Maderas-Cienc Tecnol 25(2023):9, 1-27
Ahead of Print: Accepted Authors Version

DOI:10.4067/S0718-221X2023005XXXXXX

INFLUENCE OF THE MULTIDAY AND CONTINUOUS HOT PRESS ON THE PHYSICAL, MECHANICAL AND FORMALDEHYDE EMISSION PROPERTIES OF THE PARTICLEBOARD

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Received: February 07, 2021
Accepted: November 10, 2022
Posted online: November 11, 2022

ABSTRACT

In this study, Its the influence of according to press, particleboards produced in two different press types which were multiday and continuous hot press, the thickness, density, bending strength, modulus of elasticity, internal bond, surface soundness, withdrawal of screw resistance, moisture, thickness swelling, water absorption, formaldehyde emission content were researched. 18 mm x 2100 mm x 2800 mm size particleboards were manufactured on the production line which was using urea-formaldehyde (F:U;1,07 moles), and 30 % pine, 40 % oak, 20 % beech and 10 % poplar waste mixture of the wood materials. According to results of the tests performed after the multiday and continuous hot press production of the boards; thickness (0,63 %), bending strength (1,27 %), moisture content (0,47 %), thickness swelling (37 %), and water absorption (39,9 %), modulus of elasticity (11,35 %), internal bond (7,22 %) were increased according to multiday hot press while density (2,7 %), surface soundness (18,81 %), withdrawal of screw resistance (14 %) and formaldehyde (57,12 %) decreased. Formaldehyde content,surface soundness, withdrawal of screw resistance are the most prominent properties influenced by continuous hot press.

Keywords: Continuous hot press, formaldehyde content, multiday hot press, particleboard**,** physical-mechanical properties.

INTRODUCTION

Wood-based particleboard materials are engineered wood- based particleboard materials that widely used in construction, furniture, interior design by surface decor paper coating, acrylic covering, veneering and painting or other kinds of surface coating. Owing to it cheaper and competitive remarkable is a qualifier product than other expensive wood-based boards. Due to features physical, mechanical strength properties and formaldehyde contents of particleboard is one of the most used panel materials in the furniture or construction industry. The produced particleboard is requested the lowest formaldehyde release according to related standard. According to Ayla (1999) assessed the continuous press systems are replaced the classical production over time. Continuous press systems are used more prominent wood-based panel industrials such as particleboard, medium-density fiberboards, laminate. The production system of continuous presses can be heated and, in some systems, cooled. All this system is made between double continuously rotating steel bent.

Evessen (1984) presented the describes about modern continuous pressing methods and starting with the küsters press process. He was compared to a cost the single-daylight step-pressing process and küster continuous press. Resin type and ratio in the core and surface layers, press time and temperature, wood types and mixtures are some of the essential factors that have influenced the physical and mechanical properties of particleboards.

The effects of these factors are researched by the investigator in an extensive study as followings; according to Nemli (2002) work evaluated the production parameters to obtain higher physical and mechanical properties, and formaldehyde emission of particleboards produces using E1 type resin. He explained that an increase in the

temperature, time and pressure in the pressing process develop the technological properties of particleboards.

According to the investigate of Godbille (2002) determined a two-dimensional numeric model for continuous hot press (CHP) of particle board (PB) and the effects of parameters on the process. Thoemen and Humphrey (2003) provided a numerical model that is directly applicable to modelling the continuous pressing process. The researchers used variable parameters in this continuous press modeling, such as "*changing mat thickness and steel belt temperatures in the feed direction, and the escape of vapor and air through the horizontal surfaces immediately in front of and behind the press, and the possibility to vary the mat thickness across the width of the press*". According to Nemli *et al*. (2004) the effects of the continuous press system applied in particle board production as a result of developing technology on the physical and mechanical properties of the particle board have investigated. They have investigated that the particleboards were produced in 2800 mm x 2100 mm x 18 mm dimensions, 0,68 g/cm³ density with urea formaldehyde resin by the classic (single layer press), and continuous press. In their studies, thickness, thickness swelling, water absorption, bending strength, modulus of elasticity, internal bond, screw holding performance of particleboard were determined. The properties of particleboard are affected by press types.

Arruda *et al.* (2011) using a mixture of *bamboo* with *Pinus taeda* wood particles was manufactured particleboard (650 kg/m³). In their studies, particleboards were bonded using 8 % content of urea-formaldehyde and phenol-formaldehyde resins, based on a dry weight mat. It has been better dimensional stability made of phenol-formaldehyde, than urea formaldehyde resins. Candan *et al.* (2012) 18 mm thick medium density fiberboards (MDF) were produced by using 70 % beech and 30 % birch wood chips. Physical properties were investigated under the effect of continuous press speed (6,9 m/min and

7,4 m/min) and 220 °C temperature. They explained that as the continuous press speed increases, the thickness swelling (2 h and 24 h) values of the board decrease. They explained that effective press performance can be used in production with the amount of resin and the humidity of the board.

