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TECHNOLOGICAL PERFORMANCE FOR THE CORRUGATED METAL INDUSTRIES OF FORMALDEHYDE-FREE ADHESIVES ALTERNATIVE OPTIONS

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ABSTRACT

Emissions of formaldehyde have been under pressure since the 1970s from products produced there and were constantly lowered. The debate again increased, and came into effect in 2016, with the current CLP regulation (Classification, Labeling and Packaging) that categorised formaldehyde as a category 1B carcinogen. Given the possible and even tighter future limitations on formaldehyde use, it would be necessary to develop and implement viable alternatives in the wood processing industries for the substitution of formaldehyde-based glue systems such as urea formaldehyde. This report gives a detailed assessment of the literature's proposed yet formaldehyde-free adhesive solutions for the manufacturing of particulate wood composites. The synthetic and renewable adhesives include adhesive systems examined here. The basis of the assessment is an assessment of the different adhesive systems based on chosen technical factors (products and processes). Based on this information, we have assessed the potential of suitable other adhesives to fulfill the requirements of a major processing industry. In conclusion, the replacement of formaldehyde remains a difficulty. Apart from pMDI systems, most other adhesives, which lead to much higher costs of manufacture, are considerably less reactive? In addition, there are currently no availabilities in the amounts required of most components proposed for the development of other adhesives.

Keywords: “Adhesives for wood; Wood and wood composites; Cure; Hardening; Health and safety”

1. Introduction

The usage and expansion of the forest industry is and still will be of great importance[1]. Wood resources have been used; the essential factor in the production, construction, furnishing and other applications of modern, functional wood products[2] is the adhesive connection of solid wood and wood particles of different dimensions. Back in the twentieth century wood was tied to organic adhesives, and in particular thermosetting, adhesives were gradually improved, rendered more efficient and reliable in moist situations. Amino, phenolic and Isocyanate resins[3]. are nowadays available. The application of such thermosetting adhesives in the spectrum of cured qualities is considered to be cost effective and reactive, quickly healed and adaptable. These adhesives dominated the market for wood composites for many decades. Urea-formaldehyde is the major resin in this group in terms of quantity (UF). UF-based adhesives are used almost exclusively to produce timber materials such as particle boards or MDF boards, due to the inexpensive cost, raw ingredients they contain, fast curing, high dry bond strength and the colorless glue line in their internal applications [5]. The two products need sticks of reasonably high dry resistance, dimensionally resistant, temperature-moderate and humidity-resistance and preferably quick treatment for processing and water solubility to modify viscosity for PBs and MDF plates[6].

Approximately two thirds (6.6 − 106 t/a in 2004) of the European amino resins were used for particle boards, approximately a third for MDF manufacture, while the remaining 5% were used for all the other end uses. The proportional importance of several types of panels has recently been enhanced although the European timber-based panels comprise of particle panels, which account for 50 percent, followed by fibre-focused panels (30 percent) (11 percent).

ISSN: 2278-4632
Vol-09 Issue-10 No. 1 October 2019

The materials in question amount to 40-60%[4] of the overall cost of the product (compare the cost of the final panel discussion on alternative glue possibilities. Therefore, the price of the resin is about 30-50 per cent of the material cost, whereby, in comparison to the dry mass of wood, the product includes only 2-14 per cent of resin. The other main cost components are energy expenditure (approx. 15-20%), work (approx. 5-20%), and production costs (depreciation, repair, etc.) (approx. 25% to 30%)[7].

