

UREA FORMALDEYDE AND ISOCYANATE RESINS **Property comparisons**

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SUMMARY

Physical properties were compared for conventional particleboard bonded with varying amounts urea formaldehyde (UF) and isocyanate (PMDI and EMDI) resins. Compared with UF resin, isocyanate resins had excellent bond strength for particleboard as determined by bending properties and internal bond. Dimensional stability properties were also better for isocyanate bonded board.

INTRODUCTION

Isocyanate resins, unlike UF resins are used either as a 100 solid or as an emulsifiable liquid with which water or other additives maybe mixed. The isocyanate used in the particleboard industry is polymeric diphenylmethane diisocyanate (PMDI) and the emulsifiable polymeric isocyanate (EMDI). Isocyanate resins bond readily to hydroxyl groups in wood and water and to many other materials, including caul plates and platens. Proper care is needed to ensure that bonding occurs only where desired.

In this study, physical properties were compared for conventional particleboard bonded with varying amounts of UF and isocyanate resins.

EXPERIMENTAL

Industrially produced wood chip furnish, comprising predominantly mixed softwoods was the raw material used in this study. After screening, the chips for the manufacture of UF bonded boards were dried to 2.5-3% MC, while the chips for the isocyanate bonded boards were dried to 6.5-7% MC. It is known in the latter case, that a higher mat MC can be tolerated (Deppe, 1977). The resins used for the manufacture of boards were UF (62.4% solid) and two types of isocyanate resins: PMDI and EMDI, both 100% solid. The amount of resin used was based on the oven dry weight of wood. An aqueous solution of ammonium chloride (20% solid), 2% based on the weight of resin solids was added to the UF as a hardener before spraying. All resins were applied to the furnish with a pneumatic atomising nozzle in a rotary drum blender. The order of spraying was resin and water to bring the mat to the correct moisture level (10%).

Mat forming was performed by hand in a frame placed over a metal caul plate. Another caul plate was placed on the top of the formed mat. Chip orientation was random. Mats were pressed without stops, in a 30cm diameter electrically heated hot press, for 3 min. Target board density was 650 Kg/m³ and target board thickness 12.15 mm for all boards. Three replications of each board were made, giving a total of 27 boards.

Boards were conditioned at 20°C and 65% relative humidity prior to testing of internal bond strength (IBS) (EN 319), modulus of rupture (MOR), modulus of elasticity (MOE) (EN310), thickness swelling (TS) and water absorption (WA) (EN317).

RESULTS AND DISCUSSION

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