Iswanto *et al*. (2013) evaluated the effects of pressing temperature and pressing time on the quality of the particleboard treated by dipping in 1 % acetic acid solution. Ciobanu *et al*. (2014) have investigated the effects of some production parameters of the continuous press using melamine-urea-formaldehyde and polymeric diphenylmethane diisocyanate resins additive oriented strand boards. Ciobanu *et al*. (2014) have produced oriented strand boards (OSB). They were used continuous press speed (500 mm/s to 1190 mm/s), temperature (190 ºC to 250 °C) pressure (1,5 MPa to 5 MPa), melamine-urea-formaldehyde and polymeric diphenylmethane diisocyanate resins, mixes of softwood and hardwood species. Researchers explained that physical and mechanical properties of oriented strand board (OSB) are related to press speed and press factor, and low speed increases all mechanical properties.

Kord *et al*. (2015) have investigated that using reed stems are produced by three-layer particleboard. They have made variable parameters mixed ratio of reed and wood particles (0:100, 25:75, 50:50, 75:25 and 100:0 in the surface, and core layers), press temperature (170 ºC, 180 ºC, 190 °C) and pressing time (5 min, 6 min, 7 min). According to the results physical, and mechanical properties of particleboards have increased the increase of reed particles content. The particleboards are manufactured both single storey press and continuous press and the produced particleboards are tested of technological properties. According to test results, the single-storey presses are produced boards of higher quality than continuous press boards. However, a continuous pressing system has many advantages, so it is preferred by the factory (Güler and Sancar 2016).

Funk *et al*. (2017) have researched the use of a new type of functional inorganic additive to reduce formaldehyde emissions from particleboard. According to the results, diatomaceous earth inorganic additive in particleboard reduced free formaldehyde release. Maraghi *et al*. (2018) studied the effect of temperature on the physical and mechanical properties of particleboards. Istek *et al*. (2018) presented that the troubles related to formaldehyde and reduction methods. Zhu *et al.* (2018) explained that continuous hot presses are one of the main equipment types for medium density fiberboard (MDF) production. In addition to their work, they studied present numerical analyses of continuous hot press for medium density fiberboard (MDF) or particle board production (PB). Barragan-Lucas *et al*. (2019) have investigated the effects of pressing temperature and using resin on the formaldehyde content, physical, and mechanical properties of the particleboards. The particleboards have produced by banana pseudo-stem.

Saad *et al.* (2019) have investigated that the production of particleboard by optimizing the composition, press temperature and press time parameters using pine bark and empty fruit bunches. They have determined the density, moisture content, internal bold of particleboards properties. Solt *et al*. (2019) have investigated that the individual adhesive systems based on preferred product processes, formaldehyde emission parameters, and technological parameters suitable for particleboard production. According to the studies, they have worked on the evaluation of synthetic and renewable-based adhesives (without formaldehyde) in the production of wood-based products. Nitu *et al.* (2020) have studied the effects of particle mixing ratios, press temperatures, and pressing time on the mechanical properties and thermal stability of the jute stick binderless particleboards.

Camlibel (2020) evaluated the effects of press time, press pressure, press temperature, press speed on the particleboard's physical properties and board density. Ferrandez-Villena *et al.* (2020) have investigated that the effects of particle size, pressing time and pressing cycle on the mechanical, and physical properties of particleboards produced using *Arundo donax* L. According to the researched that mechanical properties are increased with the increase in pressing time whereas shorter pressing time caused better physical property values. Shupin *et al.* (2020) have produced three-layer low-density particleboard (400 kg/m³) from using wood particles with expanded polystyrene content ratio (0 %, 2,5 %, 5 %, 7,5 %, 10 %, 12,5 %). According to the results, the bending, and internal bond properties of boards additive expanded polystyrene are remarkably improved, and the thickness swelling is decreased.

Yel *et. al* (2020) investigated that the influence of press temperature on some properties of three-layer cement bonded particleboard manufactured from the particles of spruce (*Picea orientalis*) and poplar (*Populus tremula*). According to the results, press temperature essentially affected the properties of cement -bonded particleboard as dependent on the wood types. Lv *et al.* (2020) investigated an indefinite unsuccess mode and effects analysis technique integrated with fault and insufficiency analysis technique for the quality control of medium-density fiberboard (MDF) production using continuous hot pressing.

However, the effects of particleboards formaldehyde content, some physical and mechanical properties of particleboards, produced by continuous hot press, and multiday hot press were assessed. According to both particleboards test results, this study has assessed to performance of particleboards of tests results using two multiday and continuous hot press models.

MATERIALS AND METHODS

Materials

Scots pine (*Pinus sylvestris*), beech (*Fagus orientalis*), oak (*Quercus robur*) and poplar tree cover (*Populus alba*) wood species were used for particle boards production. These wood species were brought from the Western Black Sea, Kastamonu and Bolu stand, respectively.

