

Index

a

acid dyes 345

acid-curing PF and PMF resole resin and dispersion wood adhesives 162–163

acidic buffer capacity 19, 74–77

acidity 72, 74–77, 119, 162, 284

acrylic resins 4, 323–324, 350

acrylics 4, 321, 323, 335

additives to coatings 332

adhesion strength 20, 223, 270, 307

adhesive and interphase layers 285, 286

adhesive application rates in wood
composites 26, 96, 106, 176–177, 198, 233, 237, 243, 246

adhesive bonding theory for wood 292–301
adsorption (secondary bond forces) theory of adhesion 292–295
diffusion theory of adhesion 297–298
mechanical interlocking theory of adhesion 296–297
primary chemical bond (covalent bond) theory 298–299

adhesive bonds, evaluation of 28, 302–316

adhesive cost 26, 166, 201, 278, 280

adhesive failure versus wood failure 269, 285–286

adhesive-layer or interphase failures in wood
adhesive bonds 284–285

adhesive property of polymer solids 20

adhesive strength vs. substrate strength 283

adsorption theory in wood bonding 292–295

airless spray guns 339

alkyd resins 5, 320–321, 328, 337

alkyl resorcinol-formaldehyde resins 185

aluminum sulfate or chloride and free acids 74

American National Standard for Wood Products—Structural Glued Laminated Timber 181

ammonia 42, 46, 62–63, 72–73, 77, 88, 92, 129–130, 161, 469

anchoring in wood adhesive bonding 30, 296–297

animal blood-based wood adhesives 278

animal protein-based wood adhesive 276–277

antioxidant 266–267, 269

apparent viscosity 15–16, 200

Aspenites 239

attrition mill blenders 104–105

average molecular weight values 12–13, 57, 186, 488

b

backer materials of laminates 344

backstand sander 343

belt blending of OSB strands 105

birch plywood 313–314

biuret-type bonds formed in isocyanates resins 222

bleaching of wood in finishing 344–345

bonding adhesives of sander abrasives 344

bonding of fiber-reinforced plastics with PRF resin adhesives 182–183

bonding of wood preservative and fire-retardant treated lumber 182

Brookfield viscometer 17, 56, 175

brush back Vonnegut wheel sander 343

buffering of acidic catalysts 77–78
 burner ash problem in the particle drying process 77

C

capillary contraction temperature
 measurement of PF novolac resins 132
 carboxymethyl cellulose (ether) 8
 carriers (solvents) of coating formulations 332
 casein (protein from milk) 25
 casein wood adhesives 275–277
 application and curing of 275
 production and formulation of 275–276
 uses of 276
 catalytic curing agents of epoxy resins 271
 catalyzation of UF resins by wood acids 74–77
 cellulose, polymers 8
 cellulose acetate (CA) 8, 323
 cellulose acetate butyrates (CAB) 323, 346
 cellulose nitrate (ester) 8
 celluloseics 200–201, 251, 322–323
 chroma values 331
 class I hardboard coating finishes 350
 class II hardboard coating finishes 350
 coalescing agent of latices 36, 333–334
 coalescing of PVAc polymer particles 252–253
 coatings technology of wood 329–338
 additives to coatings 332
 carriers (solvents) of coating formulations 332
 color control methods 329–331
 color scales 331–332
 exterior coatings for wood 336–337
 film formation mechanisms 333–334
 manufacturing procedures of coatings 332–333
 pigment volume concentration (PVC) 317–319
 pigments and fillers 329
 three components of coatings 317
 vehicle polymers 319–328

water-borne coatings and coatings for less VOC emissions 334–336
 cohesive property of adhesive polymer solids 20
 cohesive strength 20, 36, 156, 265–266, 283
 measurement and viscous and elastic responses 20–21
 color control methods 329–332
 color scales 331–332
 colorimeter for checking plywood veneers 196
 commercial PVAc emulsions 250–251
 compression force 21, 307–308, 315
 contact adhesives in wood bonding 270–271, 295
 contact angles of adhesives on wood surfaces vs. good bonding 290
 continuous meter-mixing technology 176
 continuous presses or long hot-presses 27, 207
 control filler 210–213
 co-polymerization 90, 252, 265
 critical pigment volume concentration (cPVC) 318
 cross-laminated timber (CLT) 183
 cup methods of viscosity measurements 17
 cured epoxy resin structures 271–272
 cured PF resin structures 514
 cured UF resin structures 78–81, 84–85
 Cure rate I of DMA tests of UF resins 434, 438
 Cure rate II of DMA tests of resins 435, 438–439, 441–442
 curing of PRF adhesive in a laminated beam 177
 curing of thermoplastic emulsion adhesives 36–37
 curing of thermosetting adhesive resins at elevated temperatures 29–33
 curing of thermosetting adhesives at room temperature 35–36
 curing reaction mechanisms of UF resins 78–79
 curing speeds of UF resins 81
 curtain coating of adhesives and finishes 26, 198, 200, 203, 341, 347, 350

custom lumber laminators 180
 cyclic delamination test procedure 181, 312

d

decorative (high pressure) laminates 161
 defect theory of adhesive bond failures 300
 degree of polymerization, defined 12
 diisocyanate resins 219, 277, 326
 diethylene tricarbamide-formaldehyde resins
 chemical and physical properties of 469
 co-polymer DMF resins syntheses 471
 co-polymer DUF resins synthesis 471
 efficient synthesis method of 470
 higher functionality urea analogue 469
 PE formaldehyde content values of
 particleboards 474
 physical strength and water soak test values
 473–474
 pot-lives and curing characteristics of DF
 and copolymer resins 472–473
 properties of (aqueous) DF resins 471
 room temperature storage properties of DF
 and copolymer resins 472
 synthesis chemistry of DF resins 470–471
 synthesis formulations of DF resins vs. UF
 resins 471–472
 synthesis reaction characteristics of DF
 resins vs. UF and UMF resins 470
 diffusion theory of adhesion 148, 223,
 297–298
 diol 5–6, 218–219, 223, 227, 272, 321–322,
 326
 dispersion forces in adhesive bonding of wood
 292, 294–295
 distribution zone of particleboard short
 retention time blends 96
 DMA curing test results of UMF and UF
 resins 432–443
 1.05, 1.15, and 1.25 by curing on DMA at
 150 °C 441
 comparison of Resins UFA_{1,15} and UMF_{1,15}
 by curing on DMA at three different
 temperatures 439–440
 comparison of Resins UFA, UMF_{6D}, and
 UMF_{12D} made with F/(U+M) mole
 ratios of

