

# QUICK GUIDE: HOW TO USE ACCOYA® WOOD

## TRANSPORTATION AND STORAGE

Accoya® wood should be carefully transported and stored horizontally in a manner consistent with other high quality woods. This includes keeping it from getting wet shortly before being processed. The equilibrium moisture content of Accoya® wood is quite dry (3-5% in normal conditions). Wood measuring more than 8% moisture content is likely to have excessive "free" water and should be allowed to dry before further processing.

## PROCESSING

The kiln-drying and our production process can result in discoloration of the Accoya® wood generally up to 5 mm in depth with sticker marks up to 6 mm in depth, dependent on natural wood discoloration. Removal is not required when using opaque coatings or for parts that are not visible. When machining, avoid shavings being thrown onto the material as this may cause impressions. Even when dampened these marks may not disappear, so it is also important to prevent machining marks by using sharp tools.

## GLUING

Since Accoya® is drier than normal woods and absorbs water in a different manner, this can affect the suitability and curing time of some adhesives. Suitable glues for Accoya® wood are PU, Epoxy and PRF glues. The results of gluing with PVAc and MUF can vary greatly.

## FIXINGS

Always use fasteners and fixtures of a stainless steel grade A2 or A4 (EN 10088-1) or AISI type 304 or 316 when possible. Specially coated (epoxy, poly-urethane) fasteners or auxiliaries may also be used. Pre-drilling holes for fasteners is recommended, especially when using coated fixtures.

## COATING

Accoya® wood may be finished with semi-and non-film forming paint systems such as stains and oils. Oils or oil-based products tend to be absorbed quickly and in large quantities. To minimize absorption, let the first coat dry before applying additional coats. As oils can be a food source for disfiguring fungi, products containing a mouldicide are recommended. Please refer to your coating supplier for advice about the best way to apply their products.

If using film-forming opaque and translucent coating systems, they should be applied on all sides (preferably factory applied) with a minimum film thickness that corresponds to the requirements of the end product and/or paint supplier's instructions. End grains should be sealed with a suitable product so the protection of all finished sides against water (liquid) uptake is approximately equal. The rate of drying and/or curing of a coating might be different with Accoya® wood, and the paint supplier's guidance should be followed, often resulting in overnight drying. Some applications may call for the use of a primer containing stain blockers and/or a mouldicide. Please contact your coating supplier for further advice.

## APPLICATION SUITABILITY

Accoya wood® offers unsurpassed dimensional stability and durability class 1 according to EN 350-2, EN 113 and ENV 807 in risk class 1 to 4 according to EN 335-1. Prolonged contact with materials or chemicals that are pH9 and above is not recommended. The visual wood quality is described by the order confirmation and the "Accoya® Radiata Pine Lumber Grading Specifications".

## QUALITIES OF ROUGH SAWN ACCOYA® WOOD

| GRADE             | QUALITY  |
|-------------------|--|
| Accoya® A1        | 4-sides primarily clear  |
| Accoya® A2        | 3-sides primarily clear  |
| Accoya® A3        | 1-sides primarily clear  |
| Accoya® B         | Dressing quality with limited flaws on all sides                                     |
| Accoya® wood FJ-A | Optimised and finger jointed according to BRL1704-2 (USA: available on request only) |

For a more detailed description of these and other available grades, please contact Accsys Technologies.

## MORE INFORMATION

Please refer to the comprehensive version of the Accoya® Wood Information Guide or contact your supplier or Accsys Technologies for additional information. Please see below for the telephone numbers of our offices or visit [www.accoya.com](http://www.accoya.com) for your nearest distributor.

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