



# INDUSTRIAL ADHESIVES





The Incoll brand is a range of professional adhesives for the carpentry industry.

**A wide range of products will complexly meet the demand for adhesives in various stages of production, from veneering to upholstery.**

**The following groups of adhesives are available in our offer:**

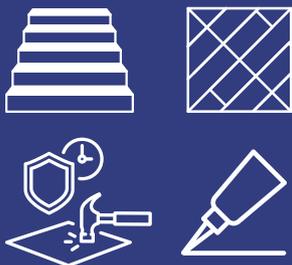
**POLYURETHANE ADHESIVES  
SOLVENT-BASED ADHESIVES  
HOT MELT ADHESIVES  
WOOD ADHESIVES BASED ON POLYVINYL ACETATE  
ADHESIVES FOR PARQUET  
POLYUREA-FORMALDEHYDE RESIN**

**In addition to the basic offer, the image of which can be found in the catalogue**

**We also provide assistance in the following areas:**

- adaptation of gluing technology, selection of glue and gluing techniques
- We supply equipment such as guns, applicators, tanks or pumps.

**We invite you to visit one of our Branches,  
where you will find professional and friendly service our sales advisors.**



# POLYURETHANE ADHESIVES



Polyurethane adhesives can be classified as specialist adhesives. They combine advantages such as: adequate operating time, strong connections and water resistance. The most popular and recognizable version is the 1kg bottle with an applicator. Thanks to their advanced technology, adhesives from the Aplicon Pur family are characterized by very high joint cohesion.



USE FOR	NAME	VISCOSITY [mPas]	OPEN TIME	PRESS TIME	CHARACTERISTICS
softwood, hardwood, MDF, HDF, LDF	<b>MONOPUR 150</b> 1kg, 10kg or larger*	7500-8500	45-180 min	4-5 h	Slow glue, best for hard wood species in layered and bent bonding. Most popular in the production of stairs, balustrades, wooden entrance doors – specialized door and window joinery.
softwood, hardwood, MDF, HDF, LDF	<b>MONOPUR EXPRESS 10</b> 1kg, 10kg or larger	7500-8500	5-10 min	40-60 min	Very fast, preferred for soft woods, optional hard grades. It requires a very quick application, ideal for gluing small surfaces.
softwood, hardwood, MDF, HDF, LDF	<b>MONOPUR EXPRESS 25</b> 1kg, 10kg or larger	7500-8500	15-25 min	1,5-2h	Moderate open-time adhesive, preferred for softwoods, hard grades optional. Good for wet wood. In the summer, it can be used as a very fast adhesive.

# POLYURETHANE ADHESIVES

USE FOR	NAME	VISCOSITY [mPas]	OPEN TIME	PRESS TIME	CHARACTERISTICS
softwood, hardwood, MDF, HDF, LDF	<b>MONOPUR 45/E</b> 1 kg, 10kg or larger	7500-8500	 25-45 min	 2h	Moderate open time glue, preferred for soft woods, optional hard woods, Good for damp wood. Ideal for layered gluing: lamellas, square timber. Due to special additives that improve wettability, it can be used for exotic wood.
sandwich panel made of various types of veneers and cores	<b>ITAPUR PRESS</b> 10kg lub larger	4500-6500	 3-8 h	 20-24 h	A relatively slow adhesive designed for layered bonding in manual application. Applied in the production of sandwich panels from various materials such as varnished sheet metal, galvanized sheet, plywood, drywall with such types of core as polystyrene, polyurethane, mineral wool or plywood. An adhesive that gives a hard-elastic foam with low expansion.
sandwich panel made of various types of veneers and cores	<b>ITAPUR PRESS EXPRESS</b> 10kg or larger	4500-5500	 15-25 min	 20-60 min	A fast adhesive designed for the production of all types of sandwich panels, dedicated to automatic, continuous application. An adhesive that gives a hard-elastic foam with low expansion. It is used in bonding sandwich panels made of materials such as: various types of sheet metal, plywood, mineral wool, polystyrene, PUI foam, drywall.
timber constructions, plywood of hard species, very demanding connections, exotic species	<b>APLICONPUR</b> 1kg, 5kg lub or larger	6500-7500	 15-25 min wet wood (or the addition of water)	 2-4h soft wood 4-6h hard species	Slow glue for wooden structures, gluing hard and exotic wood species. Specialist adhesive filled with microfibres to improve joint cohesion.
timber constructions, plywood of hard species, very demanding connections, exotic species	<b>APLICONPUR EXPRESS</b> 1kg, 5kg or larger	6500-7500	 5-10 min wet wood (or the addition of water)	 2-3h soft wood 3-4h hard species	An accelerated version of the adhesive for wooden constructions and hard and exotic wood species. The microfibers contained in it improve the cohesion of the joint, giving it high strength even with a joint thickness of 0.5 mm.