 curing chemistry of Resin UFA_{1,15}
 435–438
 effects of catalyst mix temperatures and
 durations on DMA cure properties
 438
 effects of different M addition points in
 resin synthesis on DMA resin curing
 properties 440
 first segment of curing, the gelation stage
 435
 gel time, cure rates, and cure times
 determined cured on DMA at 120 °C
 438
 second segment of curing, the rubbery
 stage 437
 third segment of curing, thermosetting
 stage 437
 three curing segments of DMA test of Resin
 UFA_{1,15} 433–435
 door skins (panels) 159
 drawer sander 344
 drum sander 342–344
 dry internal bond strengths of particleboards
 443–445
 dryers of OSB strands 231
 dryers of alkyd resins 319
 durable adhesive bonds 297, 298
 dynamic mechanical analysis (DMA) 82–85,
 153–157, 178–179, 196, 242–243, 246,
 432–445, 452, 462

e

edge sander 343–344
 Einstein equation of viscosity 16
 elastic response in mechanical testing of
 wood bonds 20–21
 elasticity of solid polymer materials 21–22
 electron-releasing tendency phenol molecule
 123
 electrostatic spray methods 33, 35, 339
 emulsion coatings 332, 333
 emulsion form of wax 102, 114
 end-grain to end-grain joints 176–177
 end-jointed lumber 27, 181, 305
 engineered wood flooring (EWF) materials
 273

- epoxy resin adhesives 7, 271–273, 321, 325
 aliphatic and aromatic primary and
 secondary amine hardeners 271–272
 cold-set adhesives in wood bonding 273
 commercial epoxy resin adhesives 272
 cyclic acid anhydride curing catalysts 272
 durable epoxy resin adhesives 273
 tertiary amine catalysts 27
- ethylene 3, 4, 10, 252, 264, 265, 469, 511
- ethylene-vinyl acetate (EVA) co-polymer resin
 4, 252, 264–268
- excitation (resonance) of nuclear spins
 in ^{13}C NMR 351–354
- extenders in softwood plywood adhesives
 201–202
- extractives of wood 195, 285, 290, 291, 313,
 315
- f**
- face-laminated lumber, testing of 302, 305
- fast-drying oils 320
- fatty oils 318–321, 333
- fiber manufacture and blowline resin
 blending in MDF manufacture
 102–104
- fillers of wood adhesives 175, 252, 266
 fillers in softwood plywood adhesives
 200–201
- film formation mechanisms of coatings
 333–334
- flake board 239
- flat line finishing procedures 346–347
- flexible and rigid urethane foams 219
- flow coating 342
- formaldehyde 41–42, 123, 137
 emission in curing of UF resins 79–80
 emission test results of particleboard (PB)
 381–382
 emission tests, small-chamber and
 perforator methods 443
 emission values of particleboards 394–396
 reactivity with lignins 279
 species in PF resole resins 487
- fracture mechanics test 306
- free carboxylic acid and phenolic species in
 wood 76
- free formaldehyde and hemi-formal groups in
 UF resins 358, 374
- free formaldehyde species in UF resins 52,
 363, 369–372, 379, 394, 407–408
- free induction decays (FID) in ^{13}C NMR 354
- free urea 45, 48, 63, 69, 358, 362, 369, 374,
 377, 380, 391, 392, 402–405, 407, 408,
 449, 458
- F/U₁ mole ratios of UF resins, definition of
 52–54
- Furafil 100 200
- g**
- gap-filling capability of softwood plywood
 adhesives 199
- Gardener–Holdt bubble tube method of
 testing viscosity 17
- gel permeation chromatography (GPC) 13,
 57, 127, 171, 480, 482, 487–488, 490,
 500
- gel time measurement by DMA, defined 434
- gelation of adhesive layer, definition of 32
- gelation point of UF and PF resins- 32, 83,
 84, 151, 155
- gem-dihydroxymethyl group in UF resins
 360
- general acid catalysis mechanism 407, 418
- glass-wool insulation 161
- glazes in wood finishing 346
- glueline's curing problems 284
- good wetting and low contact angle 287
- h**
- hand-held block sander 344
- hardboard air-suspension process of
 manufacturing 160
- hardboard and hardwood plywood wall
 panels 335
- hardboard panels 159, 349
 finishing procedures 349–350
- hardboard wet process of manufacturing
 159–160
- hardeners of PRF resins 173–176, 191
- hardeners of epoxy resins 272, 273
- hardwood plywood 109–111
 plywood grades 111

