

# BreezeBond™ Technical Data Sheet

## Decorative Paper

### Features and performance

BreezeBond™ is a water-based soybean adhesive made up mostly of modified soy flour and low environmental-impact inorganic additives for decorative hot-press/roller/laminator applications with the following characteristics:

- Single component adhesive
- Suitable for indoor applications
- High solids content
- Low 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:** 0.202 - 0.336 lb<sub>m</sub>/ft-sec (300 - 500 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%  
**Total VOC content:** Not yet determined  
**Formaldehyde content:** Less than 8 ppb (parts per billion)  
**Hot-press time:** 20 - 50 sec @ 30 psi (0.2 MPa) minimum  
**Spreader rate:** 0.7 - 0.8 oz/ft<sup>2</sup> (214 - 244 g/m<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 (apply in a ventilated area)

- 1) Mix the adhesive to give it a homogenous consistency before application.
- 2) Apply the adhesive to the substrate (spray, roller, rubber blade / squeegee).
- 3) Bring the paper and substrate together with your preferred heated roller/laminator technique.
- 4) Slowly apply paper at 257 °F (125 °C) minimum. Rougher surfaces require longer time/slower roll rate.

### 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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