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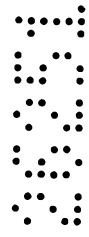
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(56) Related Art
US 2674591
US 4366275
US 5247066

ABSTRACT OF THE DISCLOSURE

An improved ketone-formaldehyde crosslinking additive having reduced free-formaldehyde content and which is useful in providing a starch-
5 based alkaline corrugating adhesive composition with enhanced water resistance and viscosity properties is obtained by a process wherein the additive is treated with selected sulfite salts.



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COMPLETE SPECIFICATION
STANDARD PATENT

Applicant:

NATIONAL STARCH AND CHEMICAL INVESTMENT HOLDING
CORPORATION

Invention Title:

WATER RESISTANT ALKALINE CORRUGATING ADHESIVE COMPOSITION

The following statement is a full description of this invention, including the best method of performing it known to me/us:

1A
WATER RESISTANT ALKALINE
CORRUGATING ADHESIVE COMPOSITION

5 This invention relates to a starch-based, alkaline corrugating adhesive composition containing an improved crosslinking additive which imparts good water resistance and has exceptional low levels of residual formaldehyde.

10 The procedures employed in the production of corrugated paperboard usually involve a continuous process whereby a strip of paperboard is first corrugated by means of heated, fluted rolls. The protruding tips on one side of this fluted paperboard strip are then coated with an adhesive, and a flat sheet of paperboard, commonly known in the trade as a facing, is thereafter applied to these tips. By applying heat and pressure to the two paperboard strips thus
15 brought together, an adhesive bond is formed therebetween. The above-described procedure produces what is known as a single-faced board in that the facing is applied to only one surface thereof. If a double-faced paperboard in which an inner fluted layer is sandwiched between two facings is desired, a second operation is performed wherein the adhesive is applied to the exposed
20 tips of a single-faced board and the adhesive-coated tips are then pressed against a second facing in the combining section of the corrugator under the influence of pressure and heat. The typical corrugating process and the use and operation of corrugators in general are described in U.S. Patent Nos. 2,051,025 and 2,102,937 to Bauer.

25 Starch-based adhesives are most commonly used in the corrugating process due to their desirable adhesive properties, low cost and ease of preparation.

 The most fundamental of starch corrugating adhesives is an alkaline adhesive which is comprised of raw, ungelatinized starch suspended in an

aqueous dispersion of cooked starch. The adhesive is produced by gelatinizing starch in water with sodium hydroxide (caustic soda) to yield a primary mix of gelatinized or cooked carrier, which is then slowly added to a secondary mix of raw (ungelatinized) starch, borax and water to produce the full-formulation adhesive. In the corrugating process, the adhesive is applied (usually at between 25° and 55°C) to the tips of the fluted paper medium or single-faced board, whereupon the application of heat causes the raw starch to gelatinize, resulting in an instantaneous increase in viscosity and formation of the adhesive bond. Such adhesives are described in the above-noted patents to Bauer.

10 Typical "no carrier" starch adhesives are described in U.S. Patent No. 3,487,033 to McElmury et al., and U.S. Patent No. 3,355,307 to Schoenberger et al.

It is often desired or necessary in the manufacture of corrugated paperboard that the adhesive yield water-resistant bonds which can withstand extended exposure to high humidity, liquid water, melting ice and the like. A number of approaches have been devised to produce water-resistant corrugating adhesives. One method involves the preparation of an acidic, starch-based adhesive wherein urea-formaldehyde resin is added to the composition, together with an acidic catalyst such as aluminum sulfate, to produce water-resistant bonds in the corrugated board manufactured therewith. The adhesive composition itself, however, is deficient in other important properties such as corrugator bonding speeds, viscosity stability, and pot life and exhibits excessive formaldehyde odor. In addition, acidic corrugating adhesives tend to be corrosive.

15

20

25 The many disadvantages associated with the acidic corrugating adhesives led to the development of water-resistant alkaline curing starch-based adhesives for use in the corrugating industry. In the preparation thereof,

a thermosetting resin, such as, e.g., urea-formaldehyde, resorcinol-formaldehyde, melamine-formaldehyde, phenol-formaldehyde, diacetone acrylamide-formaldehyde, ketone-aldehyde and urea-acetone-formaldehyde condensate, is added to the adhesive as a crosslinking additive for the
5 amylaceous components to produce water-resistant bonds. Preferred among these resins for superior water-resistant properties are ketone-formaldehyde condensates as disclosed in U.S. Patent No. 2,529,851, and particularly acetone-formaldehyde resins. Some adhesives made from such resins, however, suffer from poor pot life and viscosity instability, as well as
10 considerable formaldehyde odor.

In recent years, due to the toxicity of and increasing governmental regulations concerning formaldehyde, serious efforts have been made to reduce the levels of exposure to formaldehyde in the industrial workplace. Acetone-formaldehyde resins such as are employed as crosslinking additives in
15 corrugating adhesives contain about 1.0 to 4.0% free (unreacted) formaldehyde by weight of condensate. Prior attempts to reduce formaldehyde levels in crosslinking additives as taught in U.S. Patent Nos. 3,019,120 and 3,294,716 have not reduced free-formaldehyde amounts to a significant extent and/or have resulted in diminution of the degree of water resistance achieved in the bonds
20 formed.