- hardwood plywood industry 109–110
 - manufacturing procedure with UF resin adhesives 110
 - troubleshooting methods 111
 - hardwood plywood panel pre-finishing 348–349
 - heated airless spray guns of coatings 339
 - heavy oil in paraffin waxes 112, 113, 115
 - hot-pressing of wood composite mats 34–35
 - extents of resin cure in hot-pressing 35
 - platen pressure, mat thickness, and density profiles 33–34
 - temperature changes and moisture movements in board mat 34–35
 - high solids coatings 335
 - high-speed paddle blender of wood fiber 104
 - hot-melt adhesives 29, 263–268
 - advantages 266
 - disadvantages 266
 - materials used for 265–266
 - requirements for 263–265
 - uses of 267
 - hot-melt edge-banding operation 269–270
 - hot-plate cure time of PF resins 131
 - hot-stacking 33, 35, 99, 152, 206, 238
 - house log industry, PRF resin-bonded 181
 - hydrogen bonds 80, 277, 292–295, 298
 - hydrogen ion 18, 19, 69, 73, 74, 76, 78, 92, 124, 139, 406
 - hydroxyethyl cellulose (ether) 9
 - o*-hydroxymethyl groups of PF resins 476, 480, 486–488
 - hydroxymethyl-methylene-phenols 499, 508
 - hydroxymethylphenols, formation of 125, 137, 138
 - hydroxymethyl resorcinol (HMR) 90, 168, 179, 182, 183, 221
- i**
- inclined plate flow test of PF novolac resins 132
 - industrial coating application processes 339–350
 - airless spray guns 339
 - curtain coating 341
 - electrostatic spray methods 339
 - flat line finishing procedures 346–347
 - flow coating 342
 - hardboard panel finishing procedures 349–350
 - hardwood plywood panel pre-finishing 348–349
 - kitchen cabinet finishing procedures 347–348
 - knife coating 341
 - precision roll coaters 341
 - reverse roll coater 340–341
 - roll coating method 340
 - sanding abrasives, construction, and flexing 345
 - sanding processes 342–344
 - typical furniture finishing procedures and materials 344–346
 - industrial (high pressure) laminates 162
 - injection molding processes 132
 - inorganic polymers 2
 - in-situ* adhesion testing of wood adhesive bonds 315
 - interfacial tensions between a liquid and solid 289
 - interfacial tension values 289, 290
 - interior-grade laminated lumber 276
 - interphase in wood bonding, defined 283
 - interphase failures 284–285
 - interphase in wood adhesive bonds 283–287
 - intrinsic viscosity (IV) 16, 17, 185, 189–191, 490, 496–501, 504–508
 - isocyanate groups (—N=C=O) 218
 - isocyanate (ISO) resins 6, 25, 217–227
 - bond properties and chemical reactions of pMDI resins as OSB binders 224–226
 - chemical structures of polymeric-MDI (pMDI) resins 217–227
 - general uses of 217
 - handling procedures of 218
 - mat moisture levels in using pMDI resins for OSB bonding 223–224
 - mix with an emulsion polyol as wood adhesives 220
 - pMDI resins used in bonding of other wood composite products 226–227

isocyanate (ISO) resins (*contd.*)
 reaction of isocyanate resins with water
 218–223
 reaction with hydroxyl groups of polyols
 219
 urethane resins 326
 wood adhesives and coatings made by
 pre-mixing pMDI resins and polyols
 219–220

k

kitchen cabinet finishing procedures
 347–348
 knife coating 341
 knife-planed lumber 176, 182
 Kraft lignin 278–280

l

laminated veneer lumber (LVL) 27, 109,
 110, 159, 207, 220
 laminates 140, 149–151, 161, 259, 267, 268
 lap shear test of plywood 303, 304
 Large-Chamber test method formaldehyde
 emission from boards 447
 Larmor frequency of nuclear spin in ^{13}C NMR
 351, 352, 354
 length of stirring in viscosity measurement
 15
 light scattering method of MW measurement
 13, 144, 190, 500–508
 lignin 1, 9, 10, 26, 74, 223, 239, 278, 281,
 297, 298
 lignin uses in alkaline PF resolite resins
 279–280
 lignin uses with tannin materials 280
 lignosulfonates, ammonium 279–280
 calcium lignosulfonates, calcium 280
 lignosulfonates, sodium 280
 liquid adhesives 1, 15
 liquid hardeners of PRF resin adhesives 175
 liquid PF resin binders of OSB 234
 loss modulus in mechanical testing of wood
 bonds 20, 82, 83, 155, 433–435, 437,
 452
 lower durability grade adhesive mixes of
 plywood bonds 203

low F/P mole ratio PF resins 147–148, 150
 low pressure laminates 161

m

Mark–Houwink (M–H) equation 16, 498,
 506
 mastic adhesives 269–270
 medium density fiberboard (MDF) bonded
 with UF resins 102–109
 blowline configuration 106
 dry-out and re-activation of fiber 105
 economics of MDF manufacturing process
 106
 fiber manufacture and blowline resin
 blending 102–104
 fiber velocity 106
 fire hazard 105
 industry 109
 maintenance 106
 mat-forming and hot-pressing parameters
 107–108
 paddle blending system of resins 104–105
 physical properties of 108
 refiner sizes 106
 resin spots in boards 106
 resin usage levels 105–106
 melamine-formaldehyde (MF) resins 7, 323
 melamine-formaldehyde (MF) resins, curing
 of 89–90
 melamine-urea formaldehyde (MUF) resin
 23, 25, 29, 40, 63, 65
 curing of MUF resins 65, 90–91
 melamine, manufacture 63–64
 melamine-formaldehyde (MF) reaction
 products 64
 melamine syrup 64
 melamine-urea-formaldehyde (MUF)
 copolymer formation 65
 uses of MUF resins 65–66
 meta-carbons of phenol molecule 123, 513
 methyl methacrylic acid esters 323
 methyl or ethyl cyanoacrylates 324
 methylene groups of UF and MUF resins
 44, 360
 bond formation in curing 44, 89–90
 groups' limited heat stability 81–82

