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(54) Titre : PROCEDES DE FABRICATION DE PRODUITS COMPOSITES LIGNOCELLULOSIQUES
(54) Title: METHODS FOR MAKING LIGNOCELLULOSE COMPOSITE PRODUCTS

(57) **Abrégé/Abstract:**

Methods for making a lignocellulose composite product are provided. In one aspect, the method includes combining a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor to produce a mixture, wherein the free radical precursor comprises an oxidant and a catalyst; and at least partially curing the mixture to produce the lignocellulose composite product. In another aspect, the method includes combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound to produce a mixture; and at least partially curing the mixture to produce the lignocellulose composite product. In another aspect, the method includes combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and an unsaturated compound to produce a mixture; and at least partially curing the mixture to produce the lignocellulose composite product.

ABSTRACT

Methods for making a lignocellulose composite product are provided. In one aspect, the method includes combining a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor to produce a mixture, wherein the free radical precursor comprises an oxidant and a catalyst; and at least partially curing the mixture to produce the lignocellulose composite product. In another aspect, the method includes combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound to produce a mixture; and at least partially curing the mixture to produce the lignocellulose composite product. In another aspect, the method includes combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and an unsaturated compound to produce a mixture; and at least partially curing the mixture to produce the lignocellulose composite product.

METHODS FOR MAKING LIGNOCELLULOSE COMPOSITE PRODUCTS

BACKGROUND

Field

[0001] Embodiments described generally relate to methods for making lignocellulose composite products. More particularly, such embodiments relate to methods for making lignocellulose composite products having an increased brightness.

Description of the Related Art

[0002] The production of lignocellulose composite products generally requires an adhesive or binder to bond the discrete particulates, fibers, veneers, or other wood substrates to one another. Typical lignocellulose composite products include particleboard, fiberboard, plywood, and other composite wood products. Conventional binders used in the production of these products include urea-formaldehyde (UF) resins, melamine-formaldehyde (MF) resins, melamine-urea-formaldehyde (MUF) resins, and phenol-formaldehyde (PF) resins and produce lignocellulose composite products generally having a wood neutral color. Alternative binder compositions that do not include formaldehyde based resins, which are frequently referred to as no-added formaldehyde (NAF) resins, include tannin/hexamine based binders. These NAF resins are generally used to produce lignocellulose composite products having desired physical properties, but the color of such composite products can be significantly darker than if produced with conventional formaldehyde containing binder. From an aesthetic perspective, darker lignocellulose composite products can be undesirable.

[0003] There is a need, therefore, for improved methods for making lignocellulose composite products having an increased brightness.

SUMMARY

[0004] Methods for making lignocellulose composite products are provided. In at least one example, the method can include combining a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor to produce a mixture. The free radical precursor

can include an oxidant and a catalyst. The method can also include at least partially curing the mixture to produce a lignocellulose composite product.

[0005] In another example, the method for making lignocellulose composite products can include combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound to produce a mixture. The polyphenolic material can include lignin, tannins, a novolac resin, bisphenol A, modified phenol formaldehyde resin, humic acid, or any mixture thereof. The unsaturated compound can have two or more unsaturated carbon-carbon bonds, where at least one of the unsaturated carbon-carbon bonds can be a pi-bond that is not conjugated with an aromatic moiety and is capable of free radical addition. The method can also include at least partially curing the mixture to produce a lignocellulose composite product.

[0006] In at least one example, a lignocellulose composite product can include an at least partially cured composition. Prior to curing, the composition can include a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor. The lignocellulose composite product can have a brightness of about 15% to about 25%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

DETAILED DESCRIPTION

[0007] It has been surprisingly and unexpectedly discovered that calcium lignosulfonate and one or more free radical precursors, when combined with a plurality of lignocellulose substrates, can produce a mixture that can be at least partially cured to produce lignocellulose composite products having an increased brightness or color as compared to a comparative lignocellulose composite product made in the same way, but with ammonium lignosulfonate instead of calcium lignosulfonate. The plurality of lignocellulose substrates, calcium lignosulfonate, and the one or more free radical precursors can be mixed, blended, stirred, contacted, or otherwise combined with one another to produce a mixture. The mixture can also be referred to as a "furnish," "blended furnish," "resinated mixture," or "resinated furnish." The mixture can be heated to at least partially cure the composition and produce the lignocellulose composite product.

[0008] The lignocellulose composite product made with calcium lignosulfonate and the free radical precursor can have a brightness or directional reflectance at 457 nm of about 5%,

about 7%, about 10%, about 12%, or about 15% to about 20%, about 25%, about 30%, about 35%, or about 40%, as measured according to the Technical Association of the Pulp and Paper Industry (TAPPI) Test method T 452. For example, the lignocellulose composite product can have a brightness or directional reflectance at 457 nm of about 5% to about 10%, about 7% to about 12%, about 10% to about 15%, about 15% to about 20%, about 17% to about 23%, about 18% to about 27%, about 25% to about 30%, about 18% to about 30%, or about 25% to about 35%, as measured according to the TAPPI Test Method T 452. In another example, the lignocellulose composite product can have a brightness or directional reflectance at 457 nm of about 10% to about 17%, about 16% to about 34%, about 32% to about 44%, about 33% to about 50%, about 48% to about 70%, about 68% to about 77%, about 75% to about 90%, or about 85% to about 98%, as measured according to the TAPPI Test Method T 452. In another example, the lignocellulose composite product can have a brightness or directional reflectance at 457 nm of at least 5%, at least 7%, at least 10%, at least 11%, at least 12%, at least 13%, at least 14%, at least 15%, at least 16%, at least 17%, at least 18%, at least 19%, or at least 20% and up to about 25%, about 30%, about 35%, about 40%, or more, as measured according to the TAPPI Test Method T 452. In yet another example, the lignocellulose composite product can have a brightness or directional reflectance at 457 nm of at least 5%, at least 7%, at least 10%, at least 11%, at least 12%, at least 13%, at least 14%, at least 15%, at least 16%, at least 17%, at least 18%, at least 19%, or at least 20% and less than 90%, less than 80%, less than 70%, less than 60%, less than 50%, less than 40%, less than 35%, less than 30%, or less than 25%, as measured according to the TAPPI Test Method T 452.

[0009] The brightness of the lignocellulose composite product can be greater than a brightness of a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate. For example, the brightness of the lignocellulose composite product can be at least 1.1 times greater, at least 1.2 times greater, at least 1.3 times greater, at least 1.4 times greater, at least 1.5 times greater, at least 1.6 times greater, at least 1.7 times greater, at least 1.8 times greater, at least 1.9 times greater, at least 2 times greater, at least 2.5 times greater, at least 2.7 times greater, at least 3 times greater, at least 3.3 times greater, or at least 3.5 times greater than the brightness of the comparative lignocellulose composite product. In another example, the brightness of the lignocellulose composite product can be about 1.1 times greater to about

3.5 times greater, about 1.5 times greater to about 2.8 times greater, about 1.3 times greater to about 2.5 times greater, about 1.2 times greater to about 2.2 times greater, about 1.8 times greater to about 3 times greater, about 1.1 times greater to about 2.6 times greater, about 1.3 times greater to about 3.1 times greater, or about 1.1 times greater to about 2.1 times greater than the brightness of the comparative lignocellulose composite product.

[0010] The calcium lignosulfonate can be derived from any source or combination of sources. The calcium lignosulfonate can be in a liquid form, a solid form, or both. The liquid form can include solutions, suspensions, slurries, dispersions, emulsions, inverse emulsions, or other liquid forms. In at least one example, a liquid form of the calcium lignosulfonate can be a solution, *e.g.*, an aqueous solution. For example, calcium lignosulfonate can be dissolved in one or more liquids to produce a solution. In at least one example, the liquid form of the calcium lignosulfonate can be or include calcium lignosulfonate in the form of a solid, where the calcium lignosulfonate can be suspended, dispersed, or otherwise distributed within a liquid medium, *e.g.*, a suspension, slurry, or dispersion.

[0011] The solution or solid/liquid mixture of calcium lignosulfonate can include one or more liquid mediums. The liquid medium can be or include, but is not limited to, water, alcohols, glycols, acetonitrile, dimethyl sulfoxide, *N,N*-dimethylformamide, *N*-methylpyrrolidone, or any mixture thereof. Suitable alcohols can include, but are not limited to, methanol, ethanol, propanol, isopropanol, butanol, isomers thereof, or any mixture thereof. Suitable glycols can include, but are not limited to, ethylene glycol, propylene glycol, or a mixture thereof. As used herein, the terms "aqueous medium" and "aqueous liquid" are used interchangeably and can be or include water and/or mixtures composed of water and/or other water-miscible solvents. Illustrative water-miscible solvents can include, but are not limited to, alcohols, ethers, amines, other polar aprotic solvents.

[0012] The solution or solid/liquid mixture of calcium lignosulfonate and the liquid medium can include about 0.1 wt%, about 5 wt%, about 10 wt%, about 20 wt%, about 30 wt%, or about 40 wt% to about 70 wt%, about 80 wt%, about 90 wt%, about 95 wt% about 99 wt%, or about 99.9 wt% of the calcium lignosulfonate, based on the combined weight of the calcium lignosulfonate and the liquid medium. For example, the solution or solid/liquid mixture can include about 0.1 wt% to about 30 wt%, about 1 wt% to about 20 wt%, about 5 wt% to about 50 wt%, about 10 wt% to about 70 wt%, about 0.5 wt% to about 25 wt%, about 3 wt% to about 6 wt%, or about 2 wt% to about 8 wt% of the calcium lignosulfonate, based

on the combined weight of the calcium lignosulfonate and the liquid medium. In another example, the solution or solid/liquid mixture can include about 0.1 wt% to about 10 wt%, about 1 wt% to about 12 wt%, about 2 wt% to about 9 wt%, about 3 wt% to about 9 wt%, about 5 wt% to about 15 wt%, about 4 wt% to about 6 wt%, about 8 wt% to about 20 wt%, or about 2 wt% to about 10 wt% of calcium lignosulfonate, based on the combined weight of the calcium lignosulfonate and the liquid medium.

[0013] In another example, calcium lignosulfonate in the form of a solution, *e.g.*, an aqueous solution, can include about 0.1 wt% to about 30 wt%, about 1 wt% to about 20 wt%, about 5 wt% to about 50 wt%, about 10 wt% to about 70 wt%, about 0.5 wt% to about 25 wt%, about 3 wt% to about 6 wt%, about 2 wt% to about 8 wt%, about 45 wt% to about 50 wt%, about 55 wt% to about 60 wt%, about 46 wt% to about 49 wt%, or about 56 wt% to about 59 wt% of the calcium lignosulfonate, based on the combined weight of the calcium lignosulfonate and the liquid medium. In another example, calcium lignosulfonate in the form of a solution can include about 0.1 wt% to about 10 wt%, about 1 wt% to about 12 wt%, about 2 wt% to about 9 wt%, about 3 wt% to about 9 wt%, about 5 wt% to about 15 wt%, about 4 wt% to about 6 wt%, about 8 wt% to about 20 wt%, or about 2 wt% to about 10 wt% of the calcium lignosulfonate, based on the combined weight of the calcium lignosulfonate and the liquid medium.

[0014] As used herein, the solids concentration or solids content of a solution or solid/liquid mixture, *e.g.*, calcium lignosulfonate and a liquid medium, as understood by those skilled in the art, can be measured by determining the weight loss upon heating a small sample, *e.g.*, about 1 gram to about 5 grams of the mixture, to a suitable temperature, *e.g.*, about 125°C, and a time sufficient to remove the liquid medium combined therewith. By measuring the weight of the sample before and after heating, the percent solids in the sample can be directly calculated or otherwise estimated.

[0015] Suitable solid calcium lignosulfonate can be in the form of a powder, flakes, granules, pellets, or other form. Calcium lignosulfonate in the form of a powder can have an average particle size of about 0.05 microns, about 0.1 micron, about 0.6 microns, about 1 micron, about 5 microns, about 7 microns or about 10 microns to about 115 microns, about 225 microns, about 350 microns, about 425 microns, about 500 microns, about 700 microns, about 850 microns, or about 1,000 microns. In another example, the calcium lignosulfonate can have an average particle size of about 0.3 microns to about 160 microns, about 22

microns to about 48 microns, about 35 microns to about 60 microns, about 50 microns to about 75 microns or about 70 microns to about 120 microns about 30 microns to about 70 microns, about 60 microns to about 150 microns, about 100 microns to about 200 microns, about 175 microns to about 325 microns, about 220 microns to about 400 microns, or about 385 microns to about 500 microns.

[0016] A liquid form of calcium lignosulfonate, *e.g.*, an aqueous solution containing calcium lignosulfonate, can be dried via any suitable process or combination of processes to produce a solid calcium lignosulfonate. Illustrative processes for producing the calcium lignosulfonate in the form of a solid can include, but are not limited to, spray-drying, freeze drying, drum drying, pulse combustion drying, vacuum drying, precipitation, air drying, and/or dry spinning. For example, the liquid calcium lignosulfonate can be spray-dried to provide a particulate or otherwise solid calcium lignosulfonate.

[0017] The term "spray drying," as used herein, refers to a process for producing a dry particulate solid product or particulate from a liquid mixture. The process can include spraying or atomizing the liquid calcium lignosulfonate, *e.g.*, forming small droplets, into a temperature controlled gas stream to evaporate the liquid from the atomized droplets and produce the particulate calcium lignosulfonate. For example, in the spray drying process, the liquid calcium lignosulfonate can be atomized to small droplets and mixed with a hot gas, *e.g.*, air, to evaporate the liquid from the droplets. The temperature of the liquid mixture during the spray-drying process can usually be close to or greater than the boiling temperature of the liquid. An outlet air temperature of about 60°C to about 120°C can generally be used. The particle size and liquid, *e.g.*, moisture, content of the spray dried particulate calcium lignosulfonate can be adjusted, controlled, or otherwise influenced by one or more process variables, such as the gas feed rate, gas temperature, the feed rate of the liquid calcium lignosulfonate, the temperature of the liquid calcium lignosulfonate, the liquid droplet size, the solids concentration of the liquid calcium lignosulfonate, or any combination thereof.

[0018] The particulate calcium lignosulfonate, *e.g.*, spray-dried calcium lignosulfonate, can have a liquid, *e.g.*, moisture, content of less than 20 wt%, less than 15 wt%, less than 10 wt%, less than 8 wt%, less than 6 wt%, less than 5 wt%, less than 4 wt%, less than 3 wt%, less than 2 wt%, or less than 1 wt%. For example, calcium lignosulfonate in the form of a solid particulate, *e.g.*, a powdered calcium lignosulfonate, can be free from any liquid medium, or

can include about 0.1 wt% to about 5 wt%, about 0.5 wt% to about 8 wt%, about 1 wt% to about 10 wt%, about 3 wt% to about 6 wt%, about 2 wt% to about 12 wt%, about 5 wt% to about 15 wt%, about 3 wt% to about 9 wt%, or about 1 wt% to about 14 wt% liquid medium.

[0019] The amount of the calcium lignosulfonate mixed with the free radical precursor and lignocellulose substrates can widely vary. For example, the amount of the calcium lignosulfonate in the mixture can be about 0.01 wt% to about 50 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of the calcium lignosulfonate in the mixture can be about 0.05 wt%, about 0.1 wt%, about 0.5 wt%, about 1 wt%, about 2 wt%, about 3 wt%, about 5 wt%, or about 7 wt% to about 15 wt%, about 20 wt%, about 25 wt%, or about 30 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of the calcium lignosulfonate in the mixture can be about 0.1 wt%, about 0.5 wt%, about 1 wt%, about 3 wt%, or about 5 wt% to about 10 wt%, about 13 wt%, about 15 wt%, about 17 wt%, or about 20 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of the calcium lignosulfonate in the mixture can be about 1 wt% to about 15 wt%, about 5 wt% to about 15 wt%, about 8 wt% to about 13 wt%, about 7 wt% to about 12 wt%, or about 5 wt% to about 25 wt%, based on the dry weight of the lignocellulose substrates.

[0020] As used herein, the term "free radical precursor" refers to any compound or mixture of compounds that can generate radicals when subjected to predetermined conditions. For example, the free radical precursor can be a compound or mixture of compounds that can generate radicals when heated to a predetermined temperature. In another example, the free radical precursor can be a compound or mixture of compounds that can generate radicals when an oxidant, *e.g.*, hydrogen peroxide, is subjected to reaction with one or more transition metals (catalyst).

[0021] If the free radical precursor includes two or more components, *e.g.*, a catalyst and an oxidant, the components of the free radical precursor can be combined with the calcium lignosulfonate and the lignocellulose substrates in any order or sequence. For example, if the free radical precursor includes a catalyst and an oxidant, the catalyst can be combined with the calcium lignosulfonate and the lignocellulose substrates to produce a first partial mixture and the oxidant can be combined with the first partial mixture to produce the mixture or vice versa. In another example, the catalyst and the calcium lignosulfonate can be combined with one another to produce a first partial mixture, the first partial mixture can be combined with

the lignocellulose substrates to produce a second partial mixture, and the oxidant can be combined with the second partial mixture to produce the mixture. In still another example, the oxidant and the calcium lignosulfonate can be combined with one another to produce a first partial mixture, the first partial mixture can be combined with the lignocellulose substrates to produce a second partial mixture, and the catalyst can be combined with the second partial mixture to produce the mixture. In another example, the oxidant and the catalyst can be combined with one another to produce a first partial mixture, the first partial mixture can be combined with the lignocellulose substrates to produce a second partial mixture, and the calcium lignosulfonate can be combined with the second partial mixture to produce the mixture.

[0022] The components of the mixture can be introduced or otherwise contacted with one another via any suitable delivery method. For example, the lignocellulose substrates can be in a vessel or other container and the free radical precursor and the calcium lignosulfonate can be sprayed or otherwise directed onto the lignocellulose substrates to produce the mixture. In another example, the free radical precursor and the calcium lignosulfonate can be poured or brushed onto the lignocellulose substrates. In another example, the lignocellulose substrates can be directed, transported, introduced, or otherwise conveyed into a vessel already containing any one or more of the other components of the mixture. Said another way, the lignocellulose substrates can be dipped, soaked, or otherwise contacted with the free radical precursor and the calcium lignosulfonate. In another example, the lignocellulose substrates can be located on a surface, *e.g.*, a conveyor belt, and the free radical precursor and the calcium lignosulfonate can be sprayed, poured, brushed, or otherwise directed onto the lignocellulose substrates to produce the mixture.

[0023] The amount of free radical precursor present in the mixture can depend, at least in part, on the particular composition of the free radical precursor and, thus, can widely vary. For example, the amount of free radical precursor in the mixture can be about 1 wt% to about 200 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of free radical precursor in the mixture can be about 1 wt%, about 5 wt%, about 10 wt%, or about 20 wt% to about 80 wt%, about 100 wt%, about 120 wt%, or about 150 wt%, based on the dry weight of the lignocellulose substrates. In another example, the free radical precursor can be present in the mixture in an amount about 0.1 wt% to about 30 wt%, about 1 wt% to about 20 wt%, about 5 wt% to about 50 wt%, about 10 wt% to about 70 wt%, about

0.5 wt% to about 25 wt%, about 3 wt% to about 6 wt%, or about 2 wt% to about 8 wt%, based on the dry weight of the lignocellulose substrates. In still another example, the free radical precursor can be present in the mixture in amount of about 0.1 wt% to about 10 wt%, about 1 wt% to about 12 wt%, about 2 wt% to about 9 wt%, about 3 wt% to about 9 wt%, about 5 wt% to about 15 wt%, about 4 wt% to about 6 wt%, about 8 wt% to about 20 wt%, or about 2 wt% to about 10 wt%, based on the dry weight of the lignocellulose substrates.

[0024] Illustrative free radical precursors can include, but are not limited to, one or more azo compounds, one or more oxidants, a mixture of one or more catalysts and one or more oxidants, or any mixture thereof. Illustrative azo compounds can be represented by the general Formula $R'-N=N-R''$, where R' and R'' can independently be substituted aryl or substituted alkyl. The term "aryl" refers to an aromatic substituent containing a single aromatic ring or multiple aromatic rings that are fused together, linked covalently, or linked to a common group such as a methylene or ethylene moiety. More specific aryl groups contain one aromatic ring or two or three fused or linked aromatic rings, *e.g.*, phenyl, naphthyl, biphenyl, anthracenyl, or phenanthrenyl. The aryl substituents can have 1 carbon atom to about 20 carbon atoms. The alkyl can include branched or unbranched alkyls having 1 carbon atom to about 15 carbon atoms or 1 carbon atom to about 8 carbon atoms. Illustrative alkyls can include, but are not limited to, methyl, ethyl, *n*-propyl, isopropyl, isobutyl, *n*-butyl, *sec*-butyl, *t*-butyl, *n*-pentyl, *n*-hexyl, ethylhexyl, or isomers thereof. Suitable azo compounds can include, but are not limited to, azobisisobutyronitrile (AIBN).

[0025] The catalyst, if present in the free radical precursor, can also be referred to as an initiator, a promoter, a reducer, and/or an accelerator. Suitable catalysts can be or include, but are not limited to, metal ions, tertiary amines, polymeric tertiary amines, phosphates, bisulfites, metabisulfites, tetraacetylenediamine, cyanamides, ultraviolet light, or any mixture thereof. In addition to or in lieu of contacting the lignocellulose substrates with a free radical precursor and/or catalyst, ultrasonic waves, photo-Fenton and/or electro-Fenton reactions (*in situ* generation of hydroxyl radicals by radiation or electric currents) can be used. The catalyst can be or include one or more transition metals with coordinated Lewis bases. Any catalyst or mixture of catalysts can be combined with the lignocellulose substrates and the oxidant to produce the mixture.

[0026] Illustrative metal ions can include, but are not limited to, metal ions of iron, copper, manganese, tungsten, molybdenum, cobalt, titanium, or any mixture thereof. The metal can

be in the form of an oxide. The metal can be in the form of a salt or complex, *e.g.*, bound to one or more complexing agents or compounds. Illustrative ions or complexing compounds can include, but are not limited to, cyanide (CN^-), sulfate (SO_4^{2-}), ethylenediaminetetraacetic acid (EDTA), ethylenediamine-*N,N'*-disuccinic acid (EDDS), ethyleneglycol-bis(2-aminoethylether)-*N,N,N',N'*-tetraacetic acid (EGTA), diethylenetriaminepentaacetic acid (DTPA), *trans*-1,2-diaminocyclohexane tetraacetic acid (CDTA), iminodisuccinate (IDS), nitrilotriacetic acid (NTA), isomers thereof, salts thereof, acids thereof, hydrates thereof, or any mixture thereof. Other complexing compounds can include phosphates, or complexing agents based on phosphonic acid, oxalic acid, ascorbic acid, nitrilo acetate, gallic acid, fulvic acid, polyoxomethalates, isomers thereof, salts thereof, acids thereof, hydrates thereof, or any mixture thereof.

