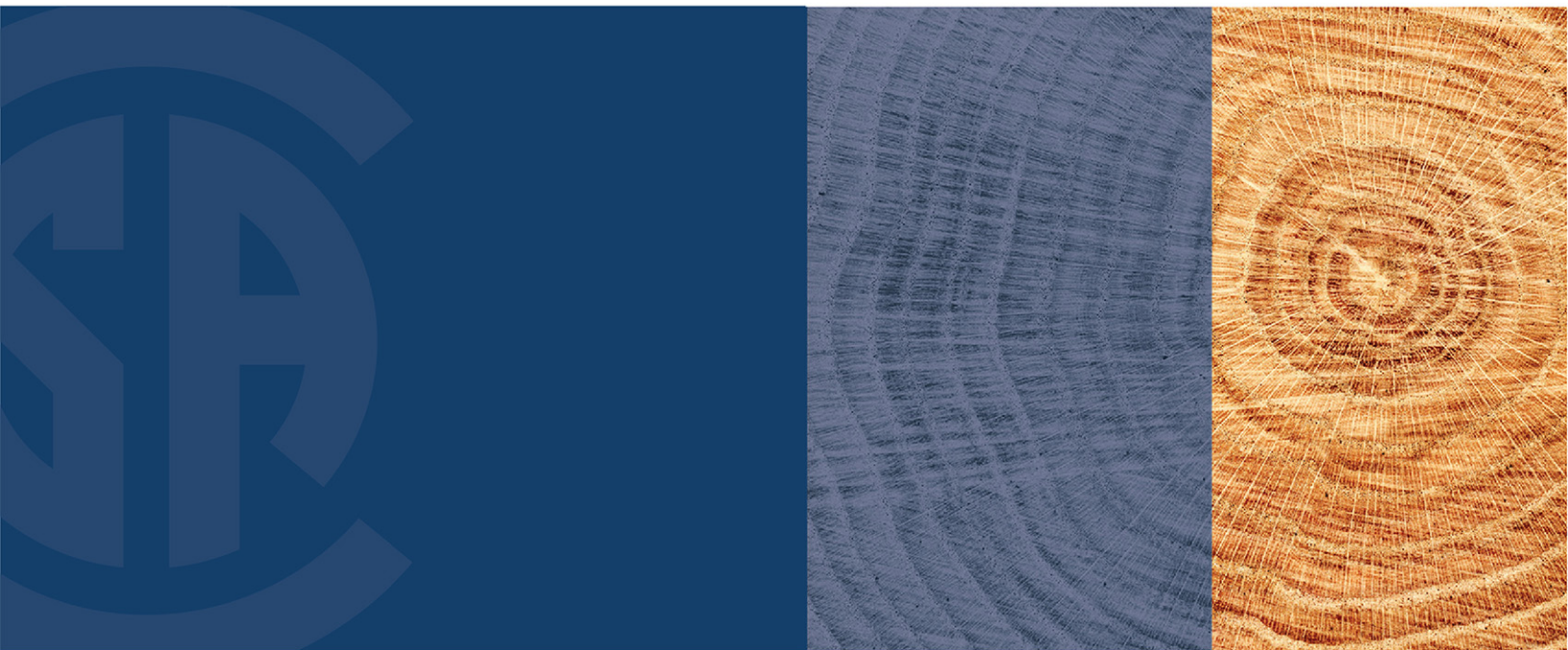




CSA 0125:23
National Standard of Canada



Mechanically laminated timber — Production and qualification specifications



Legal Notice for Standards

Canadian Standards Association (operating as “CSA Group”) develops standards through a consensus standards development process approved by the Standards Council of Canada. This process brings together volunteers representing varied viewpoints and interests to achieve consensus and develop a standard. Although CSA Group administers the process and establishes rules to promote fairness in achieving consensus, it does not independently test, evaluate, or verify the content of standards.

Disclaimer and exclusion of liability

This document is provided without any representations, warranties, or conditions of any kind, express or implied, including, without limitation, implied warranties or conditions concerning this document’s fitness for a particular purpose or use, its merchantability, or its non-infringement of any third party’s intellectual property rights. CSA Group does not warrant the accuracy, completeness, or currency of any of the information published in this document. CSA Group makes no representations or warranties regarding this document’s compliance with any applicable statute, rule, or regulation.

