

Contents

Preface *xix*

Author Biography *xxi*

1	Introduction to Polymers, Wood Adhesives, and Wood Finishes	1
1.1	Good Wood Adhesives Must Be Optimum Polymers with Optimum Secondary Forces	1
1.2	Polymeric Materials	2
1.3	Synthetic Polymer Preparation Methods	2
1.4	Typical Synthetic Polymer Materials	3
1.5	Typical Natural Polymers	8
1.6	Summary	10
	References	11
2	Principles of Polymer Chemistry for Wood Adhesives and Finishes	12
2.1	Degree of Polymerization and Molecular Weight	12
2.1.1	Determination of Molecular Weight or Degree of Polymerization	12
2.2	Properties of Polymer Solutions or Suspensions	13
2.2.1	Viscosity of Polymer Solutions	13
2.2.2	Dependence of Viscosity on the Shear Rate (Stirring Rate)	14
2.2.3	Temperature Dependence of Viscosity of Polymer Solutions	15
2.2.4	Dependence of Viscosity on the Concentration and Molecular Weight of Dissolved Polymers	15
2.2.5	Methods of Viscosity Measurement of Liquid Materials	17
2.3	Polymer Solids Level and Specific Gravity of Polymer Solutions	18
2.4	pH of Polymer Solutions and Buffers	18
2.4.1	pH	18
2.4.2	Acidic Buffers and Buffer Capacity	19
2.5	Solid Properties of Polymer Materials	20
2.5.1	Adhesive Property of Polymer Solids	20
2.5.2	Cohesive Property of Adhesive Polymer Solids	20
2.5.3	Cohesive Strength Measurement and Viscous and Elastic Responses	20
2.5.4	Measurement of the Elasticity of Solid Polymer Materials	21
	References	22

3	Thermosetting and Thermoplastic Wood Adhesives and Practices	23
3.1	Selection Criteria of Wood Adhesives	23
3.2	High Temperature-Curing Thermosetting Adhesives and Curing Conditions	24
3.3	Room Temperature-curing Thermosetting Wood Adhesives and Processes	25
3.4	Room Temperature-curing Thermoplastic Wood Adhesives	25
3.5	Adhesive Application Methods and Loading Rates and Costs	26
3.6	Adhesive Curing by Hot Presses and Other Heating Methods	26
3.7	Evaluation of Adhesive Bonds	28
3.8	Summary	28
	References	28
4	Principles of the Curing of Thermosetting and Thermoplastic Wood Adhesives	29
4.1	Principles of Curing of Thermosetting Adhesive Resins at Elevated Temperatures	29
4.1.1	Viscosity Changes of Adhesive Layer Before Hot-Pressing	30
4.1.2	Spreading and Penetration of Adhesive Layers in Hot-Pressing	30
4.1.3	Viscosity Decreases by Moisture Content Changes	31
4.1.4	Viscosity Increases and Curing of Adhesive Layer by Polymerization Reaction	31
4.1.5	Flow and Wetting of Adhesive Layers and Molecular Adsorption	31
4.1.6	Gelation of Adhesive Layer	32
4.1.7	Vitrification of Adhesive Layer	32
4.1.8	Post-Curing of Adhesive Layer	33
4.2	Relationship of Temperature and Moisture Content in Hot-Pressing of Wood Composite Mats	33
4.2.1	Platen Pressure, Mat Thickness, and Density Profiles	33
4.2.2	Temperature Changes and Moisture Movements in Board Mat	34
4.2.3	Extents of Resin Cure in Hot-Pressing	35
4.3	Curing of Thermosetting Adhesives at Room Temperature	35
4.4	Curing of Thermoplastic Emulsion Adhesives	36
4.5	Volume Contractions of Adhesive Layers upon Curing	37
4.6	Thermal and Moisture Expansion/Contraction of Adhesive Layers	38
4.7	Summary	38
	References	39
5	UF and MUF Wood Adhesive Resins (Manufacturing and Resin Chemistry)	40
5.1	Raw Materials of UF Resins	40
5.2	Urea-Formaldehyde (UF) Resins	42
5.3	Chemistry Occurring in UF Resin Synthesis	46
5.3.1	Second Step of Resin Synthesis	47
5.4	Polymer Chain Branching in UF Resins	50
5.5	Other Reactions Occurring in UF Resin Synthesis	52
5.6	F/U ₁ Mole Ratio Effects in the Polymerization Step	53
5.7	Final F/U Mole Ratios and Formaldehyde Emission Problem	54

