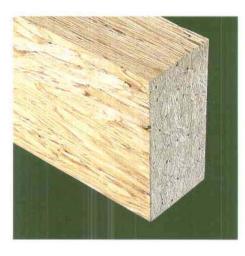
#### Manufacture

In the manufacture of parallel laminated veneer, softwood logs are de-barked, soaked in water and stripped to make 3 mm-thick veneers, which are then cut into dimensioned sheets and dried. Large defective areas are removed, as are veneers that are too light, moist or misshapen. The veneers, which are provided with staggered joints, are then glued with phenol-formaldehyde resin parallel to the grain, placed on top of one another and pressed to form a panel.

The large panels thus created can be sawn to the desired panel or beam size.

Manufacturer(s) (selection) Merk Holzbau GmbH Finnforest OY Trus Joist Mac Millan

## Manufactured Wood Products Parallel Strand Lumber



## Parallel Strand Lumber

German building authority certification: Z-9.1-241 Thermal conductivity:  $\lambda_{\rm R} = 0.15$  W/mK Vapour diffusion resistance factor:  $\mu = 50/400$ Raw density:  $\rho = 670$  kg/m<sup>3</sup> for Douglas fir  $\rho = 720$  kg/m<sup>3</sup> for southern yellow pine Building material classification: B 2 Material class: 100, 100G

#### Wood species:

- Douglas fir
- Southern pine

#### Material

Parallel Strand Lumber (PSL) consists of strands approximately 16-mm wide and 3.2 mm thick. These are aligned parallel to the longitudinal axis of the beam and glued with waterproof phenol-formaldehyde resin. The graded strands are glued to create 483 mm-thick panels and then sawn into beams.

Currently, PSL is only manufactured in the USA.

Paraffin is applied to give the lumber a water-repellent finish.

Owing to the natural resistance of the two wood species used (resistance class 3 in accordance with DIN 68364), no wood preservatives are added.

#### Application(s)

Parallel Strand Lumber can be used for all work in which glued laminated timber is permitted unless otherwise certified. Parallel Strand Lumber has material properties very similar to those of glued laminated timber; its advantages lie in its considerable flexural, compression and shearing strengths.

The adhesive bond is weather resistant, but weather exposure causes the wood to turn grey. Invitations to tender and orders:

- Certification number
- Wood species
- Thickness
- Width
- Length
- Calculated by m<sup>3</sup>

#### Manufacture

After being soaked and steamed, the logs are peeled to create veneers 2.5-3.2 mm thick. The strands are then dried to obtain a 9-10 per cent moisture content and cut into 45-260 cm-long strips. After the defects have been extracted, the strands are glued with phenol-formaldehyde resin and pressed in continuously operating press. Afterward, they are cured in a microwave process.

The veneer strands are arranged parallel to one another with their ends staggered. During the pressing process, the material is compressed to increase its raw density to a value slightly higher (approx. 15 per cent) than that of the original wood. As there are gaps between the strands, cavities are visible, especially at the ends. The resulting 20 m-long section is then cut to the desired lengths.

Dimensions: Width [mm]: 44–280 Height [mm]: 44–483 Length [m]: up to 20



# Laminated Strand Lumber

German building authority certification: Z 9.1-323 Thermal conductivity:  $\lambda_{\rm p} = 0.14 \,\mathrm{V/mK}$ Vapour diffusion resistance factor:  $\mu = 50/400$ Raw density  $\rho = 600 - 700 \text{ kg/m}^3$ Building material classification: B 2 Material class 100 Emission class: E 1 Wood moisture content: 15 %

Wood species: poplar

Glues: Polyurethar e adhesive

# Application(s)

Laminated Strand Lumber may be used for all areas of work in which glued laminated timber is permitted in accordance with DIN 1052-1 and in which laminated construction board is permitted in accordance with DIN 68705-3. The wood is preserved in the same way as glued laminated timber.

# Invitations to tender and orders:

- Manufacturer
- Certification number
- Panel type
- Wood species
- Gluing
- Emission class
- Thickness
- Width
- Length

Calculated by m<sup>2</sup>

# Manufacture

Laminated Strand Lumber consists of approx.  $1.0 \times 25 \times 300$  mm-long poplar chips which are glued together with formaldehyde-free polyurethane resin (PMDI).

After being bonded in a mixer, the chips are aligned in their original grain flow. The mass is pressed under heat and then separated and ground.

Long-chip wood is manufactured in two grades: Intraliam S and Intraliam P.

Dimensions: Thickness [mm]: 32-89 Format [mm]: max, 2,438 × 10,700

Manufacturer(s) (selection) Trus Joist MacMillan Manufactured Wood Products Oriented Strand Board



## **Oriented Strand Board (OSB)**

DIN EN 300 German building authority certification: Z-9.1-275 Z-9.1-326 Thermal conductivity:  $\lambda_{\rm p} = 0.13$  W/mK Vapour diffusion resistance factor:  $\mu = 50/100$ Raw density (depending on wood species):  $\rho = 600 - 660 \text{ kg/m}^3$ Computation weight in accordance with 1055-1: 5-7.5 kN/m<sup>3</sup> Building material classification: R 2 Material class: 100 Emission class: E 1 Wood moisture content: 5-6% Amount of swelling and shrinkage per % wood moisture content: 0.035 %

Wood species:

- pine
- Clear pine
- Douglas fir
- Oregon pine
- alder
- poplar

Dimensions Thickness [mm]: 6, 8, 9, 10, 11, 12, 13, 15, 18, 22, 25, 30 Formats [mm]: 2,500/5,000 × 1,250 5,000 × 2,500 2,440 × 1,220 2,620 × 1,250/5,000

## Material

OSB (oriented strand board) is composed of aligned strands. Owing to the alternating, cross-alignment of the strands, oriented strand boards – like plywood – have mechanical properties. Excellent mechanical properties have been obtained (two to three times those of normal chipboard types) by machinecutting the wood parallel to the grain.

A variety of glues is used for bonding: phenol resin, polycarbamide (isocyanate), MUPF (Kauramin) surface glue, and PMDI core resins. All these resins are waterproof.

#### Application(s)

Typical areas of application: OSB flat-pressed boards may be used for all work where class 100 wood-based materials are permitted under the local Building Regulations. It may be used for panelling, with weather proofing, the exterior of load-bearing/ reinforcing walls. Invitations to tender and orders:

- Manufacturer
- Certification number
- Panel type
- Emission class
- Thickness, Width, Length
- Surface

Calculated by m<sup>2</sup>

#### Manufacture

Large coarse rectangular chips (ca.  $35 \times$ 75 mm, thickness 0.6 mm) are used to manufacture OSB boards. The flat chips are obtained by peeling and crushing veneers or by using a chipper. They are then sieved, graded, dried, glued, spread out and aligned. The strands are arranged crosswise in three or five layers, depending on the required board thickness. In the case of three-ply boards, the core (comprising 50 per cent of the whole) is generally laid crosswise, whilst the grain of the surface sheets (accounting for 25 per cent each) generally runs parallel to the machined length. Once the strands have been aligned, the sheets are pressed under heat. After they have cooled, they are formatted and ground.

Manufacturer(s) (selection) CSC Forest Products (Sterling) Ltd. Glunz AG Kronospan Ltd.&Cie,

Information Verband der Deutschen Holzwerkstoffindustrie (VHI)



# Fibreboard

DIN 68754-1 Thermal conductivity:  $\lambda_{\rm p}=0.065-C.17~W/mK$ Vapour diffusion resistance factor:  $\mu = 5 - 70$ Raw density:  $\rho = 350 - 1100 \text{ kg/m}^3$ Computation weight in accordance with DIN 1055-1: 9-11 kN/m Building material classification: B2 Material class: 20 (100 with certification) Emission class: E1 Wood moisture content:  $5 \pm 3\%$ Amount of swelling and shrinkage per % change in wood moisture content: < 20 % in thickness

Wood species:

- spruce
- pine
- fir
- beech
- poplar
- birch

Glues:

Urea-forma dehyde resinsPhenol-formaldehyde resin

Dimensions: Thickness [mm]: 5–16 Width [mm]: up to 2,100 Length [mm]: up to 5,500

## Material

Fibreboards are panel-shaped materials made of fibrous – primarily wood – particles.

The particles are combined under heat, with or without glue or additives. Pressure may be applied.

Fibreboards can be manufactured as single- or multi-ply boards in a wet process without bonding agents or in a dry process using bonding agents.

Depending on their raw density they are subclassified as:

- Porous fibreboards, not bituminated
- · Bituminated porous fibreboards
- Hardboard and medium-density wood fibreboards for the construction industry
  for interiors and furniture
- Other types of wood fibreboard are also available, e.g. medium-density fibreboards.

Soft fibreboard: see insulating materials.

## Application(s)

According to DIN 1052-3, the use of fibreboards as effective and reinforcing boards in the manufacture of wall, ceiling and roof panels is restricted to wooden houses built as panel construction systems.

They may also be used in rooms with a low moisture content, i.e. in areas where wood class 20 is used and in areas in which wood class 100 is permitted by the local Building Authority. Invitations to tender and orders:

- Manufacturer
- DIN
- Certification number
- Panel type
- Gluing
- Emission class
- Thickness
- Width
- Length

Calculated by m<sup>2</sup>

## Manufacture

In the manufacture of wood fibreboards. the wood chips are placed in a reaction tank known as a defibrator, steam-treated and then defibrated mechanically with grinding plates. This approach primarily exploits the matting properties of the fibres and their natural adhesive strength. The latter can be increased by adding bonding agents and water-repellents as well as by thermal and other treatments. The various manufacturing processes differ mainly in the technique employed to produce the fibrous material and the fibrous mat. These processes are referred to as wet or dry processes, depending on whether the fibrous material is transported or formed in a wet or dry process.

Manufacturer(s) (selection) Euro MDF Board Gutex Hornitex Kunz GmbH & Co Odenwald Faserplattenwerk Pavatex Wilhelmi Werke GmbH & Co KG

## Manufactured Wood Products Flat-Pressed Boards



#### Flat-Pressed Boards (FP)

- DIN 68763 Thermal conductivity:  $\lambda_{ii} = 0.13 \text{ W/mK}$ Vapour diffusion resistance factor:  $\mu = 50/100$ Raw density:  $\rho = 550 - 700 \text{ kg/m}^3$ Computation weight in accordance with DIN 1055-1: 5-7.5 kN/m<sup>3</sup> Building material classification: B 2 Material class: 20, 100, 100 G Emission class: E1 Wood moisture content: 5 < 12 % Amount of swelling and shrinkage per % change in wood moisture content: 0.035 %
- Wood species:
- SoftwoodHardwood
- Hardwoo

#### Glues:

- Urea-formaldehyde resins
- Melamine modified urea-formaldehyde
- Phenol resin
- PMDI

## Dimensions Thickness [mm]: 4, 8,10, 13, 16, 19, 22, 25, 28, 38 Formats [mm]: 1,250 × 2,500, 1,250 × 5,000, 4,100 × 1,850, 2,710 × 2,080, 2,750/5,300 × 2,050 Lengths of up to 14,000mm are available

#### Material

Flat-pressed boards are panel-shaped wood-based materials that are made by bonding and pressing particles of wood or wood-like fibrous materials. Depending on the gluing procedure and wood preservatives, the panel types can be classified as follows:

#### • V 20

This resin is only suitable for rooms where humidity is generally low, as it is not resistant to atmospheric corrosion, Glues: aminoplasts, alkaline-hardened phenolic resins, polymeric diphenyl methylene diisocyanate (PMDI).

## • V 100

For use in humid rooms. Glues: alkaline-hardened phenolic resins, phenol-resorcinol resins, PMDI.

#### • V 100 G

Also durable in highly humid environments; protected against destructive fungi by a wood preservative. Glues: alkaline-hardened phenol resorcinol resins, PMDI.

#### Application(s)

Flat-pressed boards manufactured for the construction industry are primarily used as effective, reinforcing panelling for walls, floors, ceilings and roofs, Panel selection depends on the intended use in these building elements. Information may be found in DIN 68800-2 (see appendix).

## Invitations to tender and orders:

- Manufacturer
- DIN 68763
- Panel type
- Gluing
- Emission class
- Thickness
- Width
- Length
   Calculated by m<sup>2</sup>

#### Manufacture

Flat-pressed boards are manufactured by bonding and pressing relatively small wood chips, which are ideally aligned parallel to the board surface. These boards are generally manufactured as homogenous multi-ply panels.

Manufacturer(s) (selection) Glunz AG Hornitex Kunz GmbH Pfleiderer Industrie Schlingmann GmbH & Co.

Information Verband der Deutsche Holzwerkstoffindustrie e.V.



# Extruded Particle Boards

DIN 68764-1.2 Thermal conductivity:  $\lambda_{\rm p} = 0.17 \text{ W/rhK}$ Vapour diffusion resistance factor:  $\mu = 20$ Raw density:  $\rho = 450 - 70$  ) kg/m<sup>3</sup> Computation weight in accordance with 1055-1: 5--7.5 kN/m Building material classification: B2 Emission class: F 1 Wood moisture content: 5 < 12 %

# Wood species

- spruce
- fir
- pine

Glues:

- Urea-forma cehyde resin
- Melamine modified urea-formaldehyde
- Phenol resin
- PMDI

Dimensions Thickness [mm]: Solid extruced board: 10-34 Tubeboards [mm]: 23-80 Width [mm] 900-2,100 Length [mm] up to 5,000

# Material

Extruded particle boards have a high shearing strength but a low flexural strength and insufficient integrity. Consequently, when used in the construction industry, they must be panelled with chipboards, hardboards, veneers or plastic boards.

## Application(s)

Extruded particle boards are used in making doors. They are authorized for use as panelling in wooden panel-construction houses.

## Invitations to tender and orders:

- Manufacturer
- DIN
- Panel type
- Wood species
- Gluing
- Emission class
- Thickness
- Width
- Length
- Calculated by m<sup>2</sup>

## Manufacture

In the manufacture of extruded particle boards, particles are mixed with a bonding agent and pushed rhythmically along a heated channel by a ram. The crosssection of the channel forming the board corresponds to that of the resulting product. The particles are positioned perpendicularly to the board's surface, which produces a relatively high shearing strength at right angles to the surface. Extruded particle boards are made in a continuous manufacturing process because the heating process and the rate of feed are adjusted to the curing time. As the particles pass through the channel shaft, they are bonded together to form an endless stream of board that is only cut into sections after pressing is completed.

Solid extruded boards are produced in single layers only. Owing to the arrangement of the particles, these boards have a lower flexural strength than flat-pressed boards. Extruded particle boards are only suitable as cores in composite boards. Tubeboards, whose cores contain tubular cavities, are produced by arranging tubes parallel to the shaft.

## Manufactured Wood Products Fibre-Reinforced Cement Boards



#### Fibre-Reinforced Cement Boards

**DIN EN 633 DIN EN 634** Thermal conductivity:  $\lambda_{_{\rm P}}=0.35~W/mK$ Vapour diffusion resistance factor:  $\mu = 20/50$ Raw density:  $\rho = 1,250 - 1,300 \text{ kg/m}^3$ Building material classification: B1, A2 Material class: 20. 100.100 G Emission class: E 1 Wood moisture content:  $9 \pm 3\%$ Amount of swelling and shrinkage per % change wood moisture content: 0.03 %

Wood species:

- spruce
- fir

Bonding agent:

Cement

# Material

In contrast to organically bonded woodbased materials, fibre-reinforced cement boards are anorganically bonded with cement (which accounts for approximately one third of their weight percentage). They can be used in the same fields as wood classes 20, 100, 100G in accordance with DIN 68800-2. The bonding agent renders the boards moistureresistant. The boards can be coated and plastered for more effective and enduring weather protection. They are certified for use as load-bearing and reinforcing panels for wooden panel-construction houses under DIN 1052-3.

The panels are hardly flammable and have been classified as B1 under DIN 4102. To ensure that they meet the requirements of building material classification A 2 (not flammable), perlite (amounting to approx. 24 % of total mass) is added.

#### Application(s)

Fibre-reinforced cement boards are used as exterior wall cladding or as wall-reinforcement panelling. Effective, enduring weather protection is essential for exterior walls. Their good fire-proofing properties make these panels suitable as fire barriers. They also have good sound-insulating properties owing to their high raw density, and can be used as a floor covering.

## Invitations to tender and orders:

- Manufacturer
- DIN
- Certification number
- Panel type
- Emission class
- Thickness
- Width
- Length
- Surface
- Calculated by m<sup>2</sup>

#### Manufacture

Coniferous wood (spruce or fir) that has been stored for three to four months and not treated against fungi is chipped and separated into fine and coarse chips and then stored in chip bins. A mixture of wood chips, cement, recycled trimmings, supplementary agents and water is prepared in a semi-dry process in a mechanical mixer. The material is evenly separated into an outer layer and a core layer in a mechanical sifter and spread evenly across plates. Surplus material is fed straight back into the mixer. There is no waste water. The mix is pressed and allowed to set in a climatic chamber. Afterwards, the boards are cured for approximately four weeks in a conditioning storage unit. Prior to shipment, the panels are conditioned so that they have the right moisture balance; they are then trimmed and cut, and their edges profiled. Finally, they are impregnated and coated.

Dimensions Thickness [mm]: 8-40 Format [mm]: 1,250 × 2,600, 1,250 × 3,100

*Manufacturer(s) (selection)* Eternit AG Fulgurit Glunz AG



## **Fibre Cement Boards**

German building authority certification: Z-31.1-34 Z-31.1-36 Thermal conductivity:  $\lambda_{\rm R} = 0.58$  W/mK Vapour diffusion resistance factor:  $\mu = 11$ Raw density: p = 1,150-2,000 kg/m<sup>3</sup> Building material classification: A 2

## Material

Fibre cement is a composite material of fibre and cement. It consists of 40 % Portland cement, 11 % aggregate (limestone powder), 2 % reinforcement fibre, and 5 % cellulose fibres and water.

#### Application

Fibre cement boards are suitable as weatherproofing for roofs and walls, and may also be used as ventilated exterior wall cladding as per DIN 18516-1.

### Invitations to tender and orders:

- Manufacturer
- Certification number
- Thickness
- Width
- Length
- Surface area
- Calculated per m<sup>2</sup>

#### Production

Fibre cement boards are made of an intimate mixture of cement and water plus artificial and cellulose fibres. They are manufactured with a surface coating or with various colour additives. The inorganic materials are weatherproof, frostand rot-resistant, and incombustible. In addition, they are largely resistant to aggressive chemical atmospheres. In the mixture, the fibres perform a similar function to that of steel in reinforced concrete.

Dimensions Length [mm] 1,250, 2,000, 2,500 Width [mm]: 1,250, 1,500 Thickness [mm]: 8, 10, 12.5, 15, 18 *Manufacturer(s) (selection)* Eternit AG Fulgurit Baustoffe GmbH Wanit

#### Information

Fachregeln des Deutschen Dachdeckerhandwerks (Professional Regulations of the Germany Roofing Trade Deutsches Dachdeckerhandwerk)



### Plasterboard

DIN 18180 German building authority certification: Z-9,1-199 Z-9.1-204 Z-9,1-221 Z-9.1-246 Z-9.1-318 Z-9.1-319 Thermal conductivity:  $\lambda_{\rm p} = 0.21$  W/mK Coefficient of thermal expansion: 0,013-0,020 mm/mK Vapour diffusion resistance factor: u = 8 Raw density:  $\rho = 900 - 1000 \text{ kg/m}^3$ Building material classification: A 2 Heat storage capacity: C = 960 J/kgK

Dimensions:

Thickness [mm]: 9.5, 12.5, 15, 18, 20, 25 Width [mm]: 600, 625, 1,250 Length [mm]: 2,000-4,000 in increments of 250

#### Material

Plasterboard consists of a plaster core encased in adhesive cardboard. Natural and FGB plaster obtained from flue gas desulfurisation provide the raw materials for production.

Depending on the application, various types of plasterboard may be used, with different cardboard casings and plaster additives:

- Gypsum plasterboard Yellowish-white cardboard, blue lettering
- Fire protection plasterboard Yellowish white cardboard, red lettering
- Impregnated plasterboard
   Greenish cardboard, blue lettering
- Impregnated fire protection plasterboard
- Greenish cardboard, red lettering
- Gypsum baseboard
  Grey cardboard, blue lettering
  Gypsum dry screed board
- with/without sound-impact insulation

## Application(s)

Plasterboard can serve as wall or ceiling panelling, as a lining for suspended ceilings, as lining for prefabricated walls, and as dry screed.

It may be used wherever class 20 wooden boards are allowed as per DIN 68800-2. In addition, impregnated plasterboard may be installed on the outside of exterior wall elements if the conditions for effective, lasting weather protection, as specified in the note of authorization, are met.

Plasterboard may be used as reinforcing panelling for ceilings in wooden buildings (fixed to the bottom side) and for pitched roofs.