# SOLVENT-BASED ADHESIVES



The group of these adhesives includes contact and upholstery adhesives. They have in common is the content of low-volatile solvents. Thanks to their good adhesive properties and carefully selected solvents, they are an indispensable and difficult to replace group of adhesives.



USE FOR	NAME	VISCOSITY [mPas]	EVAPORATION TIME	TIME TO WELD	CHARACTERISTICS
Bonding Contact	<b>ITA CONTACT SPRAY</b> (0,8kg, 4kg, 15 kg, 170kg)	480	 5-15 min	 · at once - 75% strenght · after 72 h - 100% strenght	Polychloroprene adhesive designed for spraying. It has very good initial bond strength, good heat resistance and very good resistance to the aging process. The adhesive is particularly suitable for gluing panels, laminated boards made of materials such as wood, HPL laminates, PVC, ABS, polyurethane foam, polystyrene, melamine, leather, textiles, metals.

# SOLVENT-BASED ADHESIVES

USE FOR	NAME	VISCOSITY [mPas]	EVAPORATION TIME	TIME TO WELD	CHARACTERISTICS
Bonding Contact	<b>ITA CONTACT SPRAY TF</b> 15 kg	500	 5-15 min	 · at once - 75% strenght · after 72 h - 100% strenght	Polychloroprene glue in red color for spraying. It has very good initial bond strength, good high temperature resistance and very good resistance to the aging process. It does not contain toluene. The adhesive is suitable for gluing panels, laminated boards made of materials such as wood, HPL, PVC, ABS laminates, polyurethane foam, polystyrene, melamine, leather, textiles, metals
Bonding Contact	<b>PRENOCON EX 299</b> 2kg	6500	 10-20 min	 · at once - 80% strenght · after 24 h - 100% strenght	Polychloroprene adhesive for manual application with a roller or brush. It has a very good initial bond strength, good heat resistance and very good resistance to the aging process. The adhesive is particularly suitable in the production of furniture, panels, laminated boards, upholstered furniture, car upholstery. It can be used to glue materials such as wood, laminates such as HPL, PVC, ABS, polyurethane foam, polystyrene, melamine, leather, textiles, metals.
Upholstery	<b>ITAPREN SPRAY 720</b> 15kg, 170kg	720	 3-7 min	 · after 7 min - 75% strenght · after 12 h - 100% strenght	Adhesive based on resins and rubbers with a high dry residue. It can be applied by spray and by hand. It is available in a colorless version. Designed for joining upholstery materials together or gluing them to wooden elements of upholstered furniture. It can be used to make mattresses. It has a very high bonding strength, excellent performance and exceptional ease of application. After drying, the coating remains flexible and invisible.



# HOTMELT ADHESIVES



Hotmelt adhesives are among the fastest adhesives in carpentry and furniture making. The working principle is to change the adhesive into a liquid form and then lower the temperature to crystallize. These adhesives include unfilled, filled, reactive and specialized adhesives.



USE FOR	NAME	VISCOSITY [mPas]	SOFTENING TEMPERATURE	WORK TEMPERATURE	CHARACTERISTICS
Edge bonding	<b>THERMOSTICK 525</b> 20kg	160°C 50000 200°C 18000	93°C	145-165°C melter 145-165°C roller	EVA hotmelt will be used for edge bonding and profiling. It has a low solids content. The wide range of viscosities makes it suitable for use in low-temperature applications, bent or manual applications, as well as in slow feed applications.
Edge bonding / profile wrapping	<b>THERMOSTICK 696</b> 20kg	200°C 6500	75-82°C	150-160°C melter 180-200°C roller	EVA hotmelt with increased bonding properties. It is particularly designed for wrapping profiles with foils and impregnated papers. It can be used for edge bonding. The adhesive does not have a filler, and thanks to its color, it gives a practically imperceptible joint.