5.8	Physical and Chemical Tests and Properties of Industrial UF Resins	55
5.9	Resin Changes Occurring After Manufacture of UF Resins	58
5.10	Bond Performances and Durability Tests of UF Resins in Industry	60
5.11	UF Resins vs. Various Operating Parameters in PB, MDF, and Hardwood Plywood Industry	61
5.12	Other UF Resin Synthesis Procedures	62
5.13	Polymeric Chemical Structures of UF Resins	63
5.14	Melamine-Urea-Formaldehyde (MUF) Resins	63
5.15	Urea-Melamine-Formaldehyde (UMF) Resins	66
5.16	Summary	69
	References	69
6	Urea-Formaldehyde and MUF/UMF Wood Adhesive Resins (Curing)	72
6.1	Typical Latent/External Catalysts Based on Ammonium Salts for UF Resins	72
6.2	Organic Tertiary Amine Salts of Strong Acids and Other Catalysts	73
6.3	Catalyzation of UF Resins by Wood Acids	74
6.4	Buffering of Acidic Catalysts	77
6.5	Thermosetting Curing Reactions, Cured Resin Structures, and Formaldehyde Emission Problem	78
6.6	Control of the Curing Speeds of UF Resins	81
6.7	Side-Reactions Occurring in the Curing of UF Resins	81
6.8	Phenomenological Changes of UF Resins in Curing	82
6.9	Chemical Curing Mechanisms, F/U Mole Ratio, and Cured Resin Structure	84
6.10	Composition of Cured UF Resins	85
6.11	Uses of UF Resins	86
6.12	Properties of UF Resin-Bonded Wood Composite Boards	86
6.13	Formaldehyde Emission Mechanisms, Mole Ratios, and Board Strength Properties	87
6.14	Various Methods Proposed/Practiced for Reducing the Formaldehyde Emissions of Boards	88
6.15	Curing of Melamine-Urea-Formaldehyde (MUF) Resins	89
6.16	Curing of Urea-Melamine-Formaldehyde (UMF) Resins	90
6.17	Cost Increases Estimated for Boards with Very Low Formaldehyde Emission Values	91
6.18	Summary	92
	References	92
7	Particleboard, MDF, and Hardwood Plywood Bonding with UF Resin Binders	94
7.1	Particleboard	94
7.1.1	Wood Furnishes in Particleboard Manufacture	94
7.1.2	Blending of Resin, Catalyst, and Wax Emulsion in Particleboard Manufacture	95
7.1.3	Mat Formation and Transport	97
7.1.4	Hot-pressing	98
7.1.5	Equilibration and Finishing	100

7.1.6	Bison–Mende process	100
7.1.7	Properties of Commercial Particleboards	100
7.1.8	US Particleboard (PB) Industry	100
7.1.9	Summary	101
7.2	Medium Density Fiberboard (MDF) Bonded with UF Resins	102
7.2.1	Fiber Manufacture and Blowline Resin Blending	102
7.2.2	Paddle Blending System of Resins	104
7.2.3	Comparison of MDF Resin Blenders	105
7.2.4	Mat-Forming and Hot-Pressing Parameters of PB and MDF in Industry	107
7.2.5	Physical Properties of Commercial MDF	108
7.2.6	Medium Density Fiberboard Industry	109
7.2.7	Summary	109
7.3	Hardwood Plywood Bonding with UF Resin Adhesives	109
7.4	Paraffin Wax and Uses in Wood Composites	112
7.4.1	Use of Paraffin Wax	112
7.4.2	Properties of Paraffin Wax	112
7.4.3	Analyses of Wax	113
7.4.4	Wax Application Methods	114
7.4.5	Wax Use Levels	114
7.4.6	Summary	114
7.5	Effects of UF Resins' Curing Catalysts on Tool Wear in Machining of Boards – An Example of Laboratory PB Manufacturing and Testing	115
7.6	Summary	120
	References	120
8	PF Novolac Wood Adhesive Resins (Manufacturing and Chemistry)	122
8.1	Raw Materials of PF Resins	122
8.2	Reaction Chemistry of Phenol	123
8.3	Synthesis and Chemistry of Novolac Phenol-Formaldehyde (PF) Resins	124
8.4	Compounding and Curing of Novolac PF Resins	129
8.5	Curing Speed and Testing Methods of Molding Compounds of PF Novolac Resins	130
8.6	Wood Adhesive Uses of Novolac PF Resins	132
8.7	Summary	133
	References	134
9	PF Resole Wood Adhesive Resins (Manufacturing and Chemistry)	136
9.1	Alkaline PF Resole Wood Adhesive Resins	136
9.2	Synthesis Chemistry and Manufacturing Practices of Alkaline PF Resole Resins	136
9.3	Typical Synthesis Procedures of Alkaline PF Resole Resins for Various Uses	140
9.4	Properties and Polymer Structures of Alkaline PF Resole Resins and Measurements	143