[0027] The metal ions can include compounds or complexes containing iron ions (*e.g.*, Fe^{2+} or Fe^{3+}), such as iron(II) sulfate, iron(II) oxide, iron(III) sulfate, iron(III) oxide. Other iron ion containing catalyst can include, but are not limited to, ferricyanide ($[\text{Fe}(\text{CN})_6]^{3-}$), ferrocyanide ($[\text{Fe}(\text{CN})_6]^{4-}$), and/or nitroprusside ($[\text{Fe}(\text{CN})_5\text{NO}]^{2-}$). For example, the catalyst can be or include, but is not limited to, potassium ferricyanide ($\text{K}_3[\text{Fe}(\text{CN})_6]$), potassium ferrocyanide ($\text{K}_4[\text{Fe}(\text{CN})_6]$), ammonium ferricyanide hydrate ($(\text{NH}_4)_3[\text{Fe}(\text{CN})_6] \cdot x\text{H}_2\text{O}$), ammonium ferrocyanide hydrate ($(\text{NH}_4)_4[\text{Fe}(\text{CN})_6] \cdot x\text{H}_2\text{O}$), sodium ferricyanide decahydrate ($\text{Na}_3[\text{Fe}(\text{CN})_6] \cdot 10\text{H}_2\text{O}$), sodium ferrocyanide decahydrate ($\text{Na}_4[\text{Fe}(\text{CN})_6] \cdot 10\text{H}_2\text{O}$), sodium nitroprusside dihydrate ($\text{Na}_2[\text{Fe}(\text{CN})_5\text{NO}] \cdot 2\text{H}_2\text{O}$). Other suitable catalyst that contain iron can include, but are not limited to, $\text{Fe}[\text{EDTA}]$, $\text{Fe}[\text{EDDS}]$, $\text{Fe}[\text{DTPA}]$, $\text{Fe}[\text{EGTA}]$, $\text{Fe}[\text{CDTA}]$, $\text{Fe}[\text{IDS}]$, or any mixture thereof. In at least one specific example, the catalyst can include ferricyanide, *e.g.*, potassium ferricyanide, a complex of iron (*e.g.*, ferric and/or ferrous) and ethylenediaminetetraacetic acid (EDTA), a complex of iron (*e.g.*, ferric and/or ferrous) and (*S,S*)-ethylenediamine-*N,N'*-disuccinic acid (*(S,S)*-EDDS), a complex of iron (*e.g.*, ferric and/or ferrous) and (*R,R*)-ethylenediamine-*N,N'*-disuccinic acid (*(R,R)*-EDDS), a complex of iron (*e.g.*, ferric and/or ferrous) and (*R,S*)-ethylenediamine-*N,N'*-disuccinic acid (*(R,S)*-EDDS), a complex of iron (*e.g.*, ferric and/or ferrous) and diethylenetriaminepentaacetic acid (DTPA), a complex of iron (*e.g.*, ferric and/or ferrous) and *trans*-1,2-diaminocyclohexane tetraacetic acid (CDTA), a complex of iron (*e.g.*, ferric and/or ferrous) and iminodisuccinate (IDS), salts thereof, acids thereof, hydrates thereof, or any mixture thereof.

[0028] Tertiary amines can be represented by the general Formula $NR^1R^2R^3$, where each R^1 , R^2 , and R^3 can independently be selected from alkyls, cycloalkyls, heterocycloalkyls, aryls, heteroaryl, and substituted aryls. The alkyl can include branched or unbranched alkyls having 1 carbon atom to about 15 carbon atoms or 1 carbon atom to about 8 carbon atoms. Illustrative alkyls can include one or more, but are not limited to, methyl, ethyl, *n*-propyl, isopropyl, *n*-butyl, *sec*-butyl, *t*-butyl, pentyl, hexyl, ethylhexyl, and isomers thereof. The cycloalkyls can include 3 carbon atoms to about 7 carbon atoms. Illustrative cycloalkyls can include, but are not limited to, cyclopentyl, substituted cyclopentyl, cyclohexyl, and substituted cyclohexyl. The term "aryl" refers to an aromatic substituent containing a single aromatic ring or multiple aromatic rings that are fused together, linked covalently, or linked to a common group such as a methylene or ethylene moiety. More specific aryl groups can include one aromatic ring or two or three fused or linked aromatic rings, *e.g.*, phenyl, naphthyl, biphenyl, anthracenyl, or phenanthrenyl. The aryl substituents can generally include up to about 20 carbon atoms. The term "heteroatom-containing," as in a "heteroatom-containing cycloalkyl group," refers to a molecule or molecular fragment in which one or more carbon atoms is replaced with an atom other than carbon, *e.g.*, nitrogen, oxygen, sulfur, phosphorus, boron, or silicon. Similarly, the term "heteroaryl" refers to an aryl substituent that is heteroatom-containing. The term "substituted," as in "substituted aryls," refers to a molecule or molecular fragment in which at least one hydrogen atom bound to a carbon atom is replaced with one or more substituents that is/are a functional group(s) such as hydroxyl, alkoxy, alkylthio, phosphino, amino, halo, and silyl. Illustrative tertiary amines can include, but are not limited to, trimethylamine, triethylamine, triethanolamine, or any mixture thereof. Illustrative polymeric tertiary amines can include, but are not limited to, poly(*N*-methyldiallyl amine), poly(*N*-dimethylvinyl amine), copolymers of *N*-dimethylvinyl amine, or any mixture thereof.

[0029] Illustrative phosphates can be or include, but are not limited to, potassium phosphate, sodium phosphate, ammonium phosphate, or any mixture thereof. Illustrative bisulfites can include sodium bisulfite. Illustrative metabisulfites can be or include, but are not limited to, sodium metabisulfite, potassium metabisulfite, or a mixture thereof. Illustrative cyanamides can include, but are not limited to, cyanamide, calcium cyanamide, sodium hydrogen cyanamide, or any mixture thereof.

[0030] The amount of catalyst, if present in the free radical precursor, can widely vary. For example, the amount of catalyst in the mixture can be about 0.00001 wt%, about 0.0001 wt%, about 0.001 wt%, about 0.01 wt%, or about 0.1 wt% to about 0.5 wt%, about 1 wt%, about 3 wt%, about 5 wt%, about 10 wt%, or about 20 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of catalyst in the mixture can be about 0.01 wt% to about 1.5 wt%, about 0.1 wt% to about 1.3 wt%, about 0.05 wt% to about 0.5 wt%, about 0.07 wt% to about 0.4 wt%, or about 0.05 wt% to about 5 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of the catalyst in the mixture can be about 0.001 wt% to about 0.5 wt%, about 0.15 wt% to about 0.35 wt%, about 0.1 wt% to about 0.4 wt%, about 0.1 wt% to about 2 wt%, about 0.05 wt% to about 3 wt%, about 0.05 wt% to about 0.35 wt%, about 0.1 wt% to about 4.5 wt%, about 0.15 wt% to about 4 wt%, about 0.05 wt% to about 3 wt%, or about 0.01 wt% to about 3.5 wt%, based on the dry weight of the lignocellulose substrates.

[0031] The catalyst, if combined with a liquid medium, can have a total concentration of solids of about 0.001 wt% to about 99.9 wt%. In one example, if the catalyst is combined with a liquid medium, the catalyst and liquid medium mixture can have a concentration of solids of about 0.1 wt%, about 0.5 wt%, about 1 wt%, or about 2 wt% to about 4 wt%, about 5 wt%, about 6 wt%, about 7 wt%, or about 8 wt%, based on the combined weight of the catalyst and the liquid medium.

[0032] The oxidant, if present in the free radical precursor, can be or include any suitable oxidant or mixture of oxidants. The oxidant can be a solid, liquid, gas, or multi-phase. Illustrative oxidants can include, but are not limited to, inorganic and/or organic peroxy compounds, ozonides, halogen containing oxidants, or any mixture thereof. Illustrative inorganic peroxy compounds can include, but are not limited to, hydrogen peroxide, hydrogen peroxide generating compounds, *e.g.*, alkali metal salts of percarbonate, perborate, peroxysulfate, peroxyphosphate, and/or peroxysilicate, and/or corresponding weak acids. Illustrative organic peroxy compounds can include, but are not limited, to *t*-butyl peroxide, benzoyl peroxide, peroxy carboxylic acids, *e.g.*, peracetic acid and/or perbenzoic acid, hydroperoxides, *e.g.*, *t*-butyl hydroperoxide, isomers thereof, acids thereof, salts thereof, or any mixture thereof. Illustrative halogen containing oxidants can include, but are not limited to, alkali metal chlorite, alkali metal hypochlorite, chlorine dioxide, and/or a chloro sodium salt of cyanuric acid. An illustrative ozonide can include, but is not limited to,

dimethyldioxirane. An illustrative azo compound can include, but is not limited to, azobisisobutyronitrile (AIBN). The free radical precursor can be or include one or more inorganic oxidants. The free radical precursor can be or include one or more inorganic peroxy compounds. The free radical precursor can be or include hydrogen peroxide.

[0033] The oxidant can be combined with one or more liquid mediums. For example, the oxidant can be or include an aqueous solution of hydrogen peroxide. The concentration of oxidant, *e.g.*, hydrogen peroxide, combined with a liquid medium, *e.g.*, water, can be about 1 wt%, about 3 wt%, about 5 wt%, about 10 wt%, about 15 wt%, about 20 wt%, about 25 wt%, or about 30 wt% to about 50 wt%, about 60 wt%, about 70 wt%, about 80 wt%, about 90 wt%, or about 98 wt%, based on the combined weight of the oxidant and the liquid medium.

[0034] The amount of oxidant present in the mixture can depend, at least in part, on the particular oxidant, catalyst, lignocellulose substrates, and/or, the calcium lignosulfonate and, thus, can widely vary. For example, the amount of oxidant in the mixture can be about 1 wt% to about 200 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of oxidant in the mixture can be about 1 wt%, about 5 wt%, about 10 wt%, or about 20 wt% to about 80 wt%, about 100 wt%, about 120 wt%, or about 150 wt%, based on the dry weight of the lignocellulose substrates. In another example, the oxidant can be present in the mixture in an amount of about 0.1 wt% to about 30 wt%, about 1 wt% to about 20 wt%, about 5 wt% to about 50 wt%, about 10 wt% to about 70 wt%, about 0.5 wt% to about 25 wt%, about 3 wt% to about 6 wt%, or about 2 wt% to about 8 wt%, based on the dry weight of the lignocellulose substrates. In still another example, the oxidant can be present in the mixture in amount of about 0.1 wt% to about 10 wt%, about 1 wt% to about 12 wt%, about 2 wt% to about 9 wt%, about 3 wt% to about 9 wt%, about 5 wt% to about 15 wt%, about 4 wt% to about 6 wt%, about 8 wt% to about 20 wt%, or about 2 wt% to about 10 wt%, based on the dry weight of the lignocellulose substrates.

[0035] The amount of oxidant, if present as or as a component of the free radical precursor, that can remain present until the mixture is heated, *e.g.*, to a temperature of at least 60°C to about 300°C, can be at least at least 11%, at least 13%, at least 15%, at least 20%, at least 25%, at least 30%, at least 35%, at least 40%, at least 45%, at least 50%, at least 55%, at least 60%, at least 65%, or at least 70% of the amount of oxidant initially present in the mixture. In another example, the amount of the oxidant, if present in the free radical precursor, that can remain present until the mixture is heated, *e.g.*, to a temperature of about 60°C to about

300°C, can be about 11% to about 95%, about 15% to about 85%, about 20% to about 90%, about 30% to about 80%, about 11% to about 100%, about 35% to about 75%, about 40% to about 70%, or about 30% to about 95% of the amount of the oxidant initially present in the mixture.

[0036] The lignocellulose substrates can include any one or more of plant and vegetable materials. As used herein, the term "lignocellulose" refers to a material that includes lignin and cellulose, hemicellulose, or a mixture of cellulose and hemicelluloses. Illustrative plant and vegetable matter can include, but is not limited to, straw, hemp, sisal, cotton stalk, wheat, bamboo, sabai grass, rice straw, banana leaves, paper mulberry (*e.g.*, bast fiber), abaca leaves, pineapple leaves, esparto grass leaves, fibers from the genus *Hesperaloe* in the family Agavaceae jute, salt water reeds, palm fronds, flax, ground nut shells, recycled fiberboards such as high density fiberboard, medium density fiberboard, low density fiberboard, oriented strand board, particleboard, or any mixture thereof. For example, the plant matter can be or include wood, for example hardwoods, softwoods, or a mixture thereof. Illustrative types of wood can include, but are not limited to, alder, ash, aspen, basswood, beech, birch, cedar, cherry, cottonwood, cypress, elm, fir, gum, hackberry, hickory, maple, oak, pecan, pine, poplar, redwood, sassafras, spruce, sycamore, walnut, and willow.

[0037] The starting material, from which the lignocellulose substrates can be or can be derived from, can be shaped, reduced, or otherwise formed to the appropriate dimensions by various processes such as hogging, grinding, hammer milling, tearing, shredding, and/or flaking. Other processes for producing the substrates can include skiving, cutting, slicing, and/or sawing. Suitable forms of the lignocellulose substrates can include, but are not limited to, chips, flakes, wafers, fibers, powder, shavings, sawdust or dust, veneer, strands, and/or the like. Accordingly, the term "substrate" when used in conjunction with "lignocellulose" refers to lignocellulose material or lignocellulose containing material having any desired shape such as chips, flakes, fibers, powder, shavings, sawdust or dust, veneer, strands, and/or the like. Other suitable lignocellulose substrates can include, but are not limited to, wood chips, wood fibers, wood flakes, wood strands, wood wafers, wood shavings, wood particles, wood veneer, or any mixture thereof.

[0038] The particular configuration of the substrates can be based, at least in part, on the desired product. For example, particulates such as chips, fibers, shavings, sawdust or dust, or the like can be used for producing particleboards, fiberboards, and other board products. The

substrates can have a length of about 0.05 mm, about 0.1 mm, about 0.2 mm to about 1 mm, about 5 mm, about 10 mm, about 20 mm, about 30 mm, about 40 mm, about 50 mm, or about 100 mm. In another example, veneers, *e.g.*, layers or sheets of wood, can be used for producing plywood or laminated veneer lumber. The veneers can have a thickness of about 0.8 mm, about 0.9 mm, about 1 mm, about 1.1 mm or about 1.2 mm to about 3 mm, about 4 mm, about 5 mm, about 6 mm, about 7 mm, about 8 mm, about 9 mm, or about 10 mm.

[0039] The lignocellulose substrates can include liquid on, about, and/or within the substrates. For example, the lignocellulose substrates can have a liquid, *e.g.*, moisture, content of about 1 wt%, about 2 wt%, about 3 wt%, about 4 wt%, or about 5 wt% to about 7 wt%, about 9 wt%, about 11 wt%, about 13 wt%, about 15 wt%, about 17 wt%, about 19 wt%, about 21 wt%, about 23 wt%, about 25 wt%, about 27 wt%, about 29 wt%, about 31 wt%, about 33 wt%, about 35 wt%, or about 37 wt% based on a dry weight of the lignocellulose substrate. In another example, the lignocellulose substrates can have a liquid, *e.g.*, moisture, content of about 1 wt% to about 10 wt%, about 2 wt% to about 4 wt%, about 2 wt% to about 3 wt%, about 3 wt% to about 6 wt%, about 5 wt% to about 10 wt%, about 6 wt% to about 8 wt%, or about 4 wt% to about 9 wt%. The lignocellulose substrates can be fresh, *e.g.*, not treated or dried, or dried and/or treated. For example, the lignocellulose substrates and/or the starting material from which the lignocellulose substrates were derived can be at least partially dried. In another example, the lignocellulose substrates can be washed and/or leached with an aqueous medium such as water.

[0040] One or more compounds that include at least two hydrogen atoms that are abstractable in the presence of hydroxyl radicals can optionally be combined with the lignocellulose substrates, the calcium lignosulfonate, and the free radical precursor to produce the mixture. The optional compound having at least two hydrogen atoms that are abstractable in the presence of hydroxyl radicals can be or include, but is not limited to, one or more lignins, one or more tannins, one or more novolac resins, one or more modified phenol formaldehyde resins, bisphenol A, humic acids, or any mixture thereof. The optional compound having at least two hydrogen atoms that are abstractable in the presence of hydroxyl radicals can also be referred to as a "polyphenolic material." It should be noted that calcium lignosulfonate is also a compound having at least two hydrogen atoms that are abstractable in the presence of hydroxyl radicals or polyphenolic material. However, for the purposes of this disclosure the polyphenolic materials or compounds having at least two hydrogen atoms that are

abstractable in the presence of hydroxyl radicals discussed and described herein are intended to cover all compounds other than calcium lignosulfonate and are optional compounds that can be added to the mixture of the lignocellulose substrates, calcium lignosulfonate, and free radical precursor. If two or more polyphenolic materials are present, the two or more polyphenolic materials can be present in any amount with respect to one another.

[0041] The polyphenolic material can be combined simultaneously or in any order or sequence with respect to the lignocellulose substrates, the calcium lignosulfonate, and the free radical precursor to make the mixture. For example, the free radical precursor and, if present, the polyphenolic material can be combined with the lignocellulose substrates simultaneously. In another example, the free radical precursor can be combined with the lignocellulose substrates to produce a first mixture and then the calcium lignosulfonate and the optional polyphenolic material can be combined with the first mixture to produce the mixture. In another example, the polyphenolic material can be combined with the lignocellulose substrates to produce a first or partial mixture, and then the free radical precursor and the calcium lignosulfonate can be combined with the first or partial mixture to produce the mixture.

[0042] The polyphenolic material can be in a liquid form, a solid form, or both. The liquid form can include solutions, suspensions, slurries, dispersions, emulsions, inverse emulsions, or other liquid forms. In at least one example, a liquid form of the polyphenolic material can be a solution, *e.g.*, an aqueous solution. For example, one or more polyphenolic materials can be dissolved in one or more liquids to produce a solution. In at least one example, the liquid form of the polyphenolic material can be or include a solid polyphenolic material suspended, dispersed, or otherwise distributed within a liquid medium, *e.g.*, a suspension, slurry, or dispersion. In at least one other example, the liquid form of the polyphenolic material can be or can essentially be composed of one or more polyphenolic materials. Said another way, the polyphenolic material can be a liquid in the absence or substantial absence of any liquid medium as compared to being dissolved, dispersed, suspended, mixed, or otherwise combined with a liquid medium.

[0043] If the liquid form of the polyphenolic material includes a solid polyphenolic material dissolved, suspended, dispersed or otherwise distributed within a liquid medium, any suitable liquid medium or combination of liquid mediums can be used. Illustrative liquid mediums can be or include, but are not limited to, water, alcohols, glycols, acetonitrile, dimethyl

sulfoxide, *N,N*-dimethylformamide, *N*-methylpyrrolidone, or any mixture thereof. Suitable alcohols can include, but are not limited to, methanol, ethanol, propanol, isopropanol, butanol, or any mixture thereof. Suitable glycols can include, but are not limited to, ethylene glycol, propylene glycol, or a mixture thereof. As used herein, the terms "aqueous medium" and "aqueous liquid" are used interchangeably and can be or include water and/or mixtures composed of water and/or other water-miscible solvents. Illustrative water-miscible solvents can include, but are not limited to, alcohols, ethers, amines, or other polar aprotic solvents.

[0044] A polyphenolic material that includes a liquid medium can include about 0.1 wt%, about 1 wt%, about 3 wt%, about 5 wt%, about 10 wt%, about 20 wt%, about 30 wt%, about 40 wt%, about 43 wt%, or about 46 wt% to about 49 wt%, about 53 wt%, about 55 wt%, about 58 wt%, about 60 wt%, about 65 wt%, to about 70 wt%, about 80 wt%, about 90 wt%, about 95 wt% about 99 wt%, or about 99.9 wt% of polyphenolic material, based on the combined weight of the polyphenolic material and the liquid medium. For example, the polyphenolic material in the form of a liquid can include about 0.1 wt% to about 30 wt%, about 1 wt% to about 20 wt%, about 5 wt% to about 50 wt%, about 10 wt% to about 70 wt%, about 0.5 wt% to about 25 wt%, about 3 wt% to about 6 wt%, about 2 wt% to about 8 wt%, about 45 wt% to about 50 wt%, about 55 wt% to about 60 wt%, about 46 wt% to about 49 wt%, or about 56 wt% to about 59 wt% of the polyphenolic material, based on the combined weight of the polyphenolic material and the liquid medium. In another example, the polyphenolic material in the form of a liquid can include about 0.1 wt% to about 10 wt%, about 1 wt% to about 12 wt%, about 2 wt% to about 9 wt%, about 3 wt% to about 9 wt%, about 5 wt% to about 15 wt%, about 4 wt% to about 6 wt%, about 8 wt% to about 20 wt%, or about 2 wt% to about 10 wt% of the polyphenolic material, based on the combined weight of the polyphenolic material and the liquid medium.

[0045] In another example, a polyphenolic material in the form of a solution, *e.g.*, an aqueous solution, can include about 0.1 wt% to about 30 wt%, about 1 wt% to about 20 wt%, about 5 wt% to about 50 wt%, about 10 wt% to about 70 wt%, about 0.5 wt% to about 25 wt%, about 3 wt% to about 6 wt%, about 2 wt% to about 8 wt%, about 45 wt% to about 50 wt%, about 55 wt% to about 60 wt%, about 46 wt% to about 49 wt%, or about 56 wt% to about 59 wt% of the polyphenolic material, based on the combined weight of the polyphenolic material and the liquid medium. In another example, the polyphenolic material in the form of a solution can include about 0.1 wt% to about 10 wt%, about 1 wt% to about 12 wt%, about 2 wt% to

about 9 wt%, about 3 wt% to about 9 wt%, about 5 wt% to about 15 wt%, about 4 wt% to about 6 wt%, about 8 wt% to about 20 wt%, or about 2 wt% to about 10 wt% of the polyphenolic material, based on the combined weight of the polyphenolic material and the liquid medium.

[0046] Suitable solid polyphenolic materials can be in the form of a powder, flakes, granules, pellets, beads, or other solid particulate form. Polyphenolic materials in the form of a powder can have an average particle size of about 0.05 microns, about 0.1 micron, about 0.6 microns, about 1 micron, about 5 microns, about 7 microns or about 10 microns to about 115 microns, about 225 microns, about 350 microns, about 425 microns, or about 500 microns. In another example, the polyphenolic material can have an average particle size of about 0.3 microns to about 160 microns, about 22 microns to about 48 microns, about 35 microns to about 60 microns, about 50 microns to about 75 microns or about 70 microns to about 120 microns about 30 microns to about 70 microns, about 60 microns to about 150 microns, about 100 microns to about 200 microns, about 175 microns to about 325 microns, about 220 microns to about 400 microns, or about 385 microns to about 500 microns.

[0047] A liquid polyphenolic material, *e.g.*, an aqueous solution containing a polyphenolic material, can be dried via any suitable process or combination of processes to produce a solid polyphenolic material. Illustrative processes for producing the particulate binder composition can include, but are not limited to, spray-drying, freeze drying, drum drying, pulse combustion drying, vacuum drying, precipitation, air drying, and/or dry spinning. For example, the liquid polyphenolic material can be spray-dried to provide a particulate or otherwise solid polyphenolic material. The solid polyphenolic material can have a liquid, *e.g.*, moisture, content of less than 10 wt%, less than 8 wt%, less than 6 wt%, less than 5 wt%, less than 4 wt%, less than 3 wt%, less than 2 wt%, or less than 1 wt%.

[0048] If the polyphenolic material includes two or more polyphenolic materials, *e.g.*, a solid polyphenolic material and a liquid polyphenolic material, or two solid polyphenolic materials, or two liquid polyphenolic materials, the amount of each polyphenolic material can widely vary. For example, a polyphenolic material that includes a first polyphenolic material and a second polyphenolic can include about 1 wt% to about 99 wt% of the first polyphenolic material and conversely about 99 wt% to about 1 wt% of the second polyphenolic material, based on the total weight of the polyphenolic material, *e.g.*, the total weight of the first and second polyphenolic materials. In another example, the amount of the first polyphenolic

material can be about 5 wt%, about 10 wt%, about 15 wt%, about 20 wt%, about 25 wt%, about 30 wt%, about 35 wt%, about 40 wt%, or about 45 wt% to about 60 wt%, about 65 wt%, about 70 wt%, about 75 wt%, about 80 wt%, about 85 wt%, about 90 wt%, or about 95 wt%, based on the total weight of the first and second polyphenolic materials.

[0049] Lignin is a polymeric substance that can include substituted aromatics found in plant and vegetable matter associated with cellulose and other plant constituents discussed and described above. The lignin can be extracted, separated, or otherwise recovered from the wood, plant, and/or vegetable matter using any of a number of well-established processes. For example, in the pulp and paper industry, lignin-containing materials such as wood, straw, corn stalks, bagasse, and other vegetable and plant tissues can be processed to recover the cellulose or pulp via the well-known sulfate (kraft) process and/or sulfite process. The residual pulping liquors that include the lignin as a byproduct can be a source of lignin. The lignin recovered from the kraft and/or sulfite processes can be used as a source of lignin. The chemical structure of lignin can vary and the variation can depend, at least in part, on the particular plant from which the lignin is recovered from, location the plant was grown, and/or on the particular method used in recovery or isolation of the lignin from the plant and/or vegetable matter. Lignin can include active groups, such as active hydrogens and/or phenolic hydroxyl groups through which crosslinking or bridging can be effected.