# HOTMELT ADHESIVES

USE FOR	NAME	VISCOSITY [mPas]	SOFTENING TEMPERATURE	WORK TEMPERATURE	CHARACTERISTICS
Edge bonding	<b>THERMOSTICK 838</b> 25kg	 200°C  75000	 110-123°C	 160-190°C melter  200-215°C roller	EVA-hotmelt, filled, designed for gluing PVC and ABS edges. It has a high melting point and excellent resistance to high temperatures. The adhesive is mainly designed for linear edge bonding machines with medium to feed speeds.
Edge bonding	<b>THERMOSTICK 904</b> biały 20kg	 200°C 64000  210°C 51000	 93°C	 190-200°C melter  190-220°C roller	EVA hotmelt, white, designed for edge bonding, for edges made of PVC, ABS, polystyrene, etc. to panels, chipboard, MDF and HDF. It is characterized by a high melting point and high thermal resistance. Excellent elasticity and adhesion are due to the best quality EVA resin. It is mainly designed for linear edge banding machines with medium to fast feed speeds, also for manual edge banding machines.
Edge bonding	<b>SUPRASTIC 9003</b> 25kg	 200°C 80000  220°C 50000	 110-123°C	 170-190°C melter  200-220°C roller	EVA hotmelt adhesive with typical solids content, designed for edge bonding, for edges made of PVC, ABS, polystyrene, etc. Characterized by high melting point and excellent resistance to high temperatures. The adhesive is mainly intended for linear edge banding machines with medium to fast feed speeds.
Edge bonding	<b>SUPRASTIC 956</b> 20 kg	 190°C 97000  200°C 77000	 106-108 °C	 175-185°C melter  190-210 °C roller	EVA hotmelt, unfilled and opalescent adhesive, with high thermal resistance and excellent wettability. Designed for work with different colored edging based on ABS, PVC, paper, etc. It has a low density, which helps to reduce the amount of glue applied by 25-30% compared to standard products.

# HOTMELT ADHESIVES



USE FOR	NAME	VISCOSITY [mPas]	SOFTENING TEMPERATURE	WORK TEMPERATURE	CHARACTERISTICS
Floor board	<b>SUPRASTIC HPUR 50824</b> 20kg	140°C 19000-29 000	 Excellent high temperature resistance	130-140°C melter 130-150°C roller/nozzle	Reactive polyurethane hotmelt. It is characterized by medium-low viscosity at elevated temperature, good surface wettability, easy to apply with a strong initial bond. After full curing, it has excellent water resistance and high temperature resistance.
Edge bonding	<b>SUPRASTIC 9010</b> 25kg	200°C 90 000 220°C 58000	 155- 165°C	180-220°C melter 200-220°C roller	Polyolefin-based hotmelt adhesive with a high softening point. It is designed for edge bonding in demanding applications. It is characterized by clean processing and very high thermal resistance.
Assembly Wide range of use	<b>SUPRASTIC 1947</b> 13-15kg	160°C 5000 190°C 2000	 120-122°C	140-180°C melter 140-200°C roller	Hotmelt adhesive based on high-quality thermoplastic resins, with a very long open time. Designed for a very wide range of applications: lamination, carton folding, wrapping profiles and as an assembly adhesive. Thanks to good wettability it can bond many materials together.





# POLYUREA- FORMALDEHYDE RESIN



Marked with the Incoll-Urea formaldehyde resins, in powder form, belong to a generation of adhesives that combine convenience and ease of use with a long warranty and effectiveness of bonding. They are here resins for high temperatures and cold pressing.



USE FOR	NAME	VISCOSITY [mPas]	RATIO BY WEIGHTO	POT LIFE MIXTURE/ PRESS TIME [VENEER 0,6MM]	CHARACTERISTICS
Cold application	<b>SUPRADUR 103 SPECIAL</b> 25kg	6500	2 parts adhesives ----- 1 part water	 15°C 4,5h 20°C 3h 30°C 1-2h  20°C 4,5h 30°C 3-4h 40°C 1h	A specially developed recipe that can be used during cold pressing. Ideal for gluing hardwood frames and frames. It is used where for technological reasons it is not possible to use high temperature.
veneer, plywood production - hot applications	<b>SUPRADUR 101 STANDARD</b> 25kg	6500	2 parts adhesives ----- 1 part water	 15°C 10h 20°C 8h 30°C 3-4h  70°C 7 min 100°C 90 sec 110°C 70 sec	Resin to hot applications with low formaldehyde content. It mixes easily with water and gives a very hard joint. It is designed for veneering all types of veneers and is a ready-to-use mixture. It is characterized by poor stains. After abrasion, it is easily dyed with e.g. water stain or oil.

