



accoya 
tricoya 

Proven Performance for Sustainable Woods



H.B. Fuller and ACCSYS – A Strong Partnership for Sustainable Wood Solutions

H.B. Fuller and ACCSYS have partnered on testing towards H.B. Fullers recommendation of adhesives for bonding Accoya® and Tricoya® – delivering proven performance and opening up new opportunities for manufacturers, designers, and builders.

As one of the world's leading adhesive manufacturers, H.B. Fuller offers decades of expertise and trusted brands such as Rakoll® and Icema®, which are widely recognised in the wood and furniture industries. Customers worldwide value these adhesives for their reliable performance, innovation, and ease of use.



ACCSYS sets the standard in sustainable, high-performance wood products.

Accoya® modified wood is the benchmark for the timber industry – combining exceptional durability, dimensional stability, and design flexibility in a way no other wood can. Sustainably sourced with a low lifetime carbon footprint, Accoya supports a circular, bio-based economy and stands out as one of the few truly sustainable building materials available today.








With Tricoya®, these benefits extend into the MDF category. Tricoya high-performance exterior MDF panels combine outstanding durability and dimensional stability with the flexibility and machinability of wood-based panels. The result: panels that can be used in the most extreme outdoor and wet environments – unlocking new design possibilities and significantly reducing long-term maintenance costs.



Traditionally, MDF panels were limited by performance in challenging environments. Tricoya changes the rules – offering unrivalled versatility and reliability where conventional MDF cannot perform.

Through joint testing, H.B. Fuller and ACCSYS have now qualified multiple adhesive formulations that ensure optimal adhesion, long-term stability, and exceptional durability with Accoya and Tricoya products, even under demanding conditions.

The following table highlights optimised combinations of high-performance Rakoll®, Icema® and Rakollit® adhesives with Accoya® and Tricoya® wood substrates, ensuring reliable performance and long-lasting bonding solutions.

Adhesives	Rakoll® GXL-4*		Icema® 34*		Rakollit® 280 + Hardener WS 1 I*		Rakoll® 5010	
Technology	PVAc D4 		1K PU 		EPI 		PU Reactive Hotmelt Low Monomer 	
Key Characteristics	<ul style="list-style-type: none"> Classification according to EN 204: load group D4 as a one-component system High water resistance Improved heat- and water resistance when using high process temperatures No discolouration of the glue line due to the influence of process heat Improved adhesion on difficult wood species (oak, larch) 		<ul style="list-style-type: none"> Good balance between open time and press time Very good adhesion to a variety of substrates 		<ul style="list-style-type: none"> KOMO certified Improved heat- and water resistance when using high process temperatures Improved adhesion on difficult wood species (oak, larch) Shorter pressing times at higher press temperature No discolouration of the glue line due to the influence of process heat Good adhesion to various plastic substrates Classification according to NEN-EN 204: load group D 4 as two-component system 		<ul style="list-style-type: none"> High thermal stability after complete cross-linking Good adhesion to various plastic substrates High heat resistance High mechanical properties High initial bonding strength Long open time Low content of monomeric MDI (<0,1%) Free from hazardous labeling 	
Colour	White		Transparent, orange		Brown (mixed)		Light yellow	
Viscosity	5,500 mPa·s		3,400 mPa·s		200 mPa·s		15,000 mPa·s	
Open Time			5 min, 7 min, 10 min, 12 min, 14 min, 18 min		1.5 h (pot life)		6 min	
Use with	interior	exterior	interior	exterior	interior	exterior	interior	exterior
Accoya®	+	o**	+	+	+	+		
Tricoya®	+	o**	+	+	+	+	+	+

*Press time: ~2 h cold
Coat weight: 100-120 g/m²
Pressure: 1 N/mm²

**passed IFT test method HO 10/1
3 h water immersion at +20 °C | 3 h water immersion at +60 °C | 18 h water immersion at +20 °C | 72 h drying at +23°C / 50 % humidity

The strong collaboration between H.B. Fuller and ACCSYS delivers a complete, proven market solution:
Advanced wood materials paired with high-performance adhesives – enabling you to benefit from stronger, more sustainable, and more versatile solutions for the future of construction and design.
 Contact us today to explore how we can support your success: rakoll@hbfuller.com | sales@accsys.com

ABOUT H.B. FULLER

Since 1887, H.B. Fuller has been a leading global adhesives provider focusing on perfecting adhesives, sealants and other specialty chemical products to improve products and lives. H.B. Fuller’s commitment to innovation brings together people, products and processes that answer and solve some of the world’s biggest challenges. Our reliable, responsive service creates lasting, rewarding connections with customers in electronics, disposable hygiene, health and beauty, transportation, aerospace, clean energy, packaging, construction, woodworking, general industries and other consumer businesses. And, our promise to our people connects them with opportunities to innovate and thrive.