In U.S. Patent No. 4,366,275 to Silano et al., the crosslinking additive used with the starch-based alkaline corrugating composition comprises a mixture of acetone-formaldehyde condensate and dimethylol dihydroxy ethylene urea (DMDHEU) wherein at least a portion of the DMDHEU present is produced
25 "in situ" by reaction of the free-formaldehyde contained in the acetone-formaldehyde condensate with dihydroxy ethylene urea. The patent discloses that the unreacted formaldehyde in the acetone-formaldehyde resin condensate

is reduced to about 0.1 to 2% by weight. Experience has shown, however, that in most instances the free-formaldehyde is reduced only to a level of about 0.5 to 0.9% by weight of the condensate. Current industry requirements call for still lower levels of unreacted formaldehyde.

5 A recent patent, U.S. 5,079,067 to Willging, discloses the reduction of free-formaldehyde in formaldehyde containing resins to a level of less than 0.3%, by weight (of aqueous resin composition), by reacting the free-formaldehyde with a nitrogen base and urea in the presence of an acid catalyst.

10 Another recent patent, U.S. 5,247,066 to J. Schoenberg et al., discloses another method for reducing levels of free-formaldehyde in ketone-formaldehyde crosslinking additives by treating the unreacted formaldehyde with hydrogen peroxide. This method has resulted in significant reduction in free-formaldehyde content to levels of less than about 0.4% by weight of condensate (i.e., aqueous condensate or solution).

15 While these methods generally provide lower free-formaldehyde levels than previously attained, they do not always provide the water resistance, viscosity characteristics and ease of process conditions that are desired. Furthermore, there is a need and desire to provide even further reduction in formaldehyde levels in corrugating adhesive compositions while
20 also providing suitable water resistance, viscosity and other property attributes.

 It has also long been known to use sulfite salts to reduce formaldehyde content in different non-related technical applications such as textiles, plywood/particle board manufacture, cosmetics and paper production.

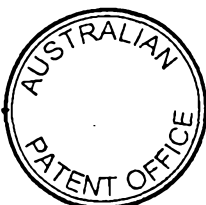
25 However, it has heretofore not been known to produce ketone-formaldehyde

additives for use in corrugating adhesives to impart low levels of free formaldehyde while also providing good water resistance and viscosity characteristics.

5 It has now been found that a crosslinking additive comprised of a ketone-formaldehyde condensate which is treated with selected sulfite salts provides significantly reduced free-formaldehyde content of less than about 0.4% and preferably less than about 0.1% by weight, based on the weight of condensate (i.e., aqueous condensate or
10 solution). Further, the use of this crosslinking additive in an alkaline corrugating adhesive composition imparts excellent water resistant properties as well as good viscosity properties.

15 According to the present invention there is provided a water-resistant, viscosity stable, alkaline curing, starch-based corrugating adhesive composition including:

- a) from 10 to 40% by weight, based on the total weight of the adhesive, of starch;
- b) from 0.3 to 5% by weight, based on the total
20 weight of starch, of an alkali;
- c) from about 0.3 to 12% by weight, dry basis, based on the weight of starch, of a crosslinking additive prepared by reacting a ketone and formaldehyde in a molar ratio of 1 mole ketone to 1.5 to 6 moles of formaldehyde
25 under aqueous alkaline conditions at 20 to 80° C, to obtain a water-soluble ketone-formaldehyde condensate containing 1 to 4% by weight of unreacted formaldehyde and wherein from 2 to 6.5 parts by weight of a water-soluble alkali metal or alkaline earth metal sulfite per part by weight
30 of unreacted formaldehyde is added to the condensate to react with the unreacted formaldehyde present and allowing the reaction to proceed at 20 to 45° C, at a pH of 5 to 9 until the unreacted formaldehyde is reduced to less than 0.6% by weight, based on the weight of condensate; and
35 d) from 54 to 89% by weight of water, based on the total weight of the adhesive wherein the viscosity of the adhesive composition does not increase more than 32% over



24 hours.

According to the present invention there is provided a process for preparing corrugated paperboard including the steps of:

5 a) applying to the tips of the corrugations of a fluted paper strip, a water-resistant, viscosity stable, alkaline curing, starch-based corrugating adhesive composition including:

10 i) from 10 to 40% by weight, based on the total weight of the adhesive, of starch;

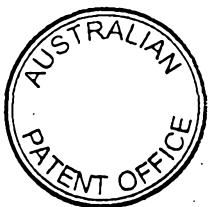
ii) from 0.3 to 5% by weight, based on the total weight of starch, of an alkali;