# POLYUREA-FORMALDEHYDE RESIN



USE FOR	NAME	VISCOSITY [mPas]	RATIO BY WEIGHT	POT LIFE MIXTURE/ PRESS TIME [VENEER 0,6MM]	CHARACTERISTICS
veneering, plywood production - hot applications	<b>SUPRADUR 102 RAPID</b> 25kg	6000	2 parts adhesives ----- 1 part water	15°C 10-12h 20°C 8-10h 30°C 3-4h 80°C 3 min 100°C 80 sec 110°C 60 sec	A very fast recipe, which is used in fast and very fast process veneering - foils, papers, veneers. It is characterized by weak stains. After abrasion, it is easily dyed with e.g. water stain or oil.
veneering, plywood production - hot applications	<b>SUPRADUR 3003</b> 25kg	3000-5000	2 parts adhesives ----- 1 part water	15°C 10h 20°C 8h 34°C 5h 70°C 10 min 100°C 100 sec 110°C 70 sec	The formula is based on urea resin. Adhesive used in the furniture industry for hot processing - production of plywood, furniture, chipboard panels, etc. Resistant to water, it gives a strong and hard bond. The product can be used in a high-frequency wave system.





# POLYVINYL ACETATE ADHESIVES



PVAc-based adhesives the most popular in furniture and carpentry, in D2, D3 and D4 classes. D4- one and two component.



USE FOR	NAME	VISCOSITY [mPas]	OPEN TIME	PRESS TIME OR INITIAL GRIP	CHARACTERISTICS
Paper industry	<b>SUPRAVIL RCL 2000</b> 20kg, 1000kg	2000	 2,5 min on paper	 30 sec. setting time 8 sek. - initial grip (paper)	The adhesive based on an aqueous dispersion of polyvinyl acetate with very low viscosity and high solids content, so it can be used in very fast automatic applications. Recommended for bonding surfaces such as paper, cardboard with aluminium foil and other porous materials.
Paper industry	<b>SUPRAVIL RCL</b> 20kg, 1000kg	2500	 1,5 - 2 min on paper	 30 sec setting time 8 sek. - initial grip (paper)	Adhesive based on polyvinyl acetate dispersion. Shows a transparent and a very flexible joint. Recommended for gluing bookbinding materials, papermaking, wood, wood-like materials with paper, cardboard, fabrics, aluminum foils, polyester and other porous materials. It is characterized by high dry matter and medium viscosity. It is used in manual and automated applications.

# POLYVINYL ACETATE ADHESIVES



USE FOR	NAME	VISCOSITY [mPas]	OPEN TIME	PRESS TIME [INITIAL GRIP]	CHARACTERISTICS
Woodworking D3 class, assembly, general purpose	<b>SUPRAVIL D3 PLUS</b> 10kg, 20kg, 1000kg	12000	 3-10 min	 25 min hard wood species 15-25 min soft species 10-15 min veneering	Polyvinyl acetate dispersion base adhesive. It is product with high thermal resistance and a transparent joint after cross-linking and water resistance class D3 according to PN-EN 204, It has a very good initial grip, quickly reaches final strength. Designed for bonding multilayer boards, MDF, laminates, plywood or chipboards, in hot and cold applications, with a medium-fast drying time. The minimum temperature of film formation is 8°C and its pH is 4.
Woodworking class D3, assembly, general purpose	<b>SUPRAVIL D3</b> 20kg, 1000kg	13000	 3-6 min	 25 min hard wood species 15-25 min soft species 10-15 min veneering	It is one-component adhesive base on a modified dispersion of polyvinyl acetate. It is characterized by D3 waterproof resistance class according to EN 204 for common use and has a good initial grip. After reaching full strength, the joint has very good adhesion to wooden surfaces subjected to static and dynamic loads. The minimum film creation temperature is 6°C, and the pH of the adhesive is around 4.
Woodworking class D3/D4 assembly, general purpose	<b>SUPRAVIL EXPRESS 6000</b> 20kg, 1000kg	12000- 15000	 7-9 min	 20-30 min hard wood species 20 -25 min soft species 5-10 min veneering	Adhesive based on water-based dispersion of polyvinyl acetate, in D3 or D4 waterproof resistance class according to EN 204/205. D4 class after the addition of a new generation of hardener. It is a high-performance adhesive with excellent strength parameters and a very hard joint, which is why it is particularly used in productions and applications that require high quality: gluing hard and exotic wood species, gluing chairs, benches and hardwood frames. Also used for joinery, kitchen furniture and bathroom fittings and veneering.