Plasterboard may also be employed as a load-bearing reinforcement for wall panelling in wooden houses erected as panel construction systems. Manufacturer(s) (selection) Danogips GmbH Fels-Werke GmbH Gebr. Knauf Westdeutsche Gipswerke Gyproc GmbH Lafarge Gips GmbH Lindner AG Rigips GmbH

Information Industriegruppe Gipsplatten

## Invitations to tender and orders:

- Board type
- Thickness
- Length
- Width
- Edge shape
- Calculated per m<sup>2</sup>

## Production

Plasterboard is produced on large conveyor belts in a continuous manufacturing process. The calcined, ground plaster is mixed with water and additives, sprayed onto a base, and formed into boards together with the cardboard lining. The boards are then lettered, cut, turned, dried and bundled.

In combination with the plaster core, the cardboard reinforces the tensile zone and lends the boards the requisite firmness and flexural strength.



## Gypsum Fibreboard

German build ing authority certification: Z-9,1-187 Z-PA-III 4.664 Thermal concluctivity:  $\lambda_{\rm R} = 0.36$  W/mK Vapour diffusion resistance factor:  $\mu = 11$ Raw density:  $\rho = 880-1,250$  kg/m<sup>3</sup> Building material classification: A 2

Dimensions: Thickness [mm]: 10, 12.5, 15, 18 Sizes [mm]: 1,000 × 1,501) 1,245 × 2,001) 1,245 × 2,5011 1,245 × 2,5411 1,245 × 2,7511 1,245 × 3,00()

#### Material

Gypsum fibreboard is a homogenous board made of a mixture of calcined natural plaster and cellulose fibres. The cellulose fibres, which are primarily obtained from recycled paper, strengthen the board.

#### Application(s)

Gypsum fibreboard can serve as wall or ceiling panelling, as a lining for suspended ceilings and prefabricated walls, and as dry screed (when used in multiple layers). In the form of composite board with foam plastic, it can be used to provide additional thermal insulation. Gypsum fibreboard may be used as a load-bearing reinforcement for wall panels in both wooden houses with a panel design and in timber skeleton buildings. It may be employed as reinforcing and load-bearing wall panelling wherever class 20 wood material is permitted (in accordance with the German building authority certification).

It may also be used to plank the outside of exterior wall elements if effective, lasting weatherproofing is ensured.

Gypsum fibreboard is resistant to fire and humidity.

For requests for tenders and orders

- Gypsum, fibreboard
- Certification number
- Thickness, length and width
- Calculated per m<sup>2</sup>

#### Production

Cellulose fibre is obtained from paper in a recycling process and then mixed with ground plaster. Water is added to the mixture, with no additional bonding agent. The mix is pressed into boards under high pressure, dried, impregnated with a water-repellent agent and formatted.

Manufacturer(s) (selection) Fels-Werke Lindner AG Rigips GmbH

## Insulating Materials Wood Fibre



## Wood Fibre

DIN 68755 DIN EN 316 Thermal conductivity:  $\lambda_{\rm R} = 0.045 - 0.060$  W/mK Vapour diffusion resistance factor:  $\mu = 5 - 10$ Raw density:  $\rho = 130 - 450$  kg/m<sup>3</sup> Building material classification: B 2 Thermal capacity: C = 360 kJ/m<sup>3</sup>K Application types: T, TV, IC

Dimensions Thickness [mm]: 6-80 Width [mm]: 400-1,220 Length [mm]: 1,200-2,500

#### Material

Porous soft fibreboard is manufactured from spruce, fir and pine pulp in a wet production process. Fibre humidity exceeds 20 per cent during the manufacturing process.

The raw density of soft fibreboard lies below 450 kg/m<sup>3</sup>, making it lower than that of medium hard and hard fibreboard.

## Application(s)

Soft fibreboards are used as insulation for floors, walls, ceilings and roofs; they are also employed as impact sound insulation under floor screed, dry screed and wood flooring, and as sound absorbing panels.

Depending on the application, the boards are connected by butt joints, rebate joints or tongue-and-groove joints. The panels are loosely laid and then mechanically fastened or glued. Special joint adhesive sealing may be required to ensure air tightness.

Like untreated wood, wooden fibreboards must be protected against UV-radiation and humidity. With a wood moisture content of less than 20 per cent, these boards are highly resistant to wood pests and other sources of damage (bacteria, fungi, and insects).

Wood fibreboards are available as insulating plaster-base elements for exterior walls. They are also suitable as elements for composite or sandwich construction in combination with hardboard or gypsum board. For invitations to tender and orders:

- Manufacturer
- DIN
- Application type
- Thickness
- Width
- Length

Calculated per m<sup>2</sup>

#### Manufacture

In the wet manufacturing process, waste from locally harvested coniferous trees is chipped and shredded. The chips are pulped with vapour in a reaction chamber and subsequently milled into fibres. Additives and, if required, wood preservatives are blended into the fibre slurry. The slurry is spread on a Foudrinier to create a flat fibrous mat, which is then dehydrated by extrusion or by applying negative pressure. In the final stage, the mats are shaped into boards and dried. Thicker panels (25–30 mm and upwards) are manufactured by laminating several individual boards.

Manufacturer(s) (selection) Emfa Baustoff GmbH Glunz AG Gutex Holzfaserplattenwerk Schönheide GmbH Pavatex Steinmann



## Bituminated Fibreboard [Asphalt-Treated Board; US]

DIN 68752

Thermal conductivity:  $\lambda_R = 0.056 - 0.060 \text{ W/mK}$ Vapour diffusion resistance factor:  $\mu = 5 - 10$ Raw density:  $\rho = 200 - 350 \text{ kg/m}^3$ Building material classification: B 2 Thermal capacity: C = 630 kJ/m<sup>3</sup>K Application t/pes: T, TV

## Material

Bituminated fibreboards are porous wood fibreboards, manufactured with a bitumen additive.

A distinction is made between bituminated fibreboards

with 10–15 per cent bitumen additive (moisture-proof) and a water absorption rate of less than 25 per cent (BPH)
with more than 15 per cent bitumen additive (increased moisture resistance) and an average water absorption of less than 20 per cent (BPH2).

## Application(s)

The primary areas of application are exterior walls, roof extensions and subfloors. Bitumen-impregnated wood fibreboards can be used under roof covering as water- and airtight layers. The bitumen content renders them resistant to moisture, rot, fungi and insects.

Manufacturer

Application type
Thickness
Width
Length

Calculated per m<sup>2</sup>

· DIN

#### Manufacture

Bituminated wood fibreboards are manufactured in the same manner as porous wood fibreboards; the only difference being that a bitumen emulsion is added to the fibre slurry.

For invitations to tender and orders:

Dimensions Thickness [mm]: 6-25 Width [mm]: 400-1,220 Length [mm]: 2,440, 2,500

Manufacturer(s) (selection) Emfa Baustoff GmbH Gutex Isofloc Wärmedämmtechnik GmbH Pavatex Insulating Materials Cork



## Cork

DIN 18161-1 Thermal conductivity:  $\lambda_{\rm R} = 0.040-0.055$  W/mK Vapour diffusion resistance factor:  $\mu = 5-10$ Raw density:  $\rho = 80-200$  kg/m<sup>3</sup> Building material classification: B 2 Thermal capacity: C = 223 kJ/m<sup>3</sup>K Application types: T, TR, TS

#### Material

Cork, the outer bark of the cork oak tree, is available – as natural or expanded granulated material (expanded cork, caking cork) – in the form of insulating panels and fill.

The cork oaks, predominantly indigenous to the western Mediterranean region, can be debarked every 8 to 10 years, They have a lifespan of 100 to 150 years.

#### Application(s)

Cork is mould and rot resistant even when thoroughly moist. However, exposure to moisture over an extended period may result in fungal decay.

Cork insulating boards are laid down loosely, then nailed, plugged or glued. Granulates are poured or injected. Insulating cork is especially suitable for use in areas subjected to pressure loads and as impact sound insulation. Cork can also be employed in composite insulating systems. For invitations to tender and orders:

- Manufacturer
- DIN
- Application type
- Thickness
- Width
- Length

Calculated per m<sup>2</sup>

#### Manufacture

Cork is processed into insulating materials in a variety of ways depending on the intended use.

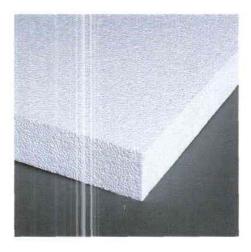
Natural granulated cork is manufactured by crushing raw cork; it is used without additives as insulating fill.

Expanded granulated cork is manufactured by adding superheated vapour to the natural granulated cork under pressure in a hermetically sealed container. The natural cork resin (suberin) shifts to the outside of the granules and bonds them to each other. The required vapour temperature depends on the resin content. The blocks are then cut into slabs or granulated.

Impregnated cork is manufactured by adding a bonding agent such as synthetic resin or bitumen to the heated granulate.

Manufacturer(s) (selection) Cortex Emfa Baustoff GmbH Gradl & Stürmann Heck Dämmsysteme GmbH Henjes Naturschrot Röthel GmbH & Co KG Zipse Korkvertrieb

Dimensions Thickness [mm]: 20–100 Format [mm]: 500 × 1,000, 600 × 1,200



## Expandable Polystyrene (EPS)

DIN 18164-1 Thermal conductivity:  $\lambda_{\rm p} = 0.035$ -D.040 W/mK Vapour diffusion resistance factor:  $\mu = 20$ -100 Raw density:  $\rho = 15$ -30 kg/m<sup>3</sup> Building material classification: B 1 Thermal capacity: C = 43 kJ/n<sup>-3</sup>K Application types: T, TV, TR, TS IC

Dimensions Thickness [mm]: 10-200 Format [mm] 500 x 1,000

#### Material

Plastic foams are oil-refining products that are manufactured by foaming the raw material and simultaneously adding propellants or blowing agents. Plastic foams are porous in structure and are mainly available as HR-foams.

Expandable polystyrene, also called styropor, is a predominantly closed-cell, hard plastic foam. The "styropor" granulate is processed into boards, mouldings and sheets. The material is rot, mould and pest resistant. It is not resistant, however, to constant moisture or humidity.

#### Application(s)

It is typically used in non-ventilated flat roofs (which must be protected against hot bitumen), and composite insulation systems for exterior walls. Rigid plastic foamboard is not very suitable for use in timber frameworks, however, because it does not compensate for wood shrinkage. EPS boards are frequently employed in sandwich constructions in combination with a variety of materials, for example, with fibrated cement panels as facade elements, or with timbering and plasterboard as wall and roof elements. In floor construction, EPS boards are used as impact sound and thermal insulation. Loose polystyrene particles can also be used as fill.

#### For invitations to tender and orders:

- Manufacturer
- · DIN
- Application type
- Grade
- Thickness
- Width
- Length
- Calculated per m<sup>2</sup>

#### Manufacture

The product is manufactured in three stages:

 Frothing The compare

The compact beads are heated with hot vapour and inflated under pressure with pentane blowing agent to make foam pellets.

Intermediate storage The beads are cooled and dried.
Foaming

The frothed beads are further inflated with vapour into solid forms and bonded to each other. Block mouldings are produced to manufacture the polystyrene boards, which are saw-cut or hot-wire cut.

*Manufacturer(s) (selection)* BASF Joma Schwenk

Information Industrieverband Hartschaum e.V.



## Extruded Polystyrene (XPS)

DIN 18164-1 Thermal conductivity:  $\lambda_{R} = 0.030 - 0.040$  W/mK Vapour diffusion resistance factor:  $\mu = 80 - 200$ Raw density:  $\rho = 25 - 45$  kg/m<sup>3</sup> Building material classification: B 1, B 2 Thermal capacity: C = 58 kJ/m<sup>3</sup>K Application types: T, TR, TS

## Material

Extruded polystyrene (XPS) is a closedcell, hard plastic foam. It differs from expandable polystyrene (EPS) in the manner of manufacture. Extruded polystyrene foam is characterised by its low moisture absorption and resistance to rot, ageing and decay; it is not, however, resistant to UV-radiation.

#### Application(s)

Extruded polystyrene foam is employed for all insulation purposes. It is not, however, used in manufacturing impact sound insulating boards. Its principal applications are the insulation of pitched roofs and perimeters.

Rigid plastic foamboard is not very suitable for use in timber frameworks, however, because it cannot compensate for wood shrinkage. For invitations to tender and orders:

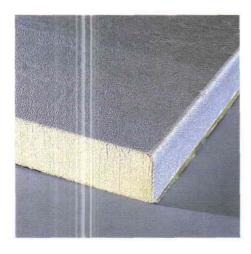
- Manufacturer
- DIN
- Application type
- Thickness
- Width
- Length
- Calculated per m<sup>2</sup>

#### Manufacture

In the production of extruded polystyrene foam, polystyrene – which is heated and melted in an extruder – is foamed by admixing a blowing agent. The resulting foam is continuously pressed through air jets into boards, whose characteristic feature is their smooth, sealed foamed skin. They are suitable for use as perimeter insulation for building components that are in direct contact with the soil and as insulation for pitched roofs. For other uses, blocks are foamed and cut into panels.

Dimensions Thickness [mm]: 20-200 Width [mm]: 600 Length [mm]: 1,250, 2,500 Manufacturer(s) (selection) BASF DOW Deutschland Gefinex

Information Industrieverband Hartschaum e.V



# Polyurethane (PUR)

DIN 18164-1 Thermal conductivity:  $\lambda_{\rm R} = 0.020-0.030$  W/mK Vapour diffusion resistance factor:  $\mu = 30-100$ Raw density  $\rho = 22-100$  kg/m<sup>3</sup> Building material classification: B 1, B 2 Thermal capacity: C = 43 kJ/m<sup>2</sup>K Application types: T, TR, TS, TRS

Dimensions Thickness [mm]: 10-300 Width [mm]: 500-1,200 Length [mm]: 1,000-3,000

## Material

Polyurethane is composed of various crude oil products with different crosslinking densities and raw densities. Polyurethane HR-foam is characterised by its low moisture absorption and its resistance to rot, ageing and decay. It is, however, not resistant to UV-radiation. In contrast to polystyrene, PUR HR-foam can withstand temperature stresses of up to 250 °C.

Polyurethane is manufactured as both HR-foam and in-situ foam.

- Polyurethane HR-foam is a strongly cross-linked, thermosetting synthetic material, which is usually foamed into a closed-cell structure (closed-cell ratio of approximately 90 per cent). Open-cell grades are also manufactured for special applications. Boards are available in both laminate and non-laminate form.
- PUR in-situ foam is manufactured on site. It is used to insulate roofs and to fill and seal building joints of doors and windows, etc.

## Application(s)

PUR foam is used:

- as flat roof insulation (PUR HR-foam is resistant to hot bitumen),
- as insulation for high pitched roofs, between and underneath rafters,
- as insulation for external walls on ventilated facades (cavity walls),
- as a component in sandwich and composite construction.

Rigid plastic foamboard is not very suitable for use in timber frameworks, however, because it does not compensate for wood shrinkage. For invitations to tender and orders:

- Manufacturer
- DIN
- Application type
- Thickness
- Width
- · Length

Calculated per m<sup>2</sup>

#### Manufacture

PUR HR-foam boards are manufactured in two different processes:

In the double-belt process, the foamed blend (with pentane blowing agent) is applied to a bottom surface layer and then bonded to a top surface layer. Mineral fibrous mats, glass fibrous mats, paper, metal- or compound (sandwich) foil, roof sheeting and moisture-proof roof sheeting are used as surface layers.

In the block foam process, the reaction mixture is poured into an ingot mould. The resulting blocks are cut into boards once the foam has hardened and settled.

Manufacturer(s) (selection) Bauder Correcthane Puren Schaumstoff GmbH

Information Industrieverband Hartschaum e.V. Insulating materials Mineral Wool



# Mineral Wool

DIN 18165-1+2 Thermal conductivity:  $\lambda_{\rm R} = 0.035 - 0.050$  W/mK Vapour diffusion resistance factor:  $\mu = 1-2$ Raw density:  $\rho = 12-250$  kg/m<sup>3</sup> Building material classification: A 1, A 2 Thermal capacity: C = 115 kJ/m<sup>3</sup>K Application types: T, TV, TR, TS, TRS, TF, I, IC

Dimensions Thickness [mm]: 20–200 Width [mm]: 600, 625, 1,200 Length [mm]: 1,200, 1,250, 6,000

#### Material

Mineral wool is a synthetic fibre manufactured from a glass, stone and slag smelt. It is supplied as insulation in the form of sheets, mats, felting or panels of differing density. A distinction is made, depending on the raw material used, between glass wool (yellow colouring) and rock wool (olive green colouring).

Mineral fibre insulation, including mineral wool, must be protected against moisture. It is resistant to micro-organisms and pests and does not rot. Composite materials of felting and panels with paper-, aluminium- and synthetic laminate are available as required.

#### Application(s)

Mineral wool insulating materials have a wide range of applications as sound, impact sound and thermal insulation, with a special material for each particular use. Sheets are used on ceilings and walls as insulating and sound absorbing layers. Composite materials composed of mineral wool and paper/aluminium foil are designed with special edges so that they can be fastened between squared timbers (e.g. rafters).

Panels or boards have a variety of uses in walls, for example, on the exterior side of masonry beneath a weather protection layer, in composite insulating systems, and (provided permission has been obtained) as core insulation. They are used as impact sound insulation in floors. Due to their relatively high degree of compressibility, the thinnest possible mineral wool impact sound insulation panels should be used. Since mineral wool is non-combustible, it is suitable in areas with special fire-protection requirements, For invitations to tender and orders:

- Manufacturer
- DIN
- Application type
- Thickness
- Width
- · Length
- Calculated per m<sup>2</sup>

#### Manufacture

Glass wool is composed of quartz sand, sodium carbonate (or: soda ash), limestone, dolomite, feldspar, borax, with a recycled glass content of up to 70 per cent.

Basalt or diabase, limestone, dolomite and flux additament are used to manufacture rock wool.

The raw materials are melted at a temperature of 1,200–1,400°C, before being blown or spun through fine nozzles, defibrated and subsequently felted into woollike materials. Synthetic resins are also added as bonding agents. Water-repellent oils are employed to bind the fibre dust. Waterproofing and bonding agents are also used.

Manufacturer(s) (selection) Deutsche Heraklith Deutsche Owens-Corning Glasswool Deutsche Rockwool Pfleiderer Saint-Gobin Isover G+H AG Thüringer Dämmstoffwerke



## Sheep's Wool

Building authority certification: Z-23,11-1022 Z-23,11-332 Z-23,1,3,-253 Thermal conductivity:  $\lambda_{\mu} = 0.040 \text{ W/mK}$ Vapour diffusion resistance factor:  $\mu = 1-2$ Raw density:  $\rho = 20-80 \text{ kg/m}^3$ Building material classification: B 2 Application types: T, TV

## Delivery formats/dimensions

Wool and braided wool packaged in sacks Mats/rolled feiting: Thickness [Imm]: 20-220 Width [mm] 450-1,000 Length [mm]: 1,000-8,000

# Cotton wool

Building authority classification: Z-23,11-251 Z-23,11-308 Z-23,11-1056 Thermal conductivity:  $\lambda_{\rm R} = 0.040 - 0.045$  W/mK Vapour diffusion resistance factor:  $\mu = 1-2$ Raw density:  $\rho = 20-60$  kg/m<sup>3</sup> Building material classification: B 1, B 2 Application types: T, TV

## Delivery formats/dimensions

Felting (thickness [mm]: 2–20): Width [mm] 625, 1,200, 1,800 Mats (thickness [mm]: 50–180): Width [mm] 500–1,200

#### Material

Sheep's wool is one of the oldest materials used by humans to protect themselves against cold. Sheep's wool fibrous mats are composed entirely of shorn sheep's wool. Up to 50 per cent of all recycled wool is used for sheep's wool felt. With the addition of borax, sheep's wool is largely resistant to insects and mould fungi.

## Application(s)

Sheep's wool is used in the form of insulating mats, braided insulation and packing wool to provide thermal and sound insulation in roofs, walls and ceilings; it is also employed in the form of felting as impact sound insulation.

According to various manufacturers, sheep's wool has an excellent moisture absorption capacity (up to 30 per cent), combined – in contrast with other fibrous insulating materials – with extremely good insulating properties.

## Material

Cotton wool insulation is composed of the hull fibres (up to 97 per cent) of the cotton bush. The long fibres of the hulls contain more than 90 per cent cellulose. The insulating material contains borax additive (as much as 3 per cent).

#### Application(s)

This material is used as thermal and sound insulation in roof, wall and ceiling cavities. Insulating feltings are employed as impact sound insulation. Cotton wool insulation is mould resistant. Damage caused by moths, carpet beetles, insects and rodents can be prevented.