9.5	Resin Characteristics and Uses of Various PF Resole Resins	147
9.6	Molecular Weights (Sizes) of Alkaline PF Resole Resins and Wood Cell Wall Penetration	148
9.7	Powder PF Resole Resin Manufacturing by Spray-drying	149
9.8	Curing of Alkaline PF Resole Resins	150
9.8.1	Pre-dry and Pre-cure, Resin Spreading, and Flow	150
9.8.2	Final Curing of Alkaline PF Resole Resins in Wood Bonding	151
9.8.3	Gel Times and Stroke Cure Times of Liquid PF Resins	153
9.8.4	Dynamic Mechanical Analysis (DMA) Method of Curing Tests for Thermosetting Resins	153
9.8.5	Differential Scanning Calorimetric (DSC) Analysis of PF Resole Resins	157
9.9	Good Wood Adhesion and Exterior Durability of PF Resin Adhesives	158
9.10	Formaldehyde Emission Problem of PF Resin-bonded Products	159
9.11	Various Binder Uses of PF Resins in the US Wood Products Industry	159
9.12	Acid-curing PF and PMF Resole Resin and Dispersion Wood Adhesives	162
9.13	Summary	163
	References	163
10	PRF Novolac Wood Adhesive Resins and Lumber Lamination	166
10.1	Manufacturing and Chemistry of PRF Resins	167
10.1.1	Chemical Structures of PRF Resins	169
10.1.2	Relationship Between Target Viscosity, Resin-Solids, and Storage Stability of PRF Resins	171
10.1.3	P/R Ratio Measurements from ^{13}C NMR Spectra	172
10.2	PRF and RF Resin Adhesives Currently Available in Industry	172
10.2.1	Some Nonideal Aspects of PRF Resins	173
10.3	Hardeners for PRF Resin Adhesives	174
10.4	Mixing of a PRF Resin and Hardener, Pot-Lives, Working Life, and Assembly Time	175
10.5	Applying and Curing of PRF Adhesives in Wood Lamination	176
10.6	Curing Chemistry of PRF Resin Adhesives and Industry Practices	179
10.7	Wood Lamination Industry	179
10.8	Recent Developments in PRF Resin Adhesives	182
10.9	Laminating Wood Adhesives Based on Other Resorcinolic Materials	184
10.10	Advanced Reading Materials on Resorcinol-Formaldehyde (RF) Resins	185
10.10.1	Synthesis and Fractionation of an RF Resin and GPC Analysis	185
10.10.2	Assignments of ^{13}C NMR Chemical Shift Values of RF Resin Fractions	187
10.10.3	Polymer Structures of RF Resins Derived from ^{13}C NMR Spectra	188
10.10.4	Relationship Between Intrinsic Viscosity and Molecular Weight Values from Equation n_3	190
10.11	Summary	191
	References	191
11	Softwood Plywood Adhesives and Manufacturing Technology	194
11.1	Softwood Plywood Manufacturing Technology	194
11.2	PF Resole Resins for Bonding of Softwood Plywood	195

