



Accoya® and Tricoya® Adhesive Selection



Powerful adhesives for bonding Accoya® and Tricoya®



Accoya® and Tricoya®



Accoya is an acetylated solid wood product brand. It is one of the world's leading high performance sustainable wood, sourced from fast growing, FSC® certified forests. It is both highly stable and resistant to rot, with properties that match or exceed those of the most durable tropical hardwoods, plastics and other non-renewable alternatives. Ideal for use across numerous internal and external applications, Accoya's primary applications are windows, doors, decking and cladding.



Tricoya panel products are similar to MDF but have enhanced properties: exceptional durability and very high dimensional stability. It is ideal for use in wet environments internally or externally. These properties open countless opportunities for specifiers, architects, joinery manufacturers and product designers.



The high durability requirements as well as the special manufacturing and treatment procedures are central aspects which must be taken into consideration when choosing an adhesive. Apart from general assembly applications and surface lamination, another established process is the edgbanding of Tricoya®. Jowapur® prepolymer adhesives as well as Jowatherm-Reaktant® hot melt adhesives are characterized by technical advantages and superior quality, which ensures that the requirements of the customer can be met. Jowat provides a wide range of adhesives to make the bonding process of Accoya® and Tricoya® convenient.

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Classification of wood adhesives for exterior use

Adhesive bonds exposed to weathering have to withstand extreme conditions. The European standard EN 17619 establishes a classification system for such adhesives. The standard specifies three adhesive categories and applies exclusively to non-structural timber products for exterior use. The three durability classes from XT5 to XT7 define different requirements for the adhesive and the constructive weathering protection depending on the intensity and frequency of exposure. XT7 describes exterior applications with frequent exposure to direct weathering, in which the bonded wooden product is not covered by a constructive protection and not in contact with the ground. Jowat supplies a range of different solutions for each durability class.

Adhesive Selection

	Application	Type	Viscosity [mPas]	Open time	Pressing time
Jowacoll® 102.50 + 15 % Jowat® 195.60	Solid Wood Bonding, Flat Lamination, Assembly	EPI dispersion adhesive	~ 11,000 at 20 °C	~ 10 min at 20 °C	~ 30 min at 20 °C
Jowatherm-Reaktant® 607.40	Edgebanding	PUR hot melt adhesive	~ 75,000 at 140 °C	~ 8 s at 140 °C	-
Jowatherm-Reaktant® 608.00	Edgebanding	PUR hot melt adhesive	~ 90,000 at 120 °C	~ 7 s at 120 °C	-
Jowatherm-Reaktant® 609.36	Flat Lamination, Assembly	PUR hot melt adhesive	~ 13,200 at 120 °C	~ 5 min at 120 °C	-
Jowapur® 681.10	Solid Wood Bonding, Flat Lamination, Assembly	PUR prepolymer adhesive	~ 15,500 at 20 °C	~ 10 min at 20 °C	~ 10 min at 20 °C
Jowapur® 686.60	Solid Wood Bonding, Flat Lamination, Assembly	PUR prepolymer adhesive	~ 10,500 at 20 °C	~ 45 min at 20 °C	~ 135 min at 20 °C
Jowapur® 687.40	Solid Wood Bonding, Flat Lamination, Assembly	PUR prepolymer adhesive	~ 8,000 at 20 °C	~ 35 min at 20 °C	~ 115 min at 20 °C

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