# For invitations to tender and orders:

- Manufacturer
- Certification No.
- Application type
- Delivery format
- Thickness
- Width
- Length
  Calculated per m<sup>2</sup>

## Manufacture

The wool is thoroughly washed with soap and soda. The cleansing agent is then completely removed through repeated rinsing in cold water. Next, the wool is mechanically bonded and impregnated. During the final rinse, some manufacturers add borax as well as a urea-derivative, such as sulcoforen, as a legally authorized preservative against keratindigesting insects (e.g., moths, carpet beetles). Some manufacturers also use polyester or cotton wool as binding fibres to improve the dimensional stability of insulating rolls with a thickness greater than 120 mm.

Manufacturer(s) (selection) Doppelmayer Falke Garne KG Klöber Purwoll GmbH ROWA F. Rothmund GmbH Thermowoll Dämmstoff GmbH

#### Manufacture

Cotton harvested in tropical to subtropical cultivation areas is processed into fibrous mats, which are then layered to achieve the desired thickness. Cotton wool is available in the form of mats, felting, padding and injection wool, and as braided insulation.

Manufacturer(s) (selection) Isocotton GmbH K + K ISO Baumwolle

## Insulating Materials Flax/Hemp



## Flax

Building authority certification: Z-23.11-239 Z-23.11-276 Z-23.11-1010 Thermal conductivity:  $\lambda_R = 0.040 \text{ W/mK}$ Vapour diffusion resistance factor:  $\mu = 1-2$ Raw density:  $\rho = 25 \text{ kg/m}^3$ Building material classification: B 2 Application types: T, TV

# Dimensions

Thickness [mm]: 40, 60, 80, 100 Width [mm]: 500-1,200 Length [mm]: 10,000

## Hemp

Building authority certification: Z-23.11-1341, ETA 02/0015 (European certification) Thermal conductivity:  $\lambda_{R} = 0.045$  W/mK Vapour diffusion resistance factor:  $\mu = 0.5-1$ Raw density:  $\rho = 20-40$  kg/m<sup>3</sup> Building material classification: B 2 Application types: T, TV

Dimensions Thickness [mm]: 20–240 Format [mm]: 575/600/625/635 × 1,200 1,000 × 2,000

### Material

Flax is a textile fibre (belonging to the group of bast fibres) harvested from the roughly 1-metre-long flax plant. As insulation, flax is resistant to mould and can absorb and release up to 20 per cent of its own weight in moisture.

#### Application(s)

Insulating mats of flax are used for roof, wall and floor insulation.

Insulating feltings are used as impact sound insulation. Cavity flocks (insulating mats cut into small pieces) and shives (wooden parts of the stalks) are used to fill cavities, for example, sound-boarded ceilings.

Flax, in the form of pipe casing, is also used to insulate ducts and pipes.

## For invitations to tender and orders:

- Manufacturer
- Certification No.
- Application type
- Thickness
- Width
- Length
- Calculated per m<sup>2</sup>

#### Manufacture

After the harvest, the stalk of the flax plant is separated into seed capsules and leaves and then roasted to free the fibre bundles of bonding agents. These steps are followed by washing, drying, breaking, tumbling (separating the fibres from the wood of the stalks) and chopping. The cellulose content of the resulting short fibres constitutes the thermal insulating material. Polyester is usually added as a stabilising and binding fibre to achieve good recovery. Some manufacturers also include borax, soluble sodium or ammonium phosphate to protect the fibres against fire.

Manufacturer(s) (selection) Deutsche Heraklith GmbH Flachshaus GmbH Pavatex GmbH Stattbauhof GmbH Best Naturdämmstoffe

#### Material

Hemp fibres are tear-resistant and also highly stress-resistant, which makes them suitable as impact sound insulation. Since hemp fibres do not contain protein, they are naturally protected against pests and mould, thus obviating the need for additives. Hemp fibres can absorb up to 18 per cent of their own weight in moisture and release the moisture when the air is dry. They therefore have a balancing effect on the interior climate. Hemp insulating materials are recyclable.

#### Application(s)

Hemp mats are used as thermal insulation in walls, ceilings and floors, as subor common-rafter insulation and as impact sound insulation (d = 15/20/30 mm) below floor screeds.

#### Manufacture

The cultivation of non-intoxicating types of hemp has been permitted in Germany since 1996. Hemp fibre is gathered from the fast-growing hemp plant, which can be harvested biannually. Safe and harmless agents, such as soda or ammonium phosphate, are added to provide flame protection. Hemp insulation is available in pure form and with an admixture of sheep's wool. The mixed grade must be protected against pests. Textile fibres, (e.g. polyester), are added for support.

Manufacturer(s) (selection) Emfa Baustoff GmbH Hock Vertriebs-GmbH & Co KG Saint-Gobin Isover G+H AG Treuhanf AG



## **Coconut Fibre**

DIN 18165 Thermal conductivity:  $\lambda_{\rm R} = 0.045$ - 0.050 W/mK Vapour diffusion resistance factor:  $\mu = 1$ -2 Raw density  $\rho = 50$ -140 kg/m<sup>3</sup> Building material classification: B 2 Thermal capacity: C = 22-57 KJ/m<sup>3</sup>K Application types: T, TV, I, IC Material

Coconut fibre is gathered from the outer, fibrous layer of the coconut. It is available in the form of rolled felting, insulating mats or boards, braided insulating material and packing wool.

#### Application(s)

Coconut insulating mats are available as:

- screed insulating boards, multiple needle-felted and pressed layers, for wet and dry screed as well as for poured asphalt;
- coconut wall panels for airborne sound insulating facing shells and partitions;
- needle-felted coconut rolled felting for cavity insulation in walls and floors; thermal insulation for roofs and walls; sound insulation; fill material for door and window joints.

Coconut insulating materials are available in the form of boards and rolled felts.

Manufacture

Manufacturer

Application type
Delivery format
Thickness
Width
Length

Calculated per m<sup>2</sup>

· DIN

The fibrous layer, which is up to 10 cm thick, is manually removed from the coconut and then stored for 6 to 10 months in seawater, during which process all perishable components decay (retting). The usable fibres are dried, aerated, refined and pressed and formed as needed.

For invitations to tender and orders:

Dimensions: Boards: Thickness [rnm]: 13, 18, 20, 23, 25, 28, 40 Width [mm]: 625 Length [mm]: 1,250 Rolled felting: Thickness [nnm]: 20, 25, 35 Width [mm]: 400, 500, 670, 1,000 Length [mm]: 10,000

Manufacturer(s) (selection) EZO Isolierstoffe GmbH Emfa Baustoff GmbH Röthel GmbH & Co KG Zipse Korkvertrieb



## Cellulose

Building authority certification: Z-23.11-280 Use is subject to compliance with DIN 18165-1 for fibre insulating materials. Thermal conductivity:  $\lambda_{\rm p} = 0.040 - 0.045$  W/mK Vapour diffusion resistance factor:  $\mu = 1 - 2$ Raw density:  $\rho = 30 - 80 \text{ kg/m}^3$ Building material classification: B1, B2 Thermal capacity:  $C = 100 \text{ kJ/m}^{3}\text{K}$ Application types: T, TV

#### Material

Old newsprint provides the base material for all cellulose flocks. Borate is added for protection against rot and flammability. Cellulose flocks are loose in structure and injected into cavities or onto horizontal, curved or inclined surfaces. Injection pressure compresses the flocks

to a density of approximately  $45-60 \text{ kg/m}^3$  in roof pitches and  $60-70 \text{ kg/m}^3$  in walls.

#### Application(s)

Cellulose is typically used to provide thermal insulation in roof, wall and ceiling cavities.

The mode of application varies: pouring or blowing for open ceilings; injection for roofs and ceilings; spraying for walls. According to DIN 18165-1, the insulating flocks cannot be assigned any specific type of application. They can only be employed in closed cavities. They must not be subjected to pressure loads and must be protected against damp. Compliance with the wood preservation regulation for hazard classification 0 under DIN 68800 is a prerequisite for use of this material. For invitations to tender and orders:

- Manufacturers
- Certification No.
- Application type
- Thickness
- Calculated per m<sup>3</sup>

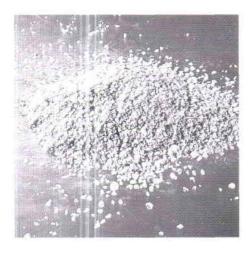
#### Manufacture

Cellulose is recycled newsprint, pulped from finely flocked stock, which is impregnated with borates (borax and boracic acid) to protect it against fire, rot and pest attack.

The paper is pre-shredded, the borate is added in pulverised dosages, and both components are blended in a milling process and mechanically bonded. The cellulose mix is freed from dust, slightly compacted and packaged in paper sacks.

Manufacturer(s) (selection) Besin Mehren GmbH Dobry GmbH Climacell GmbH Climatizer C.F.F. Cellulose CWA Cellulose Homann Dämmstoffwerk GmbH & Co.KG Intercel GmbH Isofloc Wärmedämmtechnik GmbH Stattbauhof GmbH

Delivery format Paper sacks of 12.5 kg and 13.6 kg



## Perlite

Non-standarcised Building authority certified Thermal concluctivity:  $\lambda_{\rm R} = 0.55 - 0.66$  W/mK Vapour diffusion resistance factor:  $\mu = 3 - 4.5$ Raw density:  $\rho = 60 - 300$  kg/m<sup>3</sup> Building material classification: A 1, for biturnen casing B 2, for natural resin casing

Delivery formats/dimensions Paper bags Panels: Thickness: 20-200 mm Format: 600 × 1,200 mm

## Swelling Clay

Non-standarcised Thermal concluctivity:  $\lambda_R = 0.13-0.20$  W/mK Vapour diffus on resistance factor:  $\mu = 2-8$ Raw density:  $\rho = 325-800$  kg/m<sup>3</sup> Building material classification: A1 Thermal capacity: C = 252 kJ/m<sup>3</sup>K

Delivery format Loosely packaged in bags of 50, 62.5 and 100 I by truck, rail or ship

## Material

The base material is crude perlite rock, an aluminium-siliceous rock resulting from volcanic activities with temperatures in excess of 1000 °C. It is mined in openpit mines in countries with natural deposits such as Greece and the United States. Expanded perlite contains a wide variety of additives, chiefly bitumen, natural and synthetic resins and mineral bonding agents.

## Application(s)

Expanded perlite is used as insulation in floors and roof slopes, as a levelling layer under floor construction, as sloping insulation on flat roofs and as core insulation in double-layered masonry. Perlite is also used for chimney linings and as a lightweight aggregate for gypsum plasters and mortar.

Owing to their extraordinary load capacity, perlite boards are even employed beneath screeds and floors that are subjected to high load stresses. For invitations to tender and orders: Perlite:

- Manufacturer
- Delivery format
- Certification No.
- Swelling clay:
- Manufacturer
- DIN

Calculated per m<sup>2</sup>/m<sup>3</sup>

#### Manufacture

The crude rock is crushed, ground and then flash-heated to over 1200 °C. During this process, the rock softens, and as the combined water in it evaporates, the raw perlite expands to 15 to 20 times its original volume (rock foam). The outcome is a white granulate with granules measuring 0-6 mm in diameter.

The surface of the granules, which are composed of microscopic cells, is openpored, providing good interlocking qualities for loose, dry in-fill. The surface is also highly temperature-resistant. Various agents are added to relieve the inherent sensitivity to moisture or to increase the compressive strength. Fibres and bonding agents are combined to produce compression-proof panels. (TR, TS)

Manufacturer(s) (selection) Morgan Thermal Ceramics GmbH Perlite Dämmstoff GmbH

#### Material

Swelling clay is a mineral granulate composed of clay, Swelling clay is dimensionally stable, water repellent, rot resistant and also resistant to micro-organisms and pests. As a mineral material, it is noncombustible.

Application(s)

Swelling clay is used as cavity fill for sound and thermal insulation (e.g., in ceiling cavities) or loosely as a lightweight aggregate for bricks, plaster, lightweight concrete, etc,

#### Manufacture

The clay is prepared, finely ground, granulated and fired in revolving kilns in a countercurrent process at roughly 1,200 °C. The organic matter enclosed in the clay is burnt off. Supported by heavy oil, the clay granules expand while the surface melts to some degree and forms a sintered outer skin,

Manufacturer(s) (selection) Fibrolith WilmsGmbH Leca Deutschland Lias Franken

## Vapour Retarding Layer/Vapour Barrier

## DIN 4108-4

Vapour retarding layers or vapour barriers are essential layers in multi-shell or multilayer wall structures, whose importance with regard to building physics and construction engineering is increasing as ever greater requirements are placed on thermal insulation and energy savings.

#### Material

Vapour retarding layers are composed of coated or uncoated special papers and foils. They ensure that the outward diffusion of water vapour forming in a building can be metred and controlled through its thermal insulation. Permeated or condensed water vapour has to be dissipated either directly or by ventilation. A seasonal balance at least must be maintained to ensure that the thermal insulation remains serviceable.

Vapour barriers are vapour-tight sheets of plastic, metal foil or layered paper and/or synthetic materials, which prevent the outward diffusion of water vapour from the inside. Their vapour diffusion resistance is determined by the vapour diffusion resistance of the individual layers from the inside out. As a basic principle, each building element layer should permit more diffusion than the layer below it.

The effectiveness of a vapour barrier is fundamentally dependent on the technical and permanent connections that are made. Perforations and permeation can significantly reduce the functioning of vapour barriers.

#### Properties

The s<sub>p</sub>-value, the water vapour diffusionequivalent air-layer thickness, specifies by how much lower the flow of water vapour is through a building element layer in comparison to an air layer of equal thickness. The value is specified in metres and is the product of the thickness of the building material (s) and its water vapour diffusion resistance coefficient  $\mu$ . s<sub>p</sub>= $\mu \times s$  (m) Metal foils with a thickness greater than 0.05 mm are classified as absolutely vapour-tight under DIN 4108-4. A material layer with a diffusion resistance of  $s_{\rm D}$ = 1500 m is considered vapour-tight for construction purposes. These materials can be used as vapour barriers.

A material with a diffusion resistance  $2 < s_D < 1500$  m can be used as a vapour retarding layer.

Materials with an  $s_{p}$ -value < 0.3 m are considered diffusion-open.

Diffusion-open	s <sub>p</sub> < 0.3 m
Vapour retarding layer	s <sub>p</sub> 2–1,500 m
Vapour barrier	s <sub>D</sub> ≥ 1,500 m

Recommendations for sealing joints, overlaps, junctions and penetrations of vapour retarding layers and vapour barriers are contained in DIN 4108-7.

Building papers and sheeting, in addition to their function as a vapour retarding layer or a vapour barrier, can also perform the following functions in the structure of a wall or roof construction:

- Air-tight layer
- Windproof layer
- Waterproof underlay
- Moisture barrier

• Separating layer Pay attention to the vapour diffusion resistance!

#### Use

Air-tightness is a basic principle for a wood construction designed to function in line with the requirements of building physics and construction engineering. The high insulation values, which are relatively easy to achieve, of the exterior surfaces will only be effective if they are not cancelled out by leakages involving condensation problems and draughts.

What is required is a continuous, airtight level with a minimal number of junctions and penetrations as well as joints and junctions which are not only technically For invitations to tender and orders:

- Manufacturer
- $\cdot s_{D}$ -value
- Thickness
- Width
- Length
- Calculated per m<sup>2</sup>

simple and safe to install, but also take into consideration inevitable deformations. Their correct installation can be checked using a blower door test.

This requirement applies to vapourpermeable or ventilated exterior wall constructions and especially to those where the airtight level is also the vapour barrier. The sealing materials must be co-ordinated and selected in accordance with wood construction requirements. As a rule, the air seal is attached inside and may be identical to the vapour retarding layer or vapour barrier.

The *wind seal*, however, is fastened on the outside of the thermal insulation. It protects the thermal insulation from excessive cooling and prevents exterior air from infiltrating, for instance, through the joints between the wooden construction and the thermal insulation. To satisfy the requirement of increasing vapour permeability from the inside to the outside, a diffusion-open wind seal should be chosen.

For the dimensions and materials see table p. 68 and 69

Manufacturer(s) (selection) Alkor Draka Handel GmbH Ampack Bautechnik A.W. Andernach KG Bauder Binné & Sohn GmbH&Co.KG Braas Dachsysteme GmbH Deutsche Heraklith GmbH Deutsche Rockwool Mineralwoll GmbH **DIB Potthast GmbH** Ewald Dörken GmbH Emfa Baustoff GmbH Forbo-Stamoid Klöber GmbH & Co KG Köster Bauchemie GmbH Moll Bauökologische Produkte GmbH Röthel GmbH & Co KG Saint-Gobin Isover G+H AG Vedag AG Wanit Universal GmbH WIKA Isolier- und Dämmtechnik GmbH

## Damp-Proofing

DIN 18195-1 to 10

Building seals that meet the requirements of DIN 18195 are designed to prevent damage caused by pressing or nonpressing water as well as by ground moisture on the outside along the bordering building elements.

Damp-proofing is also required to avert damage to wooden elements that could emanate from adjacent building elements such as concrete or masonry (building damp) or be baused by damp from the subsoil or weather.

For these seels, which are not included in DIN 18195, other types of bituminous sheeting can be used than listed bare bitumen sheeting, asphalt roofing felt, asphalt roofing seal sheeting, bitumen seal sheeting. asphalt sheeting with different interply sheets: e.g. thick PE foil or other flexible plastic sheeting. Separating layers become necessary when different building materials are connected in such a way that their effectiveness is impaired or completely lost.

Typical examples of this are separating layers on anticapillary courses underneath reinforced concrete floor slabs, separating layers between impact-sound insulation and wet lines, or between sheet covering and timber formwork, etc.

The following materials can be considered for use as separating layers between different building elements:

- Polyethylene foil
- Polyester felts
- Foam mats
- Oil paper
- Sodium bicarbonate kraft paper

For invitations to tender and orders:

- Manufacturer
- DIN
- Thickness
- WidthLength
- Calculated by m<sup>2</sup>

## Descriptions Bitumen sheeting

Brief	Designation
description	
R 500	Asphalt roofing felt with roofing felt intermediate ply
G 200 DD	Asphalt roofing seal sheeting
V 13	Glass fibre asphalt roofing felt
J 300 D	Bitumen seal sheeting with jute cloth
AI 0.2 D	Bitumen seal sheeting with steel tape interply sheet
V 60 S4	Asphalt sheeting with glass fibre interply sheet
PV 200	Polymer bitumen
PY DD	Roofing felt with polyester fleece interply sheet
G 200 PY S5	Polymer bitumen sheeting with glass fibre interply sheet

# Plastic Sheeting

Brief description	Designation
EPDM	Ethylene Propylene
	Diene Monomer
CSM	Chlorsulfonated
	Polyethylene
IIR	Butyl rubber (isobutylene-
	isoprene elastomer)
NBR	Nitrile rubber (nitrile
	butadiene rubber)

Manufacturer(s) (selection) A.W. Andernach KG Paul Bauder GmbH Co. Georg Börner GmbH & Co. Braas GmbH DLW AG Phoenix AG Saar-Gummiwerk GmbH Vedag AG

Information

Industrieverband Bitumen-Dach- und Dichtungsbahnen e.V. Wirtschaftsverband der deutschen Kautschukindustrie e.V.