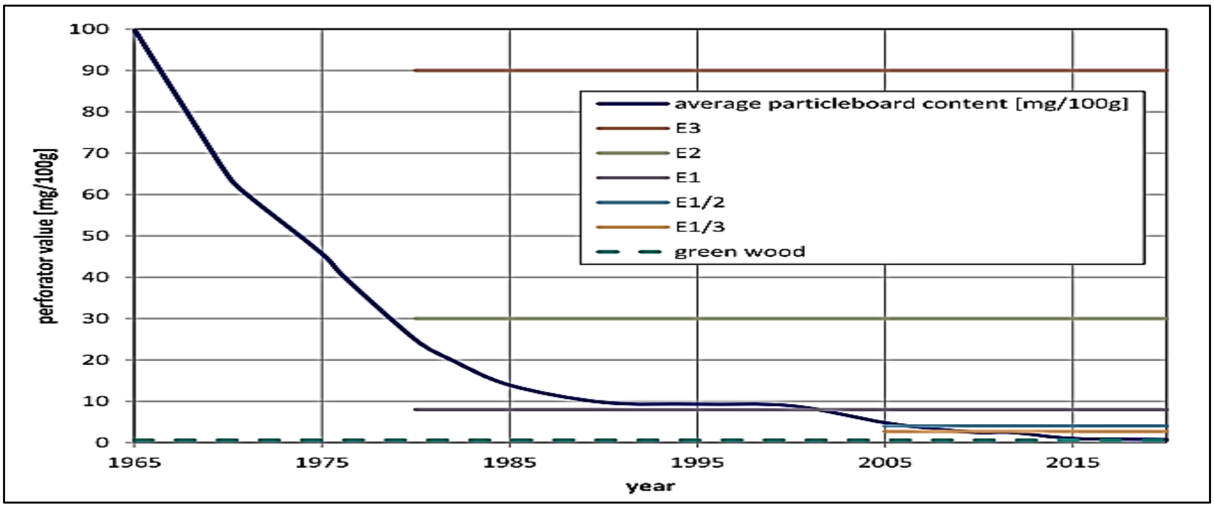

Figure 1: "Development of formaldehyde content of industrially produced particleboards" [8]

2. Crosslinking agents

Cross-link agents are compounds that produce, encourage or regulate intermolecular, covalent or ionic interactions between polymer chains that create the network EN 923 of three dimensions. Pre-polymers and/or polymers have been converted into highly molar-mass polymers, and are subsequently converted into a network. The adhesive becomes a solid substance from a liquid, which forms a stable glue line which binds wood. Like formaldehyde, reactive monomers are also some of the chemicals listed[9]. Oligomers and/or polymers having reactive groups are produced during polymerization with other monomers. Residual monomers may remain in the resultant glue as a cross-linking agent or other monomers may be included as cross-links. The next item is the quick introduction to most crosslinking agents discussed in the present study, so that the final debate at the

ISSN: 2278-4632
Vol-09 Issue-10 No. 1 October 2019

end of this examination may be based. Current volumes of production are also mentioned so the reader can estimate how much formaldehyde is currently utilised to replace. In the cited articles, several of these compounds are given various trivial and trade names along with their preferred IUPAC names and changes. We solely utilise the names in the following subtitles in our review. In addition, the CAS register numbers are also presented as support for the 'non-chemical' reader by clearly allocating the above compounds between square bracket numbers[10]

3. “Formaldehyde [50-00-0]”

“Formaldehyde is a very reactive. It's a low electron density dipole on the carbon atom, therefore it reacts easily with higher electron density atoms. By water loss, the resultant methylol group might be linked to a different molecule. Monomeric formaldehyde is a colorless gas that is formed at ambient temperature but is generally used as a formaline aqueous solution. In solution, methylene Glycol and its oligomers are actually found [463-57-0].” Concentrated formalin is utilised in the industry (> 50%), while 35–37% are more stable in laboratories. For the manufacturing of resins the biggest proportion of formaldehyde is used. Methanol oxidation is used to make formaldehyde. Formal production capacity globally is around 18% to106 t/a (2011) on the basis of 100% formaldehyde, whilst global use was projected to be 13.1% to106 t/a (2011) on the basis of 100% formaldehyde[11].

4. Alternative Aldehydes

Formaldehyde, "the simplest and cheapest" aldehyde, should be replaced with other aldehyde, ideally with similar response mechanisms as an approach to the production of formaldehyde-free adhesives. In this case, aldehydes are favoured which are cheap and widely available[12].