[0050] One process for recovering lignin can be or include the process commonly referred to as the organosolv process. The organosolv process uses an organic solvent to solubilize lignin and hemicelluloses. The organosolv process can include contacting lignocellulose material, *e.g.*, wood chips or particles, with an aqueous organic solvent at a temperature of about 130°C, about 140°C, or about 150°C to about 200°C, about 220°C, or about 230°C. The lignin can break down by hydrolytic cleavage of alpha aryl-ether links into fragments that can be solubilized in the solvent system. Illustrative solvents can include, but are not limited to, acetone, methanol, ethanol, butanol, ethylene glycol, formic acid, acetic acid, or any mixture thereof. The aqueous organic solvent can have a concentration of the solvent in water of about 30 wt%, about 40 wt% or about 50 wt% to about 70 wt%, about 80 wt%, or about 90 wt%.

[0051] Since the lignin separated from the plant can be chemically altered from that found in the plant, the term "lignin," can also refer to lignin products obtained upon separation from the cellulose or recovered from the plant matter. For example, in a sulfite pulping process,

the lignocellulose material can be digested with a bisulfite or sulfite resulting in the at least partial sulfonation of the lignin. As such, the lignin can optionally be subjected to further cleavage and/or other modifications such as alkaline treatment or reaction with other constituents to decrease the sulfonate or sulfur content and/or increase the active groups. For example, the lignin can be processed such that the lignin has a phenolic hydroxyl content of about 1.5 wt% to about 5 wt% and a sulfonate or sulfur content of less than 3 wt%. In other methods of recovery or separation of lignin from wood, plant, or vegetable material, the lignin may not be sulfonated, but could be chemically altered somewhat in some other manner. For example, in residual pulping liquors obtained in sulfate or other alkaline pulping processes, the lignin can be present as an alkali metal salt dissolved in the alkaline, aqueous liquor and can generally include a sufficient phenolic hydroxyl content to require no further modification. However, the alkali or kraft lignin can be further reacted with other constituents to further increase the active groups. "Hydrolysis lignin" that can be recovered from the hydrolysis of lignocellulose materials in the manufacture of sugar, for example, can also be altered somewhat from that found in the plant. As such hydrolysis lignin can be further modified to solubilize the lignin as well as to increase the phenolic hydroxyl content. Also, the lignin products such as residual pulping liquor may be subjected to various treatments such as, for example, acid, alkaline or heat treatments or reacted with the other chemicals which may further alter somewhat the lignin constituents.

[0052] The residual pulping liquors or the lignin products produced in the separation or recovery of lignin from the plant matter can include lignin of various weight average molecular weights (MW) of about 300 to over 100,000. For example, the lignin can have a MW of about 500, about 1,000, about 5,000, about 10,000, about 15,000, or about 20,000 to about 30,000, about 45,000, about 55,000, about 70,000, about 80,000, about 85,000, about 90,000, or about 95,000. In another example, the lignin can have a MW of about 300, about 500, about 800, about 900, about 1,000, or about 1,100 to about 1,300, about 1,500, about 1,900, about 2,300, about 2,500, about 2,700, about 3,000, about 3,300, about 3,500, about 3,700, about 4,000, about 4,300, about 4,500, about 4,700, or about 5,000. In another example, the lignin can have a MW about 500 to about 30,000, about 1,000 to about 15,000, about 800 to about 6,000, about 2,000 to about 12,000, about 400 to about 10,000, or about 600 to about 8,000. In another example, the MW of the lignin can be about 600 to about

4,500, about 350 to about 1,100, about 750 to about 2,500, about 950 to about 3,100, about 1,500 to about 3,400, or about 1,800 to about 4,200.

[0053] The liquors from which the lignin can be recovered can also include one or more other constituents in addition to the lignin. For example, in the sulfite pulping process, the spent sulfite liquor can include lignosulfonates that can be present as salts of cations, such as calcium. The spent sulfite liquor solids can include about 40 wt% to about 65 wt% lignosulfonates with the remainder being carbohydrates and other organic and inorganic constituents dissolved in the liquor. Lignin products produced by other pulping processes can also include other materials such as carbohydrates, degradation products of carbohydrates, and resinous materials which are separated from the cellulosic materials with the lignin. It should be noted that it is not necessary to separate the lignin from the other constituents that can be present.

[0054] One or more additional lignin materials in addition to the calcium lignosulfonate can also be combined with the plurality of lignocellulose substrates and the free radical precursor. Illustrative additional lignosulfonate materials can include, but are not limited to, ammonium lignosulfonate, sodium lignosulfonate, magnesium lignosulfonate, or any mixture thereof. The mixture can be substantially free of ammonium lignosulfonate, sodium lignosulfonate, and/or magnesium lignosulfonate. For example, as used herein, the term "substantially free of ammonium lignosulfonate" means the mixture contains less than 10 wt%, less than 9.5 wt%, less than 9 wt%, less than 8.5 wt%, less than 8 wt%, less than 7 wt%, less than 6 wt%, less than 5 wt%, less than 4 wt%, less than 3 wt%, less than 2 wt%, less than 1 wt%, less than 0.5 wt%, less than 0.1 wt%, less than 0.05 wt%, less than 0.01 wt%, less than 0.005 wt%, or less than 0.001 wt%, or less than 0.0005 wt% of ammonium lignosulfonate, based on a total solids weight of the mixture. In at least one example, the mixture can be free from ammonium lignosulfonate. Said another way, the mixture can contain no ammonium lignosulfonate. Similarly, the mixture can be substantially free of or free of sodium lignosulfonate and/or magnesium lignosulfonate.

[0055] Suitable processes for isolating or otherwise separating lignin or lignin containing products from wood, plant, vegetable, or other lignin containing matter can include those discussed and described in U.S. Patent Nos.: 1,856,567; 2,525,433; 2,680,113; 2,690,973; 3,094,515; 3,158,520; 3,503,762; 3,585,104; 3,726,850; 3,769,272; 3,841,887; 4,100,016; 4,131,564; 4,184,845; 4,308,203; 4,355,996; 4,470,876; 4,740,591; and 4,764,596; U.S.

Patent Application Publication Nos.: 2011/0294991; and WO Publication Nos. WO1992/018557A1, WO1993/021260A2; WO1994/024192A1; WO2005/062800A2; WO2006/031 175 A1; and WO2011/150508. Commercially available lignin can include, but is not limited to, lignosulfonates available from Tembec (Canada) and/or Borregaard. For example, a suitable powdered ammonium lignosulfonate can include ARBO[®] A02P and a suitable liquid ammonium lignosulfonate can include ARBO[®] A02L, both available from Tembec.

[0056] As used herein, the term "tannin" refers to both hydrolyzable tannins and condensed tannins. As such, the polyphenolic material can be or include hydrolyzable tannins, condensed tannins, or a mixture of hydrolyzable tannins and condensed tannins. Illustrative genera of shrubs and/or trees from which suitable tannins can be derived can include, but are not limited to, *Acacia*, *Castanea*, *Vachellia*, *Senegalia*, *Terminalia*, *Phyllanthus*, *Caesalpinia*, *Quercus*, *Schinopsis*, *Tsuga*, *Rhus*, *Juglans*, *Carya*, and *Pinus*, or any mixture thereof. In another example, genera from which suitable tannins can be derived can include, but are not limited to, *Schinopsis*, *Acacia*, or a mixture. In another example, genera from which suitable tannins can be derived can include, but are not limited to, *Pinus*, *Carya*, or a mixture thereof.

[0057] Hydrolyzable tannins are mixtures of simple phenols such as pyrogallol and ellagic acid and of esters of a sugar, e.g., glucose, with gallic and digallic acids. Illustrative hydrolyzable tannins can include, but are not limited to, extracts recovered from *Castanea sativa*, (e.g., chestnut), *Terminalia* and *Phyllanthus* (e.g., myrabalans tree species), *Caesalpinia coriaria* (e.g., divi-divi), *Caesalpinia spinosa*, (e.g., tara), algarobilla, valonea, and *Quercus* (e.g., oak). Condensed tannins are polymers formed by the condensation of flavans. Condensed tannins can be linear or branched molecules. Illustrative condensed tannins can include, but are not limited to *Acacia mearnsii* (e.g., wattle or mimosa bark extract), *Schinopsis* (e.g., quebracho wood extract), *Tsuga* (e.g., hemlock bark extract), *Rhus* (e.g., sumach extract), *Juglans* (e.g., walnut), *Carya illinoensis* (e.g., pecan), and *Pinus* (e.g., Radiata pine, Maritime pine, bark extract species).

[0058] The condensed tannins typically include about 70 wt% to about 80 wt% active phenolic ingredients (the "tannin fraction") and the remaining ingredients (the "non-tannin fraction") typically include, but are not limited to, carbohydrates, hydrocolloid gums, and amino and/or imino acid fractions. The condensed tannins can be used as recovered or extracted from the organic matter or the condensed tannins can be purified, e.g., about 95

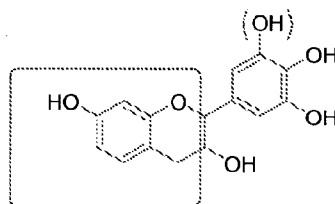
wt% or more active phenolic ingredients. Hydrolyzable tannins and condensed tannins can be extracted from the starting material, *e.g.*, trees and/or shrubs, using well-established processes. A more detailed discussion of tannins is discussed and described in the Handbook of Adhesive Technology, Second Edition, CRC Press, 2003, Chapter 27, "Natural Phenolic Adhesives I: Tannin," and in Monomers, Polymers and Composites from Renewable Resources, Elsevier, 2008, Chapter 8, "Tannins: Major Sources, Properties and Applications."

[0059] The condensed tannins can be classified or grouped into one of two main categories, namely, those containing a resorcinol unit and those containing a phloroglucinol unit. Illustrative tannins that include the resorcinol unit include, but are not limited to, black wattle tannins and quebracho tannins. The resorcinol unit can be represented by Formula I below.



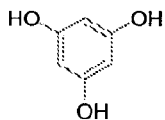
Formula I,

[0060] The resorcinol group is shown within the box overlaying the unit structure of black wattle and quebracho tannins in formula II below. For simplicity, the structure of black wattle and quebracho tannins is represented by their flavonoid unit structure.



Formula II,

[0061] Illustrative tannins that include the phloroglucinol unit include, but are not limited to, pecan tannins and pine tannins. The phloroglucinol unit can be represented by Formula III below.

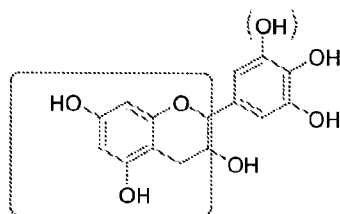


Formula III,

[0062] The phloroglucinol unit is shown within the box overlaying the unit structure of pecan and pine tannins in Formula IV below. For simplicity, the structure of pecan and pine tannins is represented by their flavonoid unit structure.

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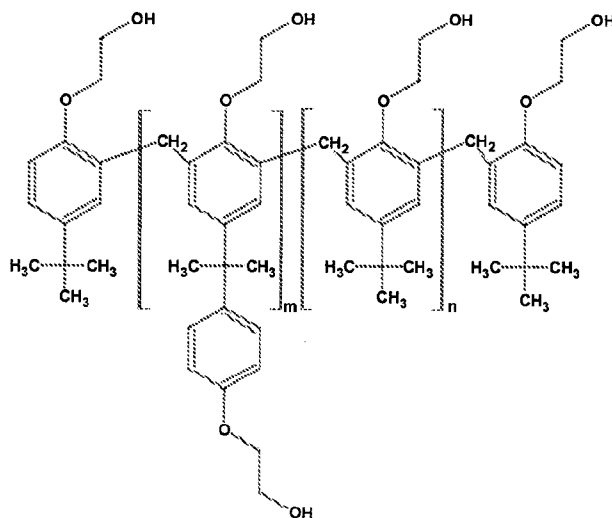


Formula IV,

[0063] Phloroglucinol is known for higher reactivity than resorcinol. As such, tannins that include the phloroglucinol unit are more reactive than tannins that include the resorcinol unit.

[0064] The tannins can have an acidic pH. For example, the pH of the tannins can be about 3, about 3.5, or about 4 to about 5, about 5.5, about 6, or about 6.5. The tannins can have resorcinol and/or phloroglucinol functional groups. Suitable, commercially available tannins can include, but are not limited to, black wattle tannin, quebracho tannin, hemlock tannin, sumach tannins, pecan tannin, mimosa tannin, pine tannins, or any mixture thereof.

[0065] Illustrative modified phenol formaldehyde resins can include ARYLZENE[®], which can be represented by the general Formula V:

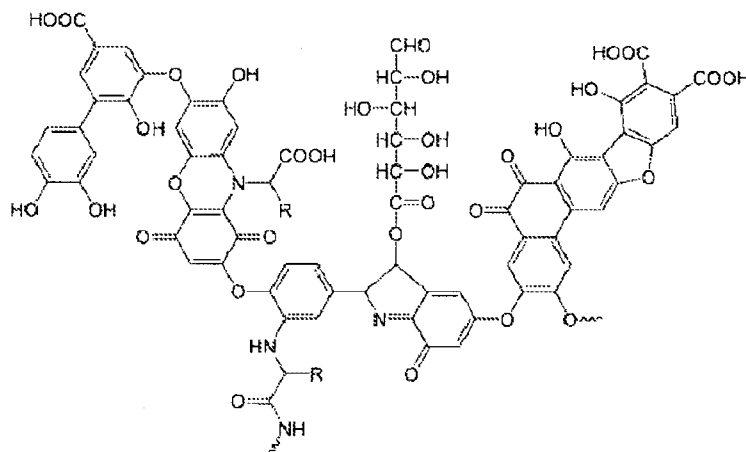


where $n = 3$ and $0.8 < m < 1.5$

Formula V,

[0066] Other illustrative modified phenol formaldehyde resins can be or include those discussed and described in U.S. Patent Nos.: 5,674,970; 5,739,259; 5,756,642; 5,756,655; 5,770,750; 5,773,552; 5,837,798; 5,889,137; 6,166,151; 6,291,077; 6,399,740; and 6,569,953.

[0067] Humic acid can be represented by the general Formula VI:



Formula VI,

[0068] where R can be hydrogen or any organic or other chemical group.

[0069] The novolac resin can be produced by reacting a phenolic component or compound with an aldehyde component or aldehyde compound(s) in the presence of an acid catalyst. The phenolic component of the novolac resin can include a variety of substituted phenolic compounds, unsubstituted phenolic compounds, or any combination of substituted and/or unsubstituted phenolic compounds. For example, the phenolic component can be mono-hydroxy benzene (phenol). Examples of substituted phenolic components can include, but are not limited to, alkyl-substituted phenols, such as the cresols and xylenols; cycloalkyl-substituted phenols, such as cyclohexyl phenol; alkenyl-substituted phenols; aryl-substituted phenols, such as *p*-phenyl phenol; alkoxy-substituted phenols, such as 3,5-dimethoxyphenol; aryloxy phenols, such as *p*-phenoxy phenol; halogen-substituted phenols, such as *p*-chlorophenol, isomers thereof, or derivatives thereof. Specific examples of suitable phenolic component or compound used in preparing and incorporated in a novolac resin can include, but are not limited to, bisphenol A, bisphenol F, catechol, resorcinol, hydroquinone, *o*-cresol, *m*-cresol, *p*-cresol, 2,6-xyleneol, 2,5-xyleneol, 2,4-xyleneol, 2,3-xyleneol, 3,5-xyleneol, 3,4-xyleneol, 3,4,5-trimethylphenol, 3-ethyl phenol, 3,5-diethyl phenol, *p*-butyl phenol, 3,5-dibutyl phenol, *p*-amyl phenol, *p*-cyclohexyl phenol, *p*-octyl phenol, 3,5-dicyclohexyl phenol, *p*-phenyl phenol, *p*-phenol, 3,5-dimethoxy phenol, 3,4,5-trimethoxy phenol, *p*-ethoxy phenol, *p*-butoxy phenol, 3-methyl-4-methoxy phenol, *p*-phenoxy phenol, naphthol, anthranol, substituted derivatives thereof, isomers thereof, or any mixture thereof. In one example,

about 80 wt% or greater, about 90 wt% or greater, or about 95 wt% or greater of the phenolic component includes phenol (mono-hydroxy benzene).

[0070] Illustrative aldehyde compounds can include the so-called masked aldehydes or aldehyde equivalents, such as acetals or hemiacetals. Suitable aldehydes can be represented by the general Formula $R''CHO$, where R'' is a hydrogen or a hydrocarbon group generally having 1 carbon atom to about 8 carbon atoms. Specific examples of suitable aldehyde compounds can include, but are not limited to, formaldehyde, acetaldehyde, propionaldehyde, butyraldehyde, furfuraldehyde, benzaldehyde, or any mixture thereof. As used herein, the term "formaldehyde" can refer to formaldehyde, formaldehyde derivatives, other aldehydes, or mixtures thereof. In one example, the aldehyde component can be formaldehyde. One or more difunctional aldehydes can also be used to produce the novolac resin, and could advantageously be used to introduce cross-links ultimately into the at least partially cured novolac resin.

[0071] The aldehyde can be used in many forms such as solid, liquid, and/or gas. Considering formaldehyde in particular, the formaldehyde can be or include paraform (solid, polymerized formaldehyde), formalin solutions (aqueous solutions of formaldehyde, sometimes with methanol, in 37%, 44%, or 50% formaldehyde concentrations), urea-formaldehyde concentrate ("UFC"), and/or formaldehyde gas in lieu of or in addition to other forms of formaldehyde can also be used. In another example, the aldehyde can be or include a pre-reacted urea-formaldehyde mixture having a urea to formaldehyde weight ratio of about 1:2 to about 1:3.

[0072] A molar ratio of formaldehyde to phenol used to produce the novolac resin can be about 0.5 to about 0.95 or about 0.7 to about 0.85. The reaction between the phenol and the formaldehyde to produce the novolac resin can be carried out in the presence of an acid catalyst under acidic conditions. Suitable acid catalysts can include, but are not limited to, oxalic acid, sulfuric acid, *p*-toluene sulfuric acid, hydrochloric acid, salicylic acid, mineral acids and salts thereof, or any mixture thereof. Mixed catalyst systems, such as ZnOAc/oxalic acid and other divalent metal compounds, *e.g.*, acetates, can be used to prepare "high-ortho" novolac resins. Divalent metal compounds can include calcium, magnesium, zinc, cadmium, lead, copper, cobalt, nickel, and iron. In some examples, the catalysts can include oxalic acid, sulfuric acid, *p*-toluene sulfonic acid, and/or ZnOAc/oxalic acid.

[0073] The amount of acid catalyst used to produce the novolac resin can be sufficient to catalyze the reaction between the phenol and formaldehyde to produce the novolac resin. The phenol/formaldehyde reaction can be conducted in about 1 hour to about 6 hours, *e.g.*, in about 2 hours to about 4 hours. The phenol/formaldehyde reaction can be carried out at a temperature of about 80°C to about 100°C, *e.g.*, about 95°C to about 100°C. The reaction can be carried out at atmospheric pressure, although increased pressure can be utilized to permit the application of higher temperatures and, therefore, faster reaction rates and accordingly shorter reaction times.

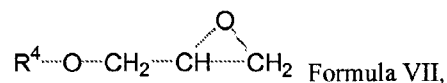
[0074] The novolac resin can be treated to remove water and/or other volatile organic materials by heating, such as by distillation. After this treatment, the free phenol can be about 0.001% to about 2.0%, or about 0.001% to about 0.5%. Distillation of the resulting novolac resin can be performed at atmospheric pressure by heating up to about 140°C, and then under a vacuum until the resin reaches a temperature of about 180°C to about 220°C. Other suitable methods for treating the resin via heat can include thin-film evaporators. The resulting molten novolac resin can be cooled to a temperature below about 100°C.

[0075] If desired, the novolac resin can be neutralized. Neutralization of the novolac resin can be accomplished by the addition of one or more bases or base compounds, such as sodium hydroxide and/or potassium hydroxide, or its equivalent. The base compound can be added in an amount sufficient to raise the pH of the novolac resin to between about 5 to about 9, *e.g.*, about 6 to about 8. Typically, about 10 wt% to about 30 wt% of water, based on the total resin solids, can be added. Suitable novolac resins and inverted novolac resins can be as discussed and described in U.S. Patent No. 5,670,571 and U.S. Patent Application Publication No. 2008/0280787.

[0076] Any one or more of the polyphenolic materials can be modified with one or more compounds having one or more carbon-carbon double bonds and one or more reactive functional groups. For example, the mixture can include one or more modified polyphenolic materials produced by at least partially reacting one or more unsaturated monomers having one or more reactive functional groups with the polyphenolic material, *e.g.*, the lignin, tannin, novolac resin, modified phenol formaldehyde resin, bisphenol A, and/or humic acid. Any suitable compounds having one or more carbon-carbon double bonds and one or more reactive functional groups or mixtures of compounds having one or more carbon-carbon double bonds and one or more reactive functional groups can be used to produce the modified

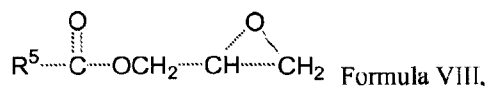
polyphenolic material. In some examples, the compounds having one or more carbon-carbon double bonds and one or more reactive functional groups are nonionic. Illustrative compounds having one or more carbon-carbon double bonds and one or more reactive functional groups can include, but are not limited to, one or more unsaturated glycidyl ethers, one or more unsaturated glycidyl esters, one or more unsaturated mono-epoxides, one or more unsaturated methylol compounds, maleic anhydride, or any mixture thereof. It should be noted that the calcium lignosulfonate can be modified with one or more compounds having one or more carbon-carbon double bonds and one or more reactive functional groups similar to the polyphenolic materials.

[0077] Illustrative unsaturated glycidyl ethers can be represented by general formula VII:



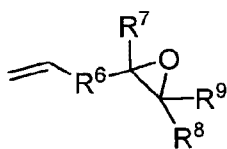
[0078] where R^4 can be an ethylenically unsaturated radical such as vinyl, allyl, or alkenyl. Suitable glycidyl ethers can include, but are not limited to, vinyl glycidyl ether, isopropenyl glycidyl ether, oleyl glycidyl ether, allyl glycidyl ether, p-vinylbenzyl glycidyl ether, o-allyl phenyl glycidyl ether, butenyl glycidyl ether, 4-vinylcyclohexyl glycidyl ether, abietylglycidyl ether, cyclohexenylmethyl glycidyl ether, methallyl glycidyl ether, or any mixture thereof.

[0079] Illustrative unsaturated glycidyl esters can be represented by general formula VIII:

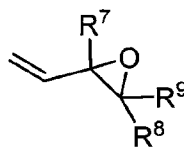


[0080] where R^5 can be an unsaturated, unsubstituted alkyl radical having 2 carbon atoms to about 19 carbon atoms. Suitable glycidyl esters can include, but are not limited to, glycidyl methacrylate, glycidyl acrylate, glycidyl crotonate, glycidyl oleate, di-glycidyl maleate, di-glycidyl fumarate, or any mixture thereof.