Resin

Urea Formaldehyde (F:U; 1,07 moles) was produced by the Kastamonu Integrated Glue Plant in Kastamonu Organized Industrial Zone in Turkey. Properties of the produced (F:U; 1,07 moles) resin were showed in Table 1.

Table 1: Properties of used resin.

Solid matter (%)	Mole ratio (U/F)	Density (g/cm³)	Viscosity-second (25 ºC cps)	Gel time-second (100 °C) (20 % $(NH4)_2SO_4$)	pH	Free Formaldehyde (%)	Metilol groups (%)	Shelf time (day)
62 ± 1	1,07	1,227	20 -35	30 - 65	7-8,2	0,2	12 -15	75
cps: centipoise (unit for measuring dynamic viscosity)								

Ammonium sulfate (hardener agent)

Ammonium sulfate chemicals were supplied from İzmit city. The hardener was prepared as 20 % solution. Hardener agent was used of UF resin in particle board production. Resin density and pH values were 0,95 g/cm³ and 6,4 g/cm³, respectively. and 6,5 g/cm³, respectively.

Paraffin

Paraffin was white to an off-white liquid solution. Paraffin was supplied by Mercan Chemical Company in Denizli, Turkey. Paraffin had chemical values which were solid content 60 %, pH; 9-11, viscosity; 12-13 second, density; 0,96 g/cm³.

178 **Production Parameters**

179 Hardwood (60 %) and softwood (40 %) were used particleboard production at the
180 kind of materials. Mixture chips of the scoth pine (*Pinus sylvestris*) 30 %, poplar (*Populus*
181 *alba*) wood waste 10 %, sessile oak (*Quercus robur*) 40 %, beech (*Fagus orientalis*) 20
182 % were used to manufacture particleboard materials. The consumed wood chips for 1 m³
183 particleboard materials were presented in Table 2. The resin properties are shown in Table
184 1. The 1 m³ particleboard includes as following; 1,07 moles ures formaldehyde resin, 20
185 % ammonium sulfate as solution and 0,95 g/cm³ off-white liquid paraffin. Particleboards
186 were produced both multiday press and continuous press. Multiday press and continuous
187 press were used the same production includes parameters.

188 **Table 2:** Production parameters of particleboard.

Parameters	Multiday Press	Continous Press
Softwood (Scoth pine) (%)	30	30
Hardwood (Oak) (%)	40	40
Hardwood (Beech) (%)	20	20
Softwood (Poplar tree cover) (%)	10	10
Resin (F:U) moles ratio	1,07	1,07
Resin solid (%)	62	62
Resin solid according to dry chips (%)	SL:13; CL:7	SL:10,8; CL:6
Hardener according to resin solid ratio (%)	SL:3,25; CL:4,9	SL:2,7; CL:4,2
Paraffin according to dry chips (%)	SL:0,28; CL:0,35	SL:0,24; CL:0,30
Chips moisture (%)	SL:14,5; CL:5,5	SL:14,88; CL:5,90
Press temperature (ºC)	183	210
Press speed (mm/s)	200	580
Press time (s)	200	85
SL: surface-layer, CL: core-layer.		

189

190 **Production of particleboards**

191 In this study, 30 % scotch pine (*Pinus slyvestris*), 40 % sessile oak (*Quercus*
192 *robur*), beech (*Fagus orientalis*) 20 %, 10 % poplar (*Populus alba*) wood waste were
193 used. Firstly, wood materials were chipped in the chipping machine as rough chips.

194 According to the wood species, chips were transported to separately chips department in
195 the silos with the belt conveyor system. The mixed chips were adjusted according to the
196 production parameters with the help of the discharge screw under the silos. Then raw
197 chips were transformed separately surface layer chips and core layer chips by an
198 industrial-scale knife ring flaker mill (Pallmann Maschinenfabrik GmbH & Co. KG,
199 Zweibrücken, Germany). According to CL and SL chips were dried separately 2,5 %
200 surface layer and core layer 1,5 % - 1,75 % moisture by horizontal rotary roller dryer.
201 then dried chips were sieved on a shaking sieve. Chips were transported by conveyor
202 bant. According to chips size as CL and SL chips were stored in two different silos.
203 According to dry chip percentage weight, SL and CL chips were added resin, hardener
204 and paraffin according to production parameters values by dosing station. Then, chips
205 were formed before prepress particleboard form (bottom, core, surface layers) by forming
206 station.

207 The particleboard form was pressed by the pre-press station and then made ready
208 for hot press. According to product parameters values, particleboards were produced by
209 multiday hot press and continuous hot press. The particleboards produced were sized as
210 18 mm x 2100 mm x 2800 mm dimensions by cut size machine. Then, the particleboards
211 were stored in storage for 5 days. The particleboards were sanded using 40-80 and 100
212 grit sandpaper by sanding machine.

213 Particleboards were produced on the production lines of a private company. The
214 flowsheet diagram in Fig. 3 of this study was presented both the multiday hot press and
215 continuous press in Fig. 1 (continuous hot press) and Fig. 2 (multiday hot press).
216

Figure 1: Continuous hot press line.