ISSN: 2278-4632
Vol-09 Issue-10 No. 1 October 2019

3.1 Glyoxal [177-22-2]

The simplest and most important industrial dialdehyde is glyoxal (Ethanedial). At ambient temperature the glyoxal anhydrous is a liquid, but it quickly polymerizes when water is added. This means that glyoxal is generally used between 30% and 50% in an aqueous solution[13]. In solution, glyoxal is generally available as hydrogen monomers, dimers and trimmers ("1,1,2,2 ethantetraol"). For over one half a century, however, urea glyoxal (including formaldehyde) resins are not known as wood adhesive but are used as wrinkles, washing and wearing materials for the textile finishing market. Later on, a urea-glyoxal urea free formaldehyde resin was proposed[13]. to create particle boards. In addition, glyoxal is an effective cross-linking agent and consequently an excellent choice for formaldehyde-free resins manufacturing due to its bi-functionality. Among the several procedures for glyoxal production are industrial applications based only on acetaldehyde oxidation or ethylene glycol. The world glyoxal production volume isglyoxal is about 120-170×103 t/a (2002) [12].

3.2 Dimethoxyethanal [51673-84-8]

“As a glyoxal *masked* Dimethoxyethanal is the methanol glyoxal monoacetal (glyoxal dimethyl acetal) that can be obtained commercially as an aqueous solution. The free aldehyde group and the second following acetal hydrolyze may react. Reactions can take place.”

3.3 Glyoxylic acid [298-12-4]

The oxidation of Glyoxylic acid in an aqueous solution is industrial. It is available either as a solution or in a solid, waterproof monohydrate [563-96-2]. On the one side of the molecule is glyoxylic acid and on the other side is the aldehyde group. The aldehyde reacts with melamine as a replacement for formaldehyde in melamine resins, but the acid group has to be esterified with Apolyol in order to be fully interlinked [13].

4. Isocyanate

Isocyanates are organic and highly reactive compounds which include Isocyanate (R—N]C]O) functional groups. Isocyanates are electrophils that react against a variety of nucleophiles, like

ISSN: 2278-4632
Vol-09 Issue-10 No. 1 October 2019

alcohols, amines and water. Two or more molecular isocyanates can be effective cross-connectors. Isocyanate is principally used in the synthesis of polyurethane, a global market of approximately 20,106 t/a(2014)[68]. When Isocyanate is reacted, polyurethanes develop with (a mixture of) polyols. Water was also often included in polyolmixture. The response to water of the Isocyanate Group results in a separation of CO_2 gas and the formation of amines capable of reacting with Isocyanate[14]. Polymerized foams in varying densities and rigidities can be formed due to gas production. The interaction in one element of Isocyanate adhesives with the second 'hidden' component is actually: air or water as often as found in wood. Polyurethane sponges are generally used as insulation materials, mattresses, cleaning sponges, sole shoes or skateboards. Furthermore, these polymers are used as fibres, lacquers and adhesives[15]. Isocyanate is manufactured industrially by reacting with phosgene to the respective amines. The synthesis is performed through a carbamoyl chloride (RNHC (O)Cl) intermediate stage in two phases. Literature describes pretty well the production techniques for timber adhesives

4.1. Methylene diphenyl diisocyanate (MDI) [101-68-8]

"Monomeric MDI from pMDI is generated. It has two groups of Isocyanates and is a major cross-linking agent. Pure MDI is a solid white with only 40 °C melting point. The global capacity of MDI stood at around 3.4 T/A worldwide (2004)."

4.2.Polymeric methylene diphenyl diisocyanate (pMDI) [9016-87-9]

"Isocyanates large industrial production is pMDI (polymeric methylene diphenyl diisocyanate). In addition to the name, a blend of homologues and MDI isomers indicates that pMDI is typically not a genuine polymer. The condensation of the formaldehyde line and subsequent phosgenation of PMDI is produced without purification". The outcome is generated via Monomeric MDI as a high-quality product and the pMDI as the residual mixture is marketed. The pMDI fluctuates, with 4,4-MDI 40% to 60% of the primary component and the rest of the isomers consisting of other MDI isomers, triisocyanates,and and top molecular oligomer. There are therefore various pMDI types as differing

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Vol-09 Issue-10 No. 1 October 2019

yellowish-brown fluids in viscosity. “As pMDI cannot be diluted with water, polyglycols have been used to react to the EMDI emulsion by water. Formaldehyde can no longer be discharged although it is used in the pMDI production process”[16].

