



# ACCOYA® AND TRICOYA® BONDING ADHESIVES & SEALANTS

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## SOUDAL BUILDING THE FUTURE

Soudal is Europe's leading independent manufacturer of adhesives, sealants and PU foams. By continuously looking for qualitative solutions for current and upcoming challenges in the world, we are fully committed to a better future. That is why innovation, quality and progress are keywords for us.

### INNOVATION

Research and development of new products, technologies, and production methods are in our DNA. In our R&D centre, highly skilled employees develop and optimize consistently our existing products. In collaboration with the market, we are also working on new, even more powerful products to be able to offer innovative solutions.

### QUALITY

External test institutes support us and help monitor the quality of our products. By applying system checks and periodic external supervision, we guarantee high-quality products that meet the demands and needs of end users and the market.



### Family business

Founded by Vic Swerts in 1966

100% family-owned

Long-term growth strategy

### Internationalisation

82  
Affiliates

4.500+  
Workforce

140  
Countries

# ABOUT ACCOYA® AND TRICOYA®



The use of Accoya® wood is an increasingly popular choice for crafting beautiful, high-performance timber doors and windows, cladding and much more.

This highly rot-resistant wood is based on the process of 'wood acetylation', where changing the cell structure of the wood has been scientifically proven to improve dimensional stability, operating performance, extend coating longevity and generally requires less maintenance.

Accoya® wood is class 1 durable, providing peace of mind of long-lasting performance in even the harshest external environments.

## KEY BENEFITS OF USING ACCOYA®:

- 50 years above ground and
- 25 year in-ground contact warranty
- Extended maintenance intervals due to outstanding coatings performance



Tricoya® is a high-performance MDF panel which enables simple manufacturing and can be used for external use and in the most extreme environments.

## KEY BENEFITS OF USING TRICOYA®:

- 50 years above ground and
- 25 year in-ground contact warranty
- Low maintenance
- Versatile



# SEALANTS

A sealant contributes to the esthetic completion of a building. However, sealing also has an important functionality in a building. The purpose of a sealant is to prevent humidity, cold air and dirt from getting into the inside structure of the building and cause damage and costs.

Different parts of a building can move due to thermal expansion, wind, vibrations caused by traffic and transport etc. To accommodate this movement a sealant needs to offer, above all, an excellent adhesion, weatherability and elasticity.

Soudal offers a wide range of high-quality sealing solutions, both hybrid and silicone technology. Different alternatives have been tested and approved for use on Accoya® wood.

## PRODUCTS



### SILIRUB® 2

**DESCRIPTION:**

Silirub® 2 is a premium low-modulus neutral silicone ideal for glazing, façade, construction and industrial sealing. Very high UV resistance and weatherability.

**PROPERTIES:**

- Low-modulus neutral silicone
- 100% silicone
- Primerless adhesion on most surfaces
- Excellent adhesion to Accoya® wood
- Independently tested to ISO 11600 F&G 25 LM
- Sealed-unit compatible
- Extensive colour range



### SILIRUB® 2AT

**DESCRIPTION:**

Silirub® 2AT is a high-quality, neutral silicone sealant with low modulus and low emissions ideal for glazing, façade, construction and industrial sealing. Very high UV resistance and weatherability.

**PROPERTIES:**

- Low-modulus neutral silicone
- EC1+, low emission, less odor
- Primerless adhesion on most surfaces
- Excellent adhesion to Accoya® wood
- Independently tested to ISO 11600 F&G 25 LM
- Sealed-unit and polycarbonate compatible
- Extensive colour range



### SOUDASEAL® GLASS & PAINT

**DESCRIPTION:**

Soudaseal® Glass & Paint is a high-quality, elastic glazing sealant based on hybrid SMX polymer. Soudaseal® Glass and Paint is specially developed to be overpainted with water and solvent-based paints.

**PROPERTIES:**

- Primerless adhesion on most surfaces like aluminium, PVC and glass
- Excellent adhesion to Accoya® wood
- Very good mechanical characteristics
- Good weather and UV resistance
- Meets ISO 11600 F 20 LM & ISO 11600 G 25 LM
- KOMO-certificate 33299 based on BRL2801 (glazing sealant)
- Paintable with most water water and solvent-based paints

Products	Silirub® 2	Silirub® 2AT	Soudaseal® Glass & Paint
Technology	Neutral silicone	Neutral silicone	Hybrid polymer
Applications	Glazing, façade, general construction joints	Glazing, façade, general construction joints	Glazing, general construction joints
Paintable	Not paintable	Not paintable	Paintable
Curing system	Moisture curing	Moisture curing	Moisture curing
Skin formation	Ca. 9 min	Ca. 8 min	Ca. 20 min
Hardness	23 ± 5 Shore A	20 ± 5 Shore A	25 ± 5 Shore A
Elongation at break (ISO 37)	> 800 %	>700 %	> 600 %
Curing speed (23°C/50% R.H.)	Ca. 2 mm/24h	Ca. 2 mm/24h	Ca. 2 mm/24h
Temperature resistance	-60 °C → 180 °C	-60 °C → 180 °C	-40 °C → 90 °C



We recommend using **Silirub® 2**, **Silirub® 2AT**, and **Soudaseal® Glass & Paint** for this application. In most cases, no surface pretreatment is necessary to achieve good adhesion, but we always advise degreasing the surface before applying the sealant.