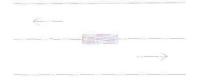
Dimensions Bitumen sheeting Thickness [rnm]: 4–5 Width [cm]: 100 Length [m]: 5 Plastic sheeting Thickness [rnm]: 1–3 Width [cm]: 100, 120, 130, 170, 200 Length [m]: 10, 20, 25

$s_p = \mu \times d$ [m]	μ	Thickness [mm]	Width [cm]	Length [m]	Material	Product	Company
0.008	15	0.50	100	100	wool fibre board, impregnant and cellulose fibre	Perkalor normal	WIKA
0.008	15	0.50	100	50	wool fibre board, impregnant and cellulose fibre, reinforced	Perkalor Diplex	WIKA
< 0.02			150, 280	100	high-pressure PE	Tyvek Soft	Klöber
< 0.02	-		150	100	high-pressure PE	Tyvek Dry	Klöber
< 0.02	-	2	150	50	high-pressure PE/PP	Tyvek Plus	Klöber
0.09	423	0.22	125	50	impregnated kraft paper	Sisalit 50	Ampack
0.12	)=		250	25	special acrylate coating on polyester fleece	Stamisol DW	Forbo- Stamoid
0.2–5	)=	0.005	200	30, 60	Polyamid	Difunorm Vario	Saint-Gobin Isover G+H AG
0.30	.=	0.30	150	50	special PE fleece with microfibre structure	Herafol	Deutsche Heraklith
0.50	2,000	0.25	75, 105, 135	100	recycling cellulose, with glass fabric	pro clima	Moll KS+
0.80	-	_	200	50	diffusion-open PP spunbonded fabric	Туvар	Klöber
0.80	-	0.20	165	100	sodium bicarbonate kraft paper	Volint	Klöber
2.00	8,700	0.23	150	50	kraft papers with flame- retarding paraffin intermed- iate ply and glass fibre mes		Ampack
2.00		-	150	50	spun fleece with vapour retarding coating	Delta-Fol WS	Dörken
2.30	-	0.23	75, 135	100	building paper reinforced with recycling cellulose paper	EMFA- PWD	Emfa
2.30	-	0.35	105	50	special paper made of building paper reinforced with cellulose	EMFA- PWS	Emfa
2.30	10,000	0.23	75, 105, 135	100	recycling cellulose	pro clima DB	Moll
2.30	10,000	0,23	14, 21, 75, 105, 135	100	recycling cellulose, with glass fabric	pro clima DB+	Moll
2.30	5,000	0.45	105	50	recycling cellulose, with glass fabric	pro clima DA+	Moll
2.90	-	0.20	100	100	double ply sodium bicarbonate kraft paper with glass fibre reinforcement	Difulint	Klöber
< 3.00	-	0.18	150	25	laminated film made of PP and LDPE coating	Wandufol	Wanit
> 3.00	-	0.25	150	25	double ply kraft paper and glass-grid vapour retarder	Wandufol	Wanit
4.39	17,560	0.25	100, 125, 150, 215	50	laminate of two kraft papers and a glass fibre mesh	Sisalit 303	Ampack

$s^{D} = h \times q$	μ	Thickness [mm]	Width [cm]	Length [m]	Material	Product	Company
21	53,304	0.40	100	100	Paper one-sided coated	Nepa	WIKA
23	68,800	0.33	150, 180	100, 50	PP fibre fleece with PP filling layer	Ampatex DB 90	Ampack
25	1	0.30	140, 280	100, 50	PP fleece with PP coating, transparent	DB 25	Bauder
26	77,000	0.33	100	100	plastic coated kraft paper	Umodan 10	WIKA
50	-	0.2	200	30, 60	PE foil	Difunorm	Saint-Gobin Isover G+H AG
58	187,000	0.31	150, 180	100, 50	PP fibre fleece with PP filling layer	Ampatex DB 95	Ampack
75	300,000	0.25	400	25	PE foil	vapour barrier PE	
100	-	0.20	200	50	Polyethylene	Rockfol PE	Deutsche Rockwool
100	-		150	50	Aluminium layer between polyester foil and mesh-reinforced PE foil	Delta-Fol Reflex	Dörken
100-30	~	O.1	392	50	laminate of two PE foils	PE vapour barrier	Köster (highly tearproof)
- 1	58,500	0.20	400, 600	25, 50	polyethylene	DIB vapour retarding sheet	DIB Potthast ing
- 2	45,000	0.25	600	25	extruded high pressure polyethylene	Alkorplus 81010	Alkor
12:0	300,000	0.40	400	25	PE foil	vapour barrier fk	Braas
- 30		-	150	50	mesh-reinforced PE foil	Delta-Fol DS 130	Dörken
- 55	62,000	0.25	400, 600	25, 50	polyethylene	DIB vapour retarding sheet	DIB Potthast ing
285	69,000	0.40	400, 600	25, 50	polyethylene	DIB vapour retarding sheet	DIB Potthast
(10	125,000	0.30	100	100	kraft paper with plastic coating and aluminium foil	Umodan DS	WIKA
:79	1,895,000	0.20	100, 125, 150	50	two impregnated kraft papers with glass fibre mes and one-sided aluminium coating	Insulex 311 h	Ampack
>500		0,14	150	25	double-ply alu foil with intermediate glass mesh	Wandufol Technonorm	Wanit
€20	1,240,000	0.50	100	100	kraft paper with plastic coating and aluminium foil	Umodan Super	WIKA
4,000	-	0.12	150	100	aluminium laminated foil with double-sided special plastic lamination	DIB aluminium laminated foil	DIB Potthast
4,500	11,250,000	0.40	122, 200	50	two watertight kraft papers with an intermediate ply of bitumen and sisal fibres, one-sided aluminium coating	Insulex 718	Ampack
vapour-ticht	00	2.50	110	50	PE with aluminium foil and polyester fibre	Umodan 3- Plus	WIKA

## Dowels

Dowels are predominantly used as joints and fasteners subject to shearing stress.



# Rectangular wooden dowels, made of dry hardwood

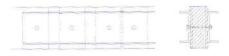
(groups A – C).

# Use

Wooden rectangular dowels are inserted in the direction of the grain into recesses in the elements to be connected. They are secured with locking bolts.

#### Ordering

Hardwood dowels Number I x b x d in mm Wood species Timber quality



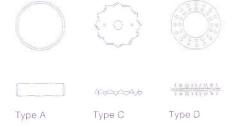


Rectangular anchor made of steel. Flat steel anchors

Use

Flat steel anchors are inserted into recesses across the grain, held with splices and secured with locking bolts.

Ordering Flat steel anchors Number I × b × d in mm Steel quality Surface



Specially designed anchors DIN 1052-2

Use

Permissible load and installation requirements; minimum timber dimensions; minimum spacing and initial wood lengths; size and depth of cut; hexagonal stud bolts matching the anchors as per DIN 1052-2

**Type A Anchor** Split ring connector (shear plate previously Appel System) Ø 65–190 mm

**Type B Anchor** Split ring connector (round wooden dowel made of oak; previously Kübler System) Ø 66 and Ø 100 mm

**Type C Anchor** Force fitted dowel (previously Bulldog System) Ø 48–165 mm

**Type D Anchor** Force fitted dowel (previously Geka System) Ø 55–115 mm

Anchor type E Split ring connector, force fitted dowel (previously Siemens-Bauunion System) Ø 55 and Ø 80 mm

**Transverse connector** for cross-grain joints with a fitting or wind rod with cross thread in the corresponding bore.

Ordering Quantity Type of anchor one-sided/two-sided plates

E.g.  $2 \times 2$  anchors Ø 65–A plate Ø 58/6

Manufacturer(s) (selection) Bierbach GmbH & Co. KG Bulldog-Simpson GmbH

*Manufacturer* Trade *Manufacturer* Trade



Anchors DIN 1052

## Material

Anchors are bin-shaped fasteners made of round steel with headless chamfered ends; they are driven into pre-drilled holes. The bore must not be greater than the diameter. Minimum diameter 6 mm, in use 8-10-12-16 mm. Lengths 60-160 mm.

## Use

Fitted by har d; the number and size of anchors required is to be calculated in relation to the load and type of load and to the thickness of the material and the installation location.

The anchor spacing is determined in relation to the diameter and to the position of the anchors vis-à-vis the load-bearing edge and the direction of the grain. Steel sheet timber joints using anchors require a minimum thickness of 3 mm for the internal sheets.

At least 2 an chors are required per joint.

## Material

Steel S 235, 3 275, S 355 in accordance with EN 10025 Surface galvanised/stainless steel

Ordering DIN Diameter Length Steel quality Surface

E.g. S Ancher DIN 1052 Ø 16 × 160 S 235, galvanised



Bolts Bolts DIN 601, DIN 931, DIN 933, DIN 6914

## Material

Bolts are pin-shaped fasteners made of round steel with heads, threads and nuts; they are driven into drilled holes with a maximum diameter 1 mm greater than their own, with washers on each side. Diameter M8–M24 (for load-bearing connections greater than 12 mm), Length 16–200 mm.

Bolts should be fitted so that they can be re-tightened to compensate for wood shrinkage.

## Use

The numbers and dimensions of the bolts are calculated in relation to the different hole soffit strengths, e.g. of solid wood, glued laminated timber, wood-based material or sheet steel-to-timber joints. The direction of the grain must be taken into account when determining distances to the load bearing and non-load bearing edges.

## Ordering

Bolts Steel quality 3.6, 4.6/4.8, 5.6/5.8, 6.8 in accordance with EN 20 898 Surface hot-dip galvanised

E.g. B M16 (Ø 16) DIN 1052



Shear pins DIN 7968

## Material

Shear pins are bolts, which – like anchors – are driven into tight pre-drilled holes. Diameter M12–M24, Length 35–100 mm.

# Use

Shear pins are used for securing anchor connections.

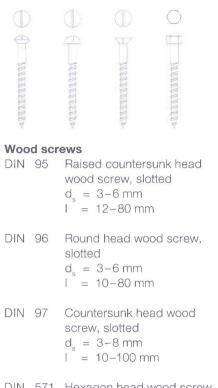
#### Ordering Stool abox

Steel shear pins Surface hot-dip galvanised Diameter, DIN

E.g. PB M16 (Ø 16) DIN 1052

Manufacturer(s) (selection) Bossard AG Schrauben Manufacturer(s) (selection) Bossard AG Schrauben

## Screws



DIN 571 Hexagon head wood screw  $d_s = 4-20 \text{ mm}$ I = 20-350 mm

#### Use

The screw spacing as for pre-drilled nails. Pilot hole:

smooth shank with d.,

threaded portion with 0.7 d.

Load-bearing assemblies:

Nominal diameter d<sub>s</sub> = min. 4 mm Observe minimum thicknesses of building elements to be connected.

*Material* Steel

- natural bright
  - galvanised
  - nickel-plated
  - brass-plated

Ordering Quantity Abbreviation Sr Nominal diameter × length in mm DIN Surface

E.g.  $10 \times Sr \emptyset 8 \times 50 - DIN 97$  galvanised.

Manufacturer(s) (selection) Altenloh, Brinck + Co Bierbach GmbH & Co. KG Bossard AG Schrauben MAGE Gehring GmbH Adolf Würth GmbH & Co. KG

# Dry wall screws

-

DIN 18182 Dry wall screws for fastening plasterboard, phosphated  $d_s = 3.5 \text{ mm}$ l = 25-70 mm

## non-standardised

chipboard screws countersunk (Spax) with • cross recessed head, • posidrive cross recessed head, • Torx hexagon socket d<sub>s</sub> = 2.5-10 mm

l = 10-400 mm

#### Use

Self-tapping, usually inserted without pilot holes.

#### *Material* Steel

- galvanised
- phosphated (partially)
  - stainless

Ordering

- Quantity Abbreviation Sr/Type Nominal diameter × length in mm DIN (for dry wall screws for fastening plasterboard) Surface
- E.g. 10 × Sr Ø 3.5 × 40 DIN 18182 phosphated

#### Staples



## Staples

U-shaped bent wires, Diameter d<sub>n</sub> 1.2–2.0 mm. Back min. 15 mm. Length of shank approx. 30–90 mm.

#### Use

Fitted by hand or with a nail gun, in accordance with the German building authority certification.

#### *Material* Steel

electrogalvanised
 rustproofing paint

#### Ordering

Staples Wire diameter  $d_n \times \text{length of shank } I_n d_n$ ,  $I_n$  in mm Staple spacing e in mm

#### E.g. KI 1.53 × 44 e = 7.5

Manufacturer(s) (selection) Altenloh, Brinck + Co Bierbach GmbH & Co. KG Bossard AG Schrauben Adolf Würth GmbH & Co. KG Manufacturer(s) (selection) Raimund Beck KG Joh. Friedr. Behrens AG Bostitch GmbH Duo-Fast GmbH Haubold-Kihlberg Karl M. Reich Paslode GmbH

#### Nails



Nails DIN 1151 wire nails DIN 1143 machine nails

Smooth sharik, mostly round nails, Diameter d<sub>r</sub> from 1.8 to 8.8 mm. Length I<sub>n</sub> from 35 to 260 mm. Countersunk, deep countersunk, compression, flat-head, clout, round-head or lentil. Head cliameter in accordance with EC 5 min. 2 d<sub>e</sub>.

## Use

The numbers and dimensions of the nails used are to tie calculated to take into account the inaterial, its thickness and the installation location (single-, double- or multi-jointed). The impact depth and the spacing of the nails from the edge and from each other is dependent on the thickness of the material, the wood species and grade as well as on the materials that are to be ointed (e.g. solid wood with wood-based material, steel, concrete....). By using pilot holes (< 0.9 d<sub>2</sub>), the splitting effect of the nails can be diminished, the spacing reduced and the load-bearing capacity increased. Nails should not be used in cross-grained timber, not even for lower level building elements.

## Material

- Steel natural bright
  - electrogalvanised
  - hot-dip galvanised
  - · possibly tempered
  - stainless

aluminium (rartially); copper (partially)

### Ordering

- Type of nail, E<sup>I</sup>N, Diameter d<sub>a</sub> < Length I d<sub>a</sub> in 1/10 mm, I<sub>a</sub> in mm Material Surface
- E.g. nails 38 x 100 DIN 1159, steel hotdip galvanised

Manufacture (s) (selection) Bierbach GnibH & Co. KG Bossard AG Schrauben



## Special nails

Special nails, with the German building authority certification, in load-bearing capacity categories I – III. V.a. for nailed joints using sheet steel brackets.

#### Groove, ridge/anchor nails

with horizontally profiled shank (barbed profile). Diameter  $d_{\rm p}$  from 2.5–6 mm. Length In from 35–100 mm.

# Self-piercing screws/rafter nails

with screw threads. Diameter d<sub>a</sub> of 4.2 and 5.1 mm, Lengths I<sub>a</sub> from 100-320 mm.

#### Use

Use in accordance with the German building authority certification

#### *Material* Steel

- electrogalvanised
  - phosphated
  - stainless

Ordering Type of nail d<sub>n</sub>/l<sub>n</sub> Material Surface

E.g. ridge nail 4/50, electrogalvanised product..... load-bearing capacity category III

Manufacturer(s) (selection)

Bierbach GmbH & Co, KG

BMF Holzverbinder GmbH

GH-Baubeschläge Hartmann GmbH

Bulldog-Simpson GmbH



#### Nail plates

These are 1–2 mm thick steel sheets with nail or claw-shapes punched and bent out on one or both sides. The German building authority certification has been issued for the different systems e.g. BAT-Multin, BMF, Gang-Nail, Hydro-Nail, TTS Twinaplatte.

## Use

The size of the nail plates must be calculated. The nail plates are pressed into the equally thick (single) timbers using hydraulic jacks.

Material Hot-dip galvanised steel

Ordering Nail plates Size b × h in mm, Type

E.g. NaPl 66 × 166 GN 200

Manufacturer(s) (selection) Eleco Bauprodukte GmbH (Gang-Nail) Mi-Tek Industries GmbH (Hydro-Nail) J. Wolf GmbH & Co Systembau KG (Wolf Nagelplatten)

Information

Informations- und Gütegemeinschaft der Nagelplattenverwender e.V.

## Sheet Steel Brackets

Sheet steel brackets are made out of 2–4 mm thick sheet steel, punched and cold-formed.

A German building authority certification has been issued for the various shapes and their mountings. The terms used to describe the same fastenings vary from supplier to supplier.

The selected sheet steel brackets do not represent the complete product range, and relate to the forces appearing in the examples chosen.

The use of modern beam constructions has rendered traditional carpentry joints affordable once again. For this reason they are being increasingly used in modern wood construction.

## Use

Sheet steel brackets are fastened with authorized special nails that are chosen according to the installation location. (wood-to-wood, wood-to-concrete/steel)

Material Hot-dip galvanised steel, Stainless steel (partly)



# Perforated steel strips

Use As connectors for smaller constructions.

Dimensions 20  $\times$  1.0/1.5 mm 25  $\times$  2.0 mm

 $\begin{array}{l} \textit{Ordering} \\ \textit{Dimensions, Type} \\ \textit{Nail type, } \textit{d}_n \times \textit{I}_n \end{array}$ 

#### **Canvas** bands

#### Use

For bracing roof constructions. Tighten to ensure the load-bearing capacity e.g. using a ratchet clamp.

Dimensions 40 × 2.0/3.0 mm 60 × 2.0 mm 80 × 2.0 mm

Ordering Dimensions, Type Nail type,  $d_n \times l_n$ 

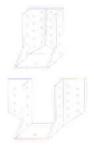
## Flat connector

Made of perforated panels in different, partially standardised dimensions.

Use For connecting flat building elements.

Ordering Dimensions, Type Nail type,  $d_n \times I_n$ 





#### Angle connectors

As a perforated plate angle or from punched sheet

Use For connecting and fastening.

Ordering Dimensions, Type Nail type,  $d_n \times I_n$ 

#### **Z-Profile**

Use For the frontal fastening of the crossbeams to the main beam.

Ordering Dimensions  $b \times h$  (mm) Manufacturer, Type Nail type,  $d_a \times l_a$ 

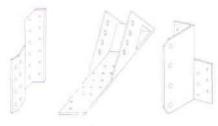
## **Beam hangers**

One or two-piece, sides bending inward or outward.

Use To fasten beams to beams/ walls.

Dimensions For wood widths from 36–200 mm with fixed heights. Customised dimensions may sometimes be ordered.

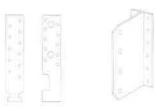
Ordering Dimensions Manufacturer, Type Nail type,  $d_n \times l_n$ 



# Rafter-to-puriin connectors/purlin anchors

Use For connecting crossing beams.

Ordering Manufacture:, Type Nail type, d. <1,



## Track anchors/profile anchors/wood connection anchors

Use To fasten wooden elements into anchor tracks or with steel profiles.

Ordering Manufacturer, Type, Length Nail type, d, × l,

# Rafter foot joints/rafter holders

Use For connecting rafters to inferior purlins or ceilings.

Ordering Manufacture:, Type, Length Nail type, d < I

## Main and cross beam-connectors/ integral connectors

## Use

For connecting main and cross beams. Fastened to the main beam/pillar with special nails slotted into the crossbeam and fixed with anchors.

Dimensions Heights from 80–240 mm

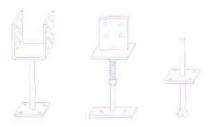
Ordering Manufacture , Type Anchor/nail t/pe, d, × l,

## Beam supports/suspended supports (T-shaped)

Use For fastening crossbeams to the main beam or from beams to pillars. Fastened to the main beam/pillar with special nails; slotted into the crossbeam and fixed with anchors.

Material Hot-dip galvanised steel

Ordering Type, Quantity, Dimensions Nails/anchors



## Pillar bases

Use

Pillar bases (pillar bracket, post holder) serve to connect the pillar with the foundation or the ceiling. The connection is made by fixing base plates and dowels onto the concrete or by using ribbed rock dowels and grouting in the recesses in the concrete.

A distinction is made between the following types:

- Pillar base made of U-shaped bent flat steel with a welded-on wing rod or circular tube.
   Fastened with wood screws or anchors, fixed or height adjustable.
- Pillar base made of T-profile with welded-on wing rod or circular tube.
   Fastened with wood screws or anchors, fixed or height adjustable.
- Pillar base made of round steel or threaded rod with plate (glulam pillar support).
   Drilled and secured with a steel spike and if necessary glued, fixed or height adjustable
- Pillar base made of two flat steel profiles.
   Fastened with wood screws

Ordering Company-specific type designation

Manufacturer(s) (selection) Hot-dip galvanised steel Bierbach GmbH & Co. KG (BILO Formteile) BMF Holzverbinder GmbH Bulldog-Simpson GmbH GH-Baubeschläge Hartmann GmbH

## Wood Preservation

DIN 68800 1 to 5 DIN 68364 DIN EN 350-2 DIN EN 460

Wood and wood-based materials are at risk from vegetable pests (fungi) and animal pests (insects). When infestation occurs, the outward appearance, the efficiency and the load-bearing capacity of wooden structures can be reduced to such an extent that they are completely destroyed.

*Fungi* require organic material (cellulose) for their development. They thrive particularly well in moist, warm areas without an air-flow. There are different types of mould, e.g. "real dry rot". As a rule the rot caused by fungi requires a wood moisture content of at least 20%.

*Insects*, primarily beetles, e.g. wood ticks, use the sap area of the wood (predominantly softwood), as a source of food and to house their larvae. The fully developed ticks leave the wood through characteristic entrances. Not only living trees can be attacked, but also dry built-in timber. A wood moisture content of at least 10% is a precondition for infestation.

Wood preservation is subdivided into remedial wood preservation, which is necessary when infestation has already taken place, and preventative wood preservation, which stops infestation by destroying the preconditions under which the pests thrive.

Preventative wood preservation Preventative wood preservation can be achieved in several ways:

- wood selection
- wood preservation by design
- chemical wood preservation

#### Wood Selection:

It is important to select well-dried and seasoned timber (wood moisture content u < 20 %) and, where possible, to use a timber species with great durability or high resistance (see appendix).

## Structural wood preservation:

This must be taken into consideration during the design phase e.g. when choosing the location of the building, designing the facade or planning protective roof projections. When working out the details, however, what must be avoided, above all, is contact to the ground, the formation of condensation, and continual moisture penetration of the wood by rain and splashing water. Damp timbers must be able to dry out. Thus a fundamental aspect of structural wood preservation involves aerating and ventilating the construction and the building element layers in order to allow any moisture to escape.