5.Sugar-based

For all mono- and disaccharide-nutrients, sugar is the chemical word. There are both primary and secondary alcohols that can be used to relate reactions to each other hypothetically. Moreover, when the sugars are heated and transformed into more or less reactant chemicals, numerous reactions can occur. The reaction of carbohydrates to furan compounds is widely recognised. While these heterocyclics are currently moderately applicable in compositions of wood glue (not necessarily without formaldehyde)[17].

5.1. Glucose [50-99-7]

Glucose is an abundant hexose sugar, and is also the monomer of starch and cellulose biopolymers. Four secondary groups and one primary group of alcohol are present in glucose. In an aqueous solution, the and β-chairs mutarotate through an open chain, which is an aldehyde, from one form to the other. In many food and non-food applications, glucose is used. In addition, lactic acid, citric acid, and bioethanol are fermented to make goods. Glucose is created by the enzyme hydrolysis of starch and can be much more essential in the industrial provision of cellulose production methods as a feedstock. It is expected that production is 30 daily (2007/2008)[16] .

6.Sucrose [57-55-6]

Sugar is only the typical legal saccharose name. It comprises three primary alcohols and five minor alcohols Glucose and Fructose dimer ("fruit sugar"). Food sector is the most important use. However, it can also be used as polyol in polyurethane manufacturing. The total overall global production of 155 alternative 106 t/a (2004) is obtained and refined with sugar cane or beet)[18].

ISSN: 2278-4632
Vol-09 Issue-10 No. 1 October 2019

7. Constraints of the technical evaluation of adhesives systems

Studies used as references to the current description of technology must meet the following criteria that must be integrated in the data set: (2) pressing parameter press time and temperature shall be stated during the work (3) the strength properties of the adhesive are indicated in the part boards or in connected veneer-based bonding systems as describable at the close of introduction (e.g. using the ABES system where the test principle has become standardised) (Table 2).[19]

		Components made out of formaldehyde	
		Yes	No
Components capable of releasing formaldehyde	Yes	e.g. paraformaldehyde, hexamine, HMMM, methylolated urea	e.g. Sugar, plant compounds (i.e. lignin...)
	no	e.g. pMDI	Numerous compounds

Table 2 "Adhesives defined as *formaldehyde free* included in the present study may only contain components depicted in the fields showing white background"[10]

7. Discussion

In respect to the relative quantity of mass-based adhesive component, the classification was formed in the following group according to the main component of the adhesive mixture (for example, amino or lignin-based). For example, lignin adhesive is comprised of 70 percent, pMDI 25 percent and certain extra components. No suggestions have been made to determine the main support component for the stated circumstance pMDI for this categorization. Since wood particleboards represent the major indicator for a force that is against the pressing factor at s/mm board thickness, results from investigations connected directly to particle boards are given and discussed first on each s/mm board thickness adhesive system (IB), The processing temperature was also ranked below or

 ISSN: 2278-4632
Vol-09 Issue-10 No. 1 October 2019

above 180°C. As indicated in the introduction, the usual temperature ranges from around 180 °C to 240 °C in the heating operations for conventional particulate board manufacture.