# SEALANTS

## GENERAL REQUIREMENTS FOR A QUALITY SEALANT

**Superior adhesion properties** to materials used in façades like Accoya® wood, concrete, aluminium panels and different window profiles. Depending on the type of application different materials are used.

**High movement capability** between the construction elements.

**Excellent weatherability:** the sealant should offer high wind, rain and UV resistance to prevent mechanical and esthetic failure like adhesion loss and discoloration.

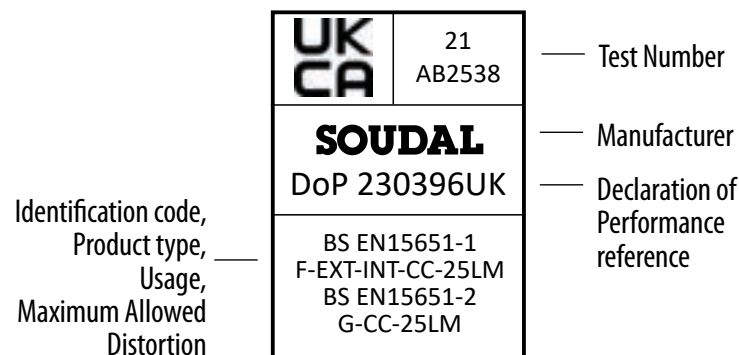
**Excellent workability:** no sagging, easy to extrude and short cut-off string. Sealants that are easy to tool will result in faster and better application.

## UKCA AND CE MARKING EXPLAINED

The UKCA and/or CE marking of the cartridge provides important information about the quality and characteristics of sealants used within the construction industry.

There are **four types** of UKCA/CE marking for sealants, each defining the area of intended use:

- EN 15651-1** = sealants for façade elements (F)
- EN 15651-2** = sealants for glazing (G)
- EN 15651-3** = sealants for sanitary applications (S)
- EN 15651-4** = sealants for pedestrians walkways (PW)



BS EN 15651-1 TYPE F-EXT-INT	Joint sealant for façade (F) elements for interior (INT) and exterior (EXT) use.
BS EN 15651-1 TYPE F-EXT-INT-CC	Joint sealant for façade (F) elements for interior (INT) and exterior (EXT) use. Suitable for use in cold climates (CC).
BS EN 15651-2 TYPE G	Joint sealant for glazing (G).
BS EN 15651-2 TYPE G-CC	Joint sealant for glazing (G) applications. Suitable for use in cold climates (CC).
BS EN 15651-3 XS1	Joint sealant for sanitary (S) applications. The 'X' refers to a low shrinkage of the sealant. 'S1' refers to the anti-fungal property of the sealant, providing the best resistance class to mould growth.



# PU WOOD ADHESIVES

PU adhesives, also known as foaming adhesives, are PU-based one-component adhesives that are considered to be one of the oldest technologies in the wood sector. They are suitable for various materials and applications. Unlike white wood glues, where the water evaporates from the adhesive joint, PU adhesives cure through a chemical reaction. This adhesive requires moisture from the air or the materials to be glued to start the curing process and will then start to bubble slightly. Ideally one of the materials is porous so that moisture can penetrate, allowing the glue to react and form a strong adhesive bond. The foaming action causes the elements to be bonded to be slightly pressed apart, making it necessary to clamp or press the materials.

Due to their versatility, not only two wooden materials can be glued together, but also a wooden surface with a substrate made of another, non-absorbent material. Polyurethane adheres so well that it is very difficult or even impossible to remove stains without mechanical treatment.

PU construction adhesives are a derivative of the more liquid PU wood adhesives. These products are typically supplied in cartridges and offer better filling capacity. PU construction adhesives have a similar technology and will also foam when curing, requiring clamping or pressing. A classic application of these adhesives is, for example, making construction connections in window profiles.

When working with PU adhesives, always ensure good ventilation and protective measures, such as gloves and goggles.



