

BreezeBond™ Technical Data Sheet for Overlays and Veneers

Features and performance

BreezeBond™ is a water-based soybean adhesive made up mostly of 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 content
- 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: 63.8 - 67.2 lb_m/ft-sec (95K - 100K centipoise)

Density: 8.3 lb/gal (1.00 g/cm³), **pH:** 8.0 - 8.5

Solids content: Can be provided at up to 50%

VOC content: Less than 8 ppb (parts per billion)

VHAP content: Not Applicable

Hot-press time: 300 sec or less @ 30 - 50 psi (0.2 - 0.345 MPa)

Spreader rate: 0.5 - 0.7 oz/ft² (153 - 214 g/m²)

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 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 at 30 - 50 psi (0.2 - 0.345 MPa).

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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