15 iii) from 0.3 to 12% by weight, dry basic, based on the weight of starch, of a crosslinking additive prepared by reacting a ketone and formaldehyde in a molar ratio of 1 mole of ketone to 1.5 to 6 moles of formaldehyde under aqueous alkaline conditions at 20 to 80°C to obtain a water-soluble ketone-formaldehyde condensate containing 1 to 4% by weight of unreacted formaldehyde and wherein from 20 2 to 6.5 parts by weight of a water-soluble alkali metal or alkaline earth metal sulfite per part by weight of unreacted formaldehyde is added to the condensate to react with the unreacted formaldehyde present and allowing the reaction to proceed at 20 to 45°C at a pH of 5 to 9 until 25 the unreacted formaldehyde is reduced to less than about 0.6% by weight, based on the weight of condensate; and

30 iv) from 54 to 89% by weight of water, based on the total weight of the adhesive wherein the viscosity of the adhesive composition does not increase more than 32% over 24 hours; and

b) applying facing to the adhesive coated tips of the fluted paper strip to form an adhesive bond.

35 The crosslinking additive of this invention is initially formed by reacting a ketone and formaldehyde under aqueous alkaline conditions at about 20 to 80°C,



preferably 40 to 60°C to produce a water-soluble ketone-
formaldehyde condensate containing about 1 to 4% by weight
of unreacted (free) formaldehyde. The proportion of
reactants will ordinarily range from about 2 to 5 moles of
5 formaldehyde to about 1 mole of ketone and preferably from
2.5 to 4.5 moles of formaldehyde to 1 mole of ketone. In
preparing the condensate, the reaction may be conducted
under a nitrogen atmosphere if desired. It will be
recognized that the alkalinity and reaction temperature
10 employed must be no greater than is necessary to produce a
water-soluble condensate which has not cured into an
infusible product. Typically, the pH of the reaction
mixture is maintained at about 8 to 12, preferably 9 to
11, by incremental addition of a solution of an alkaline
15 agent such as sodium hydroxide. The reaction is monitored
for formaldehyde content and when it is below about 3%,
the product is cooled to about 25° to about 45°C and
neutralized with acid such as acetic acid, glacial acetic
acid, and formic acid to a pH level of 4.8 to 6.2. The
20 reaction time depends mainly on the temperature,
alkalinity and desired solids content of the reaction
mixture but is ordinarily such as to obtain a water-
soluble ketone-



formaldehyde condensate containing about 1 to 4% by weight of free-formaldehyde. The condensate will typically have a solids content of 40 to 65% by weight.

The formed ketone-formaldehyde condensate is then treated with an effective amount of selected sulfite salt to react with the unreacted or free-formaldehyde present. While a varying effective amount of sulfite can be used, in order to provide good water resistance as well as reduce formaldehyde content and provide viscosity stability, amounts of from about 2 to 8.5 and preferably from about 3 to 7 parts by weight of sulfite compound per part by weight of unreacted formaldehyde have been found especially useful. The condensate/sulfite mixture is then maintained at room temperature or at a temperature of about 20 to 45°C, preferably about 25 to 35°C, and at a pH of about 5 to 9, preferably about 6.5 to 8, until the unreacted formaldehyde is reduced to less than about 0.4% and preferably less than about 0.1% by weight based on the weight of the condensate. This usually takes a fairly short period of time, e.g., 0.5 to 2 hours or more.

In making the crosslinking additive, the ketone may be any of the known monomers of the type including acetone, methylethyl ketone, acetophenone, benzophenone, cyclohexanone, etc. Acetone and its dimers, i.e., diacetone alcohol or mesityl oxide are especially useful with acetone being particularly preferred because of its cost, availability and reactivity. Sources of formaldehyde that can be used include gaseous formaldehyde, aqueous solutions of formaldehyde, trioxymethylene, hexamethylene tetraamine and paraformaldehyde.

Reduction in free-formaldehyde for the ketone-formaldehyde condensate is provided by adding an effective amount of sulfite salt. The sulfite salts which can be used are alkali metal and alkaline earth metal salts

of sulfurous acid. More particularly, alkali metal and alkaline earth metal sulfites may be used and the term sulfites includes: sulfites, bisulfites, meta-bisulfites and disulfites. Sulfites might also be generated by, for example, the use of compounds such as sulfur dioxide which are converted to sulfurous acid in the presence of water and then to a sulfite. Preferred sulfites are the sodium sulfites and more preferably sodium meta-bisulfite or sodium bisulfite. The amount of sulfite compound can be a varying effective amount to provide a low level of free-formaldehyde. However, to attain good water resistance and viscosity characteristics as well as significantly reduced free-formaldehyde levels, sulfite amounts of about 2 to 8.5 and preferably 3 to 7 parts by weight per part by weight of unreacted formaldehyde have been found especially useful.

The corrugating adhesive composition of this invention is comprised of starch, water, alkali, the selected low formaldehyde crosslinking additive as described herein, and optionally borax. The starch component, which may be the ungelatinized starch and/or gelatinized carrier starch portion of the adhesive composition herein may be selected from any of the several starches, native or converted, heretofore employed in starch corrugating adhesive compositions. Suitable starches include, for example, those starches derived from corn, potato, waxy maize, tapioca, sorghum, wheat, as well as high-amylose starches, i.e., starches which contain 30% or more by weight of amylose, and the various derivatives of these starches. Hence, among the applicable starches are included the various starch derivatives such as ethers, esters, thin-boiling types prepared by known processes such as mild acid treatments, oxidation, etc. and those derivatives of these starches which have high amylose contents. Preferred starches are those typically employed in corrugating adhesives of the alkaline type.

