

Accoya® & Tricoya®



- Durable bonding and lamination
- High resistance to moisture and heat



Jowacoll®
Jowapur®
Jowatherm-Reaktant®
Jowat-Toptherm®

Adhesives for highest stress levels



Chemically modified solid wood is manufactured under a license from Accsys Technologies and marketed with the brand names Accoya® and Tricoya®. Acetylation is used to increase the resistance against climate exposure of wood species with limited durability – making them suitable for exterior use.

The high resistance of modified solid wood (Accoya®) and wood-based panels manufactured from modified fibres (Tricoya®) is, among other factors, due to a much slower absorption and release of moisture. However, this behaviour and the additional ingredients introduced into the wood through the modification process also have a major impact on the bonding performance. For instance, the pressing time has to be extended significantly when water-based PVAc adhesives are used, making such processes very inefficient. Direct exposure to sunlight in exterior use, especially on dark surfaces, also requires a higher thermal resistance of the bondline, which thermoplastic PVAc adhesives are not able to provide in most cases.

The Jowat product portfolio offers different chemical-

ly crosslinking adhesives to match the high quality standard expected from bonded Accoya® or laminated Tricoya®. Depending on the process conditions, the following solutions are available:

- cold processed one-component PUR adhesives
- cold processed two-component EPI adhesives
- hot processed reactive PUR and PO hot melt adhesives for edgebanding and flat lamination

All these adhesive types have in common that they are highly resistant to moisture and heat, and that they are designed to bond parts intended for exterior use. Adhesives of different chemical bases are available for cold and hot processing. The type to be selected depends mainly on the technical conditions at site, e.g. type of application equipment, pressing unit, required process times etc.).

All adhesives listed below are qualified to bond Accoya® and Tricoya®. Test results demonstrated the general suitability as well as long-term durability of the adhesives and the produced compound. However, the processing parameters and the expected resistance of the compound have to be tested again in each individual case before processing.

For cold processed 1-component PUR prepolymers, the glue-line surface of Accoya® and Tricoya® must be moistened prior to adhesive application.

Jowapur® 687.40

Chemical basis		1-comp. polyurethane prepolymer
Processing temperature	[°C]	> +10
Waiting time at 20 °C / 50 % AH	[min]	approx. 40
Minimum pressing time at 20 °C	[min]	approx. 120

Jowapur® 686.20

Chemical basis		1-comp. polyurethane prepolymer
Processing temperature	[°C]	> +10
Waiting time at 20 °C / 50 % AH	[min]	approx. 20
Minimum pressing time at 20 °C	[min]	approx. 60

Jowacoll® Five Star 102.49 + 195.60

Chemical basis		2-comp. reactive EPI
Processing temperature	[°C]	> +10
Waiting time at 20 °C / 50 % AH	[min]	approx. 10
Minimum pressing time at 20 °C	[min]	approx. 25

Edgebanding on Tricoya®

Jowatherm-Reaktant® 608.00

Chemical basis		1-comp. reac. polyurethane (hot melt)
Processing temperature	[°C]	approx. 120
Viscosity	[mPas]	approx. 80,000
Density	[g/cm³]	approx. 1.1

Jowat-Toptherm® 237.10

Chemical basis		thermoplastic polyolefin (hot melt)
Processing temperature	[°C]	approx. 180 - 200
Viscosity	[mPas]	approx. 100,000
Density	[g/cm³]	approx. 1.1

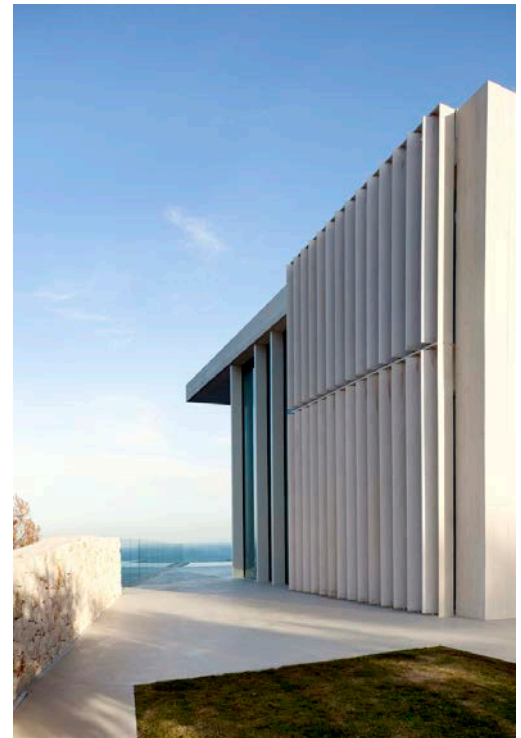
Flat lamination on Tricoya®

Jowatherm-Reaktant® 609.30

Chemical basis		1-comp. reac. polyurethane (hot melt)
Processing temperature	[°C]	approx. 110 - 130
Viscosity	[mPas]	approx. 15,000
Density	[g/cm³]	approx. 1.1

