

# BreezeBond™ Product Bulletin

## Features and Performance

BreezeBond™ is a low viscosity, soy- based adhesive made up of water, modified soy flour, and low environmental-impact inorganic additives for hot-press applications. It features the following characteristics:

- Single component adhesive
- Suitable for indoor applications
- High Solids
- Low Viscosity
- Strong wet bond strength
- Has no detectable formaldehyde
- Competitive with current wood adhesives in the market

### Physical Properties

**Adhesive capabilities:** Average wet strength 896 psi (6.18 MPa)

**Color:** Light yellow to beige when wet, almost white when dry.

**Viscosity:** 2.02-3.36 lb<sub>m</sub>/ft-second (3000-5000 cps)

**Density:** 8.3 lb/gal (1.00g/cm<sup>3</sup>), **pH:** 8.0-8.5

**Solids Content:** Can be provided up to 44%

**VOC Content:** Less than 0.008 ppm

**VHAP Content:** Not Applicable

**Hot Press Time:** 120 sec @ 27 psi (0.186 MPa)

**Spreader Rate:** 0.70-0.77 oz/ft<sup>2</sup> (21.5–23.7 mg/cm<sup>2</sup>)

**Applications to Avoid:** Cold Press

### General Usage Instructions

To be used at near room temperature (68-77 °F, 20-25 °C). Prolonged exposure to elevated temperatures (140 °F, 50 °C) can lead to partial degradation.

For maximum wet adhesion strength Calcium Nitrite can be added to adhesive prior to roller application. Contact us for more information.

- 1) Apply the adhesive to one surface with the above spreader rate.
- 2) Bring the components together quickly and correctly aligned.
- 3) Apply sufficient pressure to ensure the adhesive spreads into a thin film.
- 4) Press at 248 °F (120 °C) to 284 °F (140 °C) for 2 minutes.

### Storage/Shelf Life

- Expected shelf life of 3 months or longer when stored in a sealed container at room temperature. Keep away from direct sunlight. Avoid elevated temperatures
- Keep container tightly sealed to prevent moisture from leaving the mixture.
- After long periods of storage, stirring is recommended prior to use.

### Clean-up/Disposal

- Use hot water while the adhesive residue is still wet in the mixer.
- Removal of dried adhesive requires a water soak followed by a high-pressure water jet.
- This adhesive is compatible with most local sewage treatment methods, however, check with local authorities for proper waste disposal.



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