[0081] Illustrative unsaturated mono-epoxides can include, but are not limited to, linear or cycloaliphatic epoxy compounds, where the unsaturation is terminal. Suitable unsaturated mono-epoxides can be represented by general Formulas IXa and IXb:



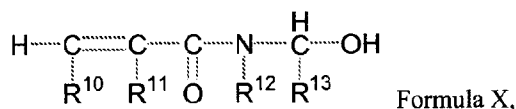
Formula IXa and



Formula IXb,

[0082] where R^6 can be an alkylene, an alkanediyl, or an alkanetriyl, optionally containing alkyl pendant groups; R^7 , R^8 , and R^9 can independently be hydrogen, alkyl straight, branched, or cyclic, or any two of R^6 , R^7 , R^8 , or R^9 can be alkylene, alkanediyl, or alkanetriyl, and combined to form a cyclic ring of 4 carbon atoms to about 12 carbon atoms, optionally containing alkyl pendants; and the number of carbon atoms in R^6 , R^7 , R^8 , and R^9 can be such that the total number of carbon atoms in the epoxide can be 4 to about 50. Illustrative alkylenes that can be used as R^6 , R^7 , R^8 , or R^9 can include, but are not limited to, methylene, ethylene, propylene, or butylene. In some examples, R^6 and R^8 , R^6 and R^9 , R^7 and R^8 , or R^7 and R^9 can form a cyclic ring of 4 carbon atoms to about 12 carbon atoms, such as, for example, cyclopentene, cyclohexene, cycloheptene, or cyclooctene. Suitable unsaturated mono-epoxides can include, but are not limited to, 4-vinyl cyclohexene oxide, 1-methyl-4-isopropenyl cyclohexene oxide, butadiene monoxide, any combination thereof, or any mixture thereof.

[0083] Illustrative unsaturated methylol compounds can be represented by the general formula X:



Formula X,

[0084] where R^{10} , R^{11} , R^{12} , and R^{13} can independently be hydrogen or a hydrocarbyl group, *e.g.*, an alkyl group, containing about 1 carbon atom to about 6 carbon atoms. For example, an alkyl group can include 1 carbon atom to about 4 carbon atoms. In at least one example, R^{10} , R^{11} , R^{12} , and R^{13} can each independently be methyl or hydrogen. Suitable unsaturated methylol compounds can include, but are not limited to, *N*-methylol acrylamide, *N*-methylol methacrylamide, *N*-methylol crotonamide, or any mixture thereof. The *N*-methylol ethylenically unsaturated amide can be in the form of an aqueous solution.

[0085] In at least one example, the modified polyphenolic material can be free or essentially free of any anionic monomers. For example, the modified polyphenolic material can contain less than 3 wt%, less than 2.5 wt%, less than 2 wt%, less than 1.5 wt%, less than 1 wt%, less

than 0.7 wt%, less than 0.5 wt%, less than 0.3 wt%, less than 0.1 wt%, less than 0.05 wt%, or less than 0.01 wt% anionic monomers. In at least one example, the modified polyphenolic material can be free or essentially free of any ionic monomers. For example, the modified polyphenolic material can contain less than 3 wt%, less than 2.5 wt%, less than 2 wt%, less than 1.5 wt%, less than 1 wt%, less than 0.7 wt%, less than 0.5 wt%, less than 0.3 wt%, less than 0.1 wt%, less than 0.05 wt%, or less than 0.01 wt% ionic monomers. In at least another example, the modified polyphenolic material can be free or essentially free of any anionic and ionic monomers. For example, the modified polyphenolic material can contain less than 3 wt%, less than 2.5 wt%, less than 2 wt%, less than 1.5 wt%, less than 1 wt%, less than 0.7 wt%, less than 0.5 wt%, less than 0.3 wt%, less than 0.1 wt%, less than 0.05 wt%, or less than 0.01 wt% anionic and ionic monomers. As used herein, the terms "essentially free of anionic monomers" and "essentially free of ionic monomers" means the modified polyphenolic material does not include any intentionally added anionic monomers or ionic monomers, respectively. Said another way, the terms "essentially free of anionic monomers" and "essentially free of ionic monomers" means the modified polyphenolic material may include anionic monomers and/or ionic monomers present as an impurity.

[0086] The amount of the polyphenolic material, if present in the mixture, can widely vary. For example, the amount of the polyphenolic material in the mixture can be about 0.01 wt% to about 50 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of the polyphenolic material in the mixture can be about 0.05 wt%, about 0.1 wt%, about 0.5 wt%, about 1 wt%, about 2 wt%, about 3 wt%, about 5 wt%, or about 7 wt% to about 15 wt%, about 20 wt%, about 25 wt%, or about 30 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of the polyphenolic material in the mixture can be about 0.1 wt%, about 0.5 wt%, about 1 wt%, about 3 wt%, or about 5 wt% to about 10 wt%, about 13 wt%, about 15 wt%, about 17 wt%, or about 20 wt%, based on the dry weight of the lignocellulose substrates. In another example, the amount of the polyphenolic material in the mixture can be about 1 wt% to about 15 wt%, about 5 wt% to about 15 wt%, about 8 wt% to about 13 wt%, about 7 wt% to about 12 wt%, or about 5 wt% to about 25 wt%, based on the dry weight of the lignocellulose substrates.

[0087] One or more unsaturated compounds can optionally be combined with the lignocellulose substrates, the calcium lignosulfonate, and the free radical precursor, and, if

present, the optional polyphenolic material to produce the mixture. As used herein, the terms "unsaturated compound" and "reactive unsaturated compound" are used interchangeably and refer to compounds having two or more unsaturated carbon-carbon bonds, where at least one of the unsaturated carbon-carbon bonds is capable of free radical addition. As used herein, the phrase "capable of free radical addition" when used in conjunction with "unsaturated compound" means that the carbon-carbon double bond is a pi-bond (π -bond) that is not conjugated with an aromatic moiety and is capable of going through a free radical chain reaction mechanism. The free radical chain mechanism can include an initiation step, a propagation step, and a termination step. In one or more examples, the unsaturated carbon-carbon bond capable of free radical addition can be an alkene conjugated with a carbonyl group in an α,β -unsaturated carbonyl compound. The α,β -unsaturated carbonyl compound can include, but is not limited to, an aldehyde, a ketone, a carboxylic acid, an ester, an amide, an acyl halide, an acid anhydride, or an imide. For example, the α,β -unsaturated carbonyl compound can be, but is not limited to, an α,β -unsaturated aldehyde (e.g., an enal), an α,β -unsaturated ketone (e.g., an enone), an α,β -unsaturated carboxylic acid, an α,β -unsaturated ester, an α,β -unsaturated amide, an α,β -unsaturated acyl halide, an α,β -unsaturated acid anhydride, or an α,β -unsaturated imide. In one or more examples, the unsaturated compound can be substantially free or completely free from any aromatic moiety.

[0088] If the mixture includes the optional unsaturated compound, the amount of the unsaturated compound combined with the plurality of lignocellulose substrates, the calcium lignosulfonate, and the free radical precursor can widely vary. For example, a weight ratio of the unsaturated compound to the free radical precursor in the mixture can be about 0.02:1, about 0.025:1, about 0.05:1, about 0.1:1, about 0.3:1, about 0.5:1, about 0.7:1, or about 1:1 to about 2:1, about 2.5:1, about 3:1, about 3.5:1, about 4:1, about 4.5:1, about 5:1, about 6:1, about 7:1, about 8:1, about 9:1, or about 10:1. In another example, the weight ratio of the unsaturated compound to the free radical precursor can be about 0.025:1 to about 10:1, about 0.1:1 to about 7.5:1, about 0.5:1 to about 5:1, about 0.3:1 to about 2.5:1, about 0.5:1 to about 1.5:1, about 3:1 to about 7:1, about 4:1 to about 6:1, about 6:1 to about 10:1, or about 0.3:1 to about 5.5:1. In another example, the weight ratio of the unsaturated compound to the free radical precursor can be at least 0.02:1, at least 0.025:1, at least 0.3:1, at least 0.35:1, at least 0.4:1, at least 0.45:1, at least 0.5:1, at least 0.6:1, at least 0.65:1, at least 0.7:1, at least 0.75:1, at least 0.8:1, at least 0.85:1, at least 0.9:1, at least 0.95:1, or at least 1:1 to about 3:1, about

4:1, about 5:1, about 6:1, about 7:1, about 8:1, about 9:1, or about 10:1. In yet another example, the weight ratio of the unsaturated compound to the free radical precursor can be about 0.125:1 to about 5:1, about 0.5:1 to about 3:1, about 1.5:1 to about 2.9:1, about 2:1 to about 4:1, or about 2.1:1 to about 4.5:1.

[0089] If the mixture includes the optional unsaturated compound, the amount of the unsaturated compound in the mixture can be about 1 wt%, about 2 wt%, about 2.5 wt%, about 5 wt%, about 10 wt%, about 15 wt%, about 20 wt%, about 25 wt%, about 30 wt%, or about 35 wt% to about 60 wt%, about 65 wt%, about 70 wt%, about 75 wt%, about 80 wt%, about 85 wt%, about 90 wt%, about 95 wt%, about 97 wt%, about 98 wt%, about 99 wt%, or about 99.5 wt%, based on the combined weight of the unsaturated compound and the free radical precursor. For example, the amount of the unsaturated compound in the mixture can be about 10 wt% to about 85 wt%, about 30 wt% to about 83 wt%, about 25 wt% to about 65 wt%, about 40 wt% to about 85 wt%, about 35 wt% to about 75 wt%, about 20 wt% to about 40 wt%, about 30 wt% to about 50 wt%, about 40 wt% to about 60 wt%, about 50 wt% to about 70 wt%, or about 70 wt% to about 90 wt%, based on the combined weight of the unsaturated compound and the free radical precursor. In another example, the amount of the unsaturated compound in the mixture can be at least 3 wt%, at least 5 wt%, at least 10 wt%, at least 15 wt%, at least 20 wt%, at least 25 wt% at least 20 wt%, at least 35 wt%, at least 40 wt%, or at least 45 wt% to about 50 wt%, about 55 wt%, about 60 wt%, about 65 wt%, about 70 wt%, about 75 wt%, about 80 wt%, about 85 wt%, about 90 wt%, or about 95 wt%, based on the combined weight of the unsaturated compound and the free radical precursor. In another example, the amount of the unsaturated compound in the binder composition can be less than 95 wt%, less than 90 wt%, less than 85 wt%, less than 80 wt%, less than 75 wt%, less than 70 wt%, less than 60 wt%, less than 55 wt%, less than 50 wt%, less than 45 wt%, or less 40 wt% and greater than 2 wt%, greater than 5 wt%, greater than 10 wt%, greater than 15 wt%, greater than 20 wt%, or greater than 25 wt%, based on the combined weight of the unsaturated compound and the free radical precursor.

[0090] If the mixture includes the optional unsaturated compound, the unsaturated compound can be or include, but is not limited to, dicyclopentadiene (DCPD), 4-vinylcyclohexene, one or more vinyl ethers, one or more allyl ethers, diallyl phthalate, allyl crotonate, allyl cinamate, allyl methacrylate, vinyl methacrylate, ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate,

trimethylethane triacrylate (TMPTA), poly(ethylene glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate (TMPTA), pentaerythritol tetraacrylate, pentaerythritol triacrylate, polyacrylate, one or more conjugated dienes, one or more terpenes, one or more drying oils having an iodine number of about 115 or greater, one or more unsaturated prepolymers, one or more polyesters with one or more incorporated vinyl unsaturations, styrene-butadiene rubber (SBR), one or more starches having at least one unsaturated and polymerizable olefinic group, polymers derived from ring-opening polymerization of allyl caprolactone, a product or products formed by reacting one or more polyamidoamines and one or more unsaturated glycidyl ethers, isomers thereof, acids thereof, salts thereof, hydrates thereof, or any mixture thereof.

[0091] In one or more examples, the unsaturated compound can have a double bond equivalent molecular weight of about 33, about 50, about 100, about 150, about 200, about 500, about 1,000, about 5,000, about 10,000, or about 15,000 to about 50,000, about 75,000, about 100,000, about 150,000, about 200,000, or about 250,000. In one or more examples, the unsaturated compound can have a double bond equivalent molecular weight of at least 33, at least 40, at least 45, at least 50, at least 75, at least 100, at least 200, at least 300, at least 400, at least 500, at least 1,000, at least 2,500, at least 5,000, at least 10,000, at least 20,000, at least 30,000, at least 40,000, at least 50,000, at least 60,000, at least 70,000, at least 80,000, at least 90,000, at least 100,000, at least 110,000, at least 120,000, at least 130,000, at least 140,000, or at least 150,000 to about 175,000, about 200,000, about 225,000, or about 250,000.

[0092] As used herein, the double bond equivalent molecular weight can be calculated by dividing the molecular weight of the unsaturated compound by the number of carbon-carbon double bonds the unsaturated compound contains. For example, if the unsaturated compound is cyclopentadiene, which has a molecular weight of 66.1 g/mol and two carbon-carbon double bonds, the double bond equivalent molecular weight is 33.05 (66.1 divided by 2). Accordingly, as used herein, the term "unsaturated compound" includes compounds that can be considered a monomer or discrete molecules. In another example, if the unsaturated compound is trimethylolpropane triacrylate (TMPTA), which has a molecular weight of 296.32 g/mol and 3 carbon-carbon double bonds, the double bond equivalent molecular weight 98.8.

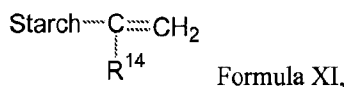
[0093] In one or more examples, the unsaturated compound can have a weight average molecular weight (MW) of about 200, about 250, about 300, about 350, about 400, about 450, about 500, about 550, about 600, or about 650 to about 1,000, about 1,500, about 2,000, about 2,500, about 3,000, about 3,500, about 4,000, about 4,500, or about 5,000. For example, the unsaturated compound can have a MW of about 300 to about 3,000, about 330 to about 770, about 380 to about 930, about 470 to about 1,150, about 700 to about 1,800, about 800 to about 2,200, about 1,200 to about 2,000, about 400 to about 2,800, about 500 to about 2,700, about 600 to about 2,600, or about 700 to about 2,500. In one or more examples, the unsaturated compound can have a MW of at least 300, at least 325, at least 350, at least 375, at least 400, at least 425, at least 450, at least 475, at least 500, at least 525, at least 550, at least 575, at least 600, at least 625, at least 650, at least 675, at least 700, at least 750, at least 775, at least 800, at least 825, at least 850, at least 875, at least 900, at least 925, at least 950, at least 975, or at least 1,000.

[0094] Illustrative vinyl aromatic compounds can include, but are not limited to, 2-allylphenol, 4-allylphenol, or a mixture thereof. Illustrative vinyl ethers can include, but are not limited to, triethyleneglycol divinyl ether, divinyl ether, or a mixture thereof. Illustrative allyl ethers can include, but are not limited to, diallyl ether, trimethylolpropane diallyl ether, triallyl cyanurate, or any mixture thereof. Illustrative conjugated dienes can include, but are not limited to, 1,3-butadiene, 2,3-dimethylbutadiene, 2-methyl-1,3-butadiene (isoprene), 1,3-pentadiene (piperylene), cyclopentadiene, 2-chloro-1,3-butadiene (chloroprene), or any mixture thereof. Illustrative terpenes can include, but are not limited to, sesquiterpenes, or any mixture thereof. Illustrative sesquiterpenes can include, but are not limited to, farnesene, or any mixture thereof. Illustrative one or more drying oils having an iodine number of about 115 or greater can include, but are not limited to, linseed oil, soybean oil, sunflower oil, tung oil, grape seed oil, wheat germ oil, corn oil, or any mixture thereof. In some examples, the drying oil can have an iodine number of about 115 to about 180 or greater. Illustrative unsaturated prepolymers can include, but are not limited to, unsaturated polyester prepolymers, unsaturated polyether prepolymers, unsaturated polyamide prepolymers, unsaturated polyurethane prepolymers, or any mixture thereof. Illustrative polyesters with one or more incorporated vinyl unsaturations can include, but are not limited to, methacrylate, acrylate modified or terminated polyesters, or any mixture thereof.

[0095] As noted above, the α,β -unsaturated carbonyl compound can be, but is not limited to, an α,β -unsaturated aldehyde (*e.g.*, an enal), an α,β -unsaturated ketone (*e.g.*, an enone), an α,β -unsaturated carboxylic acid, an α,β -unsaturated ester, an α,β -unsaturated amide, an α,β -unsaturated acyl halide, an α,β -unsaturated acid anhydride, or an α,β -unsaturated imide. Illustrative α,β -unsaturated carbonyl aldehydes can include, but are not limited to, crotonaldehyde, 3-methylcrotonaldehyde, methacrolein, tiglic aldehyde, isomers thereof, or any mixture thereof. Illustrative α,β -unsaturated ketones can include, but are not limited to, methyl vinyl ketone, ethyl vinyl ketone, isomers thereof, or any mixture thereof. Illustrative α,β -unsaturated carboxylic acids can include, but are not limited to, maleic acid, itaconic acid, fumaric acid, glutaconic acid, citraconic acid, traumatic acid, muconic acid, aconitic acid, isomers thereof or any mixture thereof. Illustrative α,β -unsaturated esters can include, but are not limited to, esters of maleic acid, itaconic acid, fumaric acid, glutaconic acid, citraconic acid, traumatic acid, muconic acid, aconitic acid, isomers thereof, or any mixture thereof. An illustrative α,β -unsaturated amide can include, but is not limited to, acrylamide. Illustrative α,β -unsaturated acyl halides can include, but are not limited to, acryloyl chloride, methacryloyl chloride, crotonoyl chloride, fumaryl chloride, itaconyl chloride, sorbic chloride, isomers thereof, or any mixture thereof. An illustrative α,β -unsaturated acid anhydride can include, but is not limited to, maleic anhydride, an isomer thereof, or a mixture thereof. An illustrative α,β -unsaturated imide can include, but is not limited to, maleimide, an isomer thereof, or a mixture thereof.

[0096] Other compounds having one or more pi-bonds (*e.g.*, unsaturated bonds) that is capable of going through a radical chain reaction mechanism, but is also conjugated with an aromatic moiety, can include, but are not limited to, vinyl aromatics, such as styrene, methylstyrenes, vinyl toluene, vinyl naphthalene, divinylbenzene (DVB), and vinylpyridine; methylstyrenes, such as α -methylstyrene and *trans*- β -methylstyrene; and any mixture thereof. Other illustrative vinyl aromatic compounds can include, but are not limited to, 2-allylphenol, 4-allylphenol, and a mixture thereof.

[0097] Illustrative unsaturated starch compounds having at least one unsaturated and polymerizable olefinic group can be represented by Formula XI below.



[0098] where R^{14} can be hydrogen or an alkyl group. Suitable starches can include, but are not limited to, maize or corn, waxy maize, high amylose maize, potato, tapioca, and wheat starch. Other starches such as genetically engineered starches can include high amylose potato and potato amylopectin starches. Suitable methods for preparing unsaturated starch compounds having at least one unsaturated and polymerizable olefinic group can include those discussed and described in U.S. Patent No. 2,668,156.

[0099] The unsaturated prepolymer can include one or more monounsaturated prepolymers, one or more polyunsaturated prepolymers, or any mixture thereof. In one or more examples, suitable polyunsaturated prepolymers can include at least two sites of unsaturation, at least three sites of unsaturation, at least 4 sites of unsaturation, at least 5 sites of unsaturation, at least 6 sites of unsaturation, or more. In one or more examples, the unsaturated prepolymer can be or include unsaturated polyester prepolymers, unsaturated polyether prepolymers, unsaturated polyamide prepolymers, unsaturated polyurethane prepolymers, or any mixture thereof.

[00100] The unsaturated polyester prepolymer can be synthesized or produced by reacting one or more polyacids and one or more polyols with one another. For example, the unsaturated prepolymer can be produced via monoester formation. In another example, the unsaturated polyester prepolymer can be produced by reacting the polyacid and the polyol via a condensation reaction. As used herein, the term "polyacid" refers to compounds having at least two reactive acid groups per molecule. The acid functionality can be a carboxylic acid, a sulfonic acid, or a combination thereof. The term "polyacid" can also refer to acid anhydrides, *e.g.*, maleic anhydride. The term "polyacid" can also refer to compounds containing at least one acid group per molecule and at least one acid anhydride group per molecule, *e.g.*, a maleated fatty acid. As used herein, the term "polyol" refers to compounds that contain two or more hydroxyl functional groups.

[00101] The one or more sites of unsaturation in the unsaturated polyester prepolymer can be directly introduced from the polyacid and/or the polyol, *e.g.*, at least one of the polyacid and the polyol can include one or more sites of unsaturation. Said another way, the unsaturated polyester prepolymer can be produced by reacting one or more unsaturated polyacids with one or more saturated polyols, reacting one or more unsaturated polyols with one or more saturated polyacids, and/or by reacting one or more unsaturated polyacids with one or more unsaturated polyols. In one or more examples, the sites of unsaturation in the unsaturated

polyester prepolymer can be appended to an initial prepolymer formed by reacting the polyacid and the polyol with one or more unsaturated compounds. In another example, the sites of unsaturation of the unsaturated polyester prepolymer can be introduced via at least one of the polyol and the poly acid, and an additional unsaturated compound. Illustrative additional unsaturated compounds can include, but are not limited to, unsaturated alcohols, unsaturated acids, unsaturated epoxides, or any mixture thereof.

[00102] The polyacid and polyol components can be mixed, blended, or otherwise combined with one another to produce a reaction mixture. The polyacid and polyol can be reacted under conditions sufficient to substantially react the primary hydroxyl groups of the polyol with the polyacid, but insufficient to cause reaction of the secondary hydroxyl groups of the polyol with the polyacid to a substantial extent. As used herein, the phrase "substantially react the primary hydroxyl groups of the polyol with the polyacid" means that at least 90% of the primary hydroxyl groups of the polyol are reacted with the polyacid. As used herein, the phrase "insufficient to cause reaction of the secondary hydroxyl groups of the polyol with the polyacid to a substantial extent" means that less than 10% of the secondary hydroxyl groups of the polyol are reacted with the polyacid. For example, the polyacid and the polyol can be combined in a reaction vessel or container and heated to a temperature of about 50°C, about 60°C, about 70°C, or about 80°C to about 110°C, about 125°C, about 140°C, or about 155°C. In another example, the polyacid and the polyol can be heated to a temperature of about 60°C to about 130°C, about 80°C to about 115°C, about 100°C to about 150°C, or about 75°C to about 135°C. The polyacid and the polyol can be reacted with one another for a time of about 10 minutes, about 30 minutes, about 1 hour, or about 2 hours to about 4 hours, about 6 hours, about 8 hours, or about 10 hours.

[00103] The progress of the reaction between the polyacid and the polyol can be monitored via any suitable method. One method for monitoring the extent of the reaction between the polyacid and the polyol can be through the use of infrared spectroscopy. For example, infrared spectroscopy can detect the presence of any unreacted polyacid. In one example, the reaction between the polyacid and the polyol can be carried out until the presence of the polyacid is no longer detected. It should be noted, however, that the unsaturated polyester prepolymer can include unreacted polyacid and/or unreacted polyol.

[00104] The polyacid and the polyol can be combined with one another in any desired ratio. For example, the polyol and the polyacid can be combined with one another at a molar ratio

of about 1:5, about 1:4, or about 1:2, to about 1:1, about 2:1, about 4:1, or about 6:1. In at least one example, the amount of the polyacid combined with the polyol can be sufficient to provide a ratio of reactive acid and/or anhydride group(s) to hydroxyl groups of about 1:1 to about 2:1. For each hydroxyl group present in the polyol about 1 acid group, about 2 acid groups, or about 3 acid groups can be present in the mixture of the polyol and the polyacid.

[00105] The polyacid can be or include, but is not limited to, one or more unsaturated and/or saturated aliphatic polyacids, one or more aromatic polyacids, one or more cycloaliphatic polyacids, one or more acid anhydrides, or any mixture thereof. Suitable unsaturated aliphatic diacids and saturated aliphatic diacids can include 2 carbon atoms to about 12 carbon atoms, 3 carbon atoms to about 10 carbon atoms, or 4 carbon atoms to about 8 carbon atoms. Illustrative unsaturated aliphatic diacids can include, but are not limited to, maleic acid, itaconic acid, fumaric acid, glutaconic acid, citraconic acid, traumatic acid, muconic acid, aconitic acid, or any mixture thereof. Illustrative saturated aliphatic diacids can include, but are not limited to, oxalic acid, malonic acid, succinic acid, glutaric acid, adipic acid, pimelic acid, suberic acid, azelaic acid, sebacic acid, or any combination or mixture thereof. Illustrative aromatic diacids can include, but are not limited to, phthalic acid, isophthalic acid, terephthalic acid, or any combination or mixture thereof. Illustrative cyclo-aliphatic diacids can include, but are not limited to, cyclobutanedicarboxylic acid, cyclopentanedicarboxylic acid, cyclohexanedicarboxylic acid, isomers thereof, or any combination or mixture thereof. Illustrative acid anhydrides can include, but are not limited to, phthalic anhydride, mellitic anhydride, pyromellitic anhydride, maleic anhydride, or any combination or mixture thereof. In one or more examples, the polyacid can also include one or more unsaturated fatty acids reacted with any one or more of the polyacids discussed and described above. For example, in at least one specific example, the polyacid can be or include the Alder-Enc reaction product between one or more unsaturated fatty acids and maleic anhydride. Therefore, for example, the polyacid can be or include one or more maleated fatty acids.