11.3	Veneer, Veneer Drying, and Adhesion Problems	196
11.4	Bond Performance Characteristics of Softwood Plywood Adhesives	197
11.5	Softwood Plywood Adhesive Mixing Procedure	197
11.6	Softwood Plywood Adhesive Formulation and Characteristics	198
11.6.1	Characteristics of PF Resin Adhesive Mixes	198
11.6.2	Gap-Filling Capability of Softwood Plywood Adhesives	199
11.6.3	Viscosity Targets of Softwood Plywood Adhesive Mixes	200
11.6.4	Fillers in Softwood Plywood Adhesives	200
11.6.5	Extenders in Softwood Plywood Adhesives	201
11.6.6	PF Resin Adhesives, Adhesive Spread Rates, and Application Methods	202
11.7	Open and Closed Assembly Times	204
11.8	Pre-pressing of Softwood Veneer Assembly	204
11.9	Hot-Pressing Parameters of Softwood Plywood	204
11.10	Laminated Veneer Lumber (LVL)	207
11.11	Parallel (Veneer) Strand Lumber (PSL)	207
11.12	New Developments in the Softwood Plywood Adhesive Technology	208
11.13	Phenolic Components Present in PF Resin-Bonded Softwood Plywood	209
11.14	Softwood Plywood Manufacturing Industry	209
11.15	Plywood Adhesive Fillers Made from Hydrolysis Residues of Municipal Newsprint Wastes	210
11.15.1	TVA Fillers and a Control Filler	210
11.15.2	Plywood Adhesive Mix	211
11.15.3	Plywood Manufacture	211
11.15.4	Plywood Test Results	212
11.16	Conclusion	214
11.17	Summary	214
	References	214
12	Isocyanate Wood Adhesive Resins	217
12.1	Chemical Compositions of Isocyanate Wood Adhesive Resins	217
12.2	Reactivity, Polymerization, and Curing Reactions of Isocyanate Resins	218
12.3	Mat Moisture Levels in Using pMDI Resins for OSB Bonding	223
12.4	Bond Properties and Uses of pMDI Resins as OSB Binders	224
12.5	pMDI Resins Used in Bonding of Other Wood Composite Products	226
12.6	Summary	227
	References	227
13	OSB Manufacturing with PF and Isocyanate Wood Adhesive Resins	229
13.1	Oriented Strand Board (OSB) Manufacturing Processes	229
13.1.1	Wood Species Used in OSB Manufacture	229
13.1.2	Stranding (Flaking)	230
13.1.3	Drying and Screening of Strands	231
13.1.4	Binder Resin Types	231
13.1.5	Blending of Binder Resin and Slack Wax	232
13.1.6	Mat Forming with Strand Orienters	234

13.1.7	Hot-Pressing of Mat	235
13.1.8	Oriented Strand Lumber (OSL)	238
13.1.9	Adhesive Improvements Needed in the OSB Industry	239
13.1.10	History of Wafer Board and Flakeboard	239
13.1.11	Durability and Span Ratings of Oriented Strandboard in Use	239
13.2	OSB Bonded with PF Resins with Various Levels of Urea Added at the End of Resin Synthesis	240
13.2.1	Syntheses of PF Resole Resins with Urea Added at the End of Synthesis	241
13.2.2	Testing of Synthesized Resins	242
13.2.3	Resin Curing Rates Determined by DMA	242
13.2.4	Laboratory OSB Manufacturing and Testing	243
13.2.5	Test Results of Manufactured OSB Panels	244
13.2.6	Conclusion	246
13.3	Summary	246
	References	247
14	Polyvinyl Acetate (PVAc) Emulsion Wood Adhesives	249
14.1	Polyvinyl Acetate (PVAc) Emulsion Wood Adhesive Resins	249
14.1.1	Manufacturing of PVAc Emulsion Resins	249
14.1.2	Properties of PVAc Emulsions and Polymers	250
14.1.3	Commercial PVAc Emulsions	250
14.1.4	Additives Used in Formulating PVAc Emulsion Wood Adhesives	251
14.1.5	Properties of Formulated PVAc Emulsion Wood Adhesives	252
14.1.6	Various Commercial Formulated PVAc Emulsion Wood Adhesives	252
14.1.7	Application Methods of PVAc Emulsion Wood Adhesives	253
14.1.8	Curing Mechanism of PVAc Emulsion Wood Adhesives	253
14.2	Summary	253
	References	254
15	Troubleshooting in Wood Bonding with PVAc Resin Adhesives	255
15.1	Effects of Moisture Content of Wood	255
15.2	Troubleshooting Methods in Various Gluing Operations	259
15.2.1	Troubleshooting in Cold-Press Lamination	260
15.2.2	Troubleshooting in Hot-Press Laminating Process	260
15.2.3	Troubleshooting in Radiofrequency Edge-Gluing	261
15.2.4	Troubleshooting in Edge and Face Gluing by Clamping	261
15.2.5	Troubleshooting in Assembly Gluing by Clamping	262
	Reference	262
16	Hot-melt and Other Specialty Wood Adhesives	263
16.1	Introduction to Hot-melt Adhesives	263
16.2	Requirements For Hot-melt Adhesives	263
16.3	Materials Used for Hot-melt Wood Adhesive Formulations	265
16.4	Advantages and Disadvantages of Hot-melt Adhesives	266
16.4.1	Advantages	266