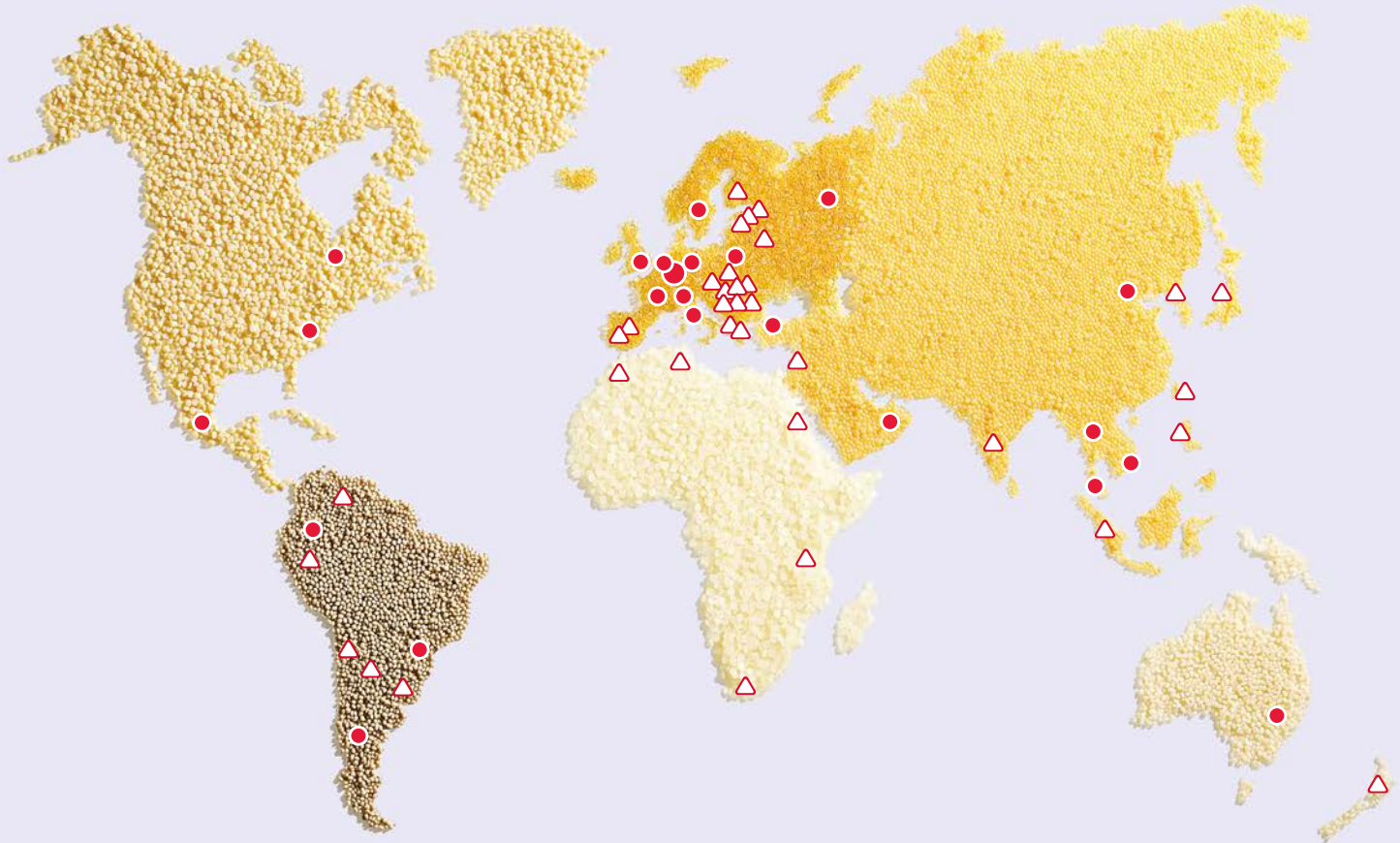
Jowat-Toptherm® 236.50

Chemical basis		thermoplastic polyolefin (hot melt)
Processing temperature	[°C]	approx. 180 - 200
Viscosity	[mPas]	approx. 10,000
Density	[g/cm³]	approx. 0.87



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Jowat – Kleben erster Klasse
Jowat – first class bonding

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