The starch content of the adhesive can vary considerably depending on several factors such as the intended end-use application of the adhesive and the type of starch used. The total amount of starch employed, including gelatinized and ungelatinized portions of starch, ordinarily will be in the range of
5 about 10 to 40% by total weight of the adhesive and preferably 18 to 35%.

The remainder of the adhesive composition is composed of about 0.3 to 5% of an alkali such as sodium hydroxide, based on total weight of starch, about 0.3 to 12% on dry basis, preferably 1 to 5%, of the low formaldehyde crosslinking additive as described herein, based on total weight of starch, and
10 about 54 to 89% of water, based on total weight of the adhesive.

If desired, small amounts of borax or other boron containing salts, up to about 5% based on the total weight of starch, may be added to the adhesive to improve the tackifying properties thereof.

The alkali (base) employed herein is preferably sodium hydroxide;
15 however, other bases may be employed in partial or full replacement of the sodium hydroxide and include, for example, alkali metal hydroxides such as potassium hydroxide, alkaline earth hydroxides such as calcium hydroxide, alkaline earth oxides such as barium oxide, alkali metal carbonates such as sodium carbonate, and alkali metal silicates such as sodium silicate. The alkali
20 may be employed in aqueous or solid form.

In addition to the essential ingredients of the adhesive composition herein, any conventional non-chemically functional additives may be incorporated into the adhesive in minor amounts, if desired. Such additives include, for example, wetting agents, proteins, plasticizers, solubilizing agents,
25 rheology modifiers, tackifiers such as borax, water conditioners, penetration control agents, peptizers such as urea, gelatinization temperature modifiers, inert fillers such as clay and finely ground polymers, thickeners such as

inorganic colloidal clays, guar, hydroxyethyl cellulose, alginates, polyvinyl alcohol, polymers of ethylene oxide and the like, and emulsions such as polyvinyl acetate.

5 Additionally urea compounds such as urea and dihydroxyethylene urea may be added to the crosslinking additive and the adhesive composition to provide further improved stability characteristics, particularly to maintain low free-formaldehyde levels over time. Such urea compounds may be added in an effective stabilizing amount or an amount of about 0.25 to 10, preferably about 2.5 to 7.5% by weight, based on the weight of the condensate.

10 Further description regarding the acetone-formaldehyde crosslinking additive and the corrugating adhesive composition may be found in U.S. Patent No. 5,247,066 issued to J. Schoenberg, et al. on September 21, 1993 and which is incorporated by reference herein.

15 In the preparation of the adhesive composition herein, a portion of the total starch required in the adhesive is gelatinized in water with caustic soda to form the carrier, which is then slowly added to a mixture of raw starch, water and optionally borax. The crosslinking additive may be added to the raw starch mixture or to the final adhesive mixture as desired. While this description of the corrugating adhesive composition is directed to a composition comprising a
20 carrier starch and a raw starch, it may also include a no carrier composition having just a single starch component comprising an ungelatinized starch which upon subsequent treatment with alkali becomes partially swollen.

The adhesive thus obtained can be used to bond single- or double-faced boards using any equipment which is presently employed for the
25 preparation of corrugated board. The adhesive is maintained at a temperature preferably between 25° and 55°C before its application to the protruding tips of the fluted paper strip. The actual application may be accomplished by the use

of glue rolls which are ordinarily employed in most corrugating machines, or one may, if desired, utilize other application methods which may be able to achieve a different distribution of adhesive. Following the application of the adhesive to the fluted paper strip, the latter is then brought into immediate contact with the facing board under the influence of heat and pressure, as is well known in the art. A double-faced board may be subsequently prepared by bringing a second facing in contact with the open fluted surface of the single-faced board by the usual procedures.

The examples which follow illustrate specific embodiments of the invention. In the examples all parts and percentages are given by weight and all temperatures in degrees Celsius unless otherwise noted.

In determining the amount of free-formaldehyde contained in the acetone-formaldehyde condensates herein, a titration method was employed whereby a 12 g sample of the condensate is weighed into a 600 mL flask to which is added water and crushed ice. This is then titrated with 0.10N sodium hydroxide until a pH of 10-10.5 is attained. A sodium sulfite solution of 127 g/L is added in an amount of 50 mL and the resulting solution is titrated with 0.10N hydrochloric acid until the pH noted above is attained. The formula to determine free-formaldehyde content of the sample is:

$$\% \text{ Free-Formaldehyde} = \frac{(\text{mL } 0.10 \text{ N HCl}) \times 0.30}{\text{weight of sample (g)}}$$

EXAMPLE I

This example illustrates a representative preparation of an acetone-formaldehyde condensate and the reduction of the amount of formaldehyde in the condensate with sodium meta-bisulfite.