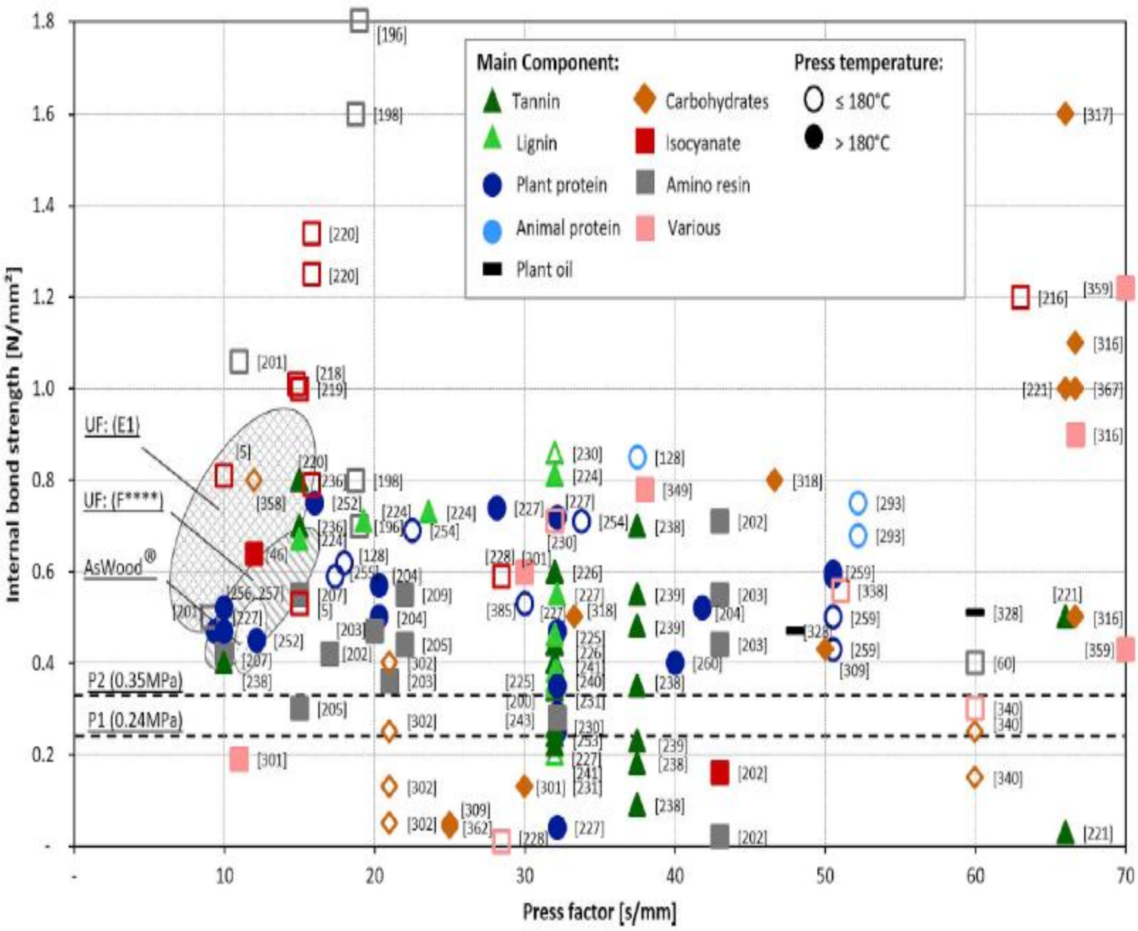

Figure 1: "Overview of the internal bond strengths as a function of pressing factor for adhesives used for particleboard manufacture. The color labeling distinguishes between the main components and the filling of the symbols provides information on the press temperature used"

8. Conclusion and Future Scope

A contemporary ULEF system characterised by formaldehyde emissions at or below the natural wood level is used to provide an equitable comparison to assess new formaldehyde-free alternatives. PMDI is considered the most obvious choice devoid of formaldehyde adhesive. The fact that this system is already used industrially in OSB production, but also in the particulate board business, but

ISSN: 2278-4632
Vol-09 Issue-10 No. 1 October 2019

in relatively limited quantities, is supporting this conclusion. Europe's predicted pMDI-based 1% of total output volume. The extremely low sticky pMDI propagation rate and the obligatory utilisation of release agent make this mandatory. In any case, the amount of pMDI adhesive based on solids is approx. 5-10 times larger than that of an E1 UF adhesive. As pMDI adhesives have been supplied by only a few providers during recent years, pMDI's prices have been significantly fluctuating, and consistent particle board pricing are therefore impossible to ensure. An additional uncertainty appears in a constant pMDI supply. The comparatively low rates of distribution of pMDI for core layers may be 2–4 per cent and 6–8 per cent for facial layers, while UF demands substantially greater distribution rates. The achieved press factor can reach an industrial scale of more than 5 s/mm, influence both the relative cost of product and the capacity of production as stated above Moreover, occupational health and safety regulations should be considered as another problem during the production of panel products for pMDI manufacturing plants, which is less significant for the processing of amino-based adhesives. Such adhesives can lead to equivalent emissions, which could be achieved by ultra-low-emitting (ULEF) systems with a similar but much increased particulate board cost, depending on the pMDI price scenario.

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