- methylene-di-urea 54, 62, 373, 380–382, 403–405, 409, 410, 414–416
 methylene-ether groups in UF resins, formation of 44, 360
 methylene-ether-cellulose bonds 80–81
 methyleneic groups 356, 366, 373, 422, 449, 496
 mineral abrading materials in wood sanding 344
 modulus of elasticity (MOE) 21, 308, 393, 443, 474
 modulus of rupture (MOR) 308, 393, 443, 474
 moisture content (MC) of wood, effects in bonding 255–259
 differences between wood substrates 255
 effects of substrate condition 258
 gluing problems 259
 manufacturing plant and location of use 256
 quality control methods of wood bonds 259, 315
 radial and tangential differences in shrinkage of wood 255
 water in water-based adhesives 258
 moisture-curing systems of isocyanate resin adhesives 221, 222, 227, 273
 molded wood products 66, 160–161
 mold sander 343
 mono-hydroxymethylurea in UF resins 371, 380, 402–405, 417
 mono-substituted urea in UF resins 362, 369, 371, 377, 380, 401–406, 450
 multi-opening hot presses 26–27, 98
- n**
- natural or reclaimed rubber-based mastics 269
 natural pre-finishing of wood panels 348
 neoprene (chloroprene) rubber-based mastics 270
 Newtonian liquid/solution, definition of 14
 nitrocelluloses 322, 323
 no-formaldehyde-added resins 87
 nondestructive testing of wood bonds 315
 non-drying oil 320
 non-Newtonian solution 14
 novolac-type phenol-formaldehyde (PF) resins 122–133
 number-average molecular weight (Mn), definition of 12, 13
 nylon 2, 5, 10, 161, 343
- o**
- oil-based paints 321, 332
 oligomeric polymers in coatings 335
 oligomeric or telechelic polymers of coatings 360
 one-component, moisture-curing polyurethanes 221, 267, 273
 one-step PF resins 5, 136
 opacity of coatings 266, 329, 331, 337
 open drum sander 343
 orbital and reciprocating pad sander 344
 orbital disc sander 344
 organic/natural polymers 2
 organic solvents 13, 14, 36, 130, 169, 218, 252, 269, 270, 321, 332–334, 345, 356
 organosolv lignins 279
 organic/synthetic/semi-synthetic polymers 2
 oriented strand board (OSB) 5, 6, 27, 29, 132, 133, 140, 159, 194, 227, 229–240, 277, 500–501, 508
 oriented strand board (OSB) manufacturing 229–246
 adhesive improvements needed 239
 binder resin types 231–234
 blending of binder resin and slack wax efficiency of resin binders vs. droplet sizes 233
 liquid PF or pMDI resin binders 233–234
 powder-type PF resin binders 233
 resin blender types and operation 232
 resinated wood strands 233
 drying and screening of wood strands 231
 durability of boards and span ratings 239–240
 hot-pressing of OSB 235–239
 industry hot pressing parameters 237–238

- oriented strand board (OSB) manufacturing (*contd.*)
 - loading of mats 235
 - pre-cure or over-cure problems 236
 - press closing and effects of press closing rate 235
 - temperature and moisture content variation 235–236
 - under-cure problems 236
 - mat forming with strand orienters 234–235
 - mat moisture levels in using pMDI resins for OSB bonding 223–224
 - oriented strand lumber (OSL) 238–239
 - post-curing (hot stacking) and finishing of OSB 238
 - ripple effects of OSB roof decking 239
 - steam transfer and condensation
 - mechanism of hot pressing of OSB 235
 - stranding (flaking) of wood boles 230–231
 - wafer board 239
 - wood species used 229–230
 - oriented strand board (OSB) made with PF resins synthesized and testing for 229–246
 - OSB binder PF resin synthesis and testing 241, 243–244
 - resin curing rates determined by DMA 242–243
 - test results of laboratory OSB 242
 - ortho*- and *para*-carbons of phenol, reactivity and definitions of 123–126 136–139
 - over-curing of UF and PF resins 33, 61, 81, 82, 99, 102, 111, 306, 441, 444, 445
- p**
- padding stains in wood finishing 346
 - paddle blending system of resins in MDF manufacturing 104–105
 - paints, coatings for wood 337
 - paper laminates 140, 149–151
 - paraffin wax 112–115
 - analyses of wax 113
 - application methods on wood substrates 114
 - melting point of commercial waxes 112
 - normality of paraffin wax 113
 - properties of 112–113
 - use levels based on wood weight 114
 - use of 112
 - paraformaldehyde 174–175
 - hardeners of PRF resin adhesives 174–175
 - pre-processing of 174
 - parallel (veneer) strand lumber (PSL) 207, 214
 - particleboard (PB), manufacturing of 94–102
 - Bison–Mende process 100
 - drying and tack development of binder UF resins 97–98
 - equilibration of boards and finishing 100
 - formaldehyde emissions of bonded boards 87–88
 - hot-pressing of particleboard, types 98
 - industry mat forming and hot-pressing parameters 107
 - mole ratio vs. board strength and formaldehyde emission levels
 - mat compaction and density profile of particleboards 98
 - mat formation and transport 97–98
 - mechanical forming machines of particleboard manufacture 97
 - methods proposed for reducing the formaldehyde emissions of boards 91
 - particleboard industry of U. S. 100–101
 - performance properties of industry particleboard 100
 - resin-solids loading levels 96–97
 - short-retention time blenders 95–96
 - softwood plywood trims 77
 - U. S. particleboard industry 100–101
 - ultra-low formaldehyde-emitting resins 87
 - uses of 86
 - wood furnishes of 94–95
 - particleboards made in laboratory for tool wear testing 115–120
 - physical tests of manufactured boards 116–117