In a reaction vessel equipped with a thermometer and means of heating and stirring, 58 g (1 mole) of acetone was combined with 253.3 g (4.2

moles) of 50% aqueous formaldehyde and the solution heated to 50° to 55°C. About 0.7 g of 6.25N sodium hydroxide was added and the mixture held at 55° to 60°C during the exothermic reaction. An additional 21.8 g of 6.25N sodium hydroxide was added over 2.5 to 3 hours while maintaining the reaction temperature between 57° to 58°C. The reaction was continued for an additional 0.25 hours and the mixture then analyzed for formaldehyde content. When the formaldehyde concentration was below 2.5%, heating was discontinued and the condensate product cooled to 40°C. The pH was adjusted to 5 to 6 with glacial acetic acid. The free-formaldehyde content was measured at 1.42%. To a small glass jar in a constant temperature water bath and fitted with an overhead stirrer, 300 g of the acetone-formaldehyde condensate (prepared as described above) which contained 1.42% formaldehyde (0.14 moles) and 13.48 g (0.07 moles) of sodium meta-bisulfite was brought up to a temperature of 25°C. The pH was adjusted with 6.25N sodium hydroxide to 6.5. The reaction was pH controlled with 0.1N sodium hydroxide or 10% acetic acid as necessary over 2 hours. The free-formaldehyde measured after 2 hours is shown in Table 1. Additional runs using different temperatures and pH were also carried out and the results shown below in Table 1.

20

TABLE 1

Run No.	pH	Temp.	% Free HCHO after 2 hours
1	6.5	25	0.08
2	7.0	25	0.05
3	7.5	25	0.05
4	8.0	25	0.06
5	8.5	25	0.08
6	6.5	35	0.06
7	7.0	35	0.06
8	7.5	35	0.05
9	8.0	35	0.07
10	8.5	35	0.12

EXAMPLE II

5 This example illustrates the lowering of formaldehyde in an acetone-formaldehyde condensate by using 3.18 parts by weight of sodium meta-bisulfite for every 1 part by weight of unreacted formaldehyde.

In a glass beaker fitted with an overhead stirrer, 1000 g of an acetone-formaldehyde condensate (prepared by the method of Example I) which contained 1.63% formaldehyde (0.54 moles) was brought up to pH 7.85 by addition of 6.25N sodium hydroxide. To the reaction at 25°C was added 10 51.59 g (0.27 moles) of sodium meta-bisulfite over 19 minutes while maintaining the pH of the reaction at 7 to 8 by addition of glacial acetic acid or 6.25N sodium hydroxide as necessary. The pH was maintained at 7.5 for 2 15 hours by addition of 10% acetic acid or 0.1N sodium hydroxide as necessary. The solution, which contained 0.06% formaldehyde was neutralized to pH 5.36 by addition of glacial acetic acid.

EXAMPLE III

20 In this example, urea is post-added after the reaction of sodium meta-bisulfite with formaldehyde in the acetone-formaldehyde condensate.

In a glass beaker fitted with an overhead stirrer, 1000 g of an acetone-formaldehyde condensate (prepared by the method of Example I) which contained 1.63% formaldehyde (0.54 moles) was brought up to pH 7.11 25 by addition of 6.25N sodium hydroxide. To the reaction at 25°C was added 51.59 g (0.27 moles) of sodium meta-bisulfite over 9 minutes while maintaining the pH of the reaction at 7 to 8 by addition of glacial acetic acid or 6.25N sodium hydroxide as necessary. The pH was maintained at 7.5 for 2

hours by addition of 10% acetic acid or 0.1N sodium hydroxide as necessary. The solution, which contained 0.06% formaldehyde was neutralized to pH 5.50 by addition of glacial acetic acid. To the reaction was added 58.0 g of urea.

5

EXAMPLE IV

This example illustrates the lowering of formaldehyde in an acetone-formaldehyde condensate by using 4.43 parts by weight of sodium meta-bisulfite for every 1 part by weight of unreacted formaldehyde.

10 To a glass beaker fitted with an overhead stirrer, 800 g of an acetone-formaldehyde condensate (prepared by the method of Example I) which contained 1.42% formaldehyde (0.378 moles) and 50.34 g (0.265 moles) of sodium meta-bisulfite at 25°C was adjusted to pH 5.0 by addition of glacial acetic acid. After 2 hours the formaldehyde content was measured to be
15 0.02%.

EXAMPLE V

This example illustrates the lowering of formaldehyde in an acetone-formaldehyde condensate by using 6.36 parts by weight of sodium meta-bisulfite for every 1 part by weight of unreacted formaldehyde.
20

In a glass beaker fitted with an overhead stirrer, 1000 g of an acetone-formaldehyde condensate (prepared by the method of Example I) which contained 1.63% formaldehyde (0.54 moles) was brought up to pH 7.26 by addition of 6.25N sodium hydroxide. To the reaction at 25°C was added
25 103.18 g (0.54 moles) of sodium-meta-bisulfite over 26 minutes while maintaining the pH of the reaction at 7 to 8 by addition of glacial acetic acid or 6.25N sodium hydroxide as necessary. The pH was maintained at 7.5 for 2

hours by addition of 10% acetic acid or 0.1N sodium hydroxide as necessary. The solution, which contained 0.005% formaldehyde was neutralized to pH 5.45 by addition of glacial acetic acid.