IN NO EVENT SHALL CSA GROUP, ITS VOLUNTEERS, MEMBERS, SUBSIDIARIES, OR AFFILIATED COMPANIES, OR THEIR EMPLOYEES, DIRECTORS, OR OFFICERS, BE LIABLE FOR ANY DIRECT, INDIRECT, OR INCIDENTAL DAMAGES, INJURY, LOSS, COSTS, OR EXPENSES, HOWSOEVER CAUSED, INCLUDING BUT NOT LIMITED TO SPECIAL OR CONSEQUENTIAL DAMAGES, LOST REVENUE, BUSINESS INTERRUPTION, LOST OR DAMAGED DATA, OR ANY OTHER COMMERCIAL OR ECONOMIC LOSS, WHETHER BASED IN CONTRACT, TORT (INCLUDING NEGLIGENCE), OR ANY OTHER THEORY OF LIABILITY, ARISING OUT OF OR RESULTING FROM ACCESS TO OR POSSESSION OR USE OF THIS DOCUMENT, EVEN IF CSA GROUP HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES, INJURY, LOSS, COSTS, OR EXPENSES.

In publishing and making this document available, CSA Group is not undertaking to render professional or other services for or on behalf of any person or entity or to perform any duty owed by any person or entity to another person or entity. The information in this document is directed to those who have the appropriate degree of experience to use and apply its contents, and CSA Group accepts no responsibility whatsoever arising in any way from any and all use of or reliance on the information contained in this document.

CSA Group is a private not-for-profit company that publishes voluntary standards and related documents. CSA Group has no power, nor does it undertake, to enforce compliance with the contents of the standards or other documents it publishes.

Intellectual property rights and ownership

As between CSA Group and the users of this document (whether it be in printed or electronic form), CSA Group is the owner, or the authorized licensee, of all works contained herein that are protected by copyright, all trade-marks (except as otherwise noted to the contrary), and all inventions and trade secrets that may be contained in this document, whether or not such inventions and trade secrets are protected by patents and applications for patents. Without limitation, the unauthorized use, modification, copying, or disclosure of this document may violate laws that protect CSA Group’s and/or others’ intellectual property and may give rise to a right in CSA Group and/or others to seek legal redress for such use, modification, copying, or disclosure. To the extent permitted by licence or by law, CSA Group reserves all intellectual property rights in this document.

Patent rights

Attention is drawn to the possibility that some of the elements of this standard may be the subject of patent rights. CSA Group shall not be held responsible for identifying any or all such patent rights. Users of this standard are expressly advised that determination of the validity of any such patent rights is entirely their own responsibility.

Authorized use of this document

This document is being provided by CSA Group for informational and non-commercial use only. The user of this document is authorized to do only the following:

If this document is in electronic form:

- load this document onto a computer for the sole purpose of reviewing it;
- search and browse this document; and
- print this document if it is in PDF format.

Limited copies of this document in print or paper form may be distributed only to persons who are authorized by CSA Group to have such copies, and only if this Legal Notice appears on each such copy.

In addition, users may not and may not permit others to

- alter this document in any way or remove this Legal Notice from the attached standard;
- sell this document without authorization from CSA Group; or
- make an electronic copy of this document.

If you do not agree with any of the terms and conditions contained in this Legal Notice, you may not load or use this document or make any copies of the contents hereof, and if you do make such copies, you are required to destroy them immediately. Use of this document constitutes your acceptance of the terms and conditions of this Legal Notice.



Standards Update Service

CSA 0125:23

May 2023

Title: *Mechanically laminated timber — Production and qualification specifications*

To register for e-mail notification about any updates to this publication

- go to www.csagroup.org/store/
- click on **Product Updates**

The **List ID** that you will need to register for updates to this publication is **2430642**.

If you require assistance, please e-mail techsupport@csagroup.org or call 416-747-2233.

Visit CSA Group's policy on privacy at www.csagroup.org/legal to find out how we protect your personal information.