Chemical wood preservation: Fungus and insect infestation should be prevented by using chemical wood preservatives.

DIN 68800-3 differentiates between chemical wood preservatives for:

- load-bearing and reinforcing wooden building elements
- non-bearing timbers which are dimensionally unstable
- dimensionally stable non-bearing timbers for windows and exterior doors

Preventative wood preservation is compulsory for load-bearing building elements. However chemical wood preservatives are only required for certain hazard classes, which are listed in DIN 68800-3 (see appendix). The standard merely makes recommendations for non-bearing building elements which are dimensionally unstable. If written agreement has been reached between the architect and the builder, the wood need not be chemically preserved. Large-area application of wood preservatives should generally be avoided on the interior.

Chemical wood preservatives need not be used on windows and exterior doors if heartwood complying with certain durability grades is used (see appendix).

Durability grades in accordance with DIN 1052:

Grade	Description
1	very durable
2	durable
3	reasonably durable
4	not very durable
5	non-durable

Hazard classes:

Under DIN 68800-3, timber building elements and wood-based materials are allocated a hazard class ranging from GK 0 to GK 4 – not at risk to highly at risk – according to their area of application. Hazard class 0 does not require chemical wood preservation,

The application of chemical agents is not mandatory for classes GK 1 to GK 4 either, e.g. if timbers are used which are considered sufficiently "naturally durable" for the hazard class in question.

A special certificate can also be obtained to assign a structure to a lower hazard class. To obtain this certificate, special structural measures must be taken to destroy destructive fungi and prevent insects from accessing covered timbers. A wood moisture content of below 20 per cent is required to avoid fungal decay. Insect attacks can be prevented by taking structural protection measures, e.g. by using suitable cladding or by keeping the wood moisture content below 10 per cent. If the wood remains open and can be inspected for insect attacks, chemical wood preservatives can also be avoided, e.g. in undeveloped roof trusses, if accessibility is ensured.

Nearly all load-bearing and reinforcing building elements can be classified as GK 0, with the exception of sills (GK 2). Chemical wood preservatives can also be dispensed with here if sap-free pine, larch or Douglas fir is used.

Chemical wood preservatives: Wood preservation by design should be given priority in every case when building wood constructions. If it is pursued consistently chemical wood preservatives can be avoided completely. Even under DIN, preventative chemical wood preservation is only a supplementary measure, and should be taken only when wood selection and design measures prove inadequate.

DIN 68800-3 specifies how the wood preservatives are to be applied:

- according to the inspection grades:
- insect repailing lv
- inimical to mould P
- weatherproof W

- inimical to mildew E, each preservative can be applied individually or in combination depending on the hazard class.

- according to the wood species (round timber, savin timber, laminated wood ...)
- according to the method of application (painting, spraying, dipping, borehole impregnation, vacuum and boiler pressure impregnation ...), including possible pre-treatments of wood species that are difficult to impregnate and the appropriate amounts to be applied for the hazard plasses stipulated, whilst observing occupational health and safety measures.

Pay attention to the manufacturers' instructions.

Wood preservatives can be divided into: • water soluble wood preservatives,

- solvent based wood preservatives,
- oleaginous wood preservatives.

Water soluble wood preservatives: These preservatives contain inorganic or organic salts as agents which act as biocides.

A problem with inorganic water-soluble wood preservative salts is leaching caused by moisture, e.g. rain. Salts for hazard classes 1 and 2 are always leachable and need to be covered on site to protect them against moisture. Non-leachable salts for hazard classes 3 and 4 contain chromates (chrome-VI-compounds) and require a fixing period of several weeks in the wood. They need to be stored and protected from rain during this time.

Organic water-soluble salts are approved for hazard classes 3 and 4 and fix in wood without the addition of chromates.

Solvent based wood preservatives: These comprise organic solvents and organic compounds which act as biocides. There is a controversial public debate about some of the fungicides and insecticides used (e.g. pyrethroid). Specific problems arise when pentachlorophenol (PCP) and lindane-containing agents are used indoors. For this reason PCP has been banned in Germany since 1990.

Oleaginous wood preservatives: These are creosote compounds and creosoles.

## Processing:

For reasons of occupational health and safety during processing, and to protect subsequent occupants from exposure to the agents and solvents contained in the wood, it is principally recommended that closed equipment be used to introduce the preservatives into the wood (boiler pressure impregnation, possibly also trough impregnation, spray tunnel procedure). The processing of wood preservatives on the construction site should be limited to the treatment of sawn edges, etc. Furthermore, the wood preservative should be applied by brush and not sprayed.

#### Identification:

Only products whose effectiveness and harmlessness have been demonstrated in tests may be used as chemical wood preservatives. They are subject to the approval mark regulation of the German *Länder* and are issued with the Institute of Structural Engineering in Berlin approval mark when their usability has been proven.

The area of constructed wood that has been treated must be provided with longterm visible identification by the contractor in accordance with DIN 68800-3.

#### Waste disposal:

Remains of wood preservatives as well as empty containers and contaminated packages are hazardous waste. Timber treated with wood preservatives must be incinerated as hazardous waste. Landfilling is prohibited.

Manufacturer(s) (selection) AURO-Pflanzenchemie GmbH Beeck GmbH & Co KG Desowag GmbH Kulba-Bauchemie GmbH Leinos-Naturfarben GmbH Livos Pflanzenchemie GmbH RCH Fluorchemie GmbH Remmers Chmie GmbH & Co Wehl GmbH Dr. Wolmann GmbH

#### Information

The Deutsche Institut für Bautechnik (DIBt) Berlin (German Institute for Structural Engineering) issues a list of approved wood preservation products annually.

Gütegemeinschaft Holzschutzmittel e.V.

## Joint sealing tapes

DIN 18542

### Material

Open-pored and closed-cell materials are used for joint sealing tapes.

Common types of sealing tapes are:

- foam sealing tape
- silicon sealing tape
- butyl rubber tape

Open-pored sealing tapes are made of polyurethane soft foam, for example, which is impregnated with pre-set flameretardant synthetic resin, partially impregnated with bitumen, and can be pre-compressed at the factory for the application in question.

Closed-cell materials made of plastic are usually used for damp-proofing.

Open-pored materials have good sound insulation properties, but are only effective as damp- and wind-proof seals when compressed.

Joint sealing tapes are available as single or double-sided adhesive tapes.

## Use

Joint sealing tapes are used to functionally connect building elements and building element layers to each other. According to the level of compression, they are either driving rain or wind-proof, and can therefore create both rain and wind barriers along joints.

To prevent the formation of condensation at a joint's edges, the joint must have a vapour-tight structure on the inside. For invitations to tender and orders:

- Manufacturer
- Thickness
- Width
- Length
- Colour

Calculated per metre

## Processing:

Sealing tapes are normally supplied precompressed (to approx. 20 per cent of the original thickness), whereby the retraction to the width of the joint is so gradual that it allows sufficient time during application to position the tape into the joint.

The seal effect of the joint sealing tape depends on its residual compression when in position:

< 20 %	Delivery condition
up to 25 %	requirements in
	accordance with
	DIN 18542
up to 35 %	seals against strong rain,
	good sound insulation
up to 50 %	water repellent,
	draught-proof, dust-tight
100 %	original thickness

The adhesive strength at the edges of the joints is primarily determined by the restoring force of the expanding tape. The self-adhesive tape surface serves as an application aid.

Dimensions: Length of reel [m]: 2–10, according to thickness Thickness (uncompressed) [mm]: 10–150 Width [mm]: 10–1,000 Manufacturer(s) (selection) Hanno-Werk GmbH & Co.KG Henkel Bautechnik GmbH Henkel Teroson GmbH Illbruck Bautechnik GmbH KAWO Karl Wolpers Sika Chemie GmbH



## **Built Examples**

- 81 Temporary Bank in Nuremberg aml architekturwerkstatt
- 82 Weekend House in Vallemaggia Robert Briccola, Gibiasco
- 84 House near Bad Tölz Fink + Jocher, Munich
- 86 Church Community Centre and Youth Centre in Lenting Andreas Meck und Stephan Köppel, Munich
- 88 Housing Development in Trofalach Hubert Riess, Graz
- 90 Lakeside Bathing Facilities in Zug, Switzerland Alfred Krähenbühl, Zug
- 92 School Building in St Peter, Switzerland Conradin Clavuot, Chur
- 94 Media Library in the Cantonal School in Küsnacht
   Bètrix & Consolascio mit Erich Maier, Erlenbach
- 96 Parquet Showrooms in Lindau Karl Theodor Keller, Munich

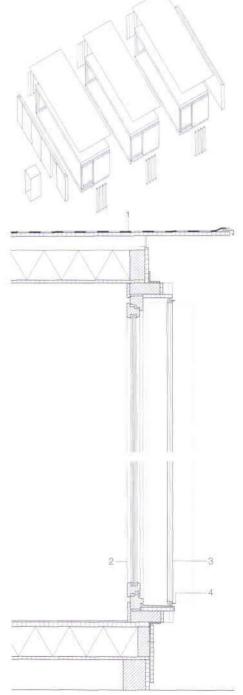
## Temporary Bank in Nuremberg

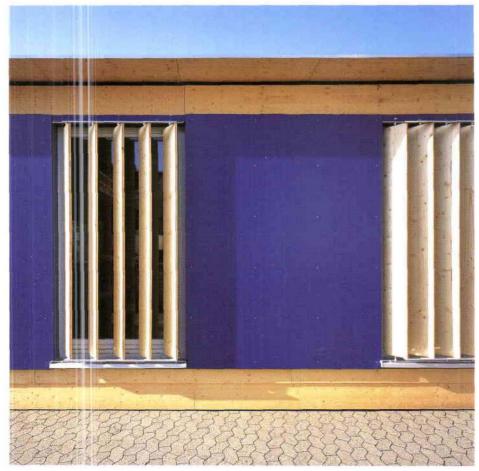
aml architekturwerkstatt Matthias Loebermann, Nuremberg

The "Blue Box" meets the requirements of the brief by providing a flexible, low-cost, temporary structure with a pleasant internal ambience. The modular system consists of a basic unit 3 m wide and 9 m long. Three modules are combined here to create a single structure  $9 \times 9$  m on plan with a room height of 2.50 m. The elements are laid on a supporting base, consisting of three beams. The wall, roof and floor panels are in timberframe construction with insulation. To reduce the span of the minimally sloping roof, a row of columns was inserted along the middle of the space. A room-height window can be installed in every module, with pivoting louvres to provide sunshading. The system can also be used for exhibition or information pavilions.

- 1 roof construction: waterproof membrane 19 mm three-ply laminated sheeting 40 mm ventilated cavity; 40–80 mm wood firrings 160 mm thermal insulation; 80/160 mm timber rafters
- 15 mm oriented strand board 2 softwood casement with insulating double glazing
- 3 30 mm five-ply larch laminated sunshade louvres
- 4 flat steel movable fixing for louvres

Isometric (not to scale) Vertical section scale 1:20





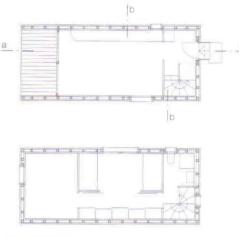
## Weekend House in Vallemaggia

Reflecting the tradition of the Walser Valley granaries, this small weekend house was designed to impinge as little as possible on the natural surroundings. The siting of the simple cubic volume allows for later additions. Raised on four corner piles, it seems to hover above the Alpine meadow.

The ground floor houses the entrance, living and dining areas, with an integrated kitchen strip. The living realm extends out into a sheltered loggia. On the upper floor are two simple sleeping cells and a shower. Apart from the concrete piles and the raking, welded-steel porch, the house is entirely in timber. The structural elements are in fir. Externally, the house is clad on all faces with larch boarding. Internally, it is lined with three-layer laminated sheeting. Q1 DETAIL 3/2001

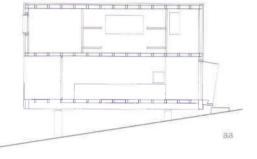
Floor plans · Sections scale 1:200

Roberto Briccola, Giubiasco



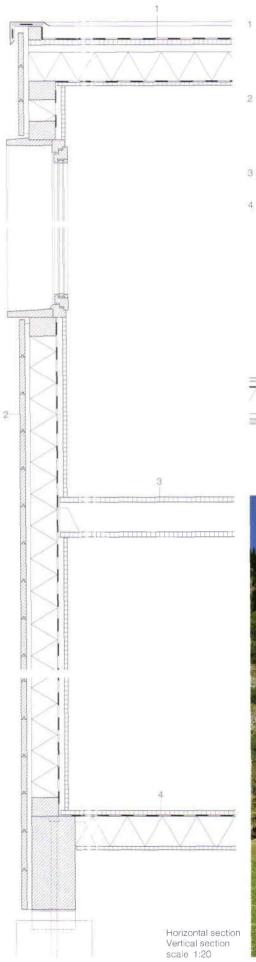


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## **Timber Structures Built Examples**

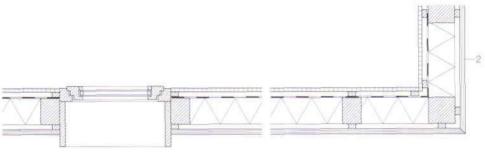


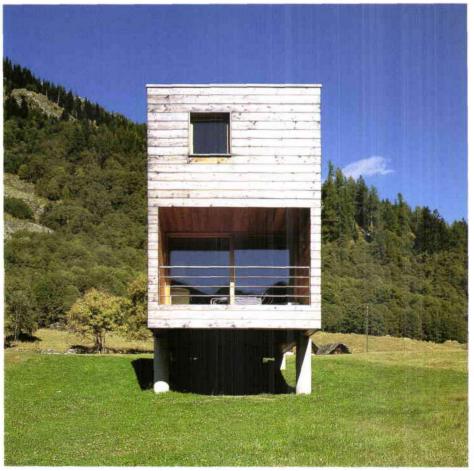
1 roof construction:

plastic sheet sealing layer 27 mm three-layer fir laminated boarding 160 mm mineral-wool thermal insulation 100/200 mm fir rafters

- vapour barrier
- 19 mm three-layer fir laminated boarding wall construction: 27 mm larch tongued-and-grooved boarding 27 mm battens 140 mm mineral-wool thermal insulation
- vapour barrier 27 mm battens
- 19 mm three-layer fir laminated boarding
   27 mm three-layer fir laminated boarding
   100/160 mm fir rafters
- 19 mm three-layer fir laminated boarding 4 27 mm three-layer fir laminated boarding
- vapour barrier 160 mm mineral-wool thermal insulation 19 mm oriented-strand board







Timber Structures Built Examples

## House near Bad Tölz

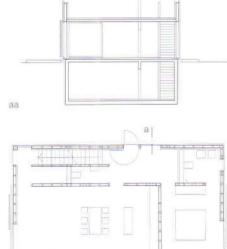
Fink + Jocher, Munich Dietrich Fink Thomas Jocher

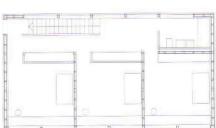
Erected within a period of nine months with prefabricated timber elements, this two-storey, low-energy house reflects the vernacular of the local farm buildings through the use of a few simple details. The transparent areas in the north facade were kept to a minimum in order to reduce energy losses. To avoid extremes of temperature, sliding shutters with louvres set at different angles were installed for the large areas of glazing in the south, west and east faces.

The timber stud walls were based on the American balloon-frame system, using full-height elements with continuous vertical members. The walls are in a two-skin form of construction and are braced by the internal plywood lining. The inner leaf, in which the mechanical services are housed, bears the loads from the floor, which stops short of the vapour barrier. This ensured a simple assembly of the house and a safe, airtight construction. The wall is insulated with a total thickness of 22 cm cellulose fibre. The problem of noise transmission via the continuous vertical studs was reduced by building the inner leaf of the wall with horizontal members. The floor is in a simple, hand-nailed vertically stacked plank construction. The advantage of this system is that it allows the use of cheaper offcut products. The floor also has great rigidity, with a structural depth comparable to that of a reinforced concrete slab. No chemical preservatives were used for the wall, floor or roof timbers. III DETAIL 1/1998

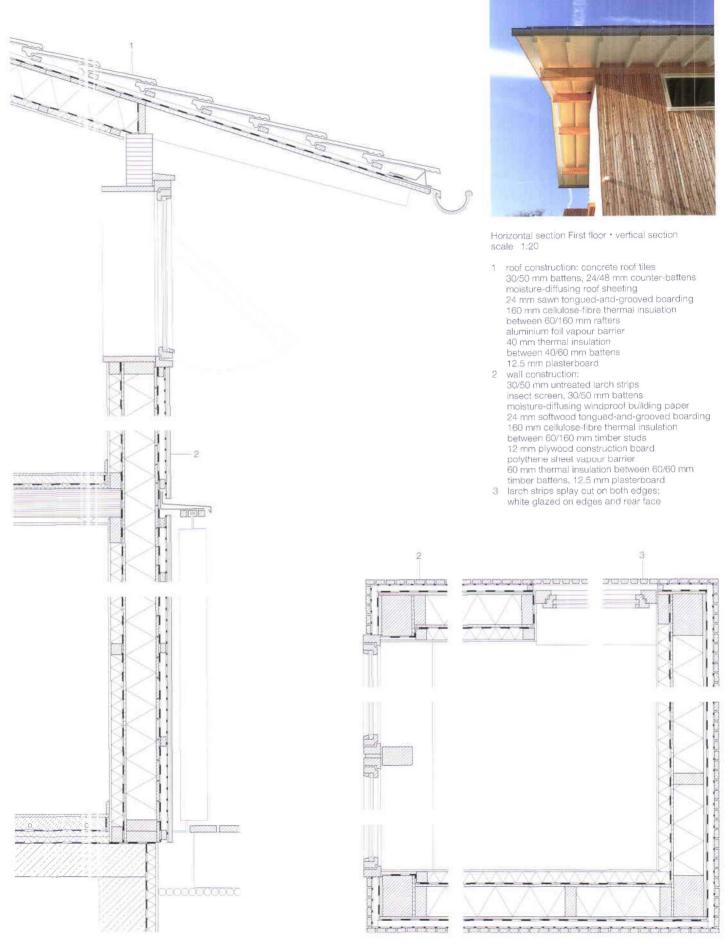
Floor plans - Section scale 1:250







al



**Church Community Centre** and Youth Centre in Lenting

Andreas Meck und Stephan Köppel, Munich

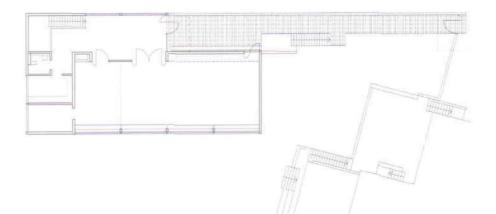
This lightweight, largely prefabricated timber structure was erected close to the site boundary, with the hall and group rooms overlooking the garden. Access from the road is via an elevated walkway, with the entrance to the community centre at upper floor level. The large hall can be divided into smaller units by sliding partitions that disappear into recesses in the wall.

The youth centre on the lower floor has its own entrance, but is linked with the main foyer by an internal staircase. The walls are in timber stud construction braced on both faces with oriented-strand board sheets. The roof over the hall is a nailed beam structure, while the floors are in a stacked plank form of construction. The external walls and foyer walls are clad in larch boarding in a warm red tone.