- elemental analyses of boards 117
- resin syntheses and additives 116
- test methods of tool wear 117
- test results of tool wear effects 117–119
- tool wear effects of acidic curing catalysts of UF resins 119–120
- perforator extraction (PE) tests of formaldehyde content in boards 443
- PF resole wood adhesive resins, alkaline 136–165
 - acid-curing PF and PMF resole resin as dispersion wood adhesives 162–163
 - binder uses for various wood products 5, 24, 94, 122, 124–129, 159–162
 - curing of alkaline PF resole resin adhesives in wood bonding 151–153
 - decorative (high pressure) laminates 161
 - differential scanning calorimetric (DSC) analysis of 157, 158
 - durable matrix-forming material 202
 - dynamic mechanical analysis (DMA) test method of 153–157
 - F/P mole ratios of 147
 - formaldehyde emission problem 159
 - gel times and stroke cure times of 153
 - glass-wool insulation binders 161
 - good wood adhesion and exterior durability 158–159
 - industrial (high pressure) laminates 162
 - laminates 161
 - low pressure laminates 161
 - molded wood products 160–161
 - molecular weights 143–144
 - molecular weights of alkaline PF resole resins and wood cell wall penetration 148–149
 - oriented strandboard manufacturing, as binder 159, 231–232
 - paper laminates 150–151
 - pH value of 145
 - polymer molecular weight and structures 141, 195–196
 - polymer structures of 145–146
 - powder PF resole resin 149, 231, 233
 - reacted F/P mole ratio of PF resins 127, 129, 147
 - reaction chemistry of phenol with formaldehyde 123–124
 - resin #1 type PF resole resins 148
 - resin #2 and #3 type PF resole resins 147–148
 - resin #4 type PF resole resins 147
 - resole-type PF resins 122, 133, 136–165
 - resole resin chemistry 183
 - softwood plywood binders 150, 159–162
 - spray-drying of 149
 - synthesis chemistry and manufacturing practices of 136–139
 - synthesis procedures of resins for various uses of 140–143
 - tri-methylolphenol 137–138
 - viscosity values of 144–145
 - wafer board binders 161
- pH of polymer solutions and buffers 18–19
- phenol, manufacturing of 122–123
- phenol-formaldehyde (PF) novolac resins 122–134
 - compounding of 129–130
 - finishing of resin manufacturing 127
 - gel permeation chromatography (GPC) of 127
 - initial reaction period resin manufacturing 125
 - novolac PF resin, ¹³C NMR spectrum 477–478, 481
 - number-average molecular weight of 128–129
 - polymerization of hydroxymethylphenols 125–126
 - polymerization reaction mechanism 126
 - properties and structures of 127
 - raw materials of 122–123
 - reaction chemistry of phenol 123–124
 - reactions occurring in the final molding step 130
 - synthesis procedure of 124
 - wood adhesive uses of 132–133

- phenol-formaldehyde (PF) resole resins
 - (advanced reading materials) 476–517
 - ^{13}C NMR analyses of model compounds and PF resole and novolac resins 477–480
 - PF resole resin synthesized at 70 °C for reaction rate study 476
 - changes of aromatic and aliphatic carbons from polymerization by ^{13}C NMR 484–487
 - GPC and ^{13}C NMR analyses of resin samples taken during synthesis 487–488
 - polymer structures of synthesized resins 489
 - reaction rates of phenol-formaldehyde resin formation by ^{13}C NMR 487
 - reaction rates of phenol-formaldehyde resin formation by GPC 488
 - PF resole resins synthesized at 102 °C (A) vs. commercial resin (B) for comparison 490
 - acetylation of the resins 491
 - ^{13}C NMR analyses of the acetylated model compounds and fractions 492–496
 - fractionation of acetylated resin A by elution 491–492
 - fractionation of acetylated resin B by precipitation 491
 - Mark–Houwink equation correlation results of resin fractions 498–499
 - polymer structures determined by ^{13}C NMR, GPC, VPO, intrinsic viscosity 493–496
 - PF resole resin synthesized at 80 °C (OSB binder) for high MW polymer structure study 501
 - acetylation of resin and fractionation into 21 fractions 501–502
 - Mark–Howink correlation and universal correlation equations of the fractions 506–507
 - polymer structures by GPC, VPO, IV, ^1H and ^{13}C NMR and light-scattering MW determinations 505
 - polymer structures of the highest MW fractions from light scattering results 506
 - PF resole resin synthesized resin at 90 °C for study of cured PF resin structures 508
 - chemical structures of sample C derived from solid-state ^{13}C NMR 515
 - cured PF resole resin's polymer structure, Sample C 516–517
 - curing of the resin at 125 (Sample B) and 190 °C (Sample A) 508–509
 - polymer structures of cured PF resole resins by solid-state ^{13}C NMR 508–515
 - solid-state ^{13}C NMR analysis methods, introduction of 508
 - solid-state ^{13}C NMR analysis results of Samples A, B, C 512–515
 - washing of Sample A with water, resulting in Sample C 509
- phenol-resorcinol-formaldehyde (PRF) resins 166–193
 - alkyl resorcinol-formaldehyde resins 185
 - availability of resins in industry 173–174
 - ^{13}C NMR analysis results of PRF resins 170–171
 - co-polymer PRF resin manufacturing and chemistry of 167–173
 - curing chemistry of resin with hardener 179
 - determination of resorcinol/phenol mole ratios of resins by ^{13}C NMR 172
 - GPC analysis results of a PRF resin 172
 - hardeners for PRF resins 174–175
 - homo-polymer RF resins 166
 - mixing procedures of resin and hardener 175–176
 - optimum MC in bonding of laminated beam 176
 - powder hardeners of PRF resin adhesives 175, 176
 - PRF resin-bonded laminated beams 36, 183
 - resorcinol-formaldehyde (RF) resins 6