16.4.2	Disadvantages	266
16.4.3	Uses of Hot-melts	267
16.5	Thermosetting Hot-melt Adhesives – Recent Development	267
16.5.1	A Typical Thermosetting Hot-melt Formulation	267
16.5.2	A Comparison of a Thermosetting Hot-melt Against Other Types	267
16.6	Key Variables in Hot-melt Edge-banding Operation	268
16.7	Other Specialty Wood Adhesives	269
16.7.1	Mastic Adhesives	269
16.7.2	Contact Adhesives	270
16.7.3	Epoxy Resin Adhesives	271
	References	273
17	Casein, Soybean Flour, Animal Blood, and Lignin Wood Adhesives	275
17.1	Casein Wood Adhesives	275
17.2	Animal Protein-Based Wood Adhesive	276
17.3	Soybean Meal and Soybean Protein Wood Adhesives	276
17.4	Animal Blood-based Wood Adhesives	278
17.5	Various Lignins and Uses in Wood Adhesives	278
	References	281
18	Theory and Practices of Adhesive Bonding for Wood	283
18.1	Formation of Interphase in Wood Adhesive Bonds and Failure Modes	283
18.1.1	Interphase Present Between Wood and Adhesive Layer in Adhesive Bond	283
18.1.2	Failure Modes in Mechanical Testing of Wood Bonds	284
18.1.3	Causes of Adhesive-layer or Interphase Failures in Wood Adhesive Bonds	284
18.1.4	Possible Further Divisions of Interphase in Wood Adhesive Bonds	285
18.1.5	Adhesive Failure vs. Wood Failure in Testing of Adhesive Bonds	285
18.1.6	Monitoring is a Must: Adhesive Quality, Adhesion Operation, and Bonded Products	286
18.2	Wettability of Solid Surface, Contact Angle, and Surface/Interface Tensions	287
18.3	Work of Adhesion	291
	References	291
19	Physical and Chemical Mechanisms of Adhesive Bonding for Wood	292
19.1	Adsorption (Secondary Bond Forces) Theory of Adhesion	292
19.2	Mechanical Interlocking Theory of Adhesion	296
19.3	Diffusion Theory of Adhesion	297
19.4	Primary Chemical Bond (Covalent Bond) Theory	298
19.5	Summary of Adhesion Mechanisms	299
19.6	Glueline Layer Thickness and Bond Strengths	299
19.7	Summary	301
	References	301

