

# BreezeBond™ Product Bulletin

## for Overlays/Veneers

### Features and Performance

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

- Single component adhesive
- Suitable for indoor applications
- High Solids
- Adjustable Viscosity
- Strong wet bond strength
- No detectable formaldehyde
- Competitive with current overlay adhesives in the market
- Compostable

### Physical Properties

**Adhesive capabilities:** Average wet strength 896 psi (6.18 MPa)  
**Color:** Light yellow to beige when wet, almost white when dry.  
**Viscosity:** 30.2-33.6 lb<sub>m</sub>/ft-second (40K-50K mPa-s, centipoise)  
**Density:** 8.3 lb/gal (1.00 g/cm<sup>3</sup>), **pH:** 8.0-8.5  
**Solids Content:** Can be provided at up to 50%  
**VOC Content:** Less than 0.008 ppm  
**VHAP Content:** Not Applicable  
**Hot Press Time:** 300 sec or less @ 50 psi (0.345 MPa)  
**Spreader Rate:** 0.5-0.7 oz/ft<sup>2</sup> (16.1–21.5 mg/cm<sup>2</sup>)

### General Usage Instructions

To be stored 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 and higher viscosity, an additive can be mixed into the adhesive prior to application. Contact the BreezeBond™ team at Specialty Organics, Inc. for more information.

### Application

- 1) Mix the adhesive to give it a homogenous consistency before application.
- 2) Apply the adhesive to the plies with your method of preference (spray, roller, rubber blade / squeegee).
- 3) Bring the aligned plies together, cold pressing may help to ensure consistent surface wetting.
- 4) Press at 248 °F (120 °C) to 284 °F (140 °C) for 5 minutes.

### Storage/Shelf Life

- Expected shelf life of up to three months 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 container/mixer/holding tank.
- 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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