- recent developments in 182–183
 - resole-type resorcinol-formaldehyde resins
 - products 183
 - resorcinol-formaldehyde (RF) resin
 - analysed for polymer structures 185–191
 - tannin-formaldehyde wood adhesive resins 184
 - use as adhesives in wood lamination 176–179
 - wood lamination industry 179–181
 - pigment volume concentration (PVC) 317–319, 332
 - pigment wiping stains 346
 - pigments and fillers 317, 329–332,
 - plasticizers 250–252, 265, 270, 273, 324, 325
 - plywood lap shear strength testing of 303
 - pneumatic drum sander 343
 - polyesters 5, 11, 265, 321–322, 335
 - polyethylene 2, 3, 5, 10, 12, 157, 265, 267, 290, 297, 480, 487
 - polymers, defined 2
 - polypropylene 3, 10, 265, 324
 - polystyrene 3, 10, 144, 501, 506, 507
 - polysulfide rubber-based mastics 270
 - polyvinyl acetate emulsion wood adhesive
 - resins 249–262
 - additives 251–252
 - application methods 253
 - coatings vehicles 324
 - commercial 250–252,
 - curing mechanism of 253
 - manufacturing of 249–250
 - properties of 250, 252
 - polyvinyl acetate (PVAc) resins 3, 25–26, 29, 40
 - polyvinyl acetate (PVAc) resin adhesives,
 - troubleshooting in gluing 259–262
 - assembly gluing by clamping process 262
 - cold-press lamination process 260
 - edge and face gluing by clamping process 261–262
 - hot-press laminating process 260–261
 - radiofrequency edge-gluing process 261
 - polyvinyl alcohol (PVA) 221, 250, 251, 324, 325
 - polyvinyl butyral 324, 325
 - polyvinyl chloride 4, 267, 325, 333
 - portable belt sander 344
 - post-curing of adhesive layers 33
 - powder coatings polymers 335
 - precision roll coaters 341
 - primary chemical bond (covalent bond)
 - theory of wood adhesion 298–299
 - primer coatings 321, 337
 - printed wood panel finishing procedure 348
 - proteins 2, 10, 11, 276
- r**
- radiation curing of coatings 335
 - radiofrequency (RF) heating processes of
 - wood bonding 27
 - red cedar 77
 - reverse roll coater 340, 341, 347, 348
 - rigidity curve of DMA 82–83
 - roll coating method of wood adhesives and
 - finishes 203, 340
 - rosins 321
- s**
- sanding abrasives, construction, and flexing 344
 - sanding processes of wood 258, 342–344, 350
 - saturated polyesters 321–322, 335
 - SBR rubber-based mastics 270
 - scarfed end-jointed plywood, lap shear
 - strength testing of 305
 - sealers in wood finishings 324, 325, 340, 341, 346
 - semi-drying oils 320
 - shear-thickening materials 15
 - shear-thinning materials 15
 - silicone resins 321, 327, 336
 - Six-Cycle Vacuum Soak Test 240
 - size coating and/or bleaching in wood
 - finishings 344–345
 - small-chamber (SC) formaldehyde emission
 - tests and results 395, 414

- softwood plywood, manufacturing of 150, 194–216
- adhesive formulation and characteristics 198–203
 - adhesive mixing procedure 197–198
 - adhesive spread rate and method of application 202–203
 - adhesive PF resole resin characteristics for 195–196
 - bond performance characteristics of 197
 - bonding with higher moisture content veneers 209
 - dryout problems 208
 - fillers and extenders 200–202
 - hot-pressing parameters of 204–207
 - hydrolysis residues of municipal newsprint waste as fillers 210–213
 - laminated veneer lumber (LVL) 159, 207
 - manufacturing industry 209–210
 - manufacturing technology 194–214
 - open and closed assembly times 204
 - parallel (veneer) strand lumber (PSL) 207
 - phenolic components in softwood plywood 209
 - pre-pressing of softwood veneer assembly 204
 - veneer, veneer drying, and adhesion problems 196–197
 - wash water of PF resin plywood adhesives 203
- solvent-borne coatings 332, 334, 335
- solvent-borne or emulsion coatings 333
- soybean meal wood adhesives
- production and formulation of 276–277
 - recent research activities on 277
 - uses of 277
- stain or pigmented lacquer toner 345
- stains in wood finishings 259, 317, 323, 336–338, 341, 345–347, 349
- starch 2, 7, 9, 11, 196, 201, 202, 208, 251, 275, 276
- steam-injection hot presses 27, 238
- storage modulus 21, 452
- stock laminating wood industry 180
- stroke sander 343
- styrene-butadiene resins 325
- styrenics 321
- substrate strength of wood in adhesive bonding 20
- surface stability of wood in adhesive bonding 108
- surface tensions of liquid and solid materials 287–288
- t**
- tack property of UF resins, development of 57
- tackifying agent of hot-melts 265
- tan delta in DMA experiments 82, 83, 155–157, 433–435
- tannin-formaldehyde wood adhesive resins 184
- telechelic polymers in coatings 335
- thermoplastic resin binder of wood 280
- thermoplastic polymers 12, 20, 21, 143, 157, 250, 251, 264, 269, 435
- thermosets, definition of 6, 29
- thermosetting acrylic resins 323, 350
- thermosetting coating vehicles 324
- thermosetting hot-melt adhesives 267–268
- thermosetting polymers 20, 21, 41, 217
- thermosetting resins 28, 29, 37, 82, 85, 129, 142, 143, 153–157, 218, 411, 437
- thixotropy 15, 182
- toluene 122, 491–492
- topcoats 337–338, 346–349
- turning sander 343
- TVA acid hydrolysis residue as fillers 210–214
- two-component adhesives or coatings 220
- u**
- UMF resins synthesized with 2.5% and 5.0% M added in the middle/end of the first step 457
- chemical structures of Resin UMF-2 and Resin UMF-3 determined by ^{13}C NMR 458
 - ^{13}C NMR spectra of 5.0%UMF_{1.05} 460
 - poor storage stability of Resin UMF-2 and Resin UMF-3 459, 461