20	Evaluation of Wood Adhesive Bonds, Quality Control, and Bond Durability	302
20.1	Mechanical Testing Modes and Methods for Measuring the Adhesive Bond Strength	302
20.1.1	Shear Strength Test	302
20.1.2	Tensile Strength Tests	303
20.1.3	Cleavage and Peel Strength Tests	306
20.1.4	Bending Strength Tests	307
20.2	Quality Control, Certification Tests, and Adhesive Bond Durability	309
20.2.1	Objectives and Scope of Quality Control Processes	309
20.2.2	Durability Evaluation of Wood Composite Boards and Certification	309
20.2.3	Certification of Exterior-Use Wood Composite Products	310
20.2.4	Certification of Exterior-Use Wood-Based Structural Panels (PS2-92)	311
20.2.5	Cyclic Delamination Test Procedure (AITC Test 110)	312
20.2.6	Other Common Laboratory Aging Test Methods Used in the Industry	312
20.2.7	Testing and Certification Organizations Involved	313
20.3	Comparison of Various Wood Adhesive Bonds by Accelerated Aging or Exterior Exposure Tests	313
20.4	Nondestructive Testing of Wood and Wood Adhesive Bonds	315
20.5	<i>In-situ</i> Adhesion Testing	315
	References	316
21	Introduction to Coatings Technology for Wood	317
21.1	Three Components of Coatings	317
21.2	Pigment Volume Concentration (PVC)	317
21.3	Various Kinds of Vehicle Polymers	319
21.3.1	Fatty Oils and Modified Fatty Oils	319
21.3.2	Alkyd Resins	320
21.3.3	Polyester – Unsaturated and Saturated Polyesters	321
21.3.4	Cellulosics	322
21.3.5	Acrylic Resins	323
21.3.6	Vinyl Resins	324
21.3.7	Epoxy Resins	325
21.3.8	Isocyanate Resins (urethane resins)	326
21.3.9	Silicone Resins	327
21.3.10	PF, MF, UF Resin Derivatives	327
	References	328
22	Introduction to Coatings Technology for Wood. II	329
22.1	Pigments and Fillers	329
22.2	Manufacturing and Kinds of Pigments and Fillers	329
22.3	Color Control Methods	329
22.4	Color Scales – Hunter <i>L, a, b</i> , and CIE 1976 <i>L*a*b*</i> (CIELAB) Color Scales	331
22.5	Carriers of Coatings	332
22.6	Additives to Coatings	332
22.7	Manufacturing Procedures of Coatings	332

22.8	Film Formation Mechanisms	333
22.9	Water-Borne Coatings and Coatings for Less VOC Emissions	334
22.10	Exterior Coatings for Wood	336
22.10.1	Stains	336
22.10.2	Varnishes	336
22.10.3	Paints	337
22.11	Summary	337
	References	338
23	Industrial Coating Application Processes	339
23.1	Application Methods of Coatings	339
23.2	Sanding Processes	342
23.3	Sanding Abrasives, Construction, and Flexing	344
23.4	Typical Furniture Finishing Procedures and Materials	344
23.5	Flat Line Finishing Procedures of Wood Composite Boards for Furniture Production	346
23.6	Kitchen Cabinet Finishing Procedures	347
23.7	Hardwood Plywood Panel Prefinishing	348
23.8	Hardboard Panel Finishing Procedures	349
23.9	Summary	350
	References	350
24	Advanced Reading Materials on UF Wood Adhesive Resins	351
24.1	Introduction to the ^{13}C NMR Spectroscopic Analysis Method	351
24.2	Introduction to ^{13}C NMR Analysis Methods of UF and UMF Wood Adhesive Resins	356
24.3	^{13}C NMR Analysis Results of Reaction Intermediates Taken in UF Resin Syntheses	360
24.4	^{13}C NMR Analysis Results of Reaction Intermediates Taken in UF Resin Syntheses with a Higher Power Instrument	366
24.4.1	Effects of the Addition of Second Urea and Mild Heat Treatments	369
24.4.2	Polymerization in the Acidic Polymerization Step Observed with Second Urea Addition	370
24.4.3	Polymerization In the Acidic Reaction Step Observed Without the Second Urea Addition	372
24.4.4	Summary	373
24.5	Chemical Changes Occurring in UF Resins on heat/stirring and Room-temperature Storage Treatments by ^{13}C NMR and Formaldehyde Emission Tests of Particleboard	374
24.5.1	Effects of Mild and Intermediate Level Heat/Stirring Treatments (Samples A ₂ –A ₆)	374
24.5.2	Effects of Room-temperature Storage Treatments of UF Resins	378
24.5.3	Formaldehyde Emission Test Results of Particleboard (PB)	381
24.5.4	Summary	382
24.6	Effects of Mild Heating/Stirring Treatments on UF Resins Synthesized with Different F/U ₁ Mole Ratios by ^{13}C NMR	382

