natureplus e.V.

Guideline 0211

Adhesive-Bonded Wood Products for Construction Purposes

Version: Oct. 23, 2026
for the awardance of the eco-label

Introduction

The International Association for Sustainable Building and Living - natureplus association - pursues the goal of promoting sustainable building products and increasing their popularity and use. To this end, sustainability criteria for building products are defined and verified as part of regular conformity assessments at the applicant's premises.

Three comprehensive sustainability definitions are created to achieve a holistic understanding of quality.

CLIMATE PROTECTION

The climate crisis is worsening, and the consequences are becoming increasingly visible. The construction sector is one of the largest emitters, accounting for around 40% [1] of global greenhouse gas emissions. Energy-intensive manufacturing processes, long transport routes and short renovation cycles are often still characteristic of the status quo.

The natureplus certification requires manufacturers to meet limit values on CO2 emissions and primary energy consumption.

[1] UNEP, 2020, 2020 Global Status Report for Buildings and Construction, p. 4.

HEALTHY LIVING

In Western societies, we spend about 90% [2] of our lives in buildings. Pollutants emitted by building materials can accumulate in the indoor air we breathe daily, posing unnecessary health risks to occupants. The accumulation of chemical pollutants from building materials in household dust is also a cause for concern.

The natureplus certification ensures that hazardous input materials are avoided or used in quantities that are harmless to health. Emissions from building products are strictly regulated and regularly monitored.

[2] Umweltbundesamt, o. D., Ausschuss für Innenraumrichtwerte (AIR)

CONSERVATION OF RESOURCES

All construction activities have an impact on nature and the environment, with the consumption of finite resources remaining unacceptably high. The production of building materials in Germany consumes about 60% of our resources, and as much as 90% if only mineral raw materials are considered. At the same time, the construction sector is responsible for 50% of the waste generated. [3]

The natureplus certification sets out requirements for increased transparency in the supply chain, respect for human rights and the environment, and the responsible use of resources throughout the life cycle of a building product.
Sustainable materials should also be durable, reusable, or recyclable.

[3] VDI ZRE, 2019, Ressourceneffizienz im Bauwesen – Von der Planung bis zum Bauwerk, p. 5.

Notes on this product guideline:

The eco-label, the certification programme including all associated documents is the property of the non-profit natureplus® environmental organisation. The Association and its specially appointed Criteria Commission are therefore responsible for the further development of the requirements.

The label is awarded by the European cooperative natureplus Institute SCE mbH.

In the event of textual discrepancies between different language versions of a guideline, the Criteria Commission's Task Force will determine the valid wording. The affected language versions will be amended to reflect the valid wording.

In the event of conflict between the basic guidelines (50XX) and this product guideline, the product award guideline shall prevail.

For questions, criticism and suggestions, please contact:

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1 Application Areas

The following award criteria contain requirements for the natureplus®-ecolabel.

They apply to untreated rod-shaped or flat glued timber components for structural, load-bearing purposes. In the case of rod-shaped glued components, these include in particular:

- Solid structural timber
- Laminated beams
- Glued laminated timber
- Web beams

Glued components with a flat surface include, in particular:

- Glued laminated timber
- Cross-laminated timber
- Cross-laminated timber
- Multi-layer solid wood panels.

The guidelines apply exclusively to the products mentioned.

2 Award Criteria

The prerequisite for a product to be awarded the natureplus® quality label in accordance with these guidelines is compliance with the following award guidelines:

- GL5001 Chemicals Directive
- GL5002 Origin of Wood and Wood Production
- GL5004 Transparency and Social Responsibility
- GL5010 Low-emission building products
- GL5020 Climate compatibility and energy efficiency

2.1 Functional Suitability

The product must fulfil the requirements for functional suitability by having a national or European technical approval or by following a harmonised standard.

The applicant shall meet this requirement by submitting one of the following documents:

- a valid European Technical Assessment (ETA)
- a declaration of performance and conformity according to a European harmonised technical specification (e.g. standard)
- a valid national technical approval (e.g. in Germany a general technical approval - abZ, in Austria a technical approval - BTZ)
- a national declaration of performance and conformity to a national technical specification (e.g. standard)

2.2 Composition, Forbidden Substances, Substance Restrictions

The proportion of wood (including moisture) in the products must be at least 97% of the mass of the end product.