DETAIL 1/2000

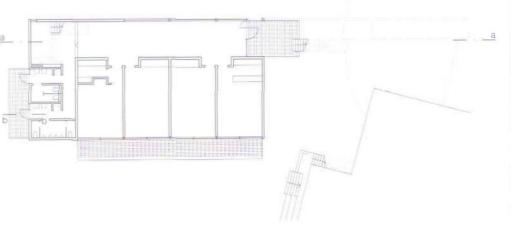




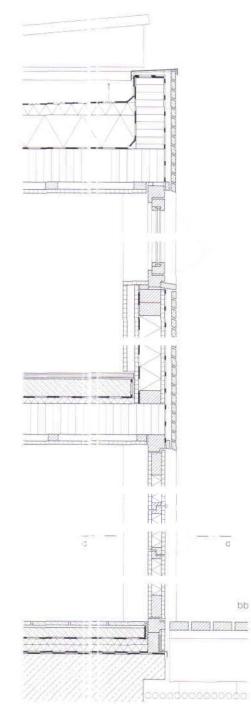


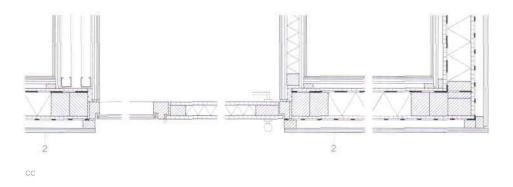
Longitudinal section Upper floor plan Ground floor plan scale 1:400



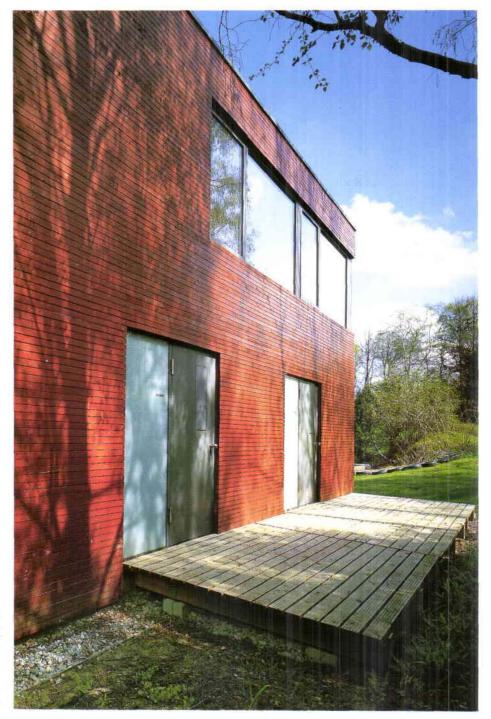


- roof construition: 1 2 mm plastic sealing layer 180-280 mm insulation finished to falls 2
- 180–280 mm insulation finished to falls vapour barri in 180 mm veri cally stacked plank floor 30/50 mm pattens 18 mm beech-laminated board wall construition: 24/52 mm alch cladding 40/60 mm pattens windproof a /er 15 mm oriented-strand board 130 mm the mall insulation vapour barri in 15 mm oriented-strand board 30/50 mm pattens 2x 12.5 mm plasterboard 8 mm mosaib lies 8 mm mosai : iles





Horizontal section • vertical section scale 1:20



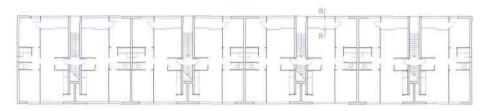
## Housing Development in Trofaiach

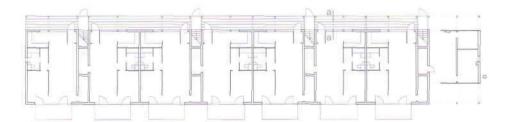


#### Hubert Riess, Graz

This housing development, which occupies an entire street block, comprises two three-storey linear tracts with a protected landscaped zone between them. The strips are divided by straight-flight staircases that extend over the full width of the blocks. Each staircase provides access from the courtyard side to two dwellings on each floor. The dwellings themselves have an east-west orientation.

All external walls and party cross-walls are load-bearing and were prefabricated in storey-height units. The facade elements, extending over the full width of a dwelling, are connected by laminated timber beams and fixed to the floors. The roofs and staircases are also in a prefabricated unit construction system. DD DETAIL 4/2001





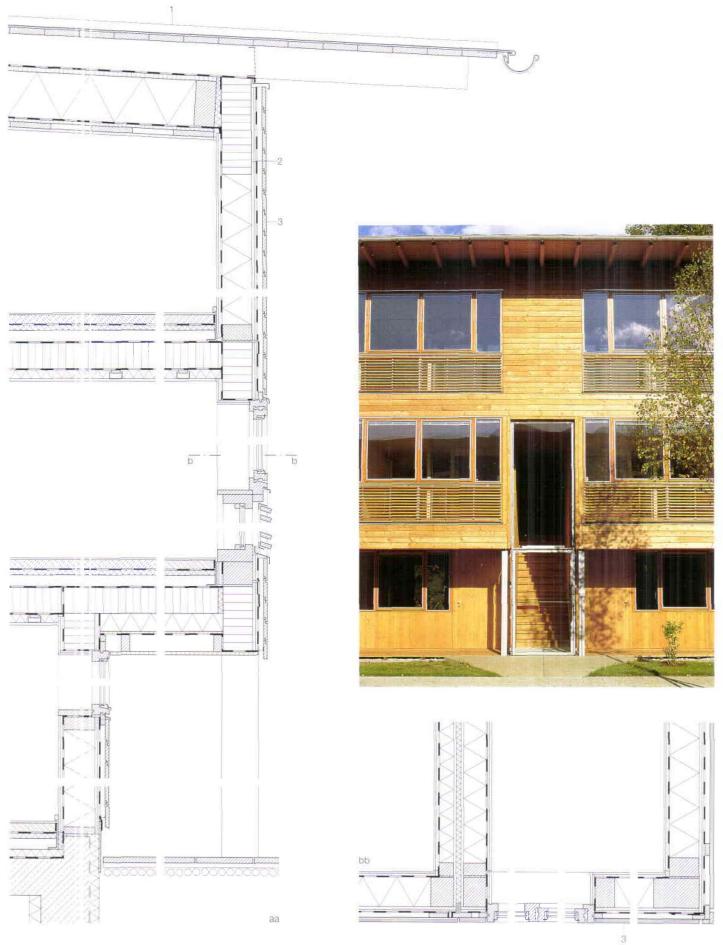


Floor plans scale 1:500

Horizontal section Vertical section scale 1:20

ť. stainless-steel standing-seam roofing, leaded 30 mm sawn timber boarding 80/180 mm timber rafters, ventilated windproof building paper 19 mm chipboard 240 mm thermal insulation between 100/240 mm softwood purlins polythene sheeting 19 mm chipboard 24 mm open-joint boarding 15 mm gypsum fibreboard 160/480 mm laminated timber beam 23 19 mm larch boarding 30/60 mm battens windproof building paper 10 mm gypsum fibreboard 12.5 mm gypsum fibreboard 160 mm thermal insulation between 80/160 mm softwood posts polythene sheeting with welded joints

12.5 mm gypsum fibreboard 10 mm gypsum fibreboard

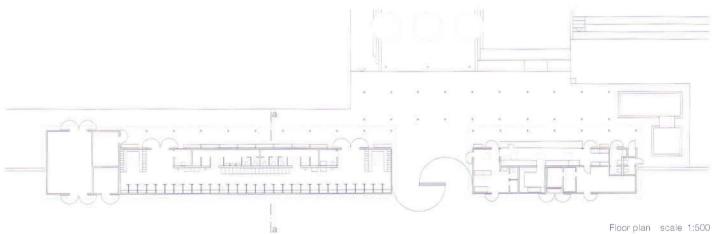


Timber Structures Built Examples

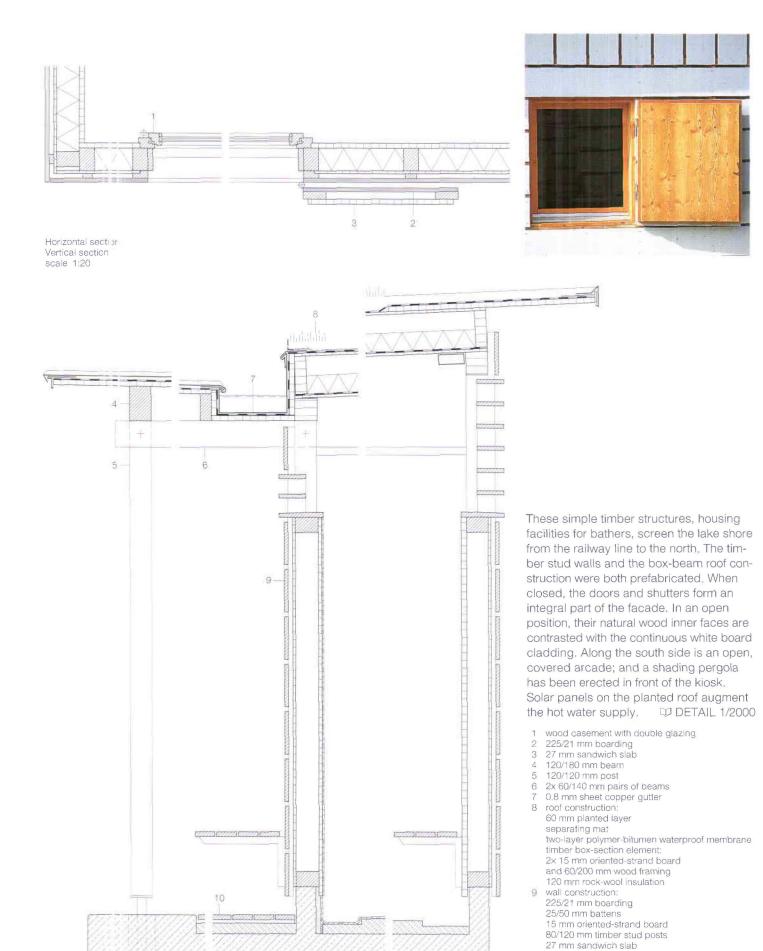
# Lakeside Bathing Facilities in Zug, Switzerland



Alfred Krähenbühl, Zug







School Building in St Peter, Switzerland



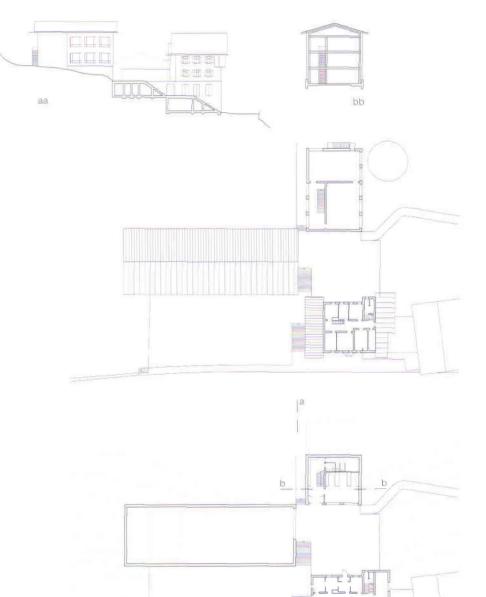
Conradin Clavuot, Chur

The new complex is well integrated into the intact local vernacular. The external walls of the school building are in a twolayer form of construction. The inner layer consists of a flexible system of 11.5 × 20 cm planed, tongued-and-grooved, but otherwise untreated horizontal beams. Shrinkage in the beams, caused by the drying out of residual moisture, together with heavy snow loads in winter, results in movement within the walls, which are up to 36 m long and 7.5 m high. To allow the wall beams to settle and still perform a load-bearing function, they are flexibly "laced" to fan-dovetailed sections screwed to a rigid system of vertical posts. The thermal insulation, casements and larch facade boarding are also fixed to the rigid posts. DETAIL 1/2000

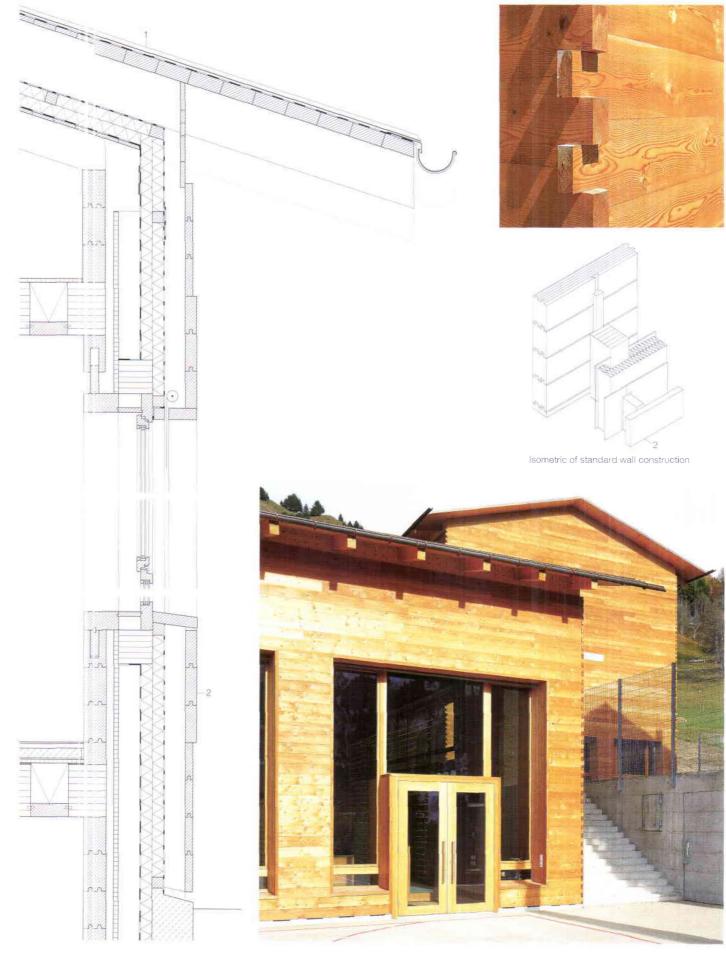
Sections Fourth floor plan Second floor plan scale 1:800

Section through facade of school building scale 1:20

- 1 roof construction: sheet copper roofing separating layer 27 mm boarding; 75 mm to projecting eaves 260/310 (160) mm beams waterproof membrane 2x 60 mm rock-wool insulation vapour barrier 27 mm boarding 120/200 mm joists 2 wall construction: 40 and 60 mm larch boarding battens/ventilated cavity windproof paper 2x 60 mm rock-wool insulation vapour barrier 120 mm cavity between posts 25 mm sandwich slab. as bracing only in casement area
  - as bracing only in casement are 45 mm space for service runs 115/200 mm horizontal laced softwood beams



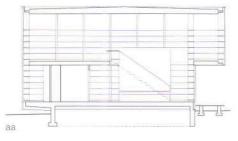
B



# Media Library in the Cantonal School in Küsnacht



Marie-Claude Bètrix & Eraldo Consolascio Eric Maier, Erlenbach

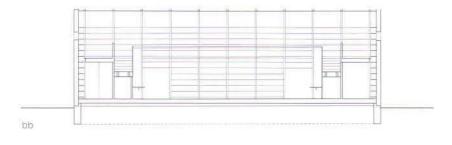


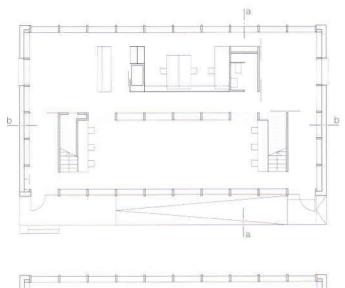
Sections · Floor plans scale 1:250

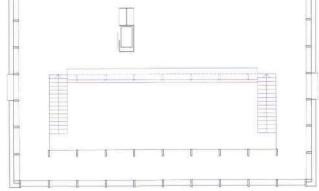
In this new building, which seeks to evoke the spatial atmosphere of classical libraries, the shelving forms part of the loadbearing structure. The closed side walls, the intermediate floor and the roof consist of prefabricated timber box elements. The sides of the shelving, in laminated timber sheeting, function as vertical columns. As tension elements, they also bear the loads from the cantilevered section of the upper floor, which is suspended from the roof. The highly insulated external walls and roof, the extremely low U-value of the glazing, and the controlled ventilation of the internal spaces coupled with a heat recovery system ensure a low energy consumption that complies with the Swiss "minergie" standard. DETAIL 5/2002

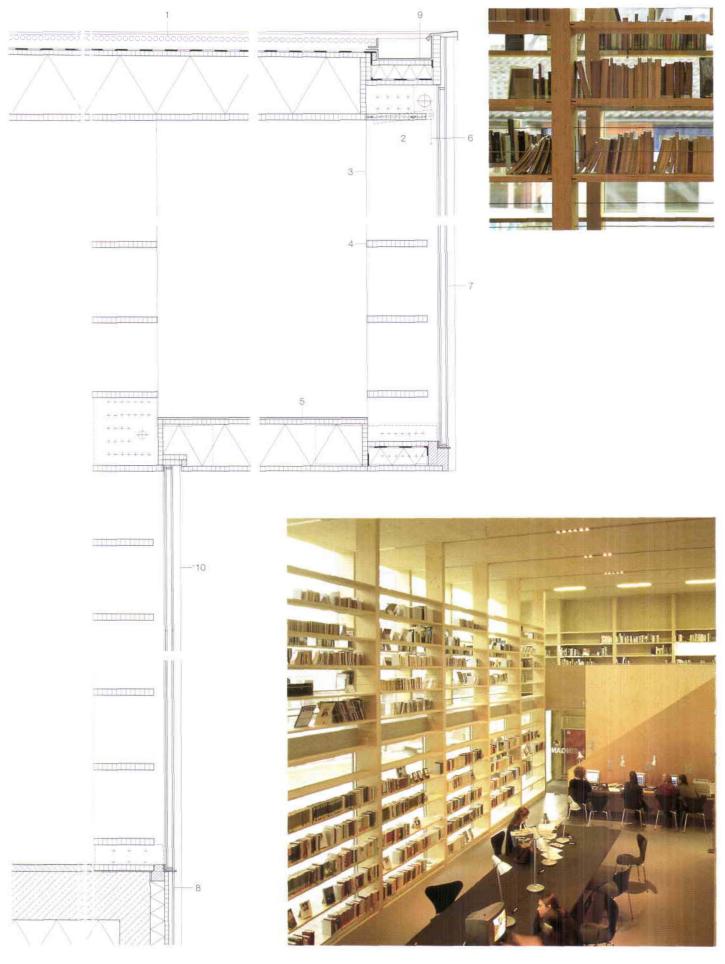
Details section scale 1:20

- 40 mm fine stone chippings on separating layer two-layer waterproof membrane with root-resisting layer
   27 mm laminated timber sheeting
   330-440 mm cellulose thermal insulation
   33 mm laminated timber sheeting
   2 demountable masking sheet
- 3 100/431 mm lam, timber sheet column
- 4 33 mm lam. timber shelf
- 5 6 mm linoleum with cork backing 27 mm lam, timber sheeting 220 mm expanded clay filling 27 mm lam, timber sheeting
- 6 fabric blind
- 7 low-E glazing; U = 0.54 W/m<sup>2</sup>K
- 8 10 mm screen-printed toughened safety glass
- 9 sheet-copper gutter and covering
- 10 softwood cover strip









## Parquet Showrooms in Lindau

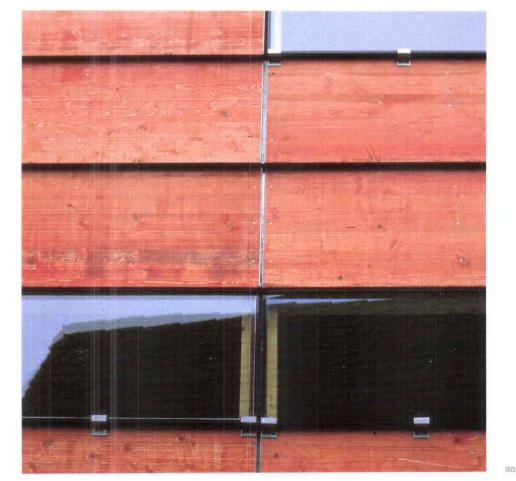


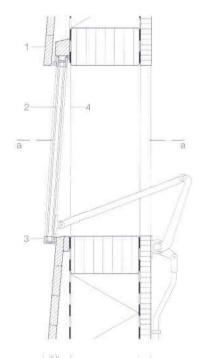
Karl Theodor Keller, Munich

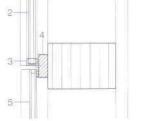
Based on a rectangular plan, this simple building replaces an earlier house of the same form. On the ground floor is a sales area and a store; on the upper floor, an office and exhibition space. The loadbearing structure consists largely of a thermally insulated timber skeleton frame. In the area of the shop, however, the outer walls and the first floor are in a solid form of construction. Externally, the building is clad with common formwork planks articulated by glass strips of the same size. This determined not only the dimensions of the external grid, but also the form of construction. A continuous horizontal band of glazing – openable in part – extends along all faces of the building. It is complemented by conventional windows. QJ DETAIL 7/1998

Standard facade details scale 1:10

- 1 wall construction: impregnated formwork panels with galvanized steel edge strips saw-tooth battens/cavity
- windproof sheeting
- rock-wool insulation between 100/180 mm posts and rails
- vapour barrier
- 16 mm untreated lam, building board
- 2 double-glazing strip; opening light
- 3 stainless-steel frame4 saw-tooth battens
- 5 fixed double glazing







# Appendix

98	Grades
99	Material classes
100	Standards
101	Literature
102	References
107	Subject index
109	Index of projects
110	Picture Credits

Grading criteria for squared timber, visually graded in accordance with DIN 4074-1

Grade characteristics	Grade S 7	Grade S 10	Grade S 13
1. Wane	all four sides must be stripped continuously with a cutting tool	up to 1/3; in each cross- section at least 1/3 of each cross-section side must be wane free	up to 1/8; in each cross- section at least 2/3 of each cross-section side must be wane free
2. Knots	up to 3/5	up to 2/5, not exceeding 70 mm	up to 1/5, no more than 50 mm
3. Avg. width of annual rings for Douglas fir	-	up to 6 mm up to 8 mm	up to 4 mm up to 6 mm
4. Grain slope	up to 200 mm/m	up to 120 mm/m	up to 70 mm/m
5. Cracks: • Radial shakes (checks) • Lightning shakes Frost cracks Round shakes	permissible not permissible	permissible not permissible	permissible not permissible
<ul> <li>6. Stains:</li> <li>blue-stain</li> <li>brown and red stripes: low nail-holding capacity</li> <li>red rot</li> <li>white rot</li> </ul>	permissible permissible for up to 3/5 of the cross section or the surface not permissible	permissible permissible for up to 2/5 of the cross- section or the surface not permissible	permissible permissible for up- to 1/5 of the cross section or the surface not permissible
7. Compression wood	permissible for up to 3/5 of the cross-section or the surface	up to 2/5 of the cross-section or permissible for the surface	permissible for up to 1/5 of the cross-section or the surface
8. Insect holes	boreholes, caused by insects attacking green wood, of up to 2 mm in diameter permissible	boreholes, caused by insects attacking green wood, of up to 2 mm in diameter permissible	boreholes, caused by insects attacking green wood, of up to 2 mm in diameter permissible
9. Misteltoe attack	not permissible	not permissible	not permissible
10. Camber, longitudinal curvature, twisting	up to 15 mm/2 m	up to 8 mm/2 m	up to 5 mm/2 m

Maximum values for the moisture of woods for load-bearing and reinforcing building elements; these values must not be exceeded during the period of use. (Table 2 DIN 68800-2)

Material class	Moisture max u	
20	15 % (12 for fibreboard)	The boards must not become moist, or only to the extent that their moisture content increases over a short period and does not exceed 15 mass-% at any point. Penetrating moisture must be able to escape unhindered.
100	18 %	If surrounding air conditions permit either a higher long-term equilibrium moisture content (EMC) in the boards or a short-term increase in their moisture content provided the latter does not exceed 18 mass-% at any point and any additional penetrating moisture can escape unhindered.
100 G	21 %	If surrounding air conditions permit a higher long-term EMC or higher moisture content in boards and penetrating moisture can only escape over an extended period of time.