24.6.1	Syntheses of UF Resins with Varying F/U ₁ Mole Ratios	382
24.6.2	Heat/Stirring Treatments of Synthesized UF Resins	383
24.6.3	Viscosity and Turbidity Changes in Heat Treatments	383
24.6.4	F/U ₁ Mole Ratio Effects on UF Resin Structures in Heat Treatments Observed by ¹³ C NMR	384
24.6.5	Summary	388
24.7	Effects of Room-temperature Storage Treatments on UF Resins Synthesized with Various F/U ₁ Mole Ratios by ¹³ C NMR and Formaldehyde Emission Tests of Particleboard	388
24.7.1	F/U ₁ Mole Ratio Effects on Viscosity/Turbidity Changes in Room-temperature Storage Treatments	389
24.7.2	Functional Group Changes of UF Resins in 7–50-day Room Temperature Storage	392
24.7.3	Test Results of Particleboards Bonded with Various UF Resins	393
24.7.3.1	Internal Bond and Bending Strengths of Particleboards (PBs)	393
24.7.3.2	F/U ₁ Mole Ratio Effects on Formaldehyde Emission Values of Particleboards	394
24.7.4	Applications to the UF Resin and PB Manufacturing Industry	396
24.7.5	Summary	397
24.8	Effects of Mild Heat/Stirring and Room-temperature Storage Treatments of UF Resins Synthesized with Various F/U ₁ Mole Ratios by ¹³ C NMR and Formaldehyde Emission Tests	397
24.8.1	Resin Synthesis and Treatment Procedures	398
24.8.2	Collection of Data	398
24.8.3	Heat Treatment Effects of UF Resins Made with Various F/U ₁ Mole Ratios	402
24.8.4	Heat Treatments at 60 °C for 2.5 hours Followed by Storage at Room Temperature for up to 27 days	405
24.8.5	Reaction Mechanisms of Methylene and Methylene-ether Group Forming Reactions	406
24.8.6	Viscosity and Phase Changes of UF Resins During Heating/Storage Treatments	408
24.8.7	F/U ₁ Mole Ratio and Posttreatment Effects on Resin Polymeric Structures and Compositions	409
24.8.8	F/U ₁ Mole Ratio and Heat Treatment Effects on Particleboard Strength Properties	411
24.8.9	Particleboards Bonded with Resins of 2.5-hours Heat and Followed Room-temperature Storage Treatments	415
24.8.10	Summary	417
	References	418
25	Advanced Reading Materials on UMF Resins Modified with 6–12% Melamine	420
25.1	Introduction and Synthesis and Analysis Results of UF and UMF Resins	420
25.1.1	Background and Known Resin Synthesis Methods of UMF Resins	420
25.1.2	Reaction Chemistry of MF and UMF Resins	421
25.1.3	Resin Syntheses of UF and UMF Resins	422

25.1.4	Characteristics of UMF Resins and Resin Intermediates Determined by ^{13}C NMR Spectra	422
25.1.5	General Resin Characteristics of Synthesized UMF Resins	429
25.1.6	Conclusion	432
25.2	DMA Curing Properties of UF and UMF Resins	432
25.2.1	Past Research Using Dynamic Mechanical Analysis (DMA) Method on Wood Adhesive Resins	432
25.2.2	DMA Sample Preparation and Experiments	433
25.2.3	Three Curing Segments of DMA Curing of Resin $\text{UFA}_{1.15}$	433
25.2.4	Curing Chemistry of Resin $\text{UFA}_{1.15}$	435
25.2.5	Effects of Catalyst Level and Mix Time and Temperature on DMA Curing of Resin $\text{UFA}_{1.15}$	438
25.2.6	Comparison of Resins $\text{UFA}_{1.15}$ and $\text{UMF}_{1.15}$ by DMA at Three Different Temperatures	439
25.2.7	Effects of Three Different F/(U + M) Mole Ratios on Curing Rates at 150 °C	441
25.2.8	Summary	441
25.3	Bond Performance of UMF Resins as Particleboard Binders	443
25.3.1	Preparation and Tests of Laboratory Particleboards	443
25.3.2	Test results of Particleboards Bonded with Resins at an F/(U + M) Ratio of 1.15	443
25.3.3	Summary	445
	References	445
26	Advanced Reading Materials on UMF Resins Modified with 2.5% and 5.0% Melamine	447
26.1	UMF Resins Synthesized with 2.5% and 5.0% Melamine Levels	447
26.1.1	Experimental Procedures	447
26.1.2	Resin Chemical Structures Determined by ^{13}C -NMR	449
26.1.3	Storage Stability of UF and UMF Resins	451
26.1.4	Properties of Catalyzed Resins	451
26.1.5	Particleboard Test Results	453
26.1.6	Summary	456
26.2	UMF Resins Synthesized by Adding Melamine at Different Points	456
26.2.1	Syntheses of UMF Resins	457
26.2.2	Physical Properties of Synthesized UMF Resins	458
26.2.3	Resins' Chemical Structures From ^{13}C NMR Results	458
26.2.4	Storage Stability of Un-catalyzed Resins	459
26.2.5	Properties of Catalyzed UMF Resin	461
26.2.6	Particleboard (PB) Test Results	462
26.2.7	Summary	466
	References	467
27	Advanced Reading Materials on Diethylene Tricarbamide-Formaldehyde Resins	468
27.1	Introduction	468
27.2	A Higher Functionality Urea Analogue – Diethylene Tricarbamide	469