[00106] Illustrative saturated polyols can include, but are not limited to, ethylene glycol, polyglycerol, hyperbranched polyglycerol, diethylene glycol, triethylene glycol, polyethylene oxide (hydroxy terminated), glycerol, pentaerythritol, trimethylolpropane, diethanolamine, triethanolamine, ethyl diethanolamine, methyl diethanolamine, sorbitol, monosaccharides, such as glucose and fructose, disaccharides, such as sucrose, and higher polysaccharides such as starch and reduced and/or modified starches, dextrin, maltodextrin, polyvinyl alcohols,

hydroxyethylcellulose, 1,4-cyclohexane diol, or any combination or mixture thereof. Illustrative unsaturated polyols can include, but are not limited to, 2-butene-1,4-diol, hydroxyl-terminated polybutadiene (HTPB) or any combination or mixture thereof.

[00107] Illustrative unsaturated alcohols suitable for introducing, appending, or otherwise providing one or more sites of unsaturation in the unsaturated polyester prepolymer can include, but are not limited to, any one or more of the unsaturated polyols discussed and described above, allylic alcohols, unsaturated alcohols obtained via metathesis reaction of hydroxyl-substituted unsaturated fatty acid or fatty acid esters, or any combination or mixture thereof. The preparation of unsaturated alcohols via metathesis reaction can be as discussed and described in U.S. Patent No. 7,176,336. Illustrative unsaturated acids suitable for introducing, appending, or otherwise providing one or more sites of unsaturation in the unsaturated polyester prepolymer can include, but are not limited to, any one or more of the unsaturated polyacids discussed and described above, or any combination or mixture thereof. Suitable unsaturated epoxides suitable for introducing, appending, or otherwise providing one or more sites of unsaturation in the unsaturated polyester prepolymer can include, but are not limited to, allyl glycidyl ether, 3,4-epoxy-1-butene, 1,2-epoxy-5-hexene, or any combination or mixture thereof.

[00108] In one or more examples, one or more catalysts or unsaturated polyester prepolymer catalysts can optionally be present when the polyacid and the polyol are reacted with one another. Suitable catalysts can include, but are not limited to, monobutyltin oxide, dibutyltin oxide, dibutyltin dilaurate, or any mixture thereof. The one or more catalysts, if present, can be present in an amount of about 0.05 wt%, about 0.1 wt%, about 0.5 wt%, or about 1 wt% to about 2 wt%, about 3 wt%, about 4 wt%, or about 5 wt%, based on the combined weight of the polyacid and the polyol.

[00109] The unsaturated polyester prepolymer can be combined with one or more reactive monomers in lieu of or in addition to the water. Illustrative reactive monomers that can be combined with the unsaturated polyester prepolymer can include, but are not limited to, styrene, methyl styrene, chlorostyrene, vinyl toluene, divinyl benzene, vinyl acetate, acrylic acid, methacrylic acid, lower alkyl esters of acrylic acid, lower alkyl esters of methacrylic acid, diallyl phthalate, vegetable oils, and drying oils, *e.g.*, linseed oil, soybean oil, sunflower oil, tung oil, grape seed oil, wheat germ oil, corn oil, or any combination or mixture thereof. If the unsaturated polyester prepolymer is combined with one or more reactive monomers, the

amount of the one or more reactive monomers can be about 1 wt%, about 5 wt%, about 10 wt%, about 15 wt%, or about 20 wt% to about 40 wt%, about 45 wt%, about 50 wt%, about 55 wt%, or about 60 wt%, based on the combined weight of the one or more reactive monomers and the unsaturated polyester prepolymer.

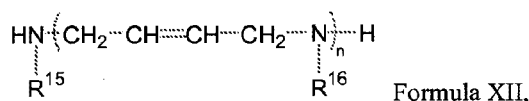
[00110] The unsaturated polyamide prepolymers can be produced by reacting one or more polyamines with one or more polyacids. The unsaturated polyamide prepolymers can also be produced by reacting one or more polyamines with one or more esters. The one or more sites of unsaturation in the unsaturated polyamide prepolymer can be directly introduced from the polyacid and/or the polyamine, *e.g.*, at least one of the polyacid and the polyamine can include one or more sites of unsaturation. Said another way, the unsaturated polyamide prepolymer can be produced by reacting one or more unsaturated polyacids with one or more saturated polyamines, reacting one or more unsaturated polyamines with one or more saturated polyacids, and/or by reacting one or more unsaturated polyacids with one or more unsaturated polyamines. The sites of unsaturation in the unsaturated polyamide prepolymer can be appended to an initial prepolymer formed by reacting the polyacid and the polyamine with one or more unsaturated compounds. In another example, the unsaturation sites of the unsaturated polyamide prepolymer can be introduced via at least one of the polyamine and the poly acid, and an additional unsaturated compound. Illustrative additional unsaturated compounds can include, but are not limited to, unsaturated alcohols, unsaturated acids, unsaturated epoxides, or any mixture thereof.

[00111] The polyacid and polyamine components can be mixed, blended, or otherwise combined with one another to produce a reaction mixture. The reaction mixture can be reacted under conditions sufficient to react the polyacid with the polyamine to produce the unsaturated polyamide prepolymer. For example, the polyacid and the polyamine can be combined in a reaction vessel or container and heated to a temperature of about 50°C, about 60°C, about 70°C, or about 80°C to about 110°C, about 125°C, about 140°C, or about 155°C. In another example, the polyacid and the polyamine can be heated to a temperature of about 60°C to about 130°C, about 80°C to about 115°C, about 100°C to about 150°C, or about 75°C to about 135°C. The polyacid and the polyamine can be reacted with one another for a time of about 10 minutes, about 30 minutes, about 1 hour, or about 2 hours to about 4 hours, about 6 hours, about 8 hours, or about 10 hours. Polyamides can also be produced or obtained via transamidation.

[00112] The progress of the reaction between the polyacid and the polyamine can be monitored via any suitable method. One method for monitoring the extent of the reaction between the polyacid and the polyamine can be through the use of infrared spectroscopy. For example, infrared spectroscopy can detect the presence of any unreacted polyacid. In one example, the reaction between the polyacid and the polyamine can be carried out until the presence of the polyacid is no longer detected. It should be noted, however, that the unsaturated polyamide prepolymer can include unreacted polyacid and/or unreacted polyamine.

[00113] The polyacid and the polyamine can be combined with one another in any desired ratio. For example, the polyamine and the polyacid can be combined with one another at a molar ratio of about 1:5, about 1:4, or about 1:2, to about 1:1, about 2:1, about 4:1, or about 6:1. In at least one example, the amount of the polyacid combined with the polyamine can be sufficient to provide a ratio of reactive acid and/or anhydride group(s) to amine groups of about 1:1 to about 2:1. For example, for each amine group present in the polyamine about 1 acid groups, about 2 acid groups, or about 3 acid groups can be present in the mixture of the polyamine and the polyacid.

[00114] Suitable polyacids can include those discussed and described above or elsewhere herein. Illustrative saturated polyamines can include, but are not limited to, ethylenediamine, propylenediamine, hexamethylenediamine, diethylenetriamine (DETA), triethylenetetramine (TETA), tetraethylenepentamine (TEPA), 1,3-propanediamine, 1,4-butanediamine, hyperbranched polyethyleneimine, or any combination or mixture thereof. Illustrative unsaturated polyamines can include those represented by the following general Formula XII below:



[00115] where R¹⁵ and R¹⁶ can independently be an organic group that can have 1 carbon atom to about 24 carbon atoms, *e.g.*, an alkyl group containing 1 carbon atom to about 12 carbon atoms, and n can be an integer of 2 to about 12. Illustrative unsaturated polyamines having Formula XII can be prepared according to the methods discussed and described in U.S. Patent No. 3,773,833.

[00116] The unsaturated polyether prepolymers can be produced by polymerization of allyl glycidyl ether (AGE) to form poly(allyl glycidyl ether) (PAGE). The unsaturated polyether prepolymer can have pendant allyl groups. Suitable reaction conditions for producing the unsaturated polyurethane prepolymer can include those discussed and described in Lee, B. F. *et al.*, "Poly(allyl Glycidyl Ether)-A Versatile and Functional Polyether Platform," *Journal of Polymer Science Part A: Polymer Chemistry*, Vol. 49, August 2011, pp. 4498-4504. The copolymerization reaction of AGE with other monomers can be as discussed and described in Sunder, A. *et al.*, "Copolymers of Glycidol and Glycidyl Ethers: Design of Branched Polyether Polyols by Combination of Latent Cyclic AB₂ and ABR Monomers," *Macromolecules*, Vol. 33, September 2000, pp. 7682-7692, and Erberich, M. *et al.*, "Polyglycidols with Two Orthogonal Protective Groups: Preparation, Selective Deprotection, and Functionalization," *Macromolecules*, Vol. 40, April 2007, pp. 3070-3079.

[00117] The unsaturated polyurethane prepolymers can be produced by reacting one or more polyisocyanates with one or more compounds having active hydrogen functionality. Moieties that provide active hydrogen functionality can include, but are not limited to, hydroxyl groups, mercaptan groups, amine groups, and carboxyl groups. In some examples, hydroxyl groups can be used as a compound having active hydrogen functionality.

[00118] Suitable polyisocyanates can include, but are not limited to, hexamethylene diisocyanate, toluene diisocyanate (TDI), diphenylmethane diisocyanate (MDI), *m*-phenylene and *p*-phenylene diisocyanates, bitolylene diisocyanate, cyclohexane diisocyanate (CHDI), bis-(isocyanatomethyl) cyclohexane (H₆XDI), dicyclohexylmethane diisocyanate (H₁₂MDI), dimer acid diisocyanate (DDI), trimethyl hexamethylene diisocyanate, lysine diisocyanate and its methyl ester, methyl cyclohexane diisocyanate, 1,5-naphthalene diisocyanate, xylylene and xylene diisocyanate and methyl derivatives thereof, polymethylene polyphenyl isocyanates, chlorophenylene 2,4-diisocyanate, polyphenylene diisocyanates available commercially as, for example, Mondur MR or Mondur MRS, isophorone diisocyanate (IPDI), hydrogenated methylene diphenyl isocyanate (HMDI), tetramethyl xylene diisocyanate (TMXDI), hexamethylene diisocyanate (HDI), or oligomer materials of these materials such as a trimer of IPDI, HDI or a biuret of HDI, and mixtures thereof. Triisocyanates and high-functional isocyanates can also be used. Aromatic and aliphatic diisocyanates, for example, biuret and isocyanurate derivatives can be used.

[00119] Suitable polyols for reacting with the polyisocyanates can include, but are not limited to, polyether polyols (*e.g.*, block polyethylene and polypropylene oxide homopolymers and/or copolymers having a molecular weight of about 300 to about 3,000), alkylated polyols (*e.g.*, polytetramethylene ether glycols), or caprolactone-based polyols. In one or more examples, the reactants for making the polyurethane prepolymer can be or include mixtures of aliphatic and aromatic polyols, or a multi-functional, active hydrogen-bearing polymer. As such, in addition to or in lieu of polyether polyols, the hydroxyl-functional component can include derivatives of acrylates, esters, vinyls, and castor oils, as well as polymers, or any mixture thereof.

[00120] Isocyanate equivalents can predominate over active hydrogen equivalents in the polyisocyanate/polyol reaction mixture to produce a prepolymer that can include residual isocyanate groups. The isocyanate and the polyol can be combined with one another in any desired ratio. For example, the isocyanate and the polyol can be combined with one another at a molar ratio of about 1:5, about 1:4, or about 1:2, to about 1:1, about 2:1, about 4:1, or about 5:1. Suitable reaction conditions for producing the unsaturated polyurethane prepolymer can include those discussed and described in Heiss, *et al.*, "Influence of Acids and Bases on Preparation of Urethane Polymers," Industrial and Engineering Chemistry, Vol. 51, No. 8, August 1959, pp. 929-934. Depending, at least in part, on the reaction conditions used (such as, for example, temperature and the presence of strong acids or bases, and catalysts), the reaction may lead to the formation of ureas, allophanates, biurets, or isocyanates.

[00121] Suitable amine group containing compounds that can be reacted with the polyisocyanates can include, but are not limited to, unsaturated polyamines represented by the general Formula XII discussed and described above. Suitable carboxyl group containing compounds that can be reacted with the polyisocyanates can include, but are not limited to, unsaturated aliphatic diacids. Illustrative unsaturated aliphatic diacids can include, but are not limited to, maleic acid, itaconic acid, fumaric acid, glutaconic acid, citraconic acid, traumatic acid, muconic acid, aconitic acid, or any mixture thereof.

[00122] Polyamidoamines and unsaturated glycidyl ethers suitable for producing one or more products formed by reacting the polyamidoamine and the unsaturated glycidyl ether can widely vary. The polyamidoamine can be a reaction product of a polyamine and a dicarboxylic acid. In some examples, the polyamine can be dimethylenetriamine,

diethylenetriamine, triethylenetetramine, tripropylenetetramine, tetraethylenepentamine, pentaethylenehexamine, or any mixture thereof. The dicarboxylic acid can be glutaric acid, adipic acid, azelaic acid, malonic acid, suberic acid, sebacic acid, succinic acid, oxalic acid, pimelic acid, derivatives thereof, or any mixture thereof. The epihalohydrin can be epichlorohydrin, epibromohydrin, epifluorohydrin, epiiodohydrin, or any mixture thereof.

[00123] Illustrative unsaturated glycidyl ethers can be represented by general Formula VII discussed and described above. Suitable reaction products produced by reacting one or more polyamidoamines and one or more unsaturated glycidyl ethers and methods for making the reaction products can be as discussed and described in U.S. Patent Nos. 2,864,775 and 3,280,054.

[00124] The product(s) formed by reacting the polyamidoamine(s) and the unsaturated glycidyl ether(s) can act or serve as active reducers. As used herein, the term "active reducer" refers to compounds that can participate in a cross-linking reaction, *e.g.*, have double bonds, and also have one or more groups that can be oxidized, *e.g.*, a tertiary amine.

[00125] In one or more examples, the unsaturated prepolymer can be combined with water to produce a water and unsaturated prepolymer mixture. For example, water can be mixed, blended, or otherwise combined with the unsaturated prepolymer to produce the water and unsaturated prepolymer mixture. The unsaturated prepolymer can be soluble in water. The unsaturated prepolymer can be dissolved in water to produce an aqueous unsaturated prepolymer solution. The unsaturated prepolymer can be combined with water to form an aqueous suspension, emulsion, or dispersion. The combined weight of the water and the unsaturated prepolymer, can be about 1 wt%, about 5 wt%, about 10 wt%, about 15 wt%, about 20 wt%, about 25 wt%, about 30 wt%, or about 35 wt% to about 50 wt%, about 55 wt%, about 60 wt%, about 65 wt%, about 70 wt%, or about 75 wt%, based on the combined weight of the water and the unsaturated prepolymer. The unsaturated polyester prepolymer combined with water can have a viscosity of about 20 cP, about 100 cP, about 1,000 cP, about 5,000 cP, or about 10,000 cP to about 50,000 cP, about 100,000 cP, about 200,000 cP, or about 300,000 cP at a temperature of about 25°C. The viscosity of the unsaturated polyester prepolymer and/or any other compound or composition discussed and described herein can be determined using a viscometer at a temperature of about 25°C. For example, a Brookfield Viscometer, Model DV-II+, with a small sample adapter with, for example, a number 3 spindle, can be used. The small sample adapter can allow the sample to be cooled

or heated by the chamber jacket to maintain the temperature of the sample surrounding the spindle at a temperature of about 25°C.

[00126] In one or more examples, one or more catalysts or unsaturated polyurethane prepolymer catalysts can be used to accelerate the rate of reaction of the polyisocyanate and the polyol to produce the unsaturated polyurethane prepolymer. Suitable catalysts can include, but are not limited to, dibutyl tin dilaurate. In one or more examples, one or more inhibitors can be used to slow the cross-linking reaction. Suitable inhibitors can include, but are not limited to, benzoyl chloride and monophenyldichlorophosphate.

[00127] In one or more examples, the unsaturated prepolymer, can have a pH of about 0.5, about 2, about 3, or about 4 to about 7, about 7.5, about 8, about 8.5, or about 9. For example, the unsaturated polyester prepolymer can have a pH of about 1.5 to about 9, about 2.5 to about 7, about 1 to about 5, about 5 to about 8, or about 3 to about 6.

[00128] One or more salts can optionally be combined with the lignocellulose substrates, the free radical precursor, and the optional polyphenolic material. The amount of salt in the mixture, if present, can be about 1 wt%, about 2 wt%, or about 3 wt% to about 10 wt%, about 20 wt%, or about 30 wt%, based on the dry weight of the lignocellulose substrates. The one or more salts can be combined with the lignocellulose substrates, catalyst, and/or oxidant in any order or sequence. Illustrative salts can include, but are not limited to, aluminum, calcium, potassium, sodium, copper, zinc, magnesium, manganese, barium, and/or lithium cations. Suitable anions can include, but are not limited to, carbonates, chlorides, nitrates, silicates, acetates, formates, sulphates, phosphates, and/or other forms.

[00129] If any one or more of the components discussed and described herein include two or more different compounds, those two or more different compounds can be present in any ratio with respect to one another. For example, if the mixture includes a first and a second type of lignocellulose substrate, calcium lignosulfonate such as solid versus liquid, free radical precursor, and/or the optional polyphenolic material the amount of the first and second components can be present in any desired ratio. For example, if the oxidant is present in the free radical precursor and includes a first oxidant and a second oxidant, the mixture can have an oxidant composition that includes the first oxidant in an amount of about 1 wt% to about 99 wt% and conversely about 99 wt% to about 1 wt% of the second oxidant, based on the total weight of the oxidant composition, e.g., the total weight of the first and second oxidants. In another example, the amount of the first oxidant can be about 5 wt%, about 10 wt%, about

15 wt%, about 20 wt%, about 25 wt% about 30 wt%, about 35 wt%, about 40 wt%, or about 45 wt% to about 60 wt%, about 65 wt%, about 70 wt%, about 75 wt%, about 80 wt%, about 85 wt%, about 90 wt%, or about 95 wt%, based on the total weight of the first and second oxidants.

[00130] In one or more examples, the amount of the one or more free radical precursors present when the mixture is heated, *e.g.*, to a temperature of about 60°C to about 300°C, can be at least 0.5 wt%, at least 0.7 wt%, at least 1 wt%, at least 1.2 wt%, at least 1.5 wt%, at least 1.7 wt%, at least 2 wt%, at least 2.2 wt%, at least 2.5 wt%, at least 2.7 wt%, at least 3 wt%, at least 3.2 wt%, at least 3.5 wt%, at least 3.7 wt%, at least 4 wt%, at least 4.2 wt%, at least 4.5 wt%, at least 4.7 wt%, or at least 5 wt%, based on the dry weight of the plurality of lignocellulose substrates. For example, the amount of the one or more free radical precursors present when the mixture is heated can be about 1 wt%, about 1.5 wt%, about 1.6 wt%, about 1.8 wt%, or about 2.1 wt% to about 5 wt%, about 7 wt%, about 10 wt%, about 15 wt%, about 20 wt% or more, based on the dry weight of the plurality of lignocellulose substrates. In another example, the amount of the one or more free radical precursors present when the mixture is heated can be about 1 wt% to about 10 wt%, about 1.5 wt% to about 7 wt%, about 2 wt% to about 6 wt%, about 2.5 wt% to about 8 wt%, about 3 wt% to about 5.5 wt%, about 4 wt% to about 6.5 wt%, about 2.2 wt% to about 11 wt%, or about 2.3 wt% to about 6.3 wt%, based on the dry weight of the plurality of lignocellulose substrates.

[00131] The pH of the mixture can be acidic, neutral, or basic. For example, the pH of the mixture can be about 1, about 2, or about 3 to about 4, about 5, about 6, about 7, or about 8. In another example, the pH of the mixture can be about 1 to about 6, about 1.5 to about 5.5, about 2.5 to about 4.5, about 2 to about 3.5, or about 2.5 to about 3.5. The pH of the mixture can be adjusted to any desired pH by combining one or more base compounds, one or more acid compounds, or mixtures of one or more base compounds and one or more acid compounds therewith.

[00132] Illustrative base compounds that can be used to adjust the pH of the mixture can include, but are not limited to, hydroxides, carbonates, ammonia, amines, or any mixture thereof. Illustrative hydroxides can include, but are not limited to, sodium hydroxide, potassium hydroxide, ammonium hydroxide (*e.g.*, aqueous ammonia), lithium hydroxide, and cesium hydroxide. Illustrative carbonates can include, but are not limited to, sodium carbonate, sodium bicarbonate, potassium carbonate, and ammonium carbonate. Illustrative

amines can include, but are not limited to, trimethylamine, triethylamine, triethanolamine, diisopropylethylamine (Hunig's base), pyridine, 4-dimethylaminopyridine (DMAP), and 1,4-diazabicyclo[2.2.2]octane (DABCO).

[00133] Illustrative acid compounds that can be used to adjust the pH of the mixture can include, but are not limited to, one or more mineral acids, one or more organic acids, one or more acid salts, or any mixture thereof. Illustrative mineral acids can include, but are not limited to, hydrochloric acid, nitric acid, phosphoric acid, sulfuric acid, or any mixture thereof. Illustrative organic acids can include, but are not limited to, acetic acid, formic acid, citric acid, oxalic acid, uric acid, lactic acid, or any mixture thereof. Illustrative acid salts can include, but are not limited to, ammonium sulfate, sodium bisulfate, sodium metabisulfite, or any mixture thereof.

[00134] The mixture can have a liquid medium concentration, *e.g.*, water, of about 1 wt%, about 3 wt%, about 5 wt%, or about 10 wt% to about 12 wt%, about 14 wt%, about 16 wt%, about 18 wt%, about 20 wt%, about 22 wt%, about 24 wt%, about 27 wt%, about 30 wt%, about 35 wt%, about 40 wt%, about 45 wt%, or about 50 wt%, based on the total weight of the mixture. For example, when the mixture contains water as the liquid, the mixture can have a moisture content of about 10 wt% to about 25 wt%, about 12 wt% to about 20 wt%, about 11 wt% to about 19 wt%, about 13 wt% to about 18 wt%, about 15 wt% to about 18 wt%, about 12 wt% to about 17 wt%, or about 14 wt% to about 17 wt%, based on the total weight of the mixture.

[00135] One or more additives can optionally be combined with the lignocellulose substrates, free radical precursor, the calcium lignosulfonate, and the optional polyphenolic material and/or the optional unsaturated compound to produce the mixture. Illustrative additives can include, but are not limited to, waxes and/or other hydrophobic additives, water, filler material(s), extenders, surfactants, release agents, dyes, fire retardants, formaldehyde scavengers, biocides, or any mixture thereof. For composite wood products, such as plywood, typical filler material(s) can include, but are not limited to, ground pecan and/or walnut shells, and typical extenders can include, for example, wheat flour. Other suitable extenders can include, but are not limited to, polysaccharides. Illustrative polysaccharides can include, but are not limited to, starch, cellulose, gums, such as guar and xanthan, alginates, pectin, gellan, or any mixture thereof. Suitable polysaccharide starches can include, for example maize or corn, waxy maize, high amylose maize, potato, tapioca, and

wheat starch. Other starches such as genetically engineered starches can include high amylose potato and potato amylopectin starches.