- resin synthesis procedure for Resin UMF-2 456
- resin synthesis procedure for Resin UMF-3 457
- UMF resins synthesized with 2.5% and 5.0% M levels added in the first step 457–467
- gel and cure times of catalyzed resins measured on rheometer 464
- gel times of catalyzed resins 463
- laboratory particleboard manufacturing parameters 464
- particleboard test results of Resin UMF-1 vs. control UF resins 464, 465
- pot-lives of catalyzed resins 461, 462
- properties of catalyzed UMF and control UF resins
- UMF resins synthesized with 2.5% and 5.0% M levels added in the 3rd step 447–456
- chemical structures determined by ¹³C NMR 450
- ¹³C NMR spectra of 5.0%UMF_{1.05} 449
- gel times of catalyzed resins 452
- gel and cure times of catalyzed resins measured with rheometer 452
- particleboard test results of Resin UMF-4 vs. control UF resins 453–456
- particleboard manufacturing parameters 455
- pot-lives of catalyzed resins 451
- storage stability of resin vs. control UF resin 451
- synthesis procedure of resins 447
- undercoats 337, 338
- unsaturated polyesters 321, 322, 335
- urea-formaldehyde (UF) and melamine-urea-formaldehyde (MUF) resins, curing of 72–93
- aluminum sulfate or chloride and free acids as catalyst 74
- ammonium salts catalysts 72–73
- buffering capacities of various woods 75–76
- buffering of acid catalysts 77–78
- catalyzation by wood acids 74–75
- composition of cured UF resins 80, 85–86
- curing reaction mechanisms and cured resin structures 78–79
- curing speed controls of UF resins 81
- degradation of cured UF resins 83
- formaldehyde emission in curing of UF resins 87–88
- gelation, rubbery stage, vitrification, and full cure in DMA tests 82–83
- latent/external catalysts based on ammonium salts 72–73
- melamine-urea-formaldehyde (MUF) resins, definition of 64
- methylene bond formation in curing 89–90
- methylene groups' limited heat stability 81–82
- performance properties of UF resin-bonded wood products 86
- proposed methods for reducing the formaldehyde emission 89–92
- reversibility of methylol groups to formaldehyde 82
- role of methylene-ether bonds in UF resins 85
- side reactions in curing of UF resins 81
- stronger acid catalysts for curing of MUF and UMF resins 90, 422, 468
- tertiary amine and other salt catalysts 73–74
- urea-formaldehyde (UF) and melamine-urea-formaldehyde (MUF) wood adhesive resins 7, 24, 40–89
- chemistry occurring in UF resin synthesis 46–50
- effects of F/U₁ mole ratio in the polymerization step 53–54
- hydroxymethyl group formation in the first and third steps 43, 45
- methylene group formation and reaction rates in the second step 47–50
- methylene-ether group formation in first step 43, 52–53
- physical and chemical tests and properties of industrial UF resins. 55–58

- urea-formaldehyde (UF) and melamine-urea-formaldehyde (MUF) wood adhesive resins (*contd.*)
- polymer chain branch formation in UF resins 50–52
 - polymeric chemical structures of UF resin 63
 - reversible hydroxymethylation reactions of urea 46–47
 - side reactions occurring 52, 81
 - final F/U mole ratio and formaldehyde emission problem 55
 - formaldehyde emission mechanisms, F/U mole ratio, and board strengths 87–88
 - methylene-ether–cellulose bonds of binder UF resins 80
 - raw materials of UF resins, formaldehyde and urea 40–42
 - resin changes occurring after resin manufacture 58–60
 - resin manufacturing procedure, typical 42–46
 - urea-formaldehyde concentrate (UFC) 42, 448, 457, 458
 - uses of UF and MUF resins 86, 90
 - urea-formaldehyde (UF) wood adhesives resins (advanced reading materials) 351–420
 - ¹³C NMR analysis methods of UF resins, introduction 356–359
 - chemical shift values of various UF resin structures 357
 - example ¹³C NMR spectra of UF resins of F/U ratio of 2.10 and 1.15 358
 - experimental procedure 359
 - peak integration values determine structural compositions of UF resins 358
 - ¹³C NMR analysis of reaction intermediates of UF resins with higher power NMR 366–374
 - bond group changes of resin samples observed by ¹³C NMR 367
 - effect of the second urea addition and mild heat treatments 369
 - formation of UF polymers in the second step observed without and with the rate of methylene bond formation at an F/U₁ mole ratio of 2.10 367
 - reaction paths to various intermediates in synthesis of UF resin polymers 368
 - second urea addition 370–373
 - ¹³C NMR analysis results of reaction intermediates taken in UF resin syntheses 360–366
 - bond group changes of resin samples observed by ¹³C NMR 361
 - first step of resin synthesis 360–362
 - particleboards bonded with UF resins made with different F/U₁ mole ratios
 - rate of methylene bond formation depending on F/U₁ mole ratio 363
 - second step of resin synthesis 362–363
 - third step of resin synthesis 363
 - ¹³C NMR chemical changes occurring in UF resins on heat/stirring and room temperature storage treatments
 - effects of mild and intermediate level heat/stirring treatments 374–378
 - formation of methylene-di-urea type groups 380
 - formaldehyde emission test results of particleboards 381
 - irreversible methylene groups of UF resins 371
 - migration of types II*t*/III hydroxymethyl groups 375
 - methylene group changes due to migration of II*t*/III type hydroxymethyl groups 176
 - reaction of the second urea indicating some polymerization occurring 377
 - ripening times of UF resins 378
 - room temperature treatment effect of UF resins 378
 - treatment procedures 374–382
 - ¹³C NMR spectroscopic analysis method, introduction 351–356
 - applied magnetic field strength 351
 - CFT-20* NMR spectrometer 359, 360