5

EXAMPLE VI

This example illustrates the lowering of formaldehyde in an acetone-formaldehyde condensate by using 9.54 parts by weight of sodium meta-bisulfite for every 1 part by weight of unreacted formaldehyde.

In a glass beaker fitted with an overhead stirrer, 1000 g of an acetone-formaldehyde condensate (prepared by the method of Example I) which contained 1.63% formaldehyde (0.54 moles) was brought up to pH 7.1 by addition of 6.25N sodium hydroxide. To the reaction at 25°C was added 154.77g (0.81 moles) of sodium meta-bisulfite over 37 minutes while maintaining the pH of the reaction at 7 to 8 by addition of glacial acetic acid or 6.25N sodium hydroxide as necessary. The pH was maintained at 7.5 for 2 hours by addition of 10% acetic acid or 0.1N sodium hydroxide as necessary. The solution, which contained 0.005% formaldehyde was neutralized to pH 5.43 by addition of glacial acetic acid.

20

EXAMPLE VII (Comparison)

This example illustrates for comparison purposes, a lowering of free-formaldehyde of an acetone-formaldehyde condensate in accordance with the process disclosed in U.S. Patent No. 5,247,066 to Schoenberg et al.

In a glass, round-bottom flask fitted with a thermometer, condenser and Teflon stirrer, a mixture of 1250 g of an acetone-formaldehyde condensate (prepared by the method of Example I) which contained 1.42% formaldehyde (0.59 moles), 0.0624 g Fe₂(SO₄)₃ hexahydrate, and 132.0 g

(1.16 moles) of 30% hydrogen peroxide was heated at 70°C for 8.5 hours. The solution, which contained 0.08% formaldehyde was cooled and neutralized to a pH of 5.47 using 40 mLs of 6.25N sodium hydroxide.

5

EXAMPLE VIII (Comparison)

This example illustrates for comparison purposes, a lowering of free-formaldehyde of an acetone-formaldehyde condensate in accordance with the process disclosed in U.S. Patent No. 5,079,067 to Willging et al.

10 In a glass, round-bottom flask fitted with a thermometer, condenser and Teflon stirrer, a mixture of 1000 g of an acetone-formaldehyde condensate (prepared by the method of Example I) which contained 1.63% formaldehyde (0.54 moles), 5.0 g citric acid, and 30.0 g of 28% ammonium hydroxide was heated at 56°C. After 2.5 hours, 50.0 g of urea was added and the reaction was allowed to cool. After the urea had dissolved and the
15 reaction temperature reached room temperature, the formaldehyde content was measured to be 0.27%.

EXAMPLE IX

20 The example illustrates the preparation of the corrugating adhesives representative of this invention.

Preparation of the carrier starch

To 2836 g of water was added 748 g of a regular corn starch/high amylose corn starch blend (about 35% amylose of weight) and the resulting slurry was heated to 57°C with stirring. About 284 g of water containing 122 g
25 of sodium hydroxide was added to the slurry and heating was continued for about 15 minutes, after which about 2836 g of water was added to cool and dilute the resultant dispersion.

Preparation of the Fully Formulated Adhesive

The carrier starch dispersion prepared above was added over a 20 minute period to a slurry of 4760 g regular corn starch, 82 g borax ($\text{Na}_2\text{B}_4\text{O}_7 \cdot 5\text{H}_2\text{O}$) and 8507 g water. The mixture was then stirred for 60 minutes, after
5 which one of the low formaldehyde condensates prepared in Examples II, III, IV, V, VI, VII, and VIII, were added to the entire adhesive or a portion of it to form Adhesives A-G. The addition amount of each of these condensates was 5.2% by weight of condensate on starch. Adhesive H served as a comparison (control) containing the condensate of Example I (no reaction with
10 sodium meta-bisulfite), and Adhesive I served as a control containing no condensate. See Example X and Table II for results.

EXAMPLE X

It is well recognized that cooked starch dispersions (and starch
15 dispersions containing a crosslinking agent of the prior art in particular) may tend to thicken with time, and this phenomenon is usually observed in all corrugating adhesives based on such starch dispersions. The corrugating adhesives of this invention exhibit a relatively stable viscosity over a given period of time and are comparable or superior to prior art adhesives.

20 Table II below describes Adhesives A-I and summarizes the viscosity data of these adhesive compositions. All adhesives were held at 37° to 39°C with mild agitation and tested for viscosity by a Brookfield Viscometer (at 20 rpm setting) after 1 hour to measure the viscosity in centipoise.