Canadian Standards Association (operating as “CSA Group”), under whose auspices this National Standard has been produced, was chartered in 1919 and accredited by the Standards Council of Canada to the National Standards system in 1973. It is a not-for-profit, nonstatutory, voluntary membership association engaged in standards development and certification activities.

CSA Group standards reflect a national consensus of producers and users — including manufacturers, consumers, retailers, unions and professional organizations, and governmental agencies. The standards are used widely by industry and commerce and often adopted by municipal, provincial, and federal governments in their regulations, particularly in the fields of health, safety, building and construction, and the environment.

More than 10 000 members indicate their support for CSA Group’s standards development by volunteering their time and skills to Committee work.

CSA Group offers certification and testing services in support of and as an extension to its standards development activities. To ensure the integrity of its certification process, CSA Group regularly and continually audits and inspects products that bear the CSA Group Mark.

In addition to its head office and laboratory complex in Toronto, CSA Group has regional branch offices in major centres across Canada and inspection and testing agencies in fourteen countries. Since 1919, CSA Group has developed the necessary expertise to meet its corporate mission: CSA Group is an independent service organization whose mission is to provide an open and effective forum for activities facilitating the exchange of goods and services through the use of standards, certification and related services to meet national and international needs.

For further information on CSA Group services, write to
CSA Group
178 Rexdale Boulevard
Toronto, Ontario, M9W 1R3
Canada

A National Standard of Canada is a standard developed by a Standards Council of Canada (SCC) accredited Standards Development Organization, in compliance with requirements and guidance set out by SCC. More information on National Standards of Canada can be found at www.scc.ca.

SCC is a Crown corporation within the portfolio of Innovation, Science and Economic Development (ISED) Canada. With the goal of enhancing Canada’s economic competitiveness and social wellbeing, SCC leads and facilitates the development and use of national and international standards. SCC also coordinates Canadian participation in standards development, and identifies strategies to advance Canadian standardization efforts.

Accreditation services are provided by SCC to various customers, including product certifiers, testing laboratories, and standards development organizations. A list of SCC programs and accredited bodies is publicly available at www.scc.ca.

Standards Council of Canada
600-55 Metcalfe Street
Ottawa, Ontario, K1P 6L5
Canada



Cette Norme Nationale du Canada n’est disponible qu’en anglais.

Although the intended primary application of this Standard is stated in its Scope, it is important to note that it remains the responsibility of the users to judge its suitability for their particular purpose.

®A trademark of the Canadian Standards Association, operating as “CSA Group”

National Standard of Canada

CSA 0125:23

***Mechanically laminated timber —
Production and qualification
specifications***



*®A trademark of the Canadian Standards Association,
operating as "CSA Group"*



*Published in May 2023 by CSA Group
A not-for-profit private sector organization
178 Rexdale Boulevard, Toronto, Ontario, Canada M9W 1R3*

*To purchase standards and related publications, visit our Online Store at
www.csagroup.org/store/ or call toll-free 1-800-463-6727 or 416-747-4044.*

*ICS 79.020, 79.040
ISBN 978-1-4883-4770-2*

*© 2023 Canadian Standards Association
All rights reserved. No part of this publication may be reproduced in any form whatsoever
without the prior permission of the publisher.*

Contents

Technical Committee on Solid and Engineered Wood Products 3

Subcommittee on Mechanically Laminated Timber 6

Preface 7

0 Introduction 8

1 Scope 8

- 1.1 Overview 8
- 1.2 Inclusions 8
- 1.3 Exclusions 8
- 1.4 Terminology 8
- 1.5 Units of measurement 9

2 Reference publications 9

3 Definitions 10

4 MLT panel dimensions and dimensional tolerances 12

- 4.1 MLT panel depth 12
- 4.2 Dimensional tolerances 12
- 4.3 Squareness 12
- 4.4 Straightness 12
- 4.5 Gaps between adjacent laminations 12

5 Component requirements 12

- 5.1 Laminations 12
- 5.2 Lamination joints 13
 - 5.2.1 General 13
 - 5.2.2 Specimen selection 13
 - 5.2.3 End-joint tension test 13
 - 5.2.4 End-joint bond durability test 13
- 5.3 Fasteners 13
 - 5.3.1 General 13
 - 5.3.2 Nails, spikes, and wood screws 13
 - 5.3.3 Proprietary fasteners 14
 - 5.3.4 Wooden dowels 14