- chemical shifts 352
- excitation (resonance) 352
- magnetic spin population 351
- nuclear Overhauser (nOe) effect 189, 355
- precautions in reading ^{13}C NMR spectra 356
- proton-decoupling 355
- relaxation of excited nuclear spins 352
- repeat scans and pulse-delays 354
- T_1 relaxation time 355
- T_2 relaxation time 354
- Technag 360* NMR spectrometer 359, 367, 449
- tetramethylsilane (TMS) 354, 357
- effects of mild heating/stirring treatments on UF resin synthesized with three different F/ U_1 mole ratios 382–388
- bond group changes occurring in the heating/stirring treatments by ^{13}C NMR 383
- polymer chain branching increases with F/ U_1 mole ratios 387
- resin F/ U_1 mole ratio effects on resin chemical structures 384–388
- resin syntheses and heating/stirring treatment procedures 382–383
- resin viscosity changes occurring in the heating/stirring treatments 384
- effects of mild heat/stirring followed by room temperature storage treatments on UF resins made with three different F/ U_1 mole ratios 397–418
- bond group content changes by ^{13}C NMR analysis 399
- bond group content changes occurring in graphic form 400
- collection of treatment data of resin samples 398
- formation of methylene-di-urea type insoluble compounds 403
- formation of mono-substituted urea groups bonded to UF polymer 403
- F/ U_1 mole ratio and heating/storage treatment effects on PB properties 415–418
- F/ U_1 mole ratio and heating treatment effects on PB properties 409–411
- F/ U_1 mole ratio and posttreatment effects on resin polymeric structures 409–411
- mechanisms proposed to formation of methylene-di-urea in alkaline pH 406–407
- viscosity/turbidity changes of UF resins during storage 402
- effects of room temperature storage treatments on UF resin synthesized with three different F/ U_1 mole ratios 388–397
- application of results to industry 396–397
- bond group content changes by ^{13}C NMR analysis 390
- bond group content changes occurring in graphic form 390–391
- formaldehyde emissions of PBs, effects of F/ U_1 ratio/storage times 394–396
- methylene group increases indicating MW increases during treatment 392
- optimum ripening times for UF resins 394
- performances of PBs bonded with UF resins with four different storage days 393
- room temperature treatment procedures (50 days) 389
- viscosity/turbidity changes of UF resins during storage 389–392
- urea-melamine-formaldehyde (UMF) resins 66–68
 - definition of 66
 - different addition points of melamine in resin synthesis 67–68
 - handling properties of UMF resins
 - resultant beneficial effects of melamine incorporation 67

- urea-melamine-formaldehyde (UMF) resins
 - modified with 6–12% M, syntheses of 420–432
 - ¹³C NMR analysis results of intermediates and UMF resins 425
 - ¹³C NMR spectra typical UMF resins with and without the addition of second urea 426
 - ¹³C NMR spectrum of an MF resin stabilized by urea addition 427
 - different (four) M addition points in resin syntheses and resin properties 422, 424, 425
 - methylene and methylene-ether group ratios of UF and UMF resins 432
 - particleboard test results for UMF resins at an F/(U+M) mole ratio of 1.15 443–445
 - reaction mechanisms of M and F of forming methylene or methylene-ether bonds 426
 - reaction of melamine with formaldehyde, optimum pH 420, 428
 - reaction of urea with formaldehyde, optimum pH 421
 - reverse hydroxymethylation reactions of melamine 428
 - syntheses of UF and MF intermediates of different extents polymerization 424
 - syntheses of various resins of different extents polymerization of UF components 423
 - viscosity increases of various UMF resins made with 2–12% melamine levels 430
 - urethane bonds 219, 223, 224, 326
 - urethane polymers 219, 321
- V**
- van der Waals bonds 292, 294, 295
 - vapor pressure osmometry (VPO) 13, 490, 496–499, 503–505, 508
 - varnishes 100, 220, 270, 326, 332, 333, 336–338, 341, 347
 - vinyl resins 324–325
 - viscosity index, definition of 13–15
 - viscosity of polymer solutions 13–16, 141–142
 - viscous response 20
 - vitrification of adhesive layer, definition of 32–33
 - vitrification point of UF and PF resins on DMA tests 33, 83, 152, 156, 206, 237, 435
 - volatility index of paraffin wax 112
- W**
- wafer boards 134, 161, 239
 - wash-coat of lacquer to smooth the wood surface 345
 - water-borne coatings and coatings for less VOC emissions 334–336
 - wax in hot-melt adhesive formulation 266
 - weight-average (M_w) molecular weights, definition of 12
 - white fir and sycamore 77
 - wide-belt sander 342
 - wind sifting-type former in particleboard manufacture 97
 - wood adhesive bond tests and evaluation methods 302–316
 - automatic boil test (ABT) and exterior exposure test results 313–314
 - bending strength tests 307–309
 - certification of durability grades 310–311
 - cleavage test 306–307
 - comparison results of wood adhesives by accelerated aging an exterior exposure 313–315
 - common laboratory aging test methods 312
 - cyclic delamination test procedure 312
 - durability evaluation results 309–310
 - effects of aging of wood before gluing 313–314
 - in-situ* adhesion testing 315
 - non-destructive testing methods 315
 - objectives and scope of quality control processes 309
 - peel tests 307
 - shear strength test 302–303
 - tensile strength tests 303–306

- testing and certification organizations 313
 - torsion shear test 303
 - wood adhesives 1, 20–38
 - adhesive property of polymer solids 20
 - cohesive property of adhesive polymer solids 20
 - cohesive strength measurement and viscous and elastic responses 20–21
 - curing of thermoplastic emulsion adhesives 36–37
 - curing of thermosetting adhesives at room temperature 35–36
 - degree of polymerization and molecular weight 12–13
 - dependence of viscosity on the concentration and molecular weight of polymers 15–17
 - dependence of viscosity on the shear rate (stirring rate) 14–15
 - elasticity of solid polymer materials 21–22
 - flow and wetting of adhesive layers and molecular adsorption 31–32
 - gelation of adhesive layer 32
 - methods of viscosity measurement of liquid materials 17
 - pH of polymer solutions and buffers 18–19
 - polymer solids level and specific gravity of polymer solutions 18
 - post-curing of adhesive layer 33
 - selection criteria of 23–24
 - spreading and penetration of adhesive layers in hot-pressing 30–31
 - temperature dependence of viscosity of polymer solutions 15
 - thermal and moisture expansion/contraction of adhesive layers 38
 - viscosity changes of adhesive layer before hot-pressing 30
 - viscosity decreases by moisture content changes 31
 - viscosity increases and curing of adhesive layer by polymerization reaction 31
 - viscosity of polymer solutions 13–14
 - vitrification of adhesive layer 32–33
 - volume contractions of adhesive layers upon curing 37–38
 - wood phase failure 284
 - work of adhesion 291
- y**
- Young's modulus 21, 33