[00136] If one or more additives are present in the mixture, the amount of each additive can be about 0.01 wt% to about 50 wt%, based on the total weight of the mixture. For example, the amount of any given component or additive can be about 0.01 wt%, about 0.05 wt%, about 0.1 wt%, about 0.5 wt%, or about 1 wt% to about 3 wt%, about 5 wt%, about 7 wt%, or about 9 wt%, based on the total weight of the mixture. In another example, the amount of any given additive or component can be about 1 wt%, about 5 wt%, about 10 wt%, about 15 wt%, or about 20 wt% to about 25 wt%, about 30 wt%, about 35 wt%, about 40 wt%, or about 45 wt%, based on the total weight of the mixture. In at least one specific example, one or more waxes, e.g., slack wax, can be present in the mixture and the amount of wax can be about 0.1 wt%, about 0.5 wt%, or about 0.9 wt% to about 1.5 wt%, about 2 wt%, or about 3 wt%, based on the dry weight of the lignocellulose substrates.

[00137] The mixture can be heated to produce the lignocellulose containing composite product or "composite product." For example, the mixture can be heated to a temperature of 60°C, about 90°C, about 120°C, about 150°C, or about 160°C to about 170°C, about 200°C, about 230°C, about 260°C, or about 300°C to produce the composite product. In another example, the mixture can be heated to a temperature of at least 60°C, at least 70°C, at least 80°C, at least 90°C, at least 100°C, at least 110°C, at least 120°C, at least 130°C, or at least 140°C to about 150°C, about 155°C, about 160°C, about 165°C, about 170°C, about 180°C, about 200°C, about 225°C, about 250°C, about 275°C, or about 300°C. In another example, the mixture can be heated to a temperature of about 140°C to about 200°C, about 155°C to about 175°C, about 160°C to about 210°C, about 160°C to about 175°C, or about 145°C to about 225°C.

[00138] The mixture can be heated in an atmosphere of ambient air. The mixture can be heated in an inert atmosphere or substantially an inert atmosphere such as nitrogen. If the mixture is heated in a substantially inert atmosphere, the amount of oxygen can be less than 5 mol%, less than 3 mol%, less than 1 mol%, less than 0.5 mol%, or less than 0.1 mol% oxygen, relative to the balance of gases in the inert atmosphere. Suitable inert gases can include, but are not limited to, nitrogen, argon, helium, or a mixture thereof.

[00139] Heating the mixture can cause or promote the at least partial curing of the mixture to produce the composite product. As used herein, the terms "curing," "cured," "at least

partially curing," "at least partially cured," and similar terms are intended to refer to the structural and/or morphological change that occurs in the mixture, such as by covalent chemical reaction (crosslinking), ionic interaction or clustering, phase transformation or inversion, and/or hydrogen bonding when subjected to conditions sufficient, *e.g.*, sufficiently heated, to cause the properties of a flexible, porous substrate, such as a nonwoven mat or blanket of lignocellulose substrates and/or a rigid or semi-rigid substrate, such as a wood or other lignocellulose containing board or sheet, to which an effective amount of the free radical precursor and the calcium lignosulfonate and, optionally, the polyphenolic material, to be altered.

[00140] The mixture can be heated as soon as the mixture is formed. The mixture can be kept, held, or otherwise maintained at a temperature of less than 60°C for a period of time prior to heating the mixture to a temperature of at least 60°C. At least one way an exothermic reaction between the components of the mixture can be substantially and significantly slowed and/or prevented such that the mixture does not significantly increase in temperature until the mixture is intentionally heated can be to select an appropriate free radical precursor or mixture of free radical precursors. In other words, the temperature of the mixture, without external heat directed to the mixture, can remain free from or substantially free from the development of an exotherm by selectively selecting an appropriate free radical precursor(s). The particular temperature of the mixture during the time period before heating can depend, at least in part, on the ambient or environmental temperature where the mixture is located. In one or more examples, the mixture can be maintained at a temperature of less than 60°C without any intentional removal of heat therefrom. In one example, the mixture can be maintained at a temperature of less than 60°C with removal of heat therefrom, *e.g.*, the mixture can be located within a refrigeration device and/or a cooled fluid such as chilled air can be directed toward and/or passed through the mixture. In another example, the mixture can be maintained at a temperature of less than 60°C by controlling or adjusting a water concentration of the mixture. For example, increasing the water concentration of the mixture can reduce, inhibit, or prevent the mixture from undergoing an exothermic reaction.

[00141] When the mixture is heated, the mixture can contain at least a portion of the free radical precursor initially added to and present in the mixture. Said another way, at least a portion of the free radical precursor can remain unreacted or otherwise in the same form as when combined with the additional components of the mixture at least until the mixture is

heated to an elevated temperature such as about 60°C or greater. For example, if the free radical precursor includes one or more oxidants, *e.g.*, hydrogen peroxide, at least a portion of the oxidant in the form of hydrogen peroxide can be present when heating of the mixture is initiated or started. In one example, the mixture can contain at least 11 wt%, at least 13 wt%, at least 15 wt%, at least 20 wt%, at least 25 wt%, at least 30 wt%, at least 35 wt%, at least 40 wt%, at least 45 wt%, at least 50 wt%, at least 55 wt%, at least 60 wt%, at least 65 wt%, or at least 70 wt% of the total or initial amount of free radical precursor initially present in the mixture, *e.g.*, the amount of the free radical precursor combined with the plurality of lignocellulose substrates to produce the mixture, when the mixture is heated to a temperature of at least 60°C. In another example, the amount of the free radical precursor present when the mixture is heated to a temperature of at least 60°C can be at least 11 wt%, at least 13%, at least 15 wt%, at least 20 wt%, at least 25 wt%, at least 30 wt%, at least 35 wt%, at least 40 wt%, at least 45 wt%, at least 50 wt%, at least 55 wt%, at least 60 wt%, at least 65 wt%, or at least 70 wt% of the one or more free radical precursors combined with the plurality of lignocellulose substrates. In still another example, the amount of the free radical precursor present when the mixture is heated to a temperature of at least 60°C, at least 65°C, or at least 70°C can be at least 11 wt%, at least 13%, at least 15 wt%, at least 20 wt%, at least 25 wt%, at least 30 wt%, at least 35 wt%, at least 40 wt%, at least 45 wt%, at least 50 wt%, at least 55 wt%, at least 60 wt%, at least 65 wt%, or at least 70 wt% of the one or more free radical precursors combined with the plurality of lignocellulose substrates. In another example, the mixture can contain about 11% to about 95%, about 15% to about 85%, about 20% to about 90%, about 30% to about 80%, about 11% to about 100%, about 35% to about 75%, about 40% to about 70%, about 50% to about 70%, about 60% to about 80%, about 65% to about 85%, or about 30% to about 95% of the total amount of free radical precursor initially present in the mixture when the mixture is heated. In at least one specific example, the mixture can include about 5 wt% free radical precursor, based on the dry weight of the lignocellulose substrates when the mixture is initially formed and when the mixture is heated to a temperature of 60°C or more at least 11% of the free radical precursor can be present in the mixture. Said another way, if the mixture contains about 5 wt% of the one or more free radical precursors, based on the dry weight of the lignocellulose substrates, upon preparation or formation of the mixture, when heating the mixture is initiated or started, the mixture can have a free radical precursor concentration of at least 11% of the initial 5 wt% or 0.55 wt%, based on the dry weight of the lignocellulose substrates.

[00142] The amount of the free radical precursor in the mixture can be about 3 wt%, about 4 wt%, about 5 wt%, about 6 wt%, about 7 wt%, about 8 wt%, about 9 wt%, or about 10 wt% and prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to any exothermic reaction(s) can be less than 75 cal/g of the mixture, less than 69 cal/g of the mixture, less than 62 cal/g of the mixture, less than 55 cal/g of the mixture, less than 48 cal/g of the mixture, less than 42 cal/g of the mixture, less than 34 cal/g of the mixture, less than 27 cal/g of the mixture, less than 20 cal/g of the mixture, or less than 13 cal/g of the mixture. For example, the amount of the free radical precursor in the mixture can be about 3 wt% and prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to exothermic reaction(s) can be less than 21 cal/g of the mixture, less than 20 cal/g of the mixture, less than 18 cal/g of the mixture, less than 16 cal/g of the mixture, less than 14 cal/g of the mixture, less than 12 cal/g of the mixture, less than 10 cal/g of the mixture, less than 8 cal/g of the mixture, less than 6 cal/g of the mixture, or less than 4 cal/g of the mixture. In another example, the amount of the free radical precursor in the mixture can be about 4 wt% and prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to exothermic reaction(s) can be less than 28 cal/g of the mixture, less than 26 cal/g of the mixture, less than 24 cal/g of the mixture, less than 22 cal/g of the mixture, less than 20 cal/g of the mixture, less than 18 cal/g of the mixture, less than 16 cal/g of the mixture, less than 14 cal/g of the mixture, less than 12 cal/g of the mixture, or less than 10 cal/g of the mixture. In another example, the amount of the free radical precursor in the mixture can be about 5 wt% and prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to exothermic reaction(s) can be less than 35 cal/g of the mixture, less than 33 cal/g of the mixture, less than 31 cal/g of the mixture, less than 29 cal/g of the mixture, less than 27 cal/g of the mixture, less than 25 cal/g of the mixture, less than 23 cal/g of the mixture, less than 21 cal/g of the mixture, less than 19 cal/g of the mixture, or less than 17 cal/g of the mixture. In another example, the amount of the free radical precursor in the mixture can be about 6 wt% and prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to exothermic reaction(s) can be less than 42 cal/g of the mixture, less than 40 cal/g of the mixture, less than 38 cal/g of the mixture, less than 36 cal/g of the mixture, less than 34 cal/g of the mixture, less than 32 cal/g of the mixture, less than 30 cal/g of the mixture, less than 28 cal/g of the mixture, less than 26 cal/g of the mixture, or less than 24 cal/g of the mixture. In another example, the amount of

the free radical precursor in the mixture can be about 7 wt% and prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to exothermic reaction(s) can be less than 49 cal/g of the mixture, less than 45 cal/g of the mixture, less than 40 cal/g of the mixture, less than 35 cal/g of the mixture, less than 30 cal/g of the mixture, less than 25 cal/g of the mixture, less than 20 cal/g of the mixture, less than 15 cal/g of the mixture, less than 10 cal/g of the mixture, or less than 8 cal/g of the mixture.

[00143] Prior to heating the mixture to a temperature of at least 60°C, the mixture can be maintained at a temperature of less than 60°C, less than 55°C, less than 50°C, less than 45°C, less than 40°C, less than 35°C, or less than 30°C for at least 10 minutes, at least 13 minutes, at least 15 minutes, at least 17 minutes, at least 20 minutes, at least 23 minutes, at least 25 minutes, at least 27 minutes, at least 30 minutes, at least 33 minutes, at least 35 minutes, at least 37 minutes, at least 40 minutes, at least 43 minutes, at least 45 minutes, at least 47 minutes, at least 50 minutes, at least 53 minutes, at least 55 minutes, at least 57 minutes, or at least 60 minutes. For example, the mixture can be maintained at a temperature of less than 60°C for at least 10 minutes to about 30 minutes, at least about 15 minutes to about 35 minutes, at least about 20 minutes to about 40 minutes, at least about 18 minutes to about 45 minutes, or at least about 15 minutes to about 40 minutes prior to heating the mixture to a temperature of at least 60°C. In another example, the mixture can be maintained at a temperature of less than 60°C for at least 10 minutes, about 30 minutes, about 45 minutes, about 1 hour, about 2 hours, about 3 hours, about 5 hours, about 12 hours, about 18 hours, about 24 hours, or about 30 hours prior to heating the mixture to a temperature of at least 60°C.

[00144] Prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to exothermic reaction(s) can be less than 35 cal/g of the mixture, less than 30 cal/g of the mixture, less than 25 cal/g of the mixture, less than 23 cal/g of the mixture, less than 20 cal/g of the mixture, less than 18 cal/g of the mixture, less than 16 cal/g of the mixture, less than 15 cal/g of the mixture, less than 14 cal/g of the mixture, or less than 13.8 cal/g of the mixture. For example, prior to heating the mixture to a temperature of at least 60°C, the amount of energy generated from the mixture due to exothermic reaction(s) can be less than 14 cal/g, less than 13.5 cal/g, less than 13 cal/g, less than 12.5 cal/g, less than 12 cal/g, less than 11.5 cal/g, less than 11 cal/g, less than 10.5 cal/g, less than 10 cal/g, less than 9.5 cal/g, less than 9 cal/g, less than 8.5 cal/g, less than 8 cal/g, less than 7.5 cal/g, less

than 7 cal/g, less than 6.5 cal/g, less than 6 cal/g, less than 5.5 cal/g, less than 5 cal/g, less than 4.5 cal/g, less than 4 cal/g, less than 3.5 cal/g, less than 3 cal/g, less than 2.5 cal/g, less than 2 cal/g, less than 1.5 cal/g, less than 1 cal/g, or less than 0.5 cal/g of the mixture.

[00145] Pressure can optionally be applied to the mixture before, during, and/or after the mixture is heated to produce the composite product. For example, if the desired composite product shape or structure is a panel, sheet, board, or the like, an amount of the mixture sufficient to produce a composite product of the desired size, can be transported, directed, placed, introduced, disposed, or otherwise located within a press capable of pressing the mixture before the mixture is heated and/or when the mixture is heated. The press can be an open press or a closed press. In at least one specific example, an open press can be used to press the mixture when the mixture is heated, *e.g.*, to a temperature of about 100°C to about 250°C. In another example, the mixture can be extruded through a die (extrusion process) and heated to produce the composite product. The mixture can be pressed under a pressure of about 0.5 MPa, about 1 MPa, about 3 MPa, or about 5 MPa to about 7 MPa, about 9 MPa, or about 11 MPa.

[00146] Illustrative open presses can be as discussed and described in U.S. Patent Nos.: 4,017,248; 5,337,655; 5,611,269; 5,950,532; 6,098,532; and 6,782,810. Suitable, commercially available, open presses can include, but are not limited to, the CONTIROLL[®] press available from Siempelkamp and the CPS press available from Dieffenbacher.

[00147] Composite products in the shape or form of a panel, sheet, board, or the like can be in the form of a rectangular prism that includes six outer surfaces, *e.g.*, three pairs of oppositely facing surfaces. The first pair of oppositely facing surfaces of the composite product can include a first or "top" surface and an opposing second or "bottom" surface. The second and third pairs of oppositely facing surfaces of the composite product can be referred to as the "side surfaces" that have a surface area less than the surface area of the first and second surfaces. As such, composite products in the shape or form of a panel, sheet, board, or the like can have an average thickness, where the average thickness is the length or distance between the first and second surfaces.

[00148] If the composite product is in the form of a panel, sheet, board, or the like, the mixture can be heated about 5 seconds per millimeter of average thickness of the composite product (s/mm), about 10 s/mm, about 12 s/mm, or about 15 s/mm to about 17 s/mm, about 19 s/mm, about 21 s/mm, about 23 s/mm, about 25 s/mm, about 27 s/mm, about 30 s/mm, about 35

s/mm, about 40 s/mm, about 50 s/mm, or about 60 s/mm. For example, the mixture can be heated for about 7 s/mm to about 27 s/mm, about 9 s/mm to about 24 s/mm, about 11 s/mm to about 22 s/mm, about 8 s/mm to about 20 s/mm, about 14 s/mm to about 18 s/mm, about 6 s/mm to about 14 s/mm, about 10 s/mm to about 18 s/mm, or about 10 s/mm to about 16 s/mm. In another example, the mixture can be heated for less than 22 s/mm, less than 20 s/mm, less than 18 s/mm, less than 17 s/mm, less than 16 s/mm, less than 15 s/mm, less than 14 s/mm, less than 13 s/mm, or less than 12 s/mm. In one specific example, a composite product in the form of a panel, sheet, board, or the like and having an average thickness of about 15 mm and subjected to a total heating time of about 4 minutes would correspond to heating the mixture for about 16 s/mm. In at least one specific example, the mixture can be heated to a temperature of about 160°C to about 170°C for about 13 s/mm to about 19 s/mm.

[00149] Illustrative composite products discussed and described herein can include, but are not limited to, particleboard, fiberboard such as medium density fiberboard ("MDF") and/or high density fiberboard ("HDF"), plywood such as hardwood plywood and/or softwood plywood, oriented strand board ("OSB"), laminated veneer lumber ("LVL"), laminated veneer boards ("LVB"), or engineered wood flooring.

[00150] The method of making one or more composite products can include a continuous or semi-continuous blending process in which the lignocellulose substrates and the other components of the mixture, *e.g.*, the catalyst, oxidant, and the polyphenolic material, can be introduced to a blender at a first or introduction region, end, area, or other location(s) configured to receive the components and the mixture can be withdrawn from the blender via one or more mixture recovery outlets. The blender can be configured to contain a few hundred kilograms to several thousand kilograms. For example, a single blender can contain about 500 kg/hr, about 5,000 kg/hr, about 10,000 kg/hr, or about 13,000 kg/hr to about 16,000 kg/hr, about 20,000 kg/hr, about 25,000 kg/hr, or about 30,000 kg/hr of the mixture. As the mixture exits the blender, the mixture can be deposited onto a conveyor belt and can be transported to one or more dryers, moistening systems, presses, and/or other processing equipment. For example, a particle board product can be made blending a first or "face" mixture and a second or "core" mixture in a first and second blend, respectively. The first blender can produce about 13,600 kg/hr to about 15,900 kg/hr of a "face" mixture and the second blender can produce about 18,100 kg/hr to about 20,400 kg/hr of a "core" mixture. The "face" and "core" mixtures can be used to produce a particleboard panel or sheet, where

the "face" mixture makes up the outer layers of the particleboard and the "core" mixture makes up the inner or core layer of the particleboard.

[00151] Referring to particleboard in particular, particleboard made according to the methods discussed and described herein can meet or exceed the requirements for H-1, H-2, H-3, M-0, M-1, M-S, M-2, M-3i, LD-1, and/or LD-2 grade particleboard as described in the American National Standards Institute (ANSI) for particleboard, *e.g.*, ANSI A208.1-2009 Particleboard, approved February 2, 2009. Particleboard made according to the methods discussed and described herein can meet or exceed the requirements for PBU, D-2, D-3, and/or M-3 as defined by the ANSI for particleboard, *e.g.*, ANSI A208.1-2009 Particleboard, approved February 2, 2009. For example, Tables A and B set out certain requirements for the different grades of particleboard. Referring to oriented strand board (OSB) in particular, OSB made according to the methods discussed and described herein can meet or exceed the U.S. Department of Commerce Voluntary Performance Standard PS 2. Referring to plywood in particular, plywood made according to the methods discussed and described herein can meet or exceed the U.S. Department of Commerce Voluntary Performance Standard PS 1 and/or PS-2.

[00152] The composite product can have a density of about 0.5 g/cm³, about 0.55 g/cm³, about 0.6 g/cm³, about 0.63 g/cm³, about 0.65 g/cm³, about 0.67 g/cm³, or about 0.7 g/cm³ to about 0.75 g/cm³, about 0.77 g/cm³, about 0.8 g/cm³, about 0.83 g/cm³, about 0.85 g/cm³, about 0.88 g/cm³, about 0.93 g/cm³, about 0.97 g/cm³, or about 1 g/cm³. For example, the composite product can have a density of about 0.7 g/cm³ to about 0.75 g/cm³, about 0.65 g/cm³ to about 0.85 g/cm³, about 0.65 g/cm³ to about 0.8 g/cm³, about 0.67 g/cm³ to about 0.77 g/cm³, about 0.5 g/cm³, to about 1 g/cm³, about 0.5 g/cm³, to about 0.8 g/cm³, about 0.5 g/cm³ to about 0.75 g/cm³, or about 0.64 g/cm³ to about 0.8 g/cm³. In another example, the composite product can have a density of less than 1 g/cm³, less than 0.95 g/cm³, less than 0.88 g/cm³, less than 0.85 g/cm³, less than 0.83 g/cm³, less than 0.8 g/cm³, less than 0.79 g/cm³, less than 0.78 g/cm³, less than 0.77 g/cm³, less than 0.76 g/cm³, less than 0.75 g/cm³, less than 0.74 g/cm³, or less than 0.73 g/cm³.

[00153] The composite product can have an internal bond strength of about 0.3 MPa, about 0.32 MPa, about 0.34 MPa, about 0.35 MPa, about 0.37 MPa, about 0.4 MPa, about 0.42 MPa, about 0.48 MPa, about 0.52 MPa, about 0.55 MPa, or about 0.58 MPa to about 0.69 MPa, about 0.75 MPa, about 0.83 MPa, about 0.9 MPa, about 0.97 MPa, about 1.05 MPa,

about 1.15 MPa, about 1.2 MPa, about 1.25 MPa, about 1.3 MPa, about 1.35 MPa, about 1.4 MPa, about 1.45 MPa, about 1.5 MPa, about 1.55 MPa, about 1.6 MPa, or about 1.7 MPa. For example, the composite product can have an internal bond strength of about 0.35 MPa to about 0.55 MPa, about 0.4 MPa to about 0.6 MPa, about 0.48 MPa to about 0.69 MPa, about 0.59 MPa to about 0.86 MPa, about 0.55 MPa to about 0.9 MPa, or about 0.51 MPa to about 0.85 MPa. In another example, the composite product can have an internal bond strength of at least 0.33 MPa, at least 0.32 MPa, at least 0.34 MPa, at least 0.38 MPa, at least 0.41 MPa, at least 0.45 MPa, at least 0.48 MPa, at least 0.51 MPa, at least 0.55 MPa, at least 0.58 MPa, at least 0.62 MPa, at least 0.66 MPa, at least 0.69 MPa, at least 0.72 MPa, at least 0.76 MPa, or at least 0.79 MPa. The internal bond strength for each example can be determined according to the test procedure provided for in ASTM D1037-06a.

[00154] The composite product can have a density of less than 1 g/cm³, less than 0.95 g/cm³, less than 0.9 g/cm³, less than 0.85 g/cm³, less than 0.8 g/cm³, less than 0.79 g/cm³, less than 0.78 g/cm³, less than 0.77 g/cm³, less than 0.76 g/cm³, less than 0.75 g/cm³, less than 0.74 g/cm³, or less than 0.73 g/cm³ and an internal bond strength of at least 0.3 MPa, at least 0.35 MPa, at least 0.4 MPa, at least 0.48 MPa, at least 0.51 MPa, at least 0.55 MPa, at least 0.58 MPa, at least 0.62 MPa, at least 0.65 MPa, or at least 0.69 MPa. In at least one specific example, the composite product can have a density of less than 0.8 g/cm³ and internal bond strength of at least 0.48 MPa. In at least one other specific example, the composite product can have a density of less than 0.8 g/cm³ and internal bond strength of at least 0.69 MPa. In at least one other specific example, the composite product can have a density of less than 0.73 g/cm³ and internal bond strength of at least 0.48 MPa. In still another example, the composite product can have a density of less than 0.73 g/cm³ and internal bond strength of at least 0.58 MPa.

[00155] Composite products such as particleboard, fiberboard, plywood, and oriented strand board, can have a thickness or average thickness of about 1.5 mm, about 5 mm, or about 10 mm to about 15 mm, about 20 mm, about 25 mm, about 30 mm, about 50 mm, about 100 mm, about 200 mm, or about 300 mm. Composite products such as particleboard, fiberboard, plywood, and oriented strand board can have a length of about 0.1 m, about 0.5 m, about 1 m, about 1.2 m, about 1.8 m, about 2.4 m, about 3 m, or about 3.6 m. The composite products can also have a width of about 0.1 m, about 0.5 m, about 1 m, about 1.2 m, about 1.8 m, about 2.4 m, or about 3 m.