Each adhesive was applied at 3 mil thickness by a Bird applicator to a
25 glass plate and transferred to sheets of single-face web (of 69 lb/thousand sq ft wet strength liner and 33 lb/thousand sq ft wet strength medium) by means of direct hand pressure. The single-face web samples were then placed on

top of 69 lb/thousand sq ft wet strength liner and the resultant double-faced board was bonded at 0.25 psi on a hot plate at 177°C for 5 seconds. The bonded boards were then placed in a conditioning atmosphere of 22°C, 50% relative humidity for 24 hours, after which 2X5 inch samples of each of the

5 boards were placed in water at 22°C for 24 hours.

At the end of this period, the samples were evaluated by a wet pin adhesion test based on that of TAPPI Standard T 821 OM 87, using a conventional testing apparatus obtainable from Testing Machines Incorporated, Mineola, NY. The results were recorded in pounds (per 24

10 inches of glue line) required to separate completely the double-face liner from the single-face web. The results are indicated in Table II, with the highest results representing the best results.

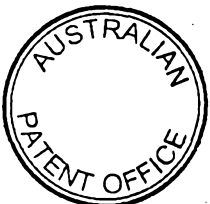
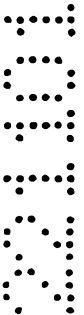
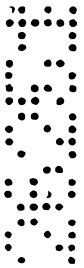
TABLE II

Adhesive	Crosslinking Condensate	Condensate (Parts Sulfite /Part of HCHO)	% Free HCHO in Condensate	1 Hr. Viscosity (CPS)	Wet Pin Adhesion (Lbs.)
A	Ex. VI	9.54	0.005	388	16.8
B	Ex. V	6.36	0.005	386	18.4
C	Ex. IV	4.43	0.02	530	19.8
D	Ex. II	3.18	0.06	418	21.5
E	Ex. III	3.18	0.06	444	20.2
F (Comparison)	Ex. VII	—	0.08	560	21.1
G (Comparison)	Ex. VIII	—	0.27	760	20.6
H (Control)	Ex. I	—	1.63	1020	22.7
I (Control)	None	—	None	365	0



For the purposes of this specification it will be clearly understood that the word "comprising" means "including but not limited to", and that the words "comprise" and "comprises" have a corresponding meaning.

5 It will be clearly understood that, although a number of prior art publications are referred to herein, this reference does not constitute an admission that any of these documents forms part of the common general knowledge in the art, in Australia or in any other
10 country.



THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:

1. A water-resistant, viscosity stable, alkaline curing, starch-based corrugating adhesive composition including:
- 5
- a) from 10 to 40% by weight, based on the total weight of the adhesive, of starch;
- b) from 0.3 to 5% by weight, based on the total weight of starch, of an alkali;
- 10
- c) from about 0.3 to 12% by weight, dry basis, based on the weight of starch, of a crosslinking additive prepared by reacting a ketone and formaldehyde in a molar ratio of 1 mole ketone to 1.5 to 6 moles of formaldehyde under aqueous alkaline conditions at 20 to 80° C, to obtain
- 15
- a water-soluble ketone-formaldehyde condensate containing 1 to 4% by weight of unreacted formaldehyde and wherein from 2 to 6.5 parts by weight of a water-soluble alkali metal or alkaline earth metal sulfite per part by weight of unreacted formaldehyde is added to the condensate to
- 20
- react with the unreacted formaldehyde present and allowing the reaction to proceed at 20 to 45° C, at a pH of 5 to 9 until the unreacted formaldehyde is reduced to less than 0.6% by weight, based on the weight of condensate; and
- d) from 54 to 89% by weight of water, based on the
- 25
- total weight of the adhesive wherein the viscosity of the adhesive composition does not increase more than 32% over 24 hours.
2. The corrugating adhesive composition of claim 1 wherein the ketone is acetone.
- 30
3. The corrugating adhesive composition of claim 1 or 2 wherein the sulfite is an alkali metal or alkaline earth metal sulfite, a bisulfite, a meta-bisulfite or a disulfite.
4. The corrugating adhesive composition of claim 3
- 35
- wherein the sulfite is sodium meta-bisulfite or sodium bisulfite.
5. The corrugating adhesive composition of any



preceding claim wherein from 2.5 to 4.5 parts by weight of sulfite per part by weight of unreacted formaldehyde is used.

5 6. The corrugating adhesive composition of any preceding claim wherein an effective stabilizing amount of urea or dihydroxyethylene urea is added to the composition.

10 7. The corrugating adhesive composition of any preceding claim wherein the unreacted formaldehyde is reduced to less than about 0.1% by weight, based on the weight of condensate.

15 8. The corrugating adhesive composition of any preceding claim wherein from 1 to 5% by weight, dry basis, based on the weight of starch, of crosslinking additive is used.

9. The corrugating adhesive composition of claim 8 wherein the ketone is acetone.

20 10. The corrugating adhesive composition of any one of claims 5 to 9 wherein the sulfite is an alkali metal or alkaline earth metal sulfite, bisulfite, a meta-bisulfite or a disulfite.

25 11. The corrugating adhesive composition of any one of claims 6 to 10 wherein from 2.5 to 4.5 parts of sulfite per part by weight of unreacted formaldehyde is used.