6 MLT assembly and certification requirements 14

- 6.1 General 14
- 6.2 Prescriptive MLT 14
 - 6.2.1 General 14
 - 6.2.2 Nail-laminated timber (NLT) 14
 - 6.2.3 Dowel-laminated timber (DLT) 18
- 6.3 Custom MLT 19
 - 6.3.1 General 19

6.3.2	Development of layup factors for custom MLT	19
6.4	Certification and marking	21
6.4.1	Certification	21
6.4.2	Product marking	21
6.4.3	Voiding marks	22
7	Test methods	22
7.1	Cyclic delamination test for end joints	22
7.1.1	Delamination test procedure	22
7.1.2	Delamination measurement	22
7.2	Bending test procedure for MLT panels	23
8	Manufacturing	24
8.1	Fabrication	24
8.1.1	General	24
8.1.2	Metal fasteners	24
8.1.3	Wooden dowels	24
8.2	Preservative treatment	24
8.3	Protection	24
9	Quality control tests	25
9.1	General	25
9.2	Inspection of lumber and MLT panels	25
9.3	End joints	25
9.3.1	General	25
9.3.2	End-joint strength	25
9.3.3	End-joint bondline durability	25

Annex A (informative)	— Conversions of SI to yard/pound (imperial) units	27
-----------------------	--	----

Technical Committee on Solid and Engineered Wood Products

R. Desjardins	National Lumber Grades Authority (NLGA), Vancouver, British Columbia, Canada <i>Category: Producer Interest</i>	<i>Chair</i>
Y. H. Chui	University of Alberta, Edmonton, Alberta, Canada <i>Category: Regulatory Authority/General Interest</i>	<i>Vice-Chair</i>
K. D. Below	Douglas Consultants, Québec, Québec, Canada <i>Category: User Interest</i>	
M. Clark	Hexion, Inc., Springfield, Oregon, USA	<i>Non-voting</i>
S. T. Craft	CHM Fire Consultants Ltd., Ottawa, Ontario, Canada <i>Category: User Interest</i>	
C. Dagenais	FPIInnovations, Québec, Québec, Canada <i>Category: Regulatory Authority/General Interest</i>	
P. Da Silva	Goodfellow Inc., Delson, Québec, Canada <i>Category: Producer Interest</i>	
K. Fargey	Western Archrib Ltd., Edmonton, Alberta, Canada <i>Category: Producer Interest</i>	
A. S. Garden	Canfor Wood Products Marketing Ltd., Vancouver, British Columbia, Canada <i>Category: Producer Interest</i>	
J. F. Grandmont	Ministère des Forêts, de la Faune et des Parcs, Québec, Québec, Canada <i>Category: Regulatory Authority/General Interest</i>	
M. Humphries	Mott MacDonald Canada Ltd., Toronto, Ontario, Canada	<i>Non-voting</i>

R. J. Jonkman	Canadian Wood Council, Ottawa, Ontario, Canada <i>Category: Producer Interest</i>	
F. Lam	University of British Columbia, Vancouver, British Columbia, Canada <i>Category: Regulatory Authority/General Interest</i>	
D. Lavoie	Boise Cascade Co., St-Jacques, New Brunswick, Canada <i>Category: Producer Interest</i>	
D. Lefebvre	PolyDM, Québec, Québec, Canada <i>Category: Producer Interest</i>	
T. V. Leung	Thomas Leung Structural Engineering, Vancouver, British Columbia, Canada <i>Category: User Interest</i>	
C. Lum	FPIInnovations, Vancouver, British Columbia, Canada	<i>Non-voting</i>
J. B. McFadden	National Research Council Canada, Ottawa, Ontario, Canada <i>Category: Regulatory Authority/General Interest</i>	
N. J. Nagy	FeNICKS Enterprises, North Vancouver, British Columbia, Canada	<i>Non-voting</i>
J. Neels	National Lumber Grades Authority (NLGA), Vancouver, British Columbia, Canada	<i>Non-voting</i>
M. S. Reid	Revive Engineering Inc., Oakville, Ontario, Canada <i>Category: User Interest</i>	
K. Rocchi	Element 5 Limited Partnership, Toronto, Ontario, Canada	<i>Non-voting</i>
A. Salenikovich	Université Laval, Québec, Québec, Canada <i>Category: Regulatory Authority/General Interest</i>	
G. Stapf	Henkel Engineered Wood Adhesives, Sempach Station, Luzern, Switzerland	<i>Non-voting</i>