27.3	Chemical and Physical Properties of Diethylene Tricarbamide	469
27.4	An Efficient Synthesis Method of Diethylene Tricarbamide	470
27.5	Synthesis Chemistry and Procedure and Properties of D-formaldehyde (DF) and Copolymer Resins	470
27.6	Synthesis Formulations of DF Resins vs. UF Resins	471
27.7	Room Temperature Storage Properties of DF and Copolymer Resins	472
27.8	Pot-lives and Curing Characteristics of DF and Copolymer Resins	472
27.9	Preparation of Laboratory Particleboards and Testing	473
27.10	Test Results of Prepared Laboratory Particleboards	473
27.11	Summary	475
	References	475
28	Advanced Reading Materials on PF Resole Wood Adhesive Resins	476
28.1	Chemical Structures of PF Resole and Novolac Resins by ^{13}C NMR Spectroscopy	476
28.1.1	PF Resin Model Compounds	476
28.1.2	An Example Spectrum of a PF Resole Resin	479
28.1.3	A Second Example Spectrum of a PF Resole Resin	480
28.1.4	A Third Example ^{13}C NMR Spectrum of a Novolac PF Resin	480
28.1.5	Summary	481
28.2	Reaction Rates and Structures of a PF Resole Resin Synthesized at 70°C	482
28.2.1	Introduction	482
28.2.2	Peak Intensity Changes of Aromatic Carbons Due to Polymerization During Resin Synthesis	483
28.2.3	Peak Intensity Changes of Aliphatic Carbons due to Polymerization Reaction	484
28.2.4	Polymerization of PF Resole Resins Observed by Gel Permeation Chromatography (GPC)	487
28.2.5	Summary	488
28.3	Polymer Structures of a PF Resole Resin Synthesized at 102°C vs. a Commercial Resin	490
28.3.1	Introduction	490
28.3.2	Acetylation of PF Resin Samples and Fractionation	491
28.3.3	^{13}C NMR Chemical Shift Values of Model Compounds and PF Resin Fractions	492
28.3.4	^{13}C NMR Results of PF Resin Model Compounds and Resin Fractions	492
28.3.5	Intrinsic Viscosity ($[\eta]$), Vapor Phase Osmometric (VPO) Analysis, and M-H Equation	496
28.3.6	Conclusion	499
28.4	Polymer Structures of High Molecular Weight Fractions of a PF Resole Resin	500
28.4.1	Synthesis of an Oriented Strand Board Binder-type PF Resin and GPC Analysis	500
28.4.2	Acetylation and Fractionation	501
28.4.3	Instrumental Analyses of Acetylated PF Resin Fractions	501

28.4.4	Results and Discussion	502
28.4.5	Conclusion and Summary	508
28.5	Polymer Structures of Cured PF Resole Resins by Solid-state ^{13}C NMR	508
28.5.1	PF Resin Synthesis and Curing Procedures	508
28.5.2	Curing Mechanisms of PF Resole Resins and Loss of Some Formaldehyde? – a Review	510
28.5.3	Solid-state CP/MAS ^{13}C NMR Spectra	511
28.5.4	Solid-state CP/MAS ^{13}C NMR Chemical Shift Assignments of Aliphatic Carbons	511
28.5.5	Solid-state CP/MAS ^{13}C NMR Chemical Shift Assignments of Phenolic Ring Carbons	513
28.5.6	Solid-state CP/MAS ^{13}C NMR Chemical Shift Assignment of Quinone Structures	513
28.5.7	Results and Discussion	514
28.5.8	Conclusion and Summary	517
	References	518
	Index	521