



**MEMORANDUM**

**To:** CLSAB Members  
**From:** Chuck Dentelbeck, President & CEO  
**Date:** May 22, 2024  
**Subject:** CLSAB Accepted Adhesives for HRA Labelling

The following Adhesives are currently accepted for HRA Labelling:

**Adhesives Accepted by CLSAB for HRA labelling**

**Method of Evaluation**

**ASTM D7374 - 08<sup>1</sup> Standard Practice for Evaluating Elevated Temperature Performance of Adhesives Used in End-Jointed Lumber**

<b>Product</b>	<b>Submitting Agency</b>	<b>Approval Date</b>
a. Hexion Wonderbond® MR-84 with M-605LY <ul style="list-style-type: none"><li>Melamine-based adhesive system</li><li>Very unique high solids formulation</li><li>Also excellent for hot pressing and radio-frequency curing</li><li>Provides superior water resistance</li></ul>	COFI	17-Sep-07
b. Hexion - Cascomel® 4720 with Wonderbond® 5025A <ul style="list-style-type: none"><li>Melamine Formaldehyde Adhesive</li><li>Laminates and composites including glue laminate products (beams, I-joists, structural finger joints)</li></ul>	AFPA	17-Sep-07
c. Hexion Wonderbond® MR-84 with M-610LY <ul style="list-style-type: none"><li>Melamine-based adhesive system</li><li>Provides superior water resistance.</li><li>Designed for ambient cure of end-jointed lumber/structural fingerjoints</li><li>Very unique high solids formulation</li></ul>	QFIC	15-Oct-07
d. Hexion Cascophen® AG-5675Q with Cascoset® FM-6310L <ul style="list-style-type: none"><li>Liquid phenol-resorcinol-formaldehyde resin with para-formaldehyde, ready-to-use liquid hardener</li><li>Designed for gluing structural wood members when fast cure times are desirable</li></ul>	QFIC	15-Nov-07
e. Hexion Cascophen® AG-5635Q with Cascoset® LQ-100 <ul style="list-style-type: none"><li>Liquid phenol-resorcinol formaldehyde resin with para-formaldehyde, ready to use liquid hardener</li><li>Designed for ambient cure of end-jointed lumber/structural fingerjoints</li><li>Provides superior water resistance</li></ul>	QFIC	21-Jan-08
f. Henkel LOCTITE® HB E032 Purbond <ul style="list-style-type: none"><li>Polyurethane adhesive</li><li>All grades and species of end-jointed lumber</li></ul>	CMSA	28-Feb-08
g. Franklin Advantage EPR-20 with Catalyst M 318LY <i>Formerly, Hexion Wonderbond® EPR-20 VS with Wonderbond® M-318LY</i> <ul style="list-style-type: none"><li>Designed for high-speed coldest finger jointing</li><li>Long pot life for pressure pot delivery</li></ul>	QFIC	7-Jan-09
h. Henkel LOCTITE® GT20 PURBOND and LOCTITE® GT205 PURBOND <ul style="list-style-type: none"><li>2-part Structural Urethane Hybrid Adhesive</li><li>Can be cold pressed, hot pressed, or radio frequency (RF) cured.</li></ul>	OLMA	14-Sep-17

## Adhesives Accepted by CLSAB for HRA labelling

### Method of Evaluation

#### ASTM D7374 - 08<sup>1</sup> Standard Practice for Evaluating Elevated Temperature Performance of Adhesives Used in End-Jointed Lumber

Product	Submitting Agency	Approval Date
<ul style="list-style-type: none"> <li>• The pot life of this 2-part adhesive is relatively short, therefore the use of a meter mixing unit, just prior to application, is recommended</li> </ul>		
i. Franklin ADVANTAGE EP-950A emulsion with hardener 200 <ul style="list-style-type: none"> <li>• Acrylic-based emulsion polymer isocyanate system</li> <li>• Water and Heat resistance</li> <li>• Can be utilized in cold and hot press equipment.</li> <li>• Must be mixed at the rate indicated by the manufacturer</li> </ul>	OLMA	14-Sep-17
j. Hexion Cascophen® LT-5210J with Cascoset® FM-7400 <ul style="list-style-type: none"> <li>• Liquid PRF Resin</li> <li>• Application PRF for wood fingerjoint and I-joist</li> </ul>	OLMA / QFIC	17-Nov-17
k. Henkel LOCTITE® UR 5180 <ul style="list-style-type: none"> <li>• Formaldehyde free one-component liquid</li> <li>• Transparent glue line</li> </ul>	CMSA	27-Jun-18
l. Henkel LOCTITE® HB X032 Purbond <ul style="list-style-type: none"> <li>• Polyurethane adhesive</li> <li>• Formaldehyde free, solvent free</li> <li>• Resistant to weak alkalis, acids and solvents</li> <li>• Good flow properties</li> </ul>	CMSA	12-Dec-19
m. Hexion Ecobind® 6500 and Wonderbond® Hardener M-700Y <ul style="list-style-type: none"> <li>• Liquid melamine formaldehyde resin system</li> <li>• "Separate application" adhesive</li> <li>• Application for finger jointed lumber, Glulam and CLT</li> </ul>	CMSA	22-Apr-20

**1 - ASTM D7374 - 08** - designed to minimize the variables in test wall assemblies to ensure that adhesive systems are isolated for qualification. Adhesives that meet this standard can be adopted by any manufacturer with any wood species or grade and any finger joint geometry, and their end-jointed lumber manufactured with the adhesive may be stamped "heat resistant adhesive" (or "HRA") without any further fire testing.