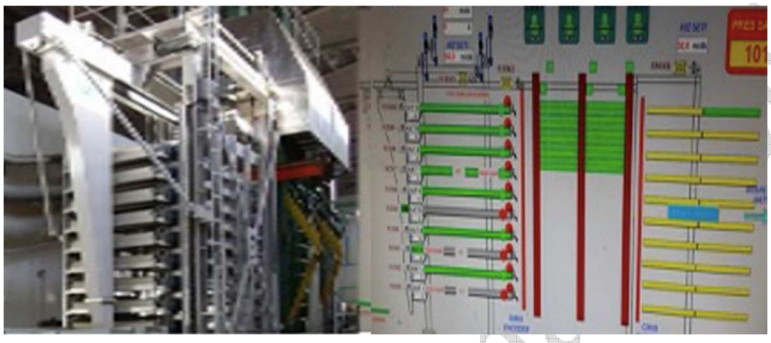

Figure 2: Multiday hot press.

The tests of particleboards

All tests of the particleboard were made in the test laboratory of the private company. All the particleboards were acclimatized at 20 ºC ± 2 ºC and 65 % ± 5 % relative humidity according to ISO 554 (1976). Particleborads properties were tested using a laboratory testing machine, IB700 (IMAL SRL, Italy), in compliance with standards.

Physical Tests

The thickness, density, moisture content, thickness swelling, and water absorption of the samples were determined in compliance with the TS EN 324-1 (TSE 1999), TS EN 323 (TSE 1999), TS EN 322 (TSE 1999), TS EN 317 (TSE 1999), and TS EN 317 (TSE 1999) standards, respectively.

Mechanical tests

The bending strength, modulus of elasticity, internal bond, and surface soundness of the particleboard samples were determined in compliance with the TS EN

310 (TSE 1999), TS EN 310 (TSE 1999), TS EN 319 (TSE 1999), and TS EN 311 (TSE 2005) standards, respectively.

Formaldehyde content analysis

The formaldehyde content of the particleboard was determined in compliance with the TS 4894 EN 120 (TSE 1999) standard.

Statistical Analysis

Independent samples T test (Mann-Whitney U) and ANOVA were used to compare means using SPSS software by a computer program. Linear regression analysis ($p < 0,05$) was performed to identify the relationship between the results of the multiday press and continuous press particleboards.

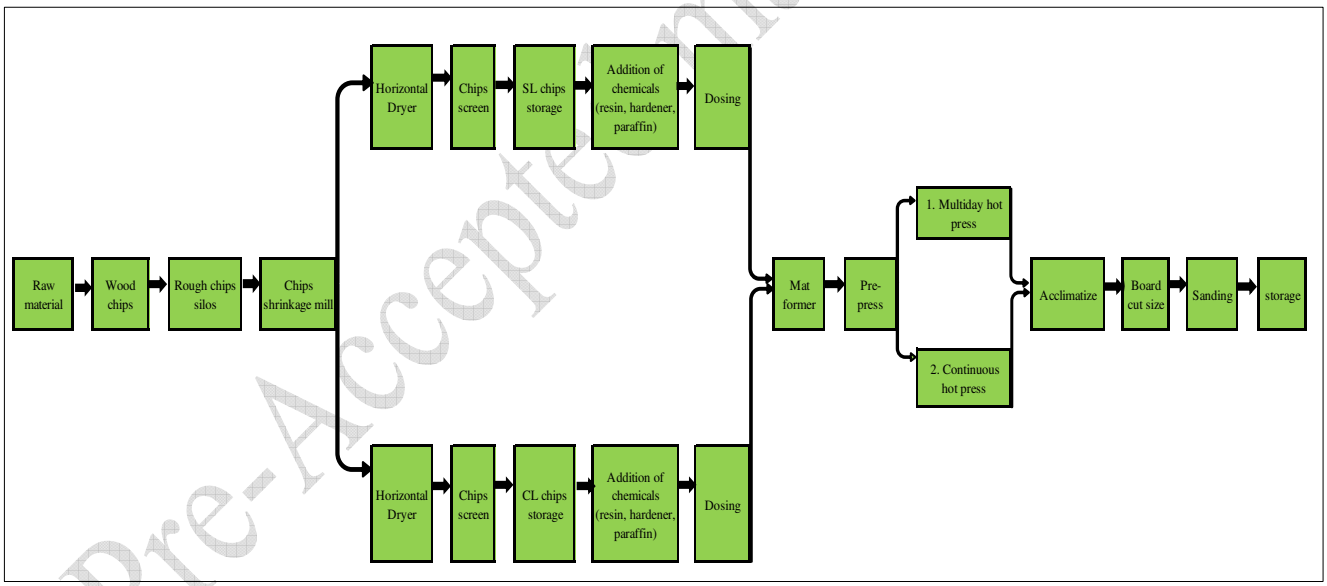

Figure 3: Workflow diagram of the test samples production.