Polyurethane/Polyurea adhesives and mixed resins based upon aminoplasts and phenol are permitted. Only the use of low-emission UF (urea-formaldehyde) compounds is permitted.

The use and addition of biozides is not permitted.

The product is subject to assessments as detailed in section 3 and must comply with the limits specified therein.

2.3 Raw Material Sourcing, Production of Preliminary Products, Production

Where wood is used as an ingredient, compliance with GL-5002 "Wood extraction and origin" must be ensured.

The applicant must declare and require its suppliers to ensure that no synthetic pesticides containing active ingredients that are excluded under the natureplus Chemicals Guideline RL-5001 are used during the growth phase or during harvesting, storage and transport of the raw materials used for chip and fibre production.

Compounds based on arsenic or mercury must not be employed.

The applicant fulfils this requirement by submitting the relevant delivery specifications or supplier agreements.

If less than 80% of the energy required to dry the products is from renewable sources, then the efficiency level of the drying plant must be above 0.5. The proportion of renewable energy in electricity will be taken into account.

In production facilities outside the European Union, the applicant must demonstrate that the production facility has a hazardous substance management system for the protection of employees that meets the relevant European standards and legal regulations. This must also include information on the release of dust and compliance with the general dust limit values. Where technical or organizational measures cannot ensure compliance with general dust limit values or other workplace limit values, suitable personal protective equipment must be provided. Efforts must be made to minimize avoidable exposure of workers.

2.4 Usage

During use, the product must not have any odor or no odor foreign to the product (see 3.3 Other analysis: Odor).

The product emissions must not exceed the natureplus requirement values for the use phase (see section 3.1 Volatile organic compounds and GL5010 Low-emission building products).

In order to ensure that the results can be replicated, emissions analyses are undertaken on a mixed sample from 4 individual samples taken from various product batches.

In the case of resin-rich softwoods (e.g. pine, Douglas fir, larch), the producer must provide evidence of suitable measures to minimise the levels of VOC's (e.g. the selection of raw materials, periodic VOC-measurements, storage/drying).

2.5 Reuse, recycling and disposal

The product must be suitable for safe disposal in a waste incineration facility.

2.6 Ecological Parameters

All products in this product group must be manufactured in such a way that the environmental parameters listed in RL5020 are complied with.

2.7 Public Declaration

A public declaration of ingredients[1] must be provided in the official language of the country in which the product is intended for sale. It must be freely accessible. Ingredients must be listed in descending order of weight. The following publicly accessible documentation paths are permitted:

- Product packaging
- Technical data sheet
- Sales brochures
- Website

Ingredients from preliminary products or preparations that remain in the final product with a content of >1 M% must also be included in the full declaration.

The following applies to the public declaration of ingredients:

- above 1 M% the name of the ingredient
- below 1 M% at least the functional name of the ingredient, the mass order is cancelled.

[1] Ingredients are substances and mixtures that remain in the final product. Reactants and ancillary input materials are included in the non-public full declaration submitted to the assessment body

Furthermore, there is an obligation to include the following information with the product or to make it available to the consumer or user in an appropriate manner (e.g. online):

- Instructions for use and safety instructions
- Storage and disposal instructions
- Batch numbers
- Country of production
- Country of origin of input materials > 20 M-% where there is a deviation from the country of production

When using ingredients with an environmentally hazardous potential, the applicant must indicate at an appropriate place which measures are to be taken within the framework of dismantling and demolition work to protect the environment (e.g. controlled dismantling).

Additionally, the following product-specific information must be made available to the consumer or user.

- Labelling according to the guidelines of the European Community (Communauté Européenne, CE marking) or the respective general technical approval, including a scope specification
- General data (designation, type, name, etc.)
- Surface weight [kg/m²] or density [kg/m³]
- Thickness, length and width in mm
- Wood type and origin
- Moisture content of the wood
- The suitability for the usage class according to DIN 1052:2004-08
- The grade indication according to DIN 4074-1:2003-06 or
- Strength class according to DIN 1052:2004-8
- Euro class according to EN 13501-1

Information about the avoidance of chemical wood preservation and special construction measures being a requirement for classifying wood materials as hazard class 0 (according to DIN 68800-2 or an equivalent standard) is to be provided in the form of a leaflet.