## Required material classes (Table 3 DIN 68800-2)

Line	Material class	Area of Application
1 1.1 1.2	20 20 100 20	Cladding on the room side of walls, as well as on ceilings and roofs in residential buildings and in buildings used for comparable purposes. In general: Surface panelling as well as load-bearing or reinforcing panelling of ceilings below attic floors that have not been fitted out. a) ventilated ceilings b) non-ventilated ceilings - without an adequate insulation layer - with an adequate insulation layer (1/Λ ≥ 0.75 m <sup>2</sup> K/W)
2 2.1 2.2 2.3 2.4	100 100 100 100	Outside panelling on exterior walls Ventilated cavity between exterior cladding and weatherproofing skin. Weatherproofing skin, cavity insufficiently ventilated, diffusion-open, and water-draining covering over the panelling. Thermal-insulating composite system directly attached to panelling. Masonry facing shell, cavity insufficiently ventilated, panel covering with: a) water-draining layer with $s_o \ge 1$ m b) HR-foam panels at least 30 mm thick.
3 3.1 3.1.1 3.2 3.2 3.2.1 3.2.2 3.3 3.3.1 3.3.2	20 100 G 100 100 G 100 G 100	Top panelling of roofs, load-bearing or reinforcing roof-boarding Panelling or boarding in contact with the room air Attached thermal -insulating layer (e.g. in residential buildings, heated halls) Without attached thermal -insulating layer (e.g. flat roofs on unheated halls) Roof cross-section ventilated beneath the panelling or boarding Pitched roof with covering Flat roof with moisture-proof roofing Roof cross-section not-ventilated beneath the panelling or boarding Ventilated cavity above the panelling or boarding, material covered on the upper side with water-repelling foil or similar material No vapour-barriers (e.g. foils) beneath the panelling or boarding, thermal insulation mainly above the panelling or boarding

Cases not mentioned here are to be classified in accordance with the above when determining the required material class. Classes 20 or 100, which have been determined in this way, may not – under any circumstances – be replaced by class 100 G. According to DIN 68800-5, wood-based materials serving as load-bearing and reinforcing elements must be protected against fungi in cases where moisture loads are high; this measure is expedient for wood-based materials not used as load-bearing elements.

The German Ordinance on Energy Saving (EnEV 2002), thermal insulation ordinance, the ordinance on energy-saving thermal protection in buildings.

## Standards

DIN 1052 Part 1: Structural use of timber; design and construction

DIN 1052 Part 2: Structural use of timber; mechanically fastened joints

DIN 1055 Action on structures

DIN 1101 Wood wool slabs and multilayered slabs as insulating materials in building

DIN 4070-1 Softwood; cross-sectional dimensions and static values for sawn timber, square timber stock and roof battens

DIN 4070-2 Coniferous timber; dimensions of cross-sections and static values, goods sawn for dimensions and specification

DIN 4071-1 Unplaned boards and planks made of coniferous timber; dimensions

DIN 4072 Boards tongued and grooved, made of coniferous timber

DIN 4073-1 Planed boards and planks, made of coniferous timber; dimensions

DIN 4074-1 Strength grading of wood; coniferous sawn timber

DIN 4102 Fire behaviour of building materials and building components

DIN 4108 Thermal protection and energy economy in buildings

DIN 4109 Sound insulation in buildings; requirements and testing

DIN 17440 Stainless steels – technical delivery conditions for drawn wire

DIN 18161-1 Cork products as insulating building materials; insulating materials for thermal insulation

DIN 18164-1 Cellular plastics as insulating building materials – Part 1: Insulating materials for thermal insulation

DIN 18165 Fibrous insulating building materials

DIN 18180 Gypsum plasterboard; types, requirements and testing

DIN 18182 Accessoires for use with gypsum plasterboards

DIN 18195-1–5 Water-proofing of buildings

DIN 18203-3 Tolerances for building; building components of timber and wood based panel products

DIN 18334 Contract procedures for building works – Part C: General technical specifications for building works: carpentry and timber construction work

DIN 18542 Sealing of outside wall joints with impregnated sealing tapes made of cellular plastics – Impregnated sealing tapes – Requirements and testing

DIN 18560 Screeds in building construction

DIN 68100 Tolerance system for wood working and wood processing; concepts, series of tolerances, shrinkage and swelling

DIN 68122 Tongued-and-grooved chamfered boards of coniferous timber

DIN 68123 Weatherboards made of coniferous timber

DIN 68126-1 Profile boards with chamfer and broad root; dimensions

DIN 68126-3 Profile boards with chamfer and broad root; grading for white-wood and redwood

DIN 68364 Properties of wood species: density, modulus of elasticity and strength

DIN 68365 Structural timber for carpentry; quality conditions

DIN 68705-2 Plywood – Part 2: Blockboard and laminboard for general use

DIN 68705-3 Plywood; structural plywood

DIN 68705-5 Plywood; structural plywood made of beech

DIN 68755 Wood-fibre products for insulation of buildings

DIN 68762 Chipboard for special purposes in building construction; concepts, requirements, testing

DIN 68764 Particle boards; extruded boards for the building; terms, properties, testing, supervision

DIN 68765 Particle boards; decorative laminated particle boards; terms, requirements

DIN 68800-1 Protection of timber used in buildings; general specifications

DIN 68800-2 Protection of timber; preventive constructional measures in buildings

DIN 68800-3 Protection of timber; preventive chemical protection

DIN 68800-5 Protection of timber used in buildings; preventive chemical protection for wood-based materials

DIN EN 300 Oriented Strand Boards (OSB) – Definitions, classification and specifications; German version

DIN EN 309 Particleboards; definition and classification

DIN EN 312 Particleboards – specifications

DIN EN 313 Plywood – classification and terminology

DIN EN 316 Wood fibreboards – definition, classification and symbols

DIN EN 335 Durability of wood and derived materials; definition of hazard classes of biological attack

DIN EN 338 Timber structures – strength classes

DIN EN 350 Durability of wood and woodbased products – natural durability of solid wood

DIN EN 351 Durability of wood and woodbased products – preservative-treated solid wood

DIN EN 384 Structural timber – determination of characteristic values of mechanical properties and density

DIN EN 386 Glued laminated timber – performance requirements and minimum production requirements

DIN EN 460 Durability of wood and woodbased products – natural durability of solid wood – guide to the durability requirements for wood to be used in hazard classes

DIN EN 622 Fibreboards - specifications

DIN EN 633 Cement-bonded particleboards: definition and classification

DIN EN 634 Cement-bonded particleboards – specifications

DIN EN 635-1 Plywood – classification by surface appearance – Part 1: General

DIN EN 636 Plywood - specifications

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Eleco Bauprod, kte GmbH Erdinger Straße 82a D-85356 Freising Tel, +49/8161/1796-0 Fax, +49/8131/1796-33 p. 73

Emfa Baustoff CimbH Stockerweg 10 D-89331 Burga J Tel, +49/8222/ €62-0 Fax, +49/8222/ €62-80 pp, 54, 55, 56, 52, 63, 66

EPF European Panel Federation Allée Hof-ter-Vieest 5 Box 5 B-1070 Brussel ; Tel, +32/2/556; 5-89 Fax, +32/2/556; 5-94 p, 47 Eternit AG Ernst-Reuter-Platz 8 D-10908 Berlin Tel, +49/30/34 85-0 Fax, +49/30/34 85-319 pp, 50, 51

EZO Isolierstoffe GmbH Ladestraße 1 D-37249 Neu-Eichenberg Tel, +49/5542/2017 Fax, +49/5542/72159 p. 63

Falke Garne Kutscherweg 1 D-57392 Schmallenberg Tel. +49/2972/307-0 Fax. +49/2972/307-323 p. 61

Fels-Werke GmbH Geheimrat-Ebert-Straße 12 D-38640 Goslar Tel: +49/5321/703-0 Fax: +49/5321/703-321 pp. 52, 53

Fibrolith-Dämmstoffe Wilms GmbH Hannebacher Straße1 D-56746 Kempenich Tel, +49/2655/9592-0 Fax, +49/2655/9592-18 p, 65

Holzwerk Ambros Fichtner Tegernseer Weg 15 D-83727 Schliersee Tel. +49/8026/9405-0 Fax. +49/8026/6512 p. 35

Finnforest Deutschland GmbH Louis-Krages-Straße 30 D-28237 Bremen Tel., +49/421/6911-0 Fax, +49/421/6911-100 pp, 42, 43

Flachshaus GmbH Pritzwalker Straße 1 D-16928 Giesensdorf Tel. +49/3395/700796 Fax. +49/3395/301925 p. 62

Fulgurit Baustoffe GmbH Postfach 1208 D-31513 Wunstorf Tel. +49/5031/51-0 Fax, +49/5031/51-203 pp, 50, 51 Gefinex-Jackon Vertriebs GmbH Carl-Benz-Straße 8 D-33803 Steinhagen Tel, +49/5204/1000-0 Fax, +49/5204/1000-59 p, 58

GH-Baubeschläge Hartmann GmbH Hinterm Schloß 8–10 D-32549 Bad Oeynhausen Tel, +49/5731/7580-0 Fax, +49/5731/7580-90 pp, 73, 74, 75

Glunz AG Grecostraße 1 D-49716 Meppen Tel, +49/5931/405-0 Fax, +49/5931/405-209 pp. 40, 42, 46, 48, 50, 54

Holzwerke Gmach GmbH Mühlbachstraße 1 D-93483 Pösing Tel, +49/9461/403-0 Fax, +49/9461/403-33 p, 41

Grossmann Bau GmbH & Co. KG Äußere Münchner Straße 20 D-83026 Rosenheim Tel. +49/8031/4401-0 Fax, +49/8031/4401-99 p, 36

Güteschutzgemeinschaft Sperrholz e.V., Wilhelmstraße 25 D-35392 Gießen Tel., +49/641/97547-0 Fax., +49/641/97547-99 p. 42

Güte- und Informationsgemeinschaft der Nagelplattenverwender e.V. Gartenstraße 6 D-37181 Hardegsen Tel. +49/180/5446675 p. 62

Gutex Holzfaserplattenwerk H, Henselmann GmbH & Co, KG Gutenburg 5 D-79761 Waldshut-Tiengen Tel. +49/7741/6099-0 Fax, +49/7741/6099-57 pp. 47, 54, 55

Gyproc GmbH Scheifenkamp 16 D-40878 Ratingen Tel. +49/2102/476-0 Fax, +49/2102/476-100 p. 52 Haas Fertigbau GmbH Industriestraße 8 D-84326 Falkenberg Tel. +49/8727/18-0 Fax, +49/8727/18-593 pp: 36, 41

Hanno-Werk GmbH & Co, KG Hanno-Ring 5 D-30880 Laatzen Tel, +49/5102/7000-0 Fax, +49/5102/7000-10 p, 78

Haubold-Kihlberg AB Industrigatan 37 S-54422 Hjo Tel<sub>\*</sub> +46/503/328-00 Fax, +46/503/328-01 p<sub>\*</sub> 72

HAUSprofi Bausysteme GmbH Rudolf-Diesel-Straße 12 D-72250 Freudenstadt Tel. +49/7441/866-0 Fax. +49/7441/84551 p. 72

Anton Heggenstaller AG Mühlenstraße 7 D-86556 Unterbernbach Tel. +49/8257/81-0 Fax. +49/8257/81-170 p. 35

F. Aug. Henjes GmbH & Co. An der Autobahn 46 D-28876 Oyten Tel. +49/4207/698-0 Fax: +49/4207/698-40 p. 56

Henkel Baufolien Am Rosengarten 5 D-63607 Wächtersbach-Neudorf Tel, +49/6053/708-0 Fax, +49/6053/708-130 pp, 66, 87

Henkel Bautechnik GmbH Erkrather Straße 230 D-40233 Düsseldorf Tel. +49/211/7379-0 Fax. +49/211/7379-304 p. 78

Henkel Teroson GmbH Henkel Teroson Straße 57 D-69123 Heidelberg Tel<sub>\*</sub> +49/6221/704-0 Fax, +49/6221/704-698 p<sub>\*</sub> 78 Hess Holzleimbau-Technologie GmbH & Co. KG Postfach 1460 D-63884 Miltenberg Tel, +49/9371/4003-0 Fax. +49/9371/4003-45 pp. 35, 43, 44

Hess Co. AG Sperrholzfabrik Toni Ackermann CH-5312 Döttingen Tel. +41/56/2687505 Fax. +41/56/2454576 p. 42

Hock Vertriebs-GmbH & Co. KG Industriestraße 7 D-76297 Stutensee-Spöck Tel. +49/7294/9471-0 Fax\_ +49/7294/9471-25 p. 62

Homatherm GmbH & Co, KG Ahornweg 1 D-06536 Berga Tel. +49/3465/1416-0 Fax, +49/3465/1416-39 p. 64

Hornitex Werke Gebr., Künnemeyer GmbH & Co. KG Bahnhofstraße 57 D-32805 Horn-Meinberg Tel, +49/5234/848-00 Fax, +49/5234/848-202 pp, 40, 48, 47

Hüster-Holz GmbH & Co. KG Innerweg 15 D-59581 Warstein Tel, +49/2902/9798-0 Fax, +49/2902/9798-99 p. 35

ICI Paints Deco GmbH Itterpark 2–4 D-40724 Hilden Tel, +49/2103/2058-00 Fax, +49/2103/2058-63 p, 77

Illbruck Bautechnik GmbH Burscheider Straße 454 D-51381 Leverkusen TeL +49/2171/391-0 Fax, +49/2171/391-586 p, 78

Industrieverband Bitumen-Dach- u, Dichtungsbahnen e,V. (VDD) Karlstraße 21 D-60329 Frankfurt/M Tel. +49/69/2556-1314 Fax, +49/69/2556-1602 p. 65 Industrieverband Hartschaum e.V. Kurpfalzring 100a D-69123 Heidelberg Tel. +49/6221/776071 Fax, +49/6221/775106 pp, 57, 58, 59

Isofloc Wärmedämmtechnik GmbH Am Fieseler Werk 3 D-34253 Lohfelden Tel\_ +49/561/95172-0 Fax\_ +49/561/95172-95 pp, 55, 64

ITW Paslode Befestigungssysteme GmbH, Paslode & Duo-Fast Gutenbergstraße 4 D-91522 Ansbach Tel. +49/981/9509-0 Fax. +49/981/9509-175 p. 72

Janssen Holzbau GmbH & Co. KG Bahnhofstraße 93 D-49753 Werlte Tel, +49/5951/9566-0 Fax, +49/5951/9566-66 p. 37

Joma-Dämmstoffwerk GmbH Jomapiatz 1 D-87752 Holzgünz Tel. +49/8393/78-0 Fax, +49/8393/78-15 p. 65

Kaufmann Holz AG Vorderreuthe 57 A-6870 Reuthe Tel, +43/5574/804-0 Fax, +43/5574/804-201 pp, 36, 37, 41

Kaufmann Leimholz GmbH Gutenbergstraße 7 D-86399 Bobingen Tel. +49/8234/9610-0 Fax. +49/8234/8572 p. 36

Kaufmann Massivholz GmbH Max-Eyth-Straße 25–27 D-89613 Oberstadion Tel. +49/7357/921346 Fax, +49/7357/921101 p. 37

KAWO-Dichtstoffe Karl Woipers Bavenstedter Straße 73 D-31135 Hildesheim Tel. +49/5121/7619-0 Fax. +49/5121/7619-29 p. 78 Johann Kirchhoff GmbH & Co., KG Bahnhofstraße 13 D-57413 Finnentrop Tel. +49/2395/9191-0 Fax. +49/2395/9191-40 p. 35

Klöber GmbH & Co, KG Scharpenberger Straße 72–90 D-58256 Ennepetal Tel. +49/2333/9877-0 Fax, +49/2333/9877-199 pp. 61, 66, 68

Knauf Alcopor GmbH Idsteiner Straße 81 D-65232 Taunusstein Tel, +49/6128/9752-0 Fax\_ +49/6128/9752-22 p, 60

Knauf Gips KG Am Bahnhof 7 D-97346 lphofen Tel, +49/9323/31-0 Fax, +49/9323/31-277 p. 52

Knauf Perlite GmbH Kipperstraße 19 D-44147 Dortmund Tel, +49/231/9980-01 Fax, +49/231/9980-138 p, 65

Kobus Industrieholz- und Montagebau GmbH Einharting 12 D-83567 Unterreit Tel. +49/8638/9870-0 Fax, +49/8638/9870-97 p. 37

Köster Bauchemie AG Dieselstraße 3–10 D-26607 Aurich Tel. +49/4941/9709-0 Fax, +49/4941/9709-40 pp, 66, 69

Kronospan Luxembourg S. A. B. P. 109 LU-4902 Sanem, Luxembourg Tel. +352/590311-1 Fax. +352/590311-500 p. 42

Kunz GmbH & Co. Im Bühlfeld 1 D-74417 Gschwend Tel. +49/7972/690 Fax. +49/7972/808 pp. 48, 47 Lafarge Dachsysteme GmbH Frankfurter Landstraße 2–4 D-61440 Oberursel Tel, +49/6171/61-001 Fax, +49/6171/61-2300 pp. 66, 67, 69

Lafarge Gips GmbH Frankfurter Landstraße 2–4 D-61440 Oberursel Tel\_ +49/6171/61-020 Fax, +49/6171/61-3999 p, 52

Leca A/S Randersvej 75 DK-8900 Randers Tel, +45/87/610201 Fax, +45/87/610205 p, 65

Leinos-Naturfarben GmbH Weilenburgstraße 29 D-42579 Heiligenhaus Tel., +49/2056/9326-0 Fax, +49/2956/9326-25 p, 77

Liapor GmbH & Co, KG Industriestraße 2 D-91352 Hallerndorf-Pautzfeld Tel, +49/9545/448-0 Fax, +49/9545/448-80 p, 65

Lignum Holzwirtschaft Schweiz Falkenstraße 26 CH-8008 Zürich Tel. +41/1/26747-77 Fax. +41/1/26747-78 pp. 34, 38, 42

Lindner Holding KGaA Bahnhofstraße 29 D-94424 Arnstorf Tel. +49/8723/20-0 Fax, +49/8723/20-2147 pp. 52, 53

Livos Pflanzenchemie GmbH & Co, KG Auengrund 10 D-29568 Wieren Tel, +49/5825/88-0 Fax, +49/5825/88-60 p, 77

Maier Holzbau GmbH & Co. Tussenhauser Straße 30 D-86842 Türkheim Tel, +49/8245/9698-0 Fax, +49/8245/9698-20 p, 36 Merk Holzbau GrnbH & Co, KG Industriestraße 2 D-86551 Aicha :r Tel. +49/8251/308-0 Fax. +49/8251/3005 pp. 36, 43, 44

Merkle Holz GnicH Straßer Weg 24 D-89278 Nersir gen-Oberfahlheim Tel, +49/7308// )€46-0 Fax, +49/7308// )€48-46 p, 35