N. Tarini	Wood Preservation Canada, Ottawa, Ontario, Canada	<i>Non-voting</i>
B. Yeh	APA – The Engineered Wood Association, Tacoma, Washington, USA <i>Category: Producer Interest</i>	
Z. Khalid	CSA Group, Toronto, Ontario, Canada	<i>Project Manager</i>

Subcommittee on Mechanically Laminated Timber

Y. H. Chui	University of Alberta, Edmonton, Alberta, Canada	<i>Chair</i>
C. Dagenais	FPInnovations, Québec, Québec, Canada	
R. Desjardins	National Lumber Grades Authority (NLGA), Vancouver, British Columbia, Canada	
L. Epp	StructureCraft Builders Inc., Abbotsford, British Columbia, Canada	
C. Ferguson	Timmerman Timberworks Inc., New Lowell, Ontario, Canada	
R. J. Jonkman	Canadian Wood Council, Ottawa, Ontario, Canada	
L. Ranger	Canadian Nuclear Laboratories, Chalk River, Ontario, Canada	
A. Salenikovich	Université Laval, Québec, Québec, Canada	
N. Tarini	Wood Preservation Canada, Ottawa, Ontario, Canada	
J. Zhou	University of Northern British Columbia, Prince George, British Columbia, Canada	
Z. Khalid	CSA Group, Toronto, Ontario, Canada	<i>Project Manager</i>

Preface

This is the first edition of CSA 0125, *Mechanically laminated timber — Production and qualification specifications*.

This Standard is intended to provide initial qualification and ongoing production quality control requirements to ensure that mechanically laminated timber products, as defined in this Standard, possess

- a) the structural design properties specified in CSA O86; and
- b) the physical characteristics that will lead to satisfactory performance in service.

The procedures in this Standard are under continuing development by the members of the Technical Committee and the Subcommittee responsible for producing this Standard.

This Standard was prepared by the Subcommittee on Mechanically Laminated Timber, under the jurisdiction of the Technical Committee on Solid and Engineered Wood Products and the Strategic Steering Committee on Construction and Civil Infrastructure, and has been formally approved by the Technical Committee.

This Standard has been developed in compliance with Standards Council of Canada requirements for National Standards of Canada. It has been published as a National Standard of Canada by CSA Group.

Notes:

- 1) *Use of the singular does not exclude the plural (and vice versa) when the sense allows.*
- 2) *Although the intended primary application of this Standard is stated in its Scope, it is important to note that it remains the responsibility of the users of the Standard to judge its suitability for their particular purpose.*
- 3) *This Standard was developed by consensus, which is defined by CSA Policy governing standardization — Code of good practice for standardization as “substantial agreement. Consensus implies much more than a simple majority, but not necessarily unanimity”. It is consistent with this definition that a member may be included in the Technical Committee list and yet not be in full agreement with all clauses of this Standard.*
- 4) *To submit a request for interpretation of this Standard, please send the following information to inquiries@csagroup.org and include “Request for interpretation” in the subject line:*
 - a) *define the problem, making reference to the specific clause, and, where appropriate, include an illustrative sketch;*
 - b) *provide an explanation of circumstances surrounding the actual field condition; and*
 - c) *where possible, phrase the request in such a way that a specific “yes” or “no” answer will address the issue.*

Committee interpretations are processed in accordance with the CSA Directives and guidelines governing standardization and are available on the Current Standards Activities page at standardsactivities.csa.ca.

- 5) *This Standard is subject to review within five years from the date of publication. Suggestions for its improvement will be referred to the appropriate committee. To submit a proposal for change, please send the following information to inquiries@csagroup.org and include “Proposal for change” in the subject line:*
 - a) *Standard designation (number);*
 - b) *relevant clause, table, and/or figure number;*
 - c) *wording of the proposed change; and*
 - d) *rationale for the change.*