The manufacturer has to give indications regarding sufficient wood conditioning before installation.

2.8 Processing and Installation

The applicant must demonstrate whether low-dust working methods are available for processing the product. If this is the case, these procedures are to be recommended and suitably presented within the processing guidelines. Compliance with the general dust limit value must be ensured by low-dust working methods. If this is not possible, the wearing of personal protective equipment must be prescribed.

2.9 Packaging

The packaging used must be recyclable.

The manufacturer must belong to a recycling system, if one exists for the corresponding material.

Paper and cardboard packaging must be made from recycled paper. Alternatively, paper from sources as per GL5002 is also permitted.

Plastic packaging must be made from polyolefins. PET, polystyrene or polycarbonates are allowed exceptionally in reasonablecases.

PVC packaging is generally not permitted.

Packaging must not contain biocides.

Once awarded, the natureplus label together with the license number must be printed on the packaging or made visible to the consumer in another suitable place.

3 LaboratoryTests

The products are subject to laboratory analyses to test for harmful substances and undesirable ancillary ingredients. A representative sample is collected during the production audit. If the sample collection cannot be conducted by a natureplus examiner, an independent person designated by natureplus can collect the sample. For products with different sizes but the same composition, a single sample is sufficient.

3.1 Volatile Organic Compounds VOC / TVOC

To check the emission of VOC and to determine the TVOC and TSVOC, an emission chamber test is carried out with the product. Measurements are usually performed after 3 and 28 days. The test-chamber examination is performed according to the current version of natureplus guideline 5010. The product must comply with the limit values specified in guideline 5010.

3.2 Element Analyses

The product is subject to an element analysis to determine the content of harmful elements and to check for undesirable contaminations. The measurements have to be in compliance with the limit values. The analysis is performed according to the current version of the test method TM-02 metals.

An eluate analysis is mandatory if the required values of the content analysis are not met.

Element	Limit value [mg/kg]
Boron (B)	≤ 25
Chromium (Cr)	≤ 5
Copper (Cu)	≤ 10
Mercury (Hg)	≤ 0,1

3.3 Other Analyses

Halogenic organic compounds

Test parameters	Limit values	Unit	Method
Halogenic organic compounds: AOX/EOX	≤ 1	mg/kg	TM-03 Halo

Odour

Test parameters	Limit values	Unit	Method
Odour	≤ 3	Odour intensity	TM-04 Odour

Pesticides

To be examined only if necessary:

Test parameters	Limit values	Unit	Method
Total pesticides	≤ 1	mg/kg	TM-05 Pesticides
Individual pesticides Organochlorine pesticides: Aldrin, Chlordane, DDD, DDE, DDT, Dichlofluanid, Dieldrin, Endrin, Heptachlor, Hexachlorobenzene, Lindane, Pentachlorophenol Organophosphate pesticides: Dimethoat, Fenthion, Parathion-methyl, Parathion-ethyl, Phosalon Pyrethroids: Cypermethrin, Lambda-Cyhalothrin, Permethrin Other: Benomyl, Carbendazim, Prochloraz	≤ 0,1	mg/kg	TM-05 Pesticides

4 Appendix

Test methods

TM-01 VOC : Volatile Organic Compounds VOC/TVOC, formaldehyde, acetaldehyde and TSVOC: DIN EN ISO 16000 series expanded by the natureplus implementation rules in guideline 5010.

TM-02 Metals: ICP-MS measurements according to DIN EN ISO 17294-2, supplemented with the natureplus implementation rules and a sample preparation adjusted to the issue analysed.

TM-03 Halo: Halogenic organic compounds after combustion, determined by microcoulometry according to the natureplus implementation rules "AOX/EOX".

TM-04 Odour: natureplus implementation rules "odour intensity", 6-degree grading scale 3 days after loading the test chamber following VDA 270:2018.

TM-05 Pesticides: DFG S 19 extended by natureplus implementing regulations

TM-08 Foreign fibres and foreign substances: scanning electron microscopy SEM

TM-09 Monomeric isocyanates: 24h after test chamber loading

TM-10 PAH: HPLC / GC-MS, sum according to EPA