MiTek Industrie 3 3mbH Deutz-Kalker-3 16 8 1 D-50679 Köln Tel, +49/1805/37620-0 Fax, +49/1805/37620-1 p, 73

Moll Bauökolog siche Produkte GmbH Rheintalstraße : 5–43 D-68723 Schv/ctzingen Tel. +49/6202/:782-0 Fax. +49/6202/:782-21 pp. 66, 68

Nexfor Inc. Suite 500 , 1 Tc cnto Street CDN-Toronto Intario MSC 2W4 Tel. +1/416/64 (£8-20 Fax, +1/416/64 (£8-27 p. 42

Odenwald Fas ( rplattenwerk GmbH Dr. -F. A. -Freuri dt-Straße 3 D-63916 Amolitiaich Tel. +49/9373//:C1-0 Fax, +49/9373/.:C1-130 p. 47

Otto-Graf-Instith t (FMPA) der Universität Stuttig art Pfaffenwaldring 4 D-70569 Stuttig ar Tel, +49/711//315-3323 Fax, +49/711//315-6820 p, 36

Pavatex GmbH Wangener Straf e 58 D-88299 Leutki c 1 Tel +49/7561/9:55-0 Fax, +49/7561/9:65-50 p, 47, 54, 55, 6: p Pfleiderer Holzvierkstoffe GmbH & Co. KG Postfach 2760 D-59753 Arnsbirr3 Tel, +49/2932/:02-0 Fax, +49/2932/:02-341 pp. 40, 48, 60 Phoenix AG Hannoversche Straße 88 D-21079 Hamburg Tel., +49/40/7667-01 Fax, +49/40/7667-2211 p, 67

PIGROL Farben GmbH Hospitalstraße 39/71 D-91522 Ansbach Tel., +49/981/6506-0 Fax, +49/981/6506-59 p. 77

Pröbstl Holzwerke GmbH Am Bahnhof 6 D-86925 Fuchstal/Asch Tel., +49/8243/9691-0 Fax, +49/8243/2613 p, 41

Proholz Holzinformation Uraniastrasse 4 A-1010 Vienna Tel, +43/1/7120474-0 Fax, +43/1/7131018 pp, 34, 42

Puren Schaumstoff GmbH Rengoldshauser Straße 4 D-88662 Überlingen Tel. +49/7551/8099-0 Fax. +49/7551/8099-20 p. 59

RCH Fluorchemie GmbH Hauptstraße 35 D-50126 Bergheim Tel<sub>\*</sub> +49/2271/451-61 Fax<sub>\*</sub> +49/2271/451-58 p<sub>\*</sub> 77

Reich Karl M. Verbindungstechnik GmbH Kisslingstraße 1 D-72622 Nürtingen Tel. +49/7022/71-0 Fax, +49/7022/71-233 p. 72

Remmers Baustofftechnik GmbH Bernhard-Remmers-Straße 13 D-49624 Löningen Tel<sub>\*</sub> +49/5432/83-0 Fax<sub>\*</sub> +49/5432/3985 p<sub>\*</sub> 77

Rettenmeier Holzindustrie GmbH & Co, KG Industriestraße 1 D-91634 Wilburgstetten Tel, +49/9853/338-0 Fax, +49/9853/338-100 p, 35 Rigips GmbH Schanzenstraße 84 D-40549 Düsseldorf TeL +49/211/5503-0 Fax, +49/211/5503-208 pp, 52, 53

Röthel GmbH & Co. KG Oderstraße 74 D-24539 Neumünster Tel. +49/4321/9992-0 Fax. +49/4321/9992-33 pp. 63, 56, 66

Rosenauer Holzverarbeitung GmbH Rosenau 48 A-4581 Hengspaß Tel., +43/7566/241-0 Fax, +43/7566/241-37 p. 42

Rougier SA 155, avenue de la Rochelle BP 8826 F-79028 Niort Cedex 09 Tel. +33/549/7720-30 Fax. +33/549/7720-40 p. 42

ROWA F. Rothmund GmbH & Co. KG Eisenschmiede 20 D-73432 Aalon Unterkochen Tel. +49/7361/9872-0 Fax. +49/7361/9872-52 p. 61

SaarGummi GmbH Eisenbahnstraße 24 D-66687 Wadern-Büschfeld Tel<sub>\*</sub> +49/6874/69-0 Fax, +49/6874/69-248 p. 67

Saint-Gobain Isover G+H AG Bürgermeister-Grünzweig-Straße 1 D-67059 Ludwigshafen Tel. +49/621/501-0 Fax, +49/621/501-988 pp. 60, 62, 66, 68, 69

Sauerländer Spanplatten GmbH & Co, KG Zur Schefferei 12 D-59821 Arnsberg Tel. +49/2931/876-0 Fax. +49/2931/876-118 p.,49

Holz Schmidt GmbH Zum Flugplatz 8 D-35091 Cölbe-Schönstadt Tel, +49/6427/9220-0 Fax, +49/6427/9220-30 p. 35 Schollmayer Holz GmbH Hauptstraße 173 D-55246 Mainz-Kostheim Tel. +49/6134/1811-0 Fax, +49/6134/24952 p. 35

Schwenk Dämmtechnik GmbH & Co, KG Isotexstraße 1 D-86899 Landsberg Tel., +49/8191/127-0 Fax., +49/8191/32954 p, 57

Sika Chemie GmbH Kornwestheimer Straße 103–107 D-70439 Stuttgart Tel, +49/711/8009-0 Fax, +49/711/8009-321 p, 78

Stamoid AG Beschichtungswerk Wasterkinger Weg CH-8193 Eglisau Tel. +41/18682626 Fax. +41/18682727 pp. 66, 68

Stanley Bostitch 110 Walker Drive CDN–Brampton, Ontario L6T 46H Tel, +1/800/5677705 p. 72

Stattbauhof GmbH Markgrafendamm 16 D-10245 Berlin Tel. +49/30/29394-0 Fax, +49/30/29394-104 pp. 64, 62

STEICO AG Hans-Riedei-Straße 21 D-85622 Feldkirchen Tel. +49/89/991551-0 Fax. +49/89/991551-99 p. 54

Studiengemeinschaft Holzleimbau e,V, Gütegemeinschaft Holzleimbau e,V, Elfriede-Stremmel-Straße 69 D-42369 Wuppertal Tel, +49/202/97835-81 Fax, +49/202/97835-79 p, 42

Matthäus Sturm GmbH Holzverarbeitung Eselsburger Straße 17 D-89542 Herbrechtingen Tel. +49/7324/953-0 Fax. +49/7324/953-100 p. 35 TS Teutoburger Sperrholz GmbH Pivitsheider Straße 22 D-32758 Detmold Tel. +49/5232/981-00 Fax. +49/5232/981-999 p. 42

Thermal Ceramics Deutschland GmbH & Co. KG Borsigstraße 4–6 D-21465 Reinbek Tel. +49/40/72709-100 Fax, +49/40/72709-5100 p. 65

Thermowoll Dämmstoffe GmbH Hoheimer Straße 1 D-97318 Kitzingen Tel. +49/9321/322-01 Fax, +49/9321/322-06 p. 61

Thüringer Dämmstoffwerke GmbH Am Schlossberg 3 D-99438 Bad Berka Tel... +49/36458/37-0 Fax... +49/36458/37-198 p. 60

TreuHanf AG Am Treptower Park 30 D-12435 Berlin Tel, +49/30/5369915-3 Fax\_ +49/30/5369915-4 p, 62

Trus Joist Behringstraße 10 D-82152 Planegg Tel., +49/89/8550-96 Fax, +49/89/8550-886 pp, 43, 44, 45

UPM-Kymmene Wood GmbH Postfach 105728 D-20039 Hamburg Tel. +49/40/248446-0 Fax. +49/40/248446-10 p. 42

Überwachungsgemeinschaft Konstruktionsvollholz e. V. Postfach 6128 D-65051 Wiesbaden Tel. +49/611/97706-0 Fax, +49/611/97706-22 p. 35

Vedag AG Flinschstraße 10–16 D-60388 Frankfurt/Main Tel. +49/69/4084-0 Fax\_ +49/69/4258-24 pp. 66, 67 Verband der Deutschen Holzwerkstoffindustrie VHI e.V. Ursulum 18 D-35396 Gießen Tel. +49/641/97547-0 Fax. +49/641/97547-99 pp. 42, 46

Westag & Getalit AG Hellweg 15 D-33378 Rheda-Wiedenbrück Tel. +49/5242/17-2000 Fax. +49/5242/17-72000 p. 42

WIKA Isolier- und Dämmtechnik GmbH Bischof-Neumann-Straße 23a D-85051 Ingolstadt Tel. +49/8450/937-0 Fax. +49/8450/1647 pp. 66, 68, 69

Wilhelmi Werke AG Dr. Hans-Wilhelmi-Weg 1 D-35633 Lahnau Tel... +49/6441/601-0 Fax... +49/6441/63439 p...47

Holzwerke Wimmer GmbH Max-Breiherr-Straße 20 D-84347 Pfarrkirchen Tel. +49/8561/3005-0 Fax. +49/8561/3005-55 p. 35

Johann Wolf GmbH & Co. Systembau KG Am Stadtwald 20 D-94486 Osterhofen Tel. +49/9932/37-0 Fax. +49/9932/2893 p. 73

Dr. Wolmann GmbH Dr.-Wolmann-Straße 31–33 D-76547 Sinzheim Tel. +49/7221/800-0 Fax, +49/7221/800-290 p. 77

Adolf Würth GmbH & Co, KG Reinhold-Würth-Straße 12–17 D-74653 Künzelsau-Gaisbach Tel. +49/7940/15-0 Fax, +49/7940/15-1000 p, 72

Ulrich Zeh GmbH & Co, KG Holz- und Leimbau Obersteig 2 D-88167 Maierhöfen/Allgäu Tel. +49/8383/92051-0 Fax. +49/8383/92051-99 p. 36 Lothar Zipse Korkvertrieb Tullastraße 26 D-79341 Kenzingen Tel.: +49/7644/9119-0 Fax.: +49/7644/9119-34 pp. 56, 63

## Subject Index

airborne-sound insulation		15,	07
airtight		14,	
anchors	70,	71,	75
anchor bolts			22
anchor nails			73
angle connectors			74
angle sealed with tape			31
animal pests			76
			10.005
backfill insulation			31
beam hange s			74
beam supports			75
bitumen sheeting			67
bituminated wood fibres			55
bituminated libreboards			55
blockboard and laminated boar	d		40
blower door lest			66
boards/plants			38
board mater a s			23
bolt			71
building boa ds		51-	
Bulldog dowes			70
butt joint			18
canvas bancis			74
cavity flocks			62
cavity insulation			63
cavity fill			65
cellulose			64
cellulose flat es		23,	
		20,	24
cemented chipboard			
centre distar ce			23
ceramic tiles			18
chemical wood preservative	12,		
		76,	77
chimney linir gs			65
chipboard	24,	46,	49
coat of paint			13
coconut		13,	63
coconut fibre	13.	23,	
coconut insulating mats			63
coconut rollec felting			63
coconut wall panels			63
			12
coarse gravel strips			
composite e ements			54
composite construction			37
composite board			53
composite materials			60
coniferous v ood		34,	50
connecting plates			43
continuous footing			25
converted building timber		34,	35
core insulation		60,	
core plywoo 1		,	40
core-stripe t lockboard			40
cork			56
cork strip			15
corner			31
corner design			31
corrosion stains			18
corrugated sheet roofing			28
cotton wool			61
counter battens			29

27	cover strips				30
18	cross-rafters			28,	29
75	cross-band veneer				4(
22	damp-proofing			22,	67
73	wood from deciduous trees				34
74	diaphragm action				26
31	dimensional tolerances				10
76	draught-proofing		12,	14,	16
31		17,	18,	19,	27
74	drainage				28
75	dry rot				76
67	dry screed board		15,	27,	52
55	dry wall screws				72
55	doorframe			15,	27
40	door reveal				15
66	dowel		22,	25,	7(
38	"dry" construction method				24
23	dry screed	15,	24,	27,	52
71	eaves flashing				28
-53	edge beam				17
70	edge of ceiling				14
18	edge rafter				1
74	energy saving			14,	66
62	equalising unevenness				25
63	expandable polystyrene				5
65	expanded mica				23
64	expansion joint			19,	3
64	exterior boarding				1
24	exterior corner				18
23	exterior lining				12
18			14,		
42,		22,	24,	31,	
77	exterior wall elements				2
65	external cladding				3
49	extruded particle boards				49
13	extruded polystyrene				5
63	face veneer				4
63	facing panels			01	31
63	facing shell			31,	
63	fascia fibrated concrete eleb				2
63 12	fibrated concrete slab			00	2.
54	fibreboard fibre cement board		10	29,	
37	fibre-reinforced cement boa	rd	12,	22,	5
53	fibrous insulating material	11 U			1:
60	fire resistance				3
50	fire resistance class				1
43	fire protection plasterboard				5
25	five-ply panel				4
35	flakes				1:
65	flat connector				7
40	flat-pressed boards				4
40	flat roofs			57,	
56	flat steel anchors			01	71
15	flax				6
31	floating foundation				2
31	floorboards				1
18	floor covering				50
28	floor construction				2
61	flooring				1
29	floor beneath roof void			16,	1

20	floor atructure		1 =	10	07
30	floor structure			19,	
29	foundations			24,	
40	frost blanket gravel				22
67	furniture construction			40,	
34	fungi				76
26	gable area				17
13	gable wall				17
16,	GEKA dowels				70
,27	glass fibre				67
28	glaze				13
76		6.	28,	31.	36
, 52	0		28,		
72	glulam pillar support	Ο,	20,	<b>U</b> ,	75
, 27	grading				34
15					56
	granulates				
,70	grey				13
24	groove nails				73
, 52	gutter bracket				16
28	gypsum baseboard				52
17	gypsum fibreboard 1	8,	23,	24,	53
14	gypsum plasterboard				52
17	hardwood		34,	40,	70
, 66	hazard classes			22,	76
25	heavy-duty bolt			12,	
57	hemp			,	62
23	heat loss				12
, 31		٦r	10	22	
17	high-expansion cement morta	21	12,	22,	
	horizontal rails				13
18	HR-foam			57,	
12	humid rooms				23
17,	humidity			53,	
, 66	impact-sound insulation		15, 1	24,	54,
23			57,	60,	67
38	in situ foam				59
49	insects				76
58	insulating board			12,	56
40		4.	19,	54-	-65
30	insulation value				23
, 63	integral connectors				75
28	interior lining				13
24	interior wall		15	25,	
, 47	interior wall elements		10,	20,	23
				- 1	
, 51	joint sealing tape		00		78
50	joints and fasteners		38,	70-	
12	joists			14-	-16
31	joist hangers				14
19	laminated construction board				42
52	laminated strand lumber				45
41	lintel beam				15
12	load-bearing lathing				38
74	loose fill				15
48	machine nails				73
, 65	manufactured wood products	2		40-	-50
70	manufacturers		10	40- )4-1	
62	matched fibreboards		10	-+-	39
			1 -	1.4	
22	material class		41,		
15	mineral wool / fibre		19,	26,	
50	moisture			12,	25
24	multi-ply boards				47
15	nails			18,	73
, 17	noil platos				70
1 1 1	nail plates				73

non-pressing water	67	self-piercing screws	73
Ordinance on Energy Saving	14,	separation layer	16
Oriented Strand Board (OSB)	13,46	service lines	19
overlapping vertical weatherbo		services shaft	18, 19, 27
overlapping vertical weatherbo			30
	17, 18, 19	shadow gap	
	, 23, 42, 49	shear pins	71
paper	28	sheathing	16
parallel laminated veneer	43	sheathing papers	66-69
Parallel Strand Lumber (PSL)	44	sheep's wool	26, 61
party wall	19	sheet bay width	17
patinated wood species	13	sheet flooring	15
perimeter insulation	12, 58	sheeting	28, 66, 67, 68, 69
PE-foil	24, 67	sheet-metal covering	16
perforated steel strips	74	sheet steel brackets	74, 75
perlite	65	shrinkage ratio	23
pillar bases	75	sill	13, 22
pillar bracket	75	skirting boards	13
planking	18, 19, 41	softboard	12
. 0		softwood	
planks	38		23, 34–41
plasterboard 18, 22, 23, 24, 31		sole plate	22
plastic	26	solid door frame	15
plastic sheeting	28, 67	solid wood	34, 35, 36
	, 25, 28, 30	sound insulation	15, 19, 23, 31, 60,
plywood panels	30		61, 63, 67
polymeric bitumen sheet	25	span	18
polyurethane HR-foam	59	special nails	73
polyurethane in-situ foam	59	split ring connector	70
polystyrene particles	57	spring shackles	31
post holder	75	stairs	40
posts	12, 17	standards	100
products	33-78	staples	72
profile anchors	75	stone bolt	25
	39		29
profile boards		storage capacity	
protective layers	13, 29	structural solid wood	35
protective measures	30	structural wood	34, 76
purlin anchors	75	styropor	57
ragbolt	12	subsoil	67
rafter arrangement	17	substructure	18, 29, 30
rafter foot joints	75	support grid	16
rafter holders	75	suspended supports	75
rafter nails	73	swelling clay	65
rafter spacing	16	tension	18
rafter-supporting purlins	28	thermal bridge	29
Rafter-to-purlin connectors	75	thermal insulation	12, 16, 22, 24,
rail	14		3, 29, 31, 57, 60, 62
rectangular wooden dowels	70	thermal protection in su	
resistance class	12, 42	threshold	15
ridge nails	73	track anchors	75
roof boarding	16, 17	three-ply panel	41
	16	timber	34–39
roof covering			28
roof edge	17	tingles	
roof members	29	tolerances	12, 13, 26
roof overhang	16, 30	tongued-and-grooved	
roof panels	41,43	upper headpiece	26
roof void	17	vapour retarding layer	
rotary cut veneers	40	18, 19, 22, 24	1, 26, 27, 28, 31, 66
"sand honeycombs"	27	vapour barrier	25, 66
sandwich constructions	54, 57	vegetable pests	76
screws	18, 30, 72	ventilation	12, 13, 19, 66
sealing material	25, 26	ventilated roof	17
"secondary" meltwater	28	verge	17
sooonaary motivator			

73 16 19 18, 19, 27 30 71 16 66-69 26, 61 17 15 28, 66, 67, 68, 69 16 74, 75 23 13, 22	wall elements weatherboarding weatherboards weather protection weather protective layer windows window frame wire nails wooden house construction 35 wood fibre wood fibreboards wood preservative wood preservation wood preservation wood preservation by design wood ticks wooden sill plate	54 47, 54, 55 12, 42, 76 76 76 76 12
13, 22 13 12	wooden sill plate Z-profile	12 74

## Index of projects

page 81 **Temporary Bank in Nuremberg** Client: Hypo-Vereinsbank, Munich Architects: aml architel turwerkstatt Matthias Loebermann, Nuremberg Associates: Werner Felcmeier, Eric Alles

page 82 Weekend House in Vallemaggia Client: Roberto Briccola, Giubiasco Architect: Roberto Briccola, Giubiasco Structural panning: Flavio Bona umi, Giubiasco

page 84 House near Bad Tölz Client: private Architects: Fink + Jochal Munich Dietrich Fink, Munich Thomas Jocher, Munich Associates: Nicole Hemminger, Thomas Pfeiffer Structural planning:

Toni Staudapher, Tegernsee

## page 86 **Church Community Centre** and Youth Centre in Lenting Client:

Pfarrgeme r de St. Nikolaus, Lenting Architects: Meck Köppel Architekten, Munich Andreas Meck, Munich Stefan Köpr el, Munich Associates: Werner Schad, Eva Maria Krebs, Susanne Frank, Peter Fretschner Structural planning: Ingenieurbüro H. L. Haushofer, Markt Schwaben

## page 88 Housing Development in Trofaiach Client: GIWOG-Gerneinnützige Industrie Wohnungs GrnbH, Linz

Architect: Hubert Riess, Graz Associate: Christoph Plazer Structural planning: Rudolf Prein Leoben

## page 90 Lakeside Bathing Facilities in Zug, Switzerland Client: Einwohnergemeinde Zug Architect: Alfred Krähenbühl, Zug Associate: Reto Keller, Construction manager Structural planning: Ernst Moos AG. Zug Xaver Keiser Zimmerei Zug AG

## page 92

## School Building in St Peter, Switzerland

#### Client.

Politische Gemeinde St. Peter, Graubünden Architect: Conradin Clavuot, Chur Associates: Claudia Clavuot-Merz, Norbert Mathis, Alex Jörg, Paula Deplazes Structural planning: Jürg Conzett, Chur

# page 94

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## page 96

Parquet Showrooms in Lindau Client: Härtl-Parkett-GmbH, Lindau Architect: Karl Theodor Keller, Munich Structural planning: Dr. Gernot Pittioni, Munich

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