# POLYVINYL ACETATE ADHESIVES

USE FOR	NAME	VISCOSITY [mPas]	OPEN TIME	PRESS TIME	CHARACTERISTICS
Woodworking class D4, assembly, general purpose	<b>SUPRAVIL D4</b> 10kg, 20kg, 1000kg	8000-10000	 7-9 min	 20-40 min	A one-component adhesive based on a modified dispersion of polyvinyl acetate with D4 waterproof resistance class according to PN-EN 204. After reaching full strength, the joint has very good strength parameters. Ideal for the production of exterior joinery and bathroom furniture and other outdoor elements. The adhesive is used in the production of hard, soft and exotic types of wood
Woodworking class D4, assembly, general purpose, automatic multi finger-joints	<b>SUPRAVIL D4 PLUS</b> 10kg, 20kg, 1000kg	3000-10000	 3-9 min	 20-40 min	A one-component adhesive based on a modified dispersion of polyvinyl acetate with D4 waterproof resistance class according to PN-EN 204. After reaching full strength, the joint has very good strength parameters. Ideal for the production of exterior joinery elements, bathroom furniture and other elements used outdoors. The adhesive is used in the production of made of hard, soft and exotic woods. Ideal for multi finger-joints systems





# PRODUCTS FOR PARQUET



Glupar, Glupar New, Pluspar are professional products used in parquet flooring. The innovative Pluspar primer ensures perfect preparation of the substrate for gluing. Adhesives, on the other hand, are characterized by a long open time, high bond strength and easy application. Adhesives and primer bring together a system form that gives a comfort of work and effectiveness of bonding for many years.



USE FOR	NAME	VISCOSITY [mPas]	POT LIFE	DRYING TIME	CHARACTERISTICS
Laying parquet floors	<b>GLUEPAR (9:1)</b> 9kg +1kg	Component A: thixotropic paste Component B: 500	 45-60 min	 70-110 min	Two-component adhesive for parquet floors. Thanks to its flexible joint, it is an excellent adhesive for long elements. It is characterized by a perfect tooth and easy application. It has a reputation as a very high quality adhesive. Its advantage is also the lack of foaming in difficult application conditions, e.g. high temperature and ambient humidity and increased local humidity of the substrate.
Laying parquet floors	<b>GLUEPAR NEW (9:1)</b> 9kg + 1kg	Component A: thixotropic paste Component B: 500	 45-60 min	 70-110 min	Two-component parquet adhesive with flexible joint and easy application. Suitable for gluing long and short elements.
Preparation of surface	<b>PLUSPAR PU</b> 5kg	1800-2500	60-120min concentrate 12-24 h solution 1:1 with PU solvent	-	Primer - a polyurethane concentrate, depending on the requirements and quality of the concrete surface, can be used as an impregnate agent, reinforcing or shut-off agent. Used as a solution with a suitable diluent in a selectable dilution, as appropriate.



# SPECIAL PRODUCTS



ICA POLSKA's offer also special agents and specialist adhesives, that can used beyond the scope of furniture and carpentry. Below only a few are listed. Thanks to our knowledge and experience, we are able to provide other, often innovative solutions that relate to the adhesive medium or the application itself. For this purpose, we invite you to contact us and cooperate with us.



USE FOR	NAME	FORM	CHARACTERISTICS
Sealing MS-based polymer	<b>SUPRAVIL MS CRYSTAL</b>	tixotropic cristal paste	Assembly bonding of various surfaces. The transparency of the product is useful as an adhesive and sealing medium in finishing works.
lamination of difficult surfaces	<b>SUPRAVIL EVA 15</b>	Modified PVAC Aqueous Dispersion	Lamination of surfaces that are difficult to glue with PVC foils and impregnated papers.
Edge bonding	<b>PATRON 5400</b>	patron	Professional hot melt adhesive in patrons form, designed to work in specialized edge bonding machines. It comes in natural, white, brown and black colours.
Quick cyanoacrylate adhesives	<b>KLEJ CA 613</b>	high viscosity	Cyanoacrylate adhesive with increased viscosity used in assembly bonding of low- and high-absorbing materials.

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## INDUSTRIAL ADHESIVES

PRODUCER:

**ICA POLSKA SP. Z O.O.**

Gliniana 10, 97-300 Piotrków Trybunalski

[www.icapolska.pl](http://www.icapolska.pl)