[00156] The mixtures discussed and described herein can be free or essentially free of formaldehyde for use in the production of the composite products, *e.g.*, wood products such as particleboard and plywood. As used herein, the term "essentially free of formaldehyde" means the mixture does not include or contain any intentionally added formaldehyde or compounds that can decompose, react, or otherwise form formaldehyde. Said another way, the term "essentially free of formaldehyde" means the mixture does not contain formaldehyde or compounds that can form formaldehyde, but may include formaldehyde present as an impurity. Accordingly, depending on the particular multifunctional aldehyde(s) used to produce the mixtures discussed and described herein, the mixture can be referred to as "no added formaldehyde" or "NAF" mixture.

[00157] The composite products discussed and described herein can exhibit a low level of formaldehyde emission. A suitable test for determining formaldehyde emission from a composite product can include ASTM D6007-02 and AST E1333-10. For example, the composite products can exhibit a formaldehyde emission of zero. In another example, the composite products can exhibit a formaldehyde emission of less than 1 part per million ("ppm"), less than 0.9 ppm, less than 0.08 ppm, less than 0.07 ppm, less than 0.06 ppm, less than 0.05 ppm, less than 0.04 ppm, less than 0.03 ppm, less than 0.02 ppm, less than 0.01 ppm, or less than 0.005 ppm.

[00158] The composite product can meet or exceed the formaldehyde emission standards required by the California Air Resources Board ("CARB") Phase 1 (less than 0.1 parts per million "ppm" formaldehyde for particleboard), and Phase 2 (less than 0.09 ppm formaldehyde for particleboard). The composite products discussed and described herein can also meet or exceed the formaldehyde emission standards required by the Japanese JIS/JAS F*** (does not exceed 0.5 mg/L formaldehyde for particleboard), Japanese JIS/JAS F**** (does not exceed 0.3 mg/L formaldehyde for particleboard), European E1, and European E2 standards.

[00159] The lignocellulose composite product can include a multilayer lignocellulose composite product. To facilitate the discussion on the multilayer lignocellulose composite product the following notation is used herein. Each layer of a multi-layer lignocellulose composite product is denoted "A" or "B," where "A" indicates a layer of lignocellulose substrates contacted with the free radical precursor and the calcium lignosulfonate, and "B" indicates a layer of lignocellulose substrates contacted with a conventional binder, adhesive,

or resin that does not contain both the free radical precursor and the calcium lignosulfonate. Where a multilayer product includes more than one A layer or more than one B layer, one or more prime symbols (', ", "", etc.) are appended to the A or B symbol to indicate layers of the same type that can be the same or can differ in one or more properties, such as, substrate composition, binder concentration, thickness, etc. Finally, the symbols for adjacent layers are separated by a slash (/).

[00160] Using this notation, a three-layer product having an inner or core layer of the lignocellulose substrates and an adhesive that does not contain both the free radical precursor and the calcium lignosulfonate (B layer), disposed between two outer or surface layers containing the lignocellulose substrates contacted with the free radical precursor and the calcium lignosulfonate (A layer), *e.g.*, the binder composition includes the aldehyde based resin and the copolymer, would be denoted A/B/A'. Similarly, a five-layer layer of alternating conventional/binder composition layers would be denoted A/B/A'/B'/A". Unless otherwise indicated, the left-to-right or right-to-left order of layers does not matter, nor does the order of prime symbols. For example, an A/B multi-layered product is equivalent to a B/A multi-layered product, and an A/A'/B/A" multi-layered product is equivalent to an A/B/A'/A" multi-layered product, for purposes described herein.

[00161] A multi-layer lignocellulose composite product that includes (the "A" layer) can be described as having any of the following exemplary structures: (a) two-layers, such as A/A, A/A', and A/B; (b) three-layers, such as A/B/B', A/B/A', A/A'/B, B/A/B' and A/A'/A"; (c) four-layer, such as A/A'/A"/B, A/A'/B/A", A/A'/B/B', A/B/A'/B', A/B/B'/A', B/A/A'/B', A/B/B'/B", B/A/B'/B", and A/A'/A"/A""; (d) five-layers, such as A/A'/A"/A""/B, A/A'/A"/B/A"", A/A'/B/A"/A"", A/A'/A"/B/B', A/A'/B/A"/B', A/A'/B/B'/A", A/B/A'/B'/A", A/B/A'/A"/B, B/A/A'/A"/B', A/A'/B/B'/B", A/B/A'/B'/B", A/B/B'/B"/A', B/A/A'/B'/B", B/A/B'/A'/B", B/A/B'/B"/A', A/B/B'/B"/B"", B/A/B'/B"/B"", B/B'/A/B"/B"", and A/A'/A"/A""/A""; and similar structures for multi-layer products having six, seven, eight, nine, ten, or any other number of layers.

[00162] For example, in a three layered lignocellulose composite product, the calcium lignosulfonate and one or more free radical precursors can be contacted with the lignocellulose substrates of the outer or surface layers and another adhesive, resin, or binder, *e.g.*, not containing both the calcium lignosulfonate and one or more free radical precursors, can be contacted with the lignocellulose substrates of the inner or "core" layer. In one

example, a three layered lignocellulose based composite product can include the calcium lignosulfonate and one or more free radical precursors in the outer layers and only an aldehyde based resin, in the inner or core layer. In another example, a three layered lignocellulose based composite product can include the calcium lignosulfonate and one or more free radical precursors in the outer layers and one or more polyphenolic compounds and one or more free radical precursors in the inner or core layer. In another example, a three layered lignocellulose composite product can include the calcium lignosulfonate and one or more free radical precursors, *e.g.*, the outer layers and the core layer. In another example, a three layered lignocellulose composite product can include calcium lignosulfonate and one or more free radical precursors in one outer layer and the other outer layer and the core layer can include only an aldehyde based resin. In another example, a three layered lignocellulose composite product can include calcium lignosulfonate and one or more free radical precursors in one outer layer and the core layer and the other outer layer can include only an aldehyde based resin.

[00163] In at least one example, a multi-layer lignocellulose composite product can include a core layer, a first outer layer bonded to a first side of the core layer, and a second outer layer bonded to a second side of the core layer, where the first and the second sides of the core layer oppose one another. At least one of the first and the second outer layers can include the plurality of lignocellulose substrates, the calcium lignosulfonate, and one or more free radical precursors. In another example, both the first and second outer layers can include the plurality of lignocellulose substrates, the calcium lignosulfonate, and one or more free radical precursors. The core layer can also include a plurality of lignocellulose substrates bonded to one another with a different binder composition, *e.g.*, a phenol-formaldehyde resin that does not include the calcium lignosulfonate, and one or more free radical precursors.

Examples

[00164] In order to provide a better understanding of the foregoing discussion, the following non-limiting examples are offered. Although the examples may be directed to specific embodiments, they are not to be viewed as limiting the invention in any specific respect. All parts, proportions, and percentages are by weight unless otherwise indicated.

[00165] A series of particleboard panels, namely, comparative examples C1 and C2 and inventive Example 1, were prepared and the brightness of the panels was measured. The comparative example C1 and inventive Example 1 were made using a medium density

fiberboard (MDF) manufacturing process. In this process wood chips from southern yellow pine were defibrated in a defibrator. The defibrated fibers were introduced into a blowline where the defibrated fibers were resinated. Ammonium lignosulfonate (C1) and calcium lignosulfonate (Ex. 1) were combined with iron EDTA (850 mL/min), and hydrogen peroxide (370 mL/min) and injected at the same time via two separate ports. The flow rate of the defibrated fibers was about 4,500 g/min based on the dry weight of the defibrated fibers. The mixture of the defibrated fibers, lignosulfonate, catalyst (iron EDTA), and oxidant (hydrogen peroxide) contained about 0.243 wt% catalyst and about 10 wt% lignosulfonate, based on the dry weight of the defibrated fibers. Each pass generated about 25 kg to about 30 kg of resinated fiber. The resinated fiber had a moisture content of about 11 wt% to about 19 wt%. The resinated fiber was placed in a 61 cm × 61 cm × 15 cm form and pressed to produce a panel having a thickness of 1.58 cm +/- 0.2 cm for about 225 seconds at a temperature of about 149°C.

[00166] Comparative example C2 was a particleboard panel made with southern yellow pine that had a moisture content of about 7 wt%. The wood was added to a ribbon blender and under mechanical blending, the resin, a urea-formaldehyde resin, was sprayed into the ribbon blender through an atomizer. The amount of resin combined with the wood was about 7 wt%, based on the dry weight of the wood. The mixture was spread into a 40.6 cm by 40.6 cm mat forming frame and manually pre-pressed. The mat forming frame was removed to provide a pre-pressed or consolidated mat. The consolidated mat was placed into a hot press at a temperature of about 174°C and subjected to a pressure sufficient to form a panel having a thickness of about 1.59 cm for about 150 seconds.

[00167] The brightness of the panels was measured according to the TAPPI Test Method T 452. A MiniScan™ XE Plus spectrophotometer at 457-nm wavelength was used to measure the brightness. The results of the brightness test are shown in the Table below.

Example	Particleboard	Wood Species	Brightness (%)
C1	Ammonium Lignosulfonate	Pine	11.67±0.18
C2	Urea-formaldehyde	Douglas Fir	16.90±0.63
Ex. 1	Calcium Lignosulfonate	Pine	19.99±0.29

[00168] As shown in the Table above, the inventive example Ex. 1 showed a surprising and unexpected increase in brightness (19.99%) as compared to both comparative examples C1 (11.67%) and C2 (16.9%), respectively.

[00169] Embodiments of the present disclosure further relate to any one or more of the following paragraphs:

[00170] 1. A method for making a composite product, comprising: combining a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor to produce a mixture, wherein the free radical precursor comprises an oxidant and a catalyst; and at least partially curing the mixture to produce a lignocellulose composite product.

[00171] 2. The method according to paragraph 1, wherein the lignocellulose composite product has a brightness of about 15% to about 25%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00172] 3. The method according to paragraph 1 or 2, wherein a brightness of the lignocellulose composite product is greater than a brightness of a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00173] 4. The method according to any one of paragraphs 1 to 3, wherein a brightness of the lignocellulose composite product is at least 1.1 times greater than a brightness of a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00174] 5. The method according to any one of paragraphs 1 to 3, wherein a brightness of the lignocellulose composite product is at least 1.5 times greater than a brightness of a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00175] 6. The method according to any one of paragraphs 1 to 5, wherein the mixture comprises about 0.05 wt% to about 5 wt% of the catalyst based on a dry weight of the plurality of lignocellulose substrates.

[00176] 7. The method according to any one of paragraphs 1 to 6, wherein the catalyst comprise potassium ferricyanide, iron ethylenediaminetetraacetic acid, iron (*S,S*)-ethylenediamine-*N,N'*-disuccinic acid, iron diethylenetriamine pentaacetic acid, iron ethyleneglycol bis(2-aminoethyleter)-*N,N,N',N'*-tetraacetic acid, iron *trans*-1,2-diaminocyclohexanetetraacetic acid, isomers thereof, acids thereof, salts thereof, hydrates thereof, or any mixture thereof.

[00177] 8. The method according to any one of paragraphs 1 to 7, wherein the oxidant comprises hydrogen peroxide, and wherein the catalyst comprises iron.

[00178] 9. The method according to any one of paragraphs 1 to 8, wherein the catalyst is in the form of a complex bound to one or more complexing agents.

[00179] 10. The method according to paragraph 9, wherein the one or more complexing agents comprises cyanide (CN⁻), sulfate (SO₄²⁻), ethylenediaminetetraacetic acid (EDTA), ethylenediamine-*N,N'*-disuccinic acid (EDDS), ethyleneglycol-bis(2-aminoethylether)-*N,N,N',N'*-tetraacetic acid (EGTA), diethylenetriaminepentaacetic acid (DTPA), *trans*-1,2-diaminocyclohexane tetraacetic acid (CDTA), iminodisuccinate (IDS), nitrilotracetic acid (NTA), isomers thereof, acids thereof, salts thereof, hydrates thereof, or any mixture thereof.

[00180] 11. The method according to any one of paragraphs 1 to 10, wherein the composite product has an internal bond strength of at least 0.5 MPa and a density of less than 0.9 g/cm³.

[00181] 12. The method according to any one of paragraphs 1 to 11, further comprising: maintaining the mixture at a temperature of less than 60°C for at least 10 minutes while retaining at least 11 wt% of the oxidant charged to the mixture; and then heating the mixture comprising at least 11 wt% of the oxidant charged to the mixture to a temperature of at least 60°C to about 300°C to produce the lignocellulose composite product.

[00182] 13. The method according to paragraph 12, wherein the mixture is maintained at the temperature of less than 60°C for at least 20 minutes while retaining at least 25 wt% of the oxidant charged to the mixture, and wherein the mixture comprising at least 25 wt% of the oxidant charged to the mixture is heated to the temperature of at least 60°C to about 300°C to produce the lignocellulose composite product.

[00183] 14. The method according to paragraph 12 or 13, wherein, prior to heating the mixture comprising at least 11 wt% of the oxidant charged to the mixture to the temperature

of at least 60°C to about 300°C to produce the lignocellulose composite product, an amount of energy generated from the mixture due to any exothermic reaction is less than 20 cal/g.

[00184] 15. The method according to any one of paragraphs 1 to 14, wherein the calcium lignosulfonate is in a solid form when combined with the plurality of lignocellulose substrates and the free radical precursor.

[00185] 16. The method according to any one of paragraphs 1 to 15, wherein the calcium lignosulfonate is in a liquid form when combined with the plurality of lignocellulose substrates and the free radical precursor.

[00186] 17. A method for making a composite product, comprising: combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and a polyphenolic material to produce a mixture, wherein the polyphenolic material comprises lignin, tannins, a novolac resin, bisphenol A, modified phenol formaldehyde resin, humic acid, or any mixture thereof; and at least partially curing the mixture to produce a lignocellulose composite product.

[00187] 18. The method according to paragraph 17, wherein at least partially curing the mixture comprises heating the mixture comprising at least 11 wt% of the free radical precursor charged to the mixture to a temperature of at least 60°C to about 300°C to produce a composite product.

[00188] 19. The method according to paragraph 18, wherein the mixture is maintained at a temperature of less than 60°C for at least 10 minutes prior to heating the mixture comprising at least 11 wt% of the free radical precursor charged to the mixture to the temperature of at least 60°C to about 300°C.

[00189] 20. A lignocellulose composite product, comprising an at least partially cured composition, wherein prior to curing the composition comprises a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor, and wherein the lignocellulose composite product has brightness of about 15% to about 25%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00190] 21. A method for making a lignocellulose composite product, comprising: combining a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor to produce a mixture, wherein the free radical precursor comprises a compound having the general formula $R'-N=N-R''$, wherein R' and R'' is independently a substituted aryl or a

substituted alkyl; and at least partially curing the mixture to produce a lignocellulose composite product.

[00191] 22. The method according to paragraph 21, wherein the one or more free radical precursors comprises azobisisobutyronitrile (AIBN).

[00192] 23. The method according to paragraph 21 or 22, wherein the lignocellulose composite product has brightness of about 15% to about 25%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00193] 24. A method for making a composite product, comprising: combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound to produce a mixture, wherein the unsaturated compound comprises two or more unsaturated carbon-carbon bonds, wherein at least one of the unsaturated carbon-carbon bonds is a pi-bond that is not conjugated with an aromatic moiety and is capable of free radical addition; and at least partially curing the mixture to produce a lignocellulose composite product.

[00194] 25. The method according to paragraph 24, wherein the polyphenolic material comprises one or more lignins, one or more tannins, one or more novolac resins, one or more bisphenols, one or more modified phenol formaldehyde resins, humic acid, or any mixture thereof, and wherein the unsaturated compound comprises dicyclopentadiene (DCPD), ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate, poly(ethylene glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate (TMPTA), pentaerythritol tetraacrylate, pentaerythritol triacrylate, polyacrylate starch, linseed oil, an unsaturated prepolymer, isomers thereof, or any mixture thereof.

[00195] 26. The method according to paragraph 24 or 25, wherein the mixture comprises the polyphenolic material.

[00196] 27. The method according to any one of paragraphs 24 to 26, wherein the mixture comprises the unsaturated compound.

[00197] 28. The method according to any one of paragraphs 24 to 27, wherein at least partially curing the mixture comprises heating the mixture comprising at least 11 wt% of the

free radical precursor charged to the mixture to a temperature of at least 60°C to about 300°C to produce a composite product.

[00198] 29. The method according to paragraph 28, wherein the mixture is maintained at a temperature of less than 60°C for at least 10 minutes prior to heating the mixture comprising at least 11 wt% of the free radical precursor charged to the mixture to the temperature of at least 60°C to about 300°C.

[00199] 30. The method according to any one of paragraphs 24 to 29, wherein the polyphenolic material is modified with one or more compounds having carbon-carbon double bonds and one or more functional groups.

[00200] 31. The method according to any one of paragraphs 25 to 30, wherein the unsaturated prepolymer is present and comprises an unsaturated polyester prepolymer, an unsaturated polyether prepolymer; an unsaturated polyamide prepolymer, an unsaturated polyurethane prepolymer, or any mixture thereof.

[00201] 32. The method according to any one of paragraphs 24 to 31, wherein at least one of the unsaturated carbon-carbon bonds that is a pi-bond that is not conjugated with an aromatic moiety and is capable of free radical addition is an α,β -unsaturated carbonyl.

[00202] 33. The method according to any one of paragraphs 24 to 32, wherein the free radical precursor comprises a mixture of one or more oxidants and one or more catalysts.

[00203] 34. The method according to any one of paragraphs 24 to 33, wherein the free radical precursor comprises a mixture of one or more inorganic oxidants and one or more catalysts.

[00204] 35. The method according to any one of paragraphs 24 to 34, wherein the free radical precursor comprises a mixture of hydrogen peroxide and one or more iron containing catalysts.

[00205] 36. The method according to any one of paragraphs 24 to 35, wherein the one or more free radical precursors comprises one or more catalysts, and wherein the one or more catalysts comprises one or more metals in the form of a complex bound to one or more complexing agents.

[00206] 37. The method according to any one of paragraphs 24 to 36, wherein the lignocellulose composite product has a brightness of about 15% to about 25%, as measured according to according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00207] 38. The method according to any one of paragraphs 24 to 37, wherein a brightness of the lignocellulose composite product is greater than a brightness of a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00208] 39. The method according to any one of paragraphs 24 to 38, wherein a brightness of the lignocellulose composite product is at least 1.1 times greater than a brightness of a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00209] 40. The method according to any one of paragraphs 24 to 39, wherein a brightness of the lignocellulose composite product is at least 1.5 times greater than a brightness of a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00210] 41. The method according to any one of paragraphs 24 to 40, wherein the mixture comprises about 0.05 wt% to about 5 wt% of the catalyst based on a dry weight of the plurality of lignocellulose substrates.

[00211] 42. The method according to any one of paragraphs 24 to 41, wherein the catalyst comprise potassium ferricyanide, iron ethylenediaminetetraacetic acid, iron (S,S)-ethylenediamine-*N,N'*-disuccinic acid, iron diethylenetriamine pentaacetic acid, iron ethyleneglycol bis(2-aminoethylether)-*N,N,N',N'*-tetraacetic acid, iron *trans*-1,2-diaminocyclohexanetetraacetic acid, or any mixture thereof.

[00212] 43. The method according to any one of paragraphs 24 to 42, wherein the oxidant comprises hydrogen peroxide, and wherein the catalyst comprises iron.

[00213] 44. The method according to any one of paragraphs 24 to 43, wherein the catalyst is in the form of a complex bound to one or more complexing agents.

[00214] 45. The method according to paragraph 44, wherein the one or more complexing agents comprises cyanide (CN⁻), sulfate (SO₄²⁻), ethylenediaminetetraacetic acid (EDTA), ethylenediamine-*N,N'*-disuccinic acid (EDDS), ethyleneglycol-bis(2-aminoethylether)-*N,N,N',N'*-tetraacetic acid (EGTA), diethylenetriaminepentaacetic acid (DTPA), *trans*-1,2-

diaminocyclohexane tetraacetic acid (CDTA), iminodisuccinate (IDS), nitrilotracetic acid (NTA), isomers thereof, acids thereof, salts thereof, hydrates thereof, or any mixture thereof.

[00215] 46. The method according to any one of paragraphs 24 to 45, wherein the composite product has an internal bond strength of at least 0.5 MPa and a density of less than 0.9 g/cm³.

[00216] 47. The method according to any one of paragraphs 24 to 46, further comprising: maintaining the mixture at a temperature of less than 60°C for at least 10 minutes while retaining at least 11 wt% of the oxidant charged to the mixture; and then heating the mixture comprising at least 11 wt% of the oxidant charged to the mixture to a temperature of at least 60°C to about 300°C to produce the lignocellulose composite product.

[00217] 48. The method according to paragraph 47, wherein the mixture is maintained at the temperature of less than 60°C for at least 20 minutes while retaining at least 25 wt% of the oxidant charged to the mixture, and wherein the mixture comprising at least 25 wt% of the oxidant charged to the mixture is heated to the temperature of at least 60°C to about 300°C to produce the lignocellulose composite product.

[00218] 49. The method according to paragraph 47 or 48, wherein, prior to heating the mixture comprising at least 11 wt% of the oxidant charged to the mixture to the temperature of at least 60°C to about 300°C to produce the lignocellulose composite product, an amount of energy generated from the mixture due to any exothermic reaction is less than 20 cal/g.

[00219] 50. The method according to any one of paragraphs 24 to 49, wherein the calcium lignosulfonate is in a solid form when combined with the plurality of lignocellulose substrates and the free radical precursor.

[00220] 51. The method according to any one of paragraphs 24 to 50, wherein the calcium lignosulfonate is in a liquid form when combined with the plurality of lignocellulose substrates and the free radical precursor.

[00221] 52. The method according to any one of paragraphs 24 to 51, wherein the polyphenolic material is present, and wherein the polyphenolic material and the calcium lignosulfonate are not the same.

[00222] 53. The method according to any one of paragraphs 24 to 51, wherein the polyphenolic material is present, and wherein the polyphenolic material and the calcium lignosulfonate are different from one another.

[00223] 54. The method or composite product according to any one of paragraphs 1 to 53, wherein the calcium lignosulfonate is a liquid form, and wherein the liquid form is an aqueous solution.

[00224] 55. The method or composite product according to any one of paragraphs 1 to 53, wherein the calcium lignosulfonate is in a liquid form, and wherein the liquid form comprises solid calcium lignosulfonate suspended or dispersed in a liquid medium.

[00225] 56. The method or composite product according to any one of paragraphs 24 to 55, wherein the polyphenolic material is in a liquid form, and wherein the liquid form is an aqueous solution.

[00226] 57. The method or composite product according to any one of paragraphs 24 to 55, wherein the polyphenolic material is in a liquid form, and wherein the liquid form comprises solid polyphenolic material suspended or dispersed in a liquid medium.

[00227] 58. A lignocellulose composite product, comprising an at least partially cured composition, wherein prior to curing the composition comprises a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor, and wherein the lignocellulose composite product has brightness of about 10% to about 35%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

[00228] 59. The composite product according to paragraph 58, wherein the lignocellulose composite product has a brightness of about 15% to about 30%.

[00229] 60. The composite product according to paragraph 58 or 59, wherein the lignocellulose composite product has a brightness of about 17% to about 30%.

[00230] 61. The composite product according to any one of paragraphs 58 to 60, wherein the lignocellulose composite product has a brightness of about 18% to about 25%.

[00231] 62. The composite product according to any one of paragraphs 58 to 61, wherein the lignocellulose composite product has a brightness of about 19% to about 27%.

[00232] 63. The composite product according to any one of paragraphs 58 to 62, wherein a brightness of the lignocellulose composite product is at least 1.1 times greater than a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate.

[00233] 64. The composite product according to any one of paragraphs 58 to 63, wherein a brightness of the lignocellulose composite product is at least 1.2 times greater than a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate.

[00234] 65. The composite product according to any one of paragraphs 58 to 64, wherein a brightness of the lignocellulose composite product is at least 1.3 times greater than a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate.

[00235] 66. The composite product according to any one of paragraphs 58 to 65, wherein a brightness of the lignocellulose composite product is at least 1.4 times greater than a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate.