RESULTS AND DISCUSSION

Physical Tests

The physical test results as a diagram of particleboard were presented in Fig. 4.

255 **Thickness**

256 According to statistical analysis (t 0,05:18 =0,000000001), presented in Table 3,
257 no statistically significant differences between the thickness properties of multiday press
258 particleboards and continuous press particleboards were seen. However, the multiday
259 press particleboard was 0,634 % thicker than the continuous press particleboard.

260

261 **Table 3**: Statistics for thickness properties of panels.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Thickness (mm)	MHP particleboards	10	17,995	0,018	0,006	11,438	18	0,000000001
	CHP particleboards	10	17,881	0,026	0,008			
*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).								

262

263 **Density**

264 According to statistical analysis (t 0,05:18=0,0076), presented in Table 4, no
265 statistically significant differences between the density properties of multiday press
266 particleboards and continuous press particleboards were seen. The densities of both
267 boards were homogeneous. However, continuous press particleboards were 2,70 % more
268 density than the multiday press particleboard. According to Sarı *et al.* (2012) assessed the
269 density is the essential determinant that influences the board properties.

270 **Table 4**: Statistics for density properties of boards.

Test of Boards	Groups	N	Average	Standard Deviation	Std. Error Mean	t (95 % CI*)	df	p
Density (kg/m³)	MHP particleboards	10	616,29	16,74	5,29	-3,007	18	0,0076
	CHP particleboards	10	633,38	6,53	2,07			
*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).								

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272

Moisture Content

According to the t-test results (t 0,05:18=0,742), seen in Table 5, there were statistically significant differences between the moisture content of the multiday press particleboards. The moisture content of the multiday press particleboards was 0,47 % higher than the continuous press particleboards. Consequently, it's seen that multiday press particleboards tend to absorb further moisture.

Table 5: Statistics for moisture content properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Moisture Content (%)	MHP particleboards	10	6,440	0,207	0,065	0,335	18	0,742
	CHP particleboards	10	6,410	0,194	0,061			

*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).

Thickness swelling

According to t-test result (t 0,05:9=0,000000002) presented in Table 6, it's seen that there were statistically significant differences between the thickness swelling of multiday hot press boards and continuous hot press boards. The thickness swelling of both boards was not homogeneous. However, multiday hot press boards swelled much more than continuous hot press boards. Therefore, 37 % increase in swelling may become meaningful due to the absorbance tendency of the multiday hot press boards as seen in moisture properties.

Table 6: Statistics for swelling in the thickness of 24 hours properties of particleboards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95% CI*)	df	p
Swelling in Thickness 24 hours (%)	MHP particleboards	10	16,95	0,92	0,29	21,65	9	0,000000002
	CHP particleboards	10	10,61	0,14	0,04			

*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).

Water absorption

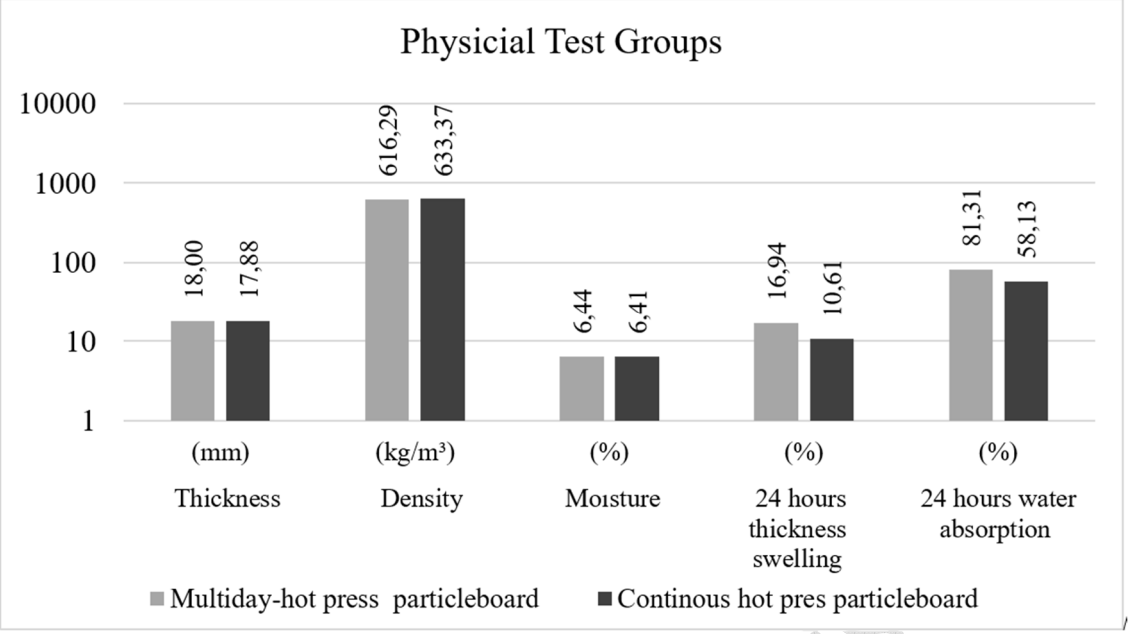
According to the t-test results (t 0,05:18=0,000000000000000000000001) presented in Table 7, there were no statistically significant differences between the water absorption of multiday hot press boards and continuous hot press boards. The water absorption of both boards was homogeneous. Therefore, 39,9 % increase in water absorption may not become meaningful due to the absorbance tendency of the multiday hot press boards as seen in absorption properties. According to Nemli *et al*. (2004) measured the 24 hours water absorption of particleboard single day press values higher than the continuous press.