12. The corrugating adhesive composition of any one of claims 7 to 12 wherein an effective stabilizing amount of urea or dihydroxyethylene urea is added to the composition.

30 13. The corrugating adhesive composition of any one of claims 2 to 12 wherein acetone and formaldehyde are reacted in a molar ratio of 1 mole of acetone to 2 to 4.5 moles of formaldehyde.

35 14. The corrugating adhesive composition of any one of claims 8 to 13 wherein the unreacted formaldehyde is reduced to less than 0.1% by weight, based on the weight of condensate.

15. The corrugating adhesive composition of any one



of claims 8 to 14 wherein from 2.5 to 4.5 parts by weight of sulfite per part by weight of unreacted formaldehyde is used.

16. The corrugating adhesive composition of claim 15
5 wherein ketone and formaldehyde are reacted in a molar ratio of 1 mole of ketone to 2 to 4.5 moles of formaldehyde.

17. The corrugating adhesive composition of claim 16 wherein the ketone is acetone.

10 18. The corrugating adhesive composition of claim 17 wherein the sulfite is an alkali metal or alkaline earth metal sulfite, a bisulfite, a meta-bisulfite or a disulfite.

15 19. The corrugating adhesive composition of claim 18 wherein the sulfite is sodium meta-bisulfite or sodium bisulfite.

20. The corrugating adhesive composition of claim 18 or 19 wherein an effective stabilizing amount of urea or dihydroxyethylene urea is added to the composition.

20 21. The corrugating adhesive composition of any one of claims 18 to 20 wherein the unreacted formaldehyde is reduced to less than 0.1% by weight, based on the weight of condensate.

25 22. A process for preparing corrugated paperboard including the steps of:

a) applying to the tips of the corrugations of a fluted paper strip, a water-resistant, viscosity stable, alkaline curing, starch-based corrugating adhesive composition including:

30 i) from 10 to 40% by weight, based on the total weight of the adhesive, of starch;

ii) from 0.3 to 5% by weight, based on the total weight of starch, of an alkali;

35 iii) from 0.3 to 12% by weight, dry basic, based on the weight of starch, of a crosslinking additive prepared by reacting a ketone and formaldehyde in a molar ratio of 1 mole of ketone to 1.5 to 6 moles of formaldehyde under



aqueous alkaline conditions at 20 to 80°C to obtain a water-soluble ketone-formaldehyde condensate containing 1 to 4% by weight of unreacted formaldehyde and wherein from 2 to 6.5 parts by weight of a water-soluble alkali metal or alkaline earth metal sulfite per part by weight of unreacted formaldehyde is added to the condensate to react with the unreacted formaldehyde present and allowing the reaction to proceed at 20 to 45°C at a pH of 5 to 9 until the unreacted formaldehyde is reduced to less than about 0.6% by weight, based on the weight of condensate; and

iv) from 54 to 89% by weight of water, based on the total weight of the adhesive wherein the viscosity of the adhesive composition does not increase more than 32% over 24 hours;

b) applying facing to the adhesive coated tips of the fluted paper strip to form an adhesive bond.

23. The method of claim 22 wherein the ketone in said adhesive composition is acetone.

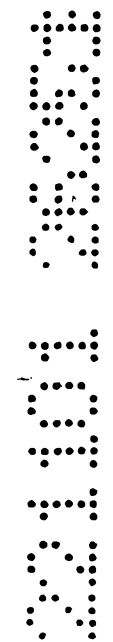
24. The process of claim 22 or 23 wherein the sulfite in said adhesive composition is an alkali metal or alkaline earth metal sulfite, a bisulfite, a meta-bisulfite or a disulfite.

25. The process of any one of claims 22 to 24 wherein the sulfite in said adhesive composition is sodium meta-bisulfite or sodium bisulfite.

26. The process of any one of claims 22 to 25 wherein from 2.5 to 4.5 parts by weight of sulfite per part by weight of unreacted formaldehyde is used in said adhesive composition.

27. The process of any one of claims 22 to 26 wherein an effective stabilizing amount of urea or dihydroxyethylene urea is added to the adhesive composition.

28. The process of any one of claims 22 to 27 wherein the unreacted formaldehyde in said adhesive composition is reduced to less than 0.1% by weight, based on the weight of condensate.



29. The process of any one of claims 22 to 28 wherein from 1 to 5% by weight, dry basis, based on the weight of starch, of crosslinking additive is used in said adhesive composition.

5 30. A water-resistant, viscosity stable, alkaline curing, starch-based corrugating adhesive composition substantially as herein before described with reference to any one of the foregoing examples.

10 31. A process for preparing corrugated paperboard substantially as herein before described with reference to any one of the foregoing examples.

Dated this 22nd day of November 2001

15 NATIONAL STARCH AND CHEMICAL INVESTMENT HOLDING CORPORATION

By their Patent Attorneys

GRIFFITH HACK

Fellows Institute of Patent and

20 Trade Mark Attorneys of Australia

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