## PRO 40P

Water resistant timber adhesive

### DESCRIPTION:

PRO 40P is powerful PU liquid timber adhesive with excellent water resistance that also sticks on damp/humid and hardwood. Glues windows, doors, trusses, sandwich panels, insulation materials (except polystyrene), wood and construction elements, etc. Suitable for Accoya® and Tricoya® and exterior applications.

### PROPERTIES:

- DIN EN 204: D4
- Water resistant
- Open time: 15 min
- Application temperature: +5°C - +35°C
- Packaging: 750 g – 5 Kg



## PUROCOL

Transparent PU based construction adhesive (D4)

### DESCRIPTION:

Purocol is an ultra-high-strength, rapid-curing, PU-based construction adhesive designed for transparent and water-resistant (D4 according to EN 204) bonding. Offers superior strength build-up speed. Ideal for heavy-duty wood bonding and compatible with other common construction materials.

### PROPERTIES:

- DIN EN 204: D4
- Water resistant
- Filling characteristics
- Open time: 30 min
- Application temperature: +5°C - +35°C
- Packaging: 310 ml (cartridge)



## APPLICATION TIME

For optimal results, the open times and pressing times of the respective wood adhesive must be taken into consideration during application. The open time, i.e. the time between applying the adhesive and pressing the workpieces together depends on the temperature and humidity. The specified values are based on a temperature of 20° C and normal humidity. Deviating conditions will affect the open and drying time.



# HYBRID CONSTRUCTION ADHESIVES

The latest generation of wood and construction adhesives is based on hybrid polymer technology. This adhesive combines the end strength of white wood or PU adhesives with the benefits of working with a hybrid formula. The adhesive meets the highest water resistance, class D4, making it perfect for both indoor and outdoor applications. Working with a hybrid also means no risk of black hands thanks to the absence of isocyanates. The curing process starts from the reaction with moisture in the air or the materials, so no clamping is necessary. It is sufficient to secure the connection, for example with tape, and it becomes hand-tight after 45 minutes, significantly increasing work speed. After curing, the excess glue can be easily trimmed off with a chisel. Thanks to its good filling capacity and availability in three colors (wood, white, and black), this glue is the ideal solution for all connections where the glued seam remains visible.



## HB CONSTRUCT

### STRONG WATERPROOF CONSTRUCTION ADHESIVE

#### DESCRIPTION:

HB Construct is a unique waterproof (D4), non-foaming and very strong construction adhesive. Suitable for the bonding of non-carrying bondings between different sorts of wood. Specific for bondings with a wooden seam which will remain visible. Suitable for Accoya® and Tricoya®.

#### PROPERTIES:

- DIN EN 204: D4
- Water resistant
- No clamping needed
- Open time: ca. 10 min
- Application temperature: +5°C - +35°C
- Packaging: 290 ml (cartridge)



## TIPS FOR A PERFECT BOND



- Carefully read the instruction manual on the packaging.



- Make sure the parts to be bonded are clean and free of dust and grease.



- Work at room temperature.



- Remove adhesive residue immediately after use.



- Close the packaging properly.



- Store in a dry, cool and frost-free place.



- All technical data sheets are available on our website [www.soudal.com](http://www.soudal.com).

# SUMMARY TABLE



	PRO 40P	Purocol	HB Construct
<b>PROPERTIES</b>			
<b>Type</b>	Polyurethane	Polyurethane	Hybrid polymer
<b>Curing system</b>	Chemical reaction	Chemical reaction	Chemical reaction
<b>Water resistance</b>	D4 (EN204)	D4 (EN204)	D4 (EN204)
<b>Shrink / Expansion</b>	Expansion - foaming	Expansion - foaming	Stable
<b>End strength</b>	>100kg/cm <sup>2</sup>	>100kg/cm <sup>2</sup>	>100kg/cm <sup>2</sup>
<b>Paintable</b>	Yes	Yes	Depending on the paint
<b>Application temperature</b>	5°C - 35°C	5°C - 35°C	5°C - 35 °C
<b>Viscosity (Brookfield)</b>	2.500 - 4.500	185.000 - 190.000	96.000
<b>pH</b>	6 - 7	6 - 7	7
<b>Color after curing</b>	Amber	Transparent	Brown/Black/White
<b>CURING</b>			
<b>Min. / max. pressing time</b>	3u	3u	No pressing, just positioning
<b>Open time</b>	ca.15min.	ca. 30 min.	ca 10 min.
<b>PACKAGING</b>			
<b>Article number</b>	750g: 108766 5Kg: 108901	310ml: 107300	290ml brown: 135782 290ml black: 135783 290ml white: 135784



**SODAL NV**

Everdongenlaan 18  
2300 Turnhout  
Belgium  
Tel: +32 14 42 42 31  
[www.soudal.com](http://www.soudal.com)