[00236] 67. The composite product according to any one of paragraphs 58 to 66, wherein a brightness of the lignocellulose composite product is at least 1.5 times greater than a comparative lignocellulose composite product made under the same conditions except the calcium lignosulfonate is replaced with ammonium lignosulfonate.

[00237] 68. The composite product according to any one of paragraphs 58 to 62, wherein a brightness of the lignocellulose composite product is at least 1.1 times greater than a comparative lignocellulose composite product made the same way but with ammonium lignosulfonate instead of calcium lignosulfonate.

[00238] 69. The composite product according to any one of paragraphs 58 to 62, wherein a brightness of the lignocellulose composite product is at least 1.2 times greater than a comparative lignocellulose composite product made the same way but with ammonium lignosulfonate instead of calcium lignosulfonate.

[00239] 70. The composite product according to any one of paragraphs 58 to 62, wherein a brightness of the lignocellulose composite product is at least 1.3 times greater than a comparative lignocellulose composite product made the same way but with ammonium lignosulfonate instead of calcium lignosulfonate.

[00240] 71. The composite product according to any one of paragraphs 58 to 62, wherein a brightness of the lignocellulose composite product is at least 1.4 times greater than a

comparative lignocellulose composite product made the same way but with ammonium lignosulfonate instead of calcium lignosulfonate.

[00241] 72. The composite product according to any one of paragraphs 58 to 62, wherein a brightness of the lignocellulose composite product is at least 1.5 times greater than a comparative lignocellulose composite product made the same way but with ammonium lignosulfonate instead of calcium lignosulfonate.

[00242] Certain embodiments and features have been described using a set of numerical upper limits and a set of numerical lower limits. It should be appreciated that ranges including the combination of any two values, *e.g.*, the combination of any lower value with any upper value, the combination of any two lower values, and/or the combination of any two upper values are contemplated unless otherwise indicated. Certain lower limits, upper limits, and ranges appear in one or more claims below. All numerical values are “about” or “approximately” the indicated value, and take into account experimental error and variations that would be expected by a person having ordinary skill in the art.

[00243] Various terms have been defined above. To the extent a term used in a claim is not defined above, it should be given the broadest definition persons in the pertinent art have given that term as reflected in at least one printed publication or issued patent.

[00244] While the foregoing is directed to embodiments of the present invention, other and further embodiments of the invention may be devised without departing from the basic scope thereof, and the scope thereof is determined by the claims that follow.

Claims

What is claimed is:

1. A method for making a lignocellulose composite product, comprising:

combining a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor to produce a mixture, wherein the free radical precursor comprises an oxidant and a catalyst; and

at least partially curing the mixture to produce the lignocellulose composite product.
2. The method of claim 1, wherein the lignocellulose composite product has a brightness of about 15% to about 25%, as measured according to according to TAPPI Test Method T 452 at a wavelength of 457 nm.
3. The method of claim 1, wherein a brightness of the lignocellulose composite product is greater than a brightness of a lignocellulose composite product made under the same conditions with ammonium lignosulfonate instead of calcium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.
4. The method of claim 1, wherein a brightness of the lignocellulose composite product is at least 1.1 times greater than a brightness of a lignocellulose composite product made under the same conditions with ammonium lignosulfonate instead of calcium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.
5. The method of claim 1, wherein a brightness of the lignocellulose composite product is at least 1.5 times greater than a brightness of a lignocellulose composite product made under the same conditions with ammonium lignosulfonate instead of calcium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.
6. The method of claim 1, wherein the mixture comprises about 0.05 wt % to about 5 wt % of the catalyst based on a dry weight of the plurality of lignocellulose substrates.

7. The method of claim 1, wherein the catalyst comprises potassium ferricyanide, iron ethylenediaminetetraacetic acid, iron (S,S)-ethylenediamine-N,N'-disuccinic acid, iron diethylenetriamine pentaacetic acid, iron ethyleneglycol bis(2-aminoethylether)-N, N,N',N'-tetraacetic acid, iron trans-1,2-diaminocyclohexanetetraacetic acid, or any mixture thereof.
8. The method of claim 1, wherein the oxidant comprises hydrogen peroxide, and wherein the catalyst comprises iron.
9. The method of claim 1, wherein the catalyst is in the form of a complex bound to one or more complexing agents.
10. The method of claim 9, wherein the one or more complexing agents comprises cyanide (CN^-), sulfate (SO_4^{2-}), ethylenediaminetetraacetic acid (EDTA), ethylenediamine-N,N'-disuccinic acid (EDDS), ethyleneglycol-bis(2-aminoethylether)-N,N,N',N'-tetraacetic acid (EGTA), diethylenetriaminepentaacetic acid (DTPA), trans-1,2-diaminocyclohexane tetraacetic acid (CDTA), iminodisuccinate (IDS), nitrilotracetic acid (NTA), isomers thereof, acids thereof, salts thereof, hydrates thereof, or any mixture thereof.
11. The method of claim 1, further comprising: maintaining the mixture at a temperature of less than 60° C. for at least 10 minutes while retaining at least 11 wt % of the oxidant charged to the mixture; and then heating the mixture comprising at least 11 wt % of the oxidant charged to the mixture to a temperature of at least 60° C. to about 300° C. to produce the lignocellulose composite product.
12. The method of claim 11, wherein the mixture is maintained at the temperature of less than 60° C. for at least 20 minutes while retaining at least 25 wt % of the oxidant charged to the mixture, and wherein the mixture comprising at least 25 wt % of the oxidant charged to the mixture is heated to the temperature of at least 60° C. to about 300° C. to produce the lignocellulose composite product.

13. The method of claim 11, wherein, prior to heating the mixture comprising at least 11 wt % of the oxidant charged to the mixture to the temperature of at least 60° C. to about 300° C. to produce the lignocellulose composite product, an amount of energy generated from the mixture due to any exothermic reaction is less than 20 cal/g.
14. The method of claim 1, wherein the calcium lignosulfonate is in a solid form when combined with the plurality of lignocellulose substrates and the free radical precursor.
15. The method of claim 1, wherein the calcium lignosulfonate is in a liquid form when combined with the plurality of lignocellulose substrates and the free radical precursor.
16. A method for making a lignocellulose composite product, comprising: combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound to produce a mixture, wherein the unsaturated compound comprises two or more unsaturated carbon-carbon bonds, wherein at least one of the unsaturated carbon-carbon bonds is a pi-bond that is not conjugated with an aromatic moiety and is capable of free radical addition, and wherein the polyphenolic material comprises lignin, tannins, a novolac resin, bisphenol A, modified phenol formaldehyde resin, humic acid, or any mixture thereof, and wherein the free radical precursor comprises an oxidant and a catalyst; and at least partially curing the mixture to produce the lignocellulose composite product.
17. The method of claim 16, wherein the mixture comprises the unsaturated compound, and wherein the unsaturated compound comprises dicyclopentadiene (DCPD), ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate, poly(ethylene glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate (TMPTA), pentaerythritol tetraacrylate, pentaerythritol triacrylate, polyacrylate starch, linseed oil, an unsaturated prepolymer, or any mixture thereof.

18. The method of claim 16, wherein at least partially curing the mixture comprises heating the mixture comprising at least 11 wt % of the oxidant charged to the mixture to a temperature of at least 60° C. to about 300° C. to produce a composite product.
19. The method of claim 18, wherein the mixture is maintained at a temperature of less than 60° C. for at least 10 minutes prior to heating the mixture comprising at least 11 wt % of the oxidant charged to the mixture to the temperature of at least 60° C. to about 300° C.
20. A method for making a lignocellulose composite product, comprising:
- combining a plurality of lignocellulose substrates, calcium lignosulfonate, a free radical precursor, and an unsaturated compound to produce a mixture, wherein:
- the free radical precursor comprises an oxidant and a catalyst,
- the unsaturated compound comprises dicyclopentadiene (DCPD), ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate, poly(ethylene glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate (TMPTA), pentaerythritol tetraacrylate, pentaerythritol triacrylate, an unsaturated polyester prepolymer, an unsaturated polyether prepolymer, an unsaturated polyamide prepolymer, an unsaturated polyurethane prepolymer, or any mixture thereof, and
- the mixture comprises about 1 wt % to 80 wt % of the unsaturated compound, based on a combined weight of the unsaturated compound and the free radical precursor; and
- at least partially curing the mixture to produce the lignocellulose composite product.
21. A lignocellulose composite product, comprising an at least partially cured composition, wherein, prior to curing, the composition comprises a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor, and wherein the lignocellulose composite

product has a brightness of about 10% to about 35%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

22. The composite product according to claim 21, wherein the lignocellulose composite product has a brightness of at least 15%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

23. The composite product according to claim 21, wherein the lignocellulose composite product has a brightness of at least 19%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

24. The composite product according to any one of claims 21 to 23, wherein the brightness of the lignocellulose composite product is at least 1.1 times greater than a brightness of a lignocellulose composite product made under the same conditions with ammonium lignosulfonate instead of calcium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

25. The composite product according to any one of claims 21 to 23, wherein the brightness of the lignocellulose composite product is at least 1.5 times greater than a brightness of a lignocellulose composite product made under the same conditions with ammonium lignosulfonate instead of calcium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

26. The composite product according to claim 24 or claim 25, wherein the brightness of the lignocellulose composite product is up to about 3.5 times greater than the lignocellulose composite product made under the same conditions with ammonium lignosulfonate instead of calcium lignosulfonate, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

27. The composite product according to any one of claims 21 to 26, wherein the free radical precursor comprises an oxidant and a catalyst.

28. The composite product according to claim 27, wherein the composite product comprises about 0.01 wt% to about 5 wt% of the catalyst, based on the dry weight of the plurality of lignocellulose substrates.

29. The composite product according to claim 27 or claim 28, wherein the catalyst comprises iron, copper, manganese, tungsten, molybdenum, cobalt, titanium, or a mixture thereof.

30. The composite product according to any one of claims 21 to 29, wherein the composite product comprises about 0.1 wt% to about 30 wt% of the calcium lignosulfonate, based on the dry weight of the lignocellulose substrates.

31. The composite product according to any one of claims 21 to 30, wherein the composite product is essentially free of formaldehyde.

32. The composite product according to any one of claims 21 to 31, wherein, prior to curing, the composition further comprises a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound.

33. The composite product according to claim 32, wherein, prior to curing, the composition comprises the polyphenolic material, and wherein the polyphenolic material comprises lignin, tannins, a novolac resin, bisphenol A, modified phenol formaldehyde resin, humic acid, or a mixture thereof.

34. The composite product according to claim 32, wherein, prior to curing, the composition comprises the unsaturated compound, wherein the unsaturated compound comprises two or more unsaturated carbon-carbon bonds, and wherein at least one of the unsaturated carbon-carbon bonds is a pi-bond that is not conjugated with an aromatic moiety and is capable of free radical addition.

35. The composite product according to claim 34, wherein the unsaturated compound comprises dicyclopentadiene (DCPD), ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate, poly(ethylene

glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate (TMPTA), pentaerythritol tetraacrylate, pentaerythritol triacrylate, polyacrylate starch, linseed oil, an unsaturated prepolymer, or a mixture thereof.

36. The composite product according to any one of claims 32 to 35, wherein, prior to curing, the composition comprises the polyphenolic material and the unsaturated compound.

37. The composite product according to any one of claims 21 to 36, wherein the composite product is particleboard, fiberboard, plywood, oriented strand board, laminated veneer lumber, laminated veneer boards, or engineered wood flooring.

38. The composite product according to any one of claims 21 to 36, wherein the composite product is fiberboard.

39. A multi-layer lignocellulose composite product, comprising:
a core layer disposed between two outer layers, wherein at least one of the two outer layers comprises an at least partially cured composition, wherein, prior to curing, the composition comprises a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor, and wherein the at least one of the two outer layers has a brightness of about 10% to about 35%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

40. The multi-layer lignocellulose composite product according to claim 39, wherein each of the two outer layers comprises the at least partially cured composition, and wherein each of the two outer layers has a brightness of about 10% to about 35%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

41. The multi-layer lignocellulose composite product according to claim 39 or claim 40, wherein the core layer comprises an at least partially cured second composition, wherein, prior to curing, the second composition comprises a second plurality of lignocellulose substrates and a binder composition that is free of calcium lignosulfonate.

42. The multi-layer lignocellulose composite product according to claim 39 or claim 40, wherein the core layer comprises an at least partially cured second composition, wherein, prior to curing, the second composition comprises a second plurality of lignocellulose substrates and a binder composition that is free of calcium lignosulfonate and free of a radical precursor.
43. The multi-layer lignocellulose composite product according to claim 39, wherein the at least one of the two outer layers has a brightness of at least 15%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.
44. The multi-layer lignocellulose composite product according to claim 39, wherein the at least one of the two outer layers has a brightness of at least 19%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.
45. The multi-layer lignocellulose composite product according to any one of claims 39 to 44, wherein the free radical precursor comprises an oxidant and a catalyst.
46. The multi-layer lignocellulose composite product according to claim 45, wherein the at least one of the two layers comprises about 0.01 wt% to about 5 wt% of the catalyst, based on the dry weight of the plurality of lignocellulose substrates.
47. The multi-layer lignocellulose composite product according to claim 45 or claim 46, wherein the catalyst comprises iron, copper, manganese, tungsten, molybdenum, cobalt, titanium, or a mixture thereof.
48. The multi-layer lignocellulose composite product according to any one of claims 39 to 47, wherein the at least one of the two outer layers comprises about 0.1 wt% to about 30 wt% of the calcium lignosulfonate, based on the dry weight of the lignocellulose substrates.
49. The multi-layer lignocellulose composite product according to any one of claims 39 to 48, wherein the at least one of the two outer layers is essentially free of formaldehyde.

50. The multi-layer lignocellulose composite product according to any one of claims 39 to 49, wherein, prior to curing, the composition further comprises a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound.

51. The multi-layer lignocellulose composite product according to claim 50, wherein, prior to curing, the composition comprises the polyphenolic material, and wherein the polyphenolic material comprises lignin, tannins, a novolac resin, bisphenol A, modified phenol formaldehyde resin, humic acid, or a mixture thereof.

52. The multi-layer lignocellulose composite product according to claim 50, wherein, prior to curing, the composition comprises the unsaturated compound, wherein the unsaturated compound comprises two or more unsaturated carbon-carbon bonds, and wherein at least one of the unsaturated carbon-carbon bonds is a pi-bond that is not conjugated with an aromatic moiety and is capable of free radical addition.

53. The multi-layer lignocellulose composite product according to claim 52, wherein the unsaturated compound comprises dicyclopentadiene (DCPD), ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate, poly(ethylene glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate (TMPTA), pentaerythritol tetraacrylate, pentaerythritol triacrylate, polyacrylate starch, linseed oil, an unsaturated prepolymer, or a mixture thereof.

54. The multi-layer lignocellulose composite product according to any one of claims 50 to 53, wherein, prior to curing, the composition comprises the polyphenolic material and the unsaturated compound.

55. A resinated furnish comprising a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor, wherein the free radical precursor comprises an oxidant and a catalyst.

56. The resinated furnish according to claim 55, wherein the oxidant comprises an inorganic peroxy compound, an organic peroxy compound, an ozonide, a halogen containing oxidant, or any mixture thereof.

57. The resinated furnish according to claim 55 or 56, wherein the oxidant comprises hydrogen peroxide.

58. The resinated furnish according to any one of claims 55 to 57, wherein the oxidant is present in an amount that is about 0.01 times to about 2 times the amount of the plurality of lignocellulose substrates, based on a dry weight of the plurality of lignocellulose substrates.

59. The resinated furnish according to any one of claims 55 to 58, wherein the catalyst comprises iron, copper, manganese, tungsten, molybdenum, cobalt, titanium, or any mixture thereof.

60. The resinated furnish according to any one of claims 55 to 59, wherein the catalyst comprises iron(II) sulfate, iron(II) oxide, iron(III) sulfate, iron(III) oxide, ferricyanide, ferrocyanide, nitroprusside, potassium ferricyanide, potassium ferrocyanide, ammonium ferricyanide hydrate, ammonium ferrocyanide hydrate, sodium ferricyanide decahydrate, sodium ferrocyanide decahydrate, sodium nitroprusside dihydrate, or any mixture thereof.

61. The resinated furnish according to any one of claims 55 to 60, wherein the catalyst comprises a complex of iron and ethylenediaminetetraacetic acid, a complex of iron and (S,S)-ethylenediamine-*N,N'*-disuccinic acid, a complex of iron and (*R,R*)-ethylenediamine-*N,N'*-disuccinic acid, a complex of iron and (*R,S*)-ethylenediamine-*N,N'*-disuccinic acid, a complex of iron and diethylenetriaminepentaacetic acid, a complex of iron and *trans*-1,2-diaminocyclohexane tetraacetic acid, a complex of iron and iminodisuccinate, salts thereof, acids thereof, hydrates thereof, or any mixture thereof.

62. The resinated furnish according to any one of claims 55 to 61, wherein the catalyst comprises potassium ferricyanide, iron ethylenediaminetetraacetic acid, iron (S,S)-ethylenediamine-*N,N'*-disuccinic acid, iron diethylenetriamine pentaacetic acid, iron ethylene glycol bis(2-aminoethyleter)-*N, N,N',N'*-tetraacetic acid, iron *trans*-1,2-diaminocyclohexanetetraacetic acid, or any mixture thereof.

63. The resinated furnish according to any one of claims 55 to 62, wherein the catalyst comprises a tertiary amine, a polymeric tertiary amine, a phosphate, a bisulfite, a metabisulfite, tetraacetylenediamine, a cyanamide, or any mixture thereof.

64. The resinated furnish according to any one of claims 55 to 63, wherein the resinated furnish comprises about 0.01 wt% to about 5 wt% of the catalyst based on a dry weight of the plurality of lignocellulose substrates.

65. The resinated furnish according to any one of claims 55 to 64, wherein the catalyst comprises metal ions in the form of a complex bound to one or more complexing agents.

66. The resinated furnish of claim 65, wherein the one or more complexing agents comprises cyanide, sulfate, ethylenediaminetetraacetic acid, ethylenediamine-N,N'-disuccinic acid, ethyleneglycol-bis(2-aminoethylether)-N,N,N',N'-tetraacetic acid, diethylenetriaminepentaacetic acid, trans-1,2-diaminocyclohexane tetraacetic acid, iminodisuccinate, nitrilotracetic acid, isomers thereof, acids thereof, salts thereof, hydrates thereof, or any mixture thereof.

67. The resinated furnish according to any one of claims 55 to 66, wherein the resinated furnish further comprises a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound.

68. The resinated furnish of claim 67, wherein the resinated furnish comprises the polyphenolic material, and wherein the polyphenolic material comprises lignin, tannins, a novolac resin, bisphenol A, modified phenol formaldehyde resin, humic acid, or any mixture thereof.

69. The resinated furnish according to claim 67 or 68, wherein the resinated furnish comprises the unsaturated compound, and wherein the unsaturated compound comprises dicyclopentadiene, ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate, poly(ethylene glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate, pentaerythritol tetraacrylate,

pentaerythritol triacrylate, polyacrylate starch, linseed oil, an unsaturated prepolymer, or any mixture thereof.

70. The resinated furnish according to any one of claims 55 to 69, wherein the resinated furnish comprises about 0.1 wt% to about 30 wt% of the calcium lignosulfonate, based on the dry weight of the lignocellulose substrates.

71. The resinated furnish according to any one of claims 55 to 70, wherein the resinated furnish is essentially free of formaldehyde.

72. The resinated furnish according to any one of claims 55 to 71, wherein the resinated furnish comprises about 1 wt% to about 50 wt% of a liquid medium, based on the total weight of the resinated furnish.

73. The resinated furnish of claim 72, wherein the liquid medium comprises water.

74. The resinated furnish according to any one of claims 55 to 73, further comprising an additive.

75. The resinated furnish according to claim 74, wherein the additive comprises a hydrophobic additive, a filler material, an extender, a surfactant, a release agent, a fire retardant, a biocide, or any mixture thereof.

76. The resinated furnish according to any one of claims 55 to 75, wherein the plurality of lignocellulose substrates is in the form of chips, flakes, fibers, powder, shavings, dust, veneer, strands, or a mixture thereof.

77. A two-layer lignocellulose composite product, comprising:
a first layer bonded to a second layer, wherein at least one of the first layer and the second layer comprises an at least partially cured composition, wherein, prior to curing, the composition comprises a plurality of lignocellulose substrates, calcium lignosulfonate, and a free radical precursor, and wherein the at least one of the first layer and the second layer has a

brightness of about 10% to about 35%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

78. The two-layer lignocellulose composite product according to claim 77, wherein each of the first layer and the second layers comprises the at least partially cured composition, and wherein each of the two outer layers has a brightness of about 10% to about 35%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

79. The two-layer lignocellulose composite product according to claim 78, wherein the first layer and the second layer are different with respect to one another.

80. The two-layer lignocellulose composite product according to claim 79, wherein the first layer and the second layer comprise different lignocellulose substrates, a different amount of the at least partially cured composition, a different thickness, or a combination thereof.

81. The two-layer lignocellulose composite product according to claim 77, wherein the first layer comprises the at least partially cured composition, wherein the second layer comprises an at least partially cured second composition, and wherein, prior to curing, the second composition comprises a second plurality of lignocellulose substrates and a binder composition that is free of calcium lignosulfonate.

82. The two-layer lignocellulose composite product according to claim 77, wherein the first layer comprises the at least partially cured composition, wherein the second layer comprises an at least partially cured second composition, and wherein, prior to curing, the second composition comprises a second plurality of lignocellulose substrates and a binder composition that is free of calcium lignosulfonate and free of a radical precursor.

83. The two-layer lignocellulose composite product according to any one of claims 77 to 82, wherein the first layer comprises the at least partially cured composition, and wherein the first layer has a brightness of at least 15%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

84. The two-layer lignocellulose composite product according to any one of claims 77 to 83, wherein the first layer comprises the at least partially cured composition, and wherein the first layer has a brightness of at least 19%, as measured according to TAPPI Test Method T 452 at a wavelength of 457 nm.

85. The two-layer lignocellulose composite product according to any one of claims 77 to 84, wherein the free radical precursor comprises an oxidant and a catalyst.

86. The two-layer lignocellulose composite product according to claim 85, wherein the at least one of the first layer and the second layer comprises about 0.01 wt% to about 5 wt% of the catalyst, based on the dry weight of the plurality of lignocellulose substrates.

87. The two-layer lignocellulose composite product according to claim 85 or claim 86, wherein the catalyst comprises iron, copper, manganese, tungsten, molybdenum, cobalt, titanium, or a mixture thereof.

88. The two-layer lignocellulose composite product according to any one of claims 77 to 87, wherein the at least one of the first layer and the second layer comprises about 0.1 wt% to about 30 wt% of the calcium liginosulfonate, based on the dry weight of the lignocellulose substrates.

89. The two-layer lignocellulose composite product according to any one of claims 77 to 88, wherein the at least one of the first layer and the second layer is essentially free of formaldehyde.

90. The two-layer lignocellulose composite product according to any one of claims 77 to 89, wherein, prior to curing, the composition further comprises a polyphenolic material, an unsaturated compound, or both a polyphenolic material and an unsaturated compound.

91. The two-layer lignocellulose composite product according to claim 90, wherein the composition comprises the polyphenolic material, and wherein the polyphenolic material comprises lignin, tannins, a novolac resin, bisphenol A, modified phenol formaldehyde resin, humic acid, or a mixture thereof.

92. The two-layer lignocellulose composite product according to claim 90 or 91, wherein the composition comprises the unsaturated compound, and wherein the unsaturated compound comprises dicyclopentadiene, ethylene glycol diacrylate, ethylene glycol dimethacrylate, diethylene glycol diacrylate, diethylene glycol dimethacrylate, poly(ethylene glycol) diacrylate, poly(ethylene glycol) dimethacrylate, trimethylolpropane triacrylate, pentaerythritol tetraacrylate, pentaerythritol triacrylate, polyacrylate starch, linseed oil, an unsaturated prepolymer, or a mixture thereof.