Table 7: Statistics for water absorption 24 hours properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Water Absorption 24 hours (%)	MHP particleboards	10	81,31	0,84	0,27	72,37	18	0,000000000000000000001
	CHP particleboards	10	58,13	0,56	0,18			

*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).

According to Figure 4 results, the physical properties of particleboards have resulted in more quality continuous press boards than multiday press boards properties. The continuous press particleboards of physical properties (thickness swelling, water absorptions) less measured than multiday press particleboard.



313 **Figure 4:** Physical test groups of particleboards.

314

315 **Mechanical Tests**

316 The mechanical test results as a diagram of particleboard were presented in Fig.
317 5.

318 **Bending strength**

319 According to the t-test results (t 0,05:18=0,747) presented in Table 8, there were
320 no statistically significant differences between the bending strength of multiday hot press
321 boards and continuous hot press boards. The bending strength of both boards was
322 homogeneous. Consequently, 1,27 % increase in provided that bending strength of the
323 multiday hot press boards than continuous hot press boards as seen in bending properties.
324 According to Nemli *et al*. (2004) study the elasticity modulus of particleboard made test
325 which is single day press 2134,57 N/mm² and continuous press 1824,53 N/mm². The
326 elasticity of the single-layer pressboards was measured higher. Nemli *et al.* (2004) test
327 results of the study have supported this study.

328

329

330 **Table 8**: Statistics for bending strength properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Bending Strength (N/mm^2)	MHP particleboards	10	14,38	1,02	0,32	0,33	18	0,747
	CHP particleboards	10	14,20	1,42	0,45			

*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).

331
332 **Modulus of elasticity**

333 According to the t-test results (t 0,05:18=0,004) presented in Table 9, there were
334 no statistically significant differences between the modulus of elasticity of the multiday
335 hot press boards and continuous hot press boards. The modulus of elasticity of both
336 boards was homogeneous. The modulus of elasticity the multiday press particleboards
337 was 11,35 % more flexibility than the continuous press particleboards. Consequently,
338 11,35 % increase in provided that bending strength of the multiday hot press boards than
339 continuous hot press boards as seen in bending properties.

340 **Table 9**: Statistics for modulus of elasticity properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Modulus of Elasticity (N/mm^2)	MHP particleboards	10	2908,40	177,43	56,11	3,33	18	0,004
	CHP particleboards	10	2612,00	218,80	69,19			

*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).

341
342 **Internal bond**

343 According to the t-test results (t 0,05:18=0,176) presented in Table 10, there were
344 no statistically significant differences between the internal bond of multiday hot press
345 boards and continuous hot press boards. The internal bond of both boards was
346 homogeneous. The internal bond of the multiday press particleboards was 7,22 % higher
347 than the continuous press particleboards. Consequently, 7,22 % increase in provided that

348 internal bond of the multiday hot press boards than continuous hot press boards as seen
349 in internal bond breakage properties. Ferrandez-Villena *et al.* (2020) have explained that
350 mechanical properties are amplified with the increase in pressing time (7, 7+7, 15, 15+15
351 min) whereas shorter pressing time caused better physical property values.

352 **Table 10**: Statistics for internal bond properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Internal Bond (N/mm²)	MHP particleboards	10	0,401	0,050	0,016	1,407	18	0,176
	CHP particleboards	10	0,374	0,034	0,011			
*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).								

353

354 **Surface soundness**

355 According to the t-test results (t 0,05:18=0,000007) presented in Table 11, there
356 were no statistically significant differences between the surface soundness of multiday
357 hot press boards and continuous hot press boards. The surface soundness of both boards
358 was homogeneous. The surface soundness of the continuous press particleboards was a
359 percentage 18,81 % higher than the multiday press particleboards. However, the
360 percentage 18,81 % increased on surface soundness of the continuous hot press boards
361 than multiday hot press boards.

362 **Table 11**: Statistics for surface soundness properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Surface Soundness (N/mm²)	MHP particleboards	10	1,127	0,078	0,025	-6,270	18	0,000007
	CHP particleboards	10	1,339	0,073	0,023			
*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).								

363 **Withdrawal of screw resistance**

364 According to the t-test results (t 0,05:9,57=0,0418) presented in Table 12, there
365 were statistically significant differences between the withdrawal of screw resistance of

366 multiday hot press boards and continuous hot press boards. The withdrawal of screw
367 resistance of both boards was not measured as homogeneous. The reason was that the
368 working principles of the multiday hot press from the continuous hot press and the
369 features of the hot press were different from each other. The withdrawal of screw
370 resistance of the continuous press particleboards was percentage 14 % higher than the
371 multiday press particleboards. Consequently, the percentage 18,81 % increased on
372 surface soundness of the continuous hot press boards than multiday hot press boards.

373 **Table 12**: Statistics for withdrawal of screw resistance properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Withdrawal of Screw Resistance (N/mm²)	MHP particleboards	10	74,64	13,86	4,38	-2,349	9,57	0,0418
	CHP particleboards	10	85,10	2,47	0,78			

*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).

374

375 According to Güler and Sancar (2016) assessed that the single-storey press
376 particleboards and continuous press particleboards of mechanical properties (bending
377 strength, modulus of elasticity, internal bond) of all test results compared and the single
378 storey press boards mechanical properties resulted in more quality than continuous press
379 boards properties.

380 According to Figure 5 results, the mechanical properties (bending strength,
381 modulus of elasticity, internal bond) of particleboards have resulted in more quality
382 multiday press particleboards than continuous press boards properties. However, the
383 continuous press particleboards of mechanical properties (surface soundness, withdrawal
384 of screw resistance) higher measured than multiday press particleboard. Güler and Sancar
385 (2016) test results of the mechanical properties (bending strength, modulus of elasticity,
386 internal bond) of particleboards were supported test results in this study. Camlibel (2021)

showed in his study that according to multiday layer hot press parameters which were the increase in pressing time and a decrease in press temperature and press speed; as a result of testing the produced boards the internal bond, modulus of elasticity, screw holding strength increased, but the flexural strength and surface resistance of the board decreased.

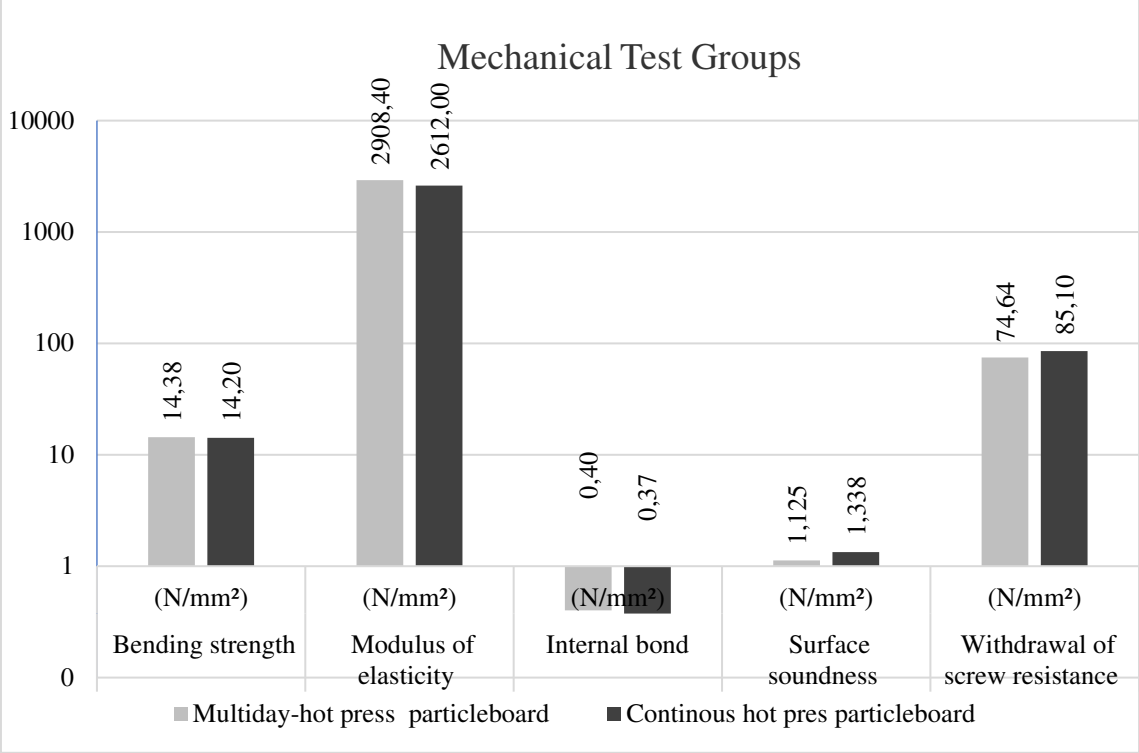


Figure 5: Mechanical test groups of particleboards.

Formaldehyde gas emission

The Formaldehyde content emission results as a diagram of particleboard were presented in Fig. 6. According to the t-test results (t 0,05:18=0,000000000000000002) presented in Table 13, there were no statistically significant differences between the formaldehyde gas emissions of multiday hot press particleboards and continuous hot press particleboards. The formaldehyde gas emissions of both boards were homogeneous. Consequently, there are differences ($p < 0,05$) between the groups. As shown in Table 13, continuous hot press particleboards production provided a significant reduction (57,12 %) in formaldehyde gas emission when compared to multiday hot press

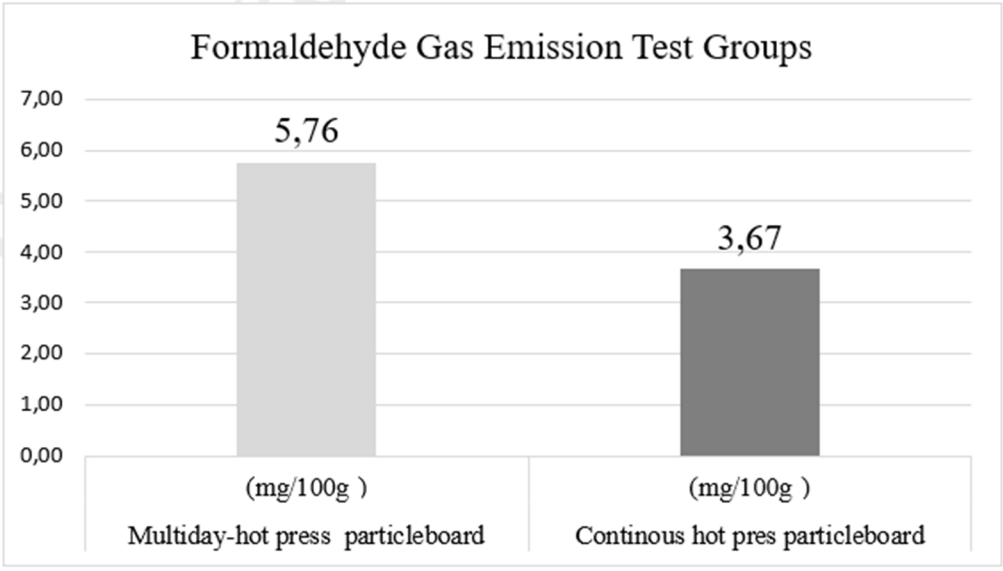
403 particleboards result. Therefore, the utilization of continuous hot press production not
404 only contributes to the reduction of gas emission but also health more than the multiday
405 hot press. A remarkable decrease (57,12) in formaldehyde emission was observed when
406 particleboard production using to continuous hot press. Camlibel (2020) performed that
407 carried out his work in a panel production continuous press pross in the factory.
408 According to the assess results, the biggest formaldehyde content emission performed
409 0,98 mole UF resin while the lowest values 0,88 moles resin. According to Hong *et al*.
410 (2017) assessed the study's results, formaldehyde content emission of the MDF boards
411 decreased and increased with the increase in density and adhesive content (from 8 % to
412 14 %), respectively.

413 **Table 13**: Statistics for formaldehyde content properties of boards.

Test of Boards	Groups	N	Average	Std. Deviation	Std. Error Mean	t (95 % CI*)	df	p
Formaldehyde Content (mg / 100 g)	MHP particleboards	10	5,763	0,143	0,045	37,062	18	0,000000000000000002
	CHP particleboards	10	3,668	0,107	0,034			

*Confidence Interval, N: Number of samples, t: the computed test statistic, df: the degrees of freedom, p values: confidence level for a confidence interval, multiday hot press (MHP), continous hot press (CHP).

414



415 **Figure 6:** Formaldehyde gas emission test groups.

According to figure 6 results, formaldehyde gas emission analysis less measured the continuous press particleboards (3,67 mg / 100 g) than multiday press particleboard (5,76 mg / 100 g). Camlibel and Ayata (2021) according to this study as a result of the increase in the mole amount of urea-formaldehyde glue, the free formaldehyde emission in the high-density fiberboard (HDF) increased. The free formaldehyde analysis result of high-density fiberboard (HDF) produced with 0.88 moles urea formaldehyde glue; 7,40 (mg / 100 g) measured. The free formaldehyde analysis result of high-density fiberboard (HDF) produced with 1.17 moles urea-formaldehyde glue; 14,76 (mg / 100 g) measured. Camlibel and Aydın (2022) explained that according to the results of the studies performed on unconditioned and conditioned particle boards, the most obvious parameter affected by the increase in continuous press speed was free formaldehyde.

CONCLUSIONS

The influence of the multiday hot press and continuous hot press on the physical and mechanical properties, and formaldehyde gas emission content of the particleboards were investigated in this study. It is shown that thickness, density, moisture content were not an important increase in both research particleboards. The thickness swelling percentage 37 % and water absorption percentage 40 % test measurement results of multiday hot press boards have increased significantly compared to the test measurement results of continuous hot press boards. It is seen that thickness swelling and water absorption were increased in the multiday hot press of particleboards.

Internal bond percentage 7,22 %, bending elasticity percentage 1,27 % and modulus of elasticity percentage 11,35 % are increased in multiday hot press particleboards than continuous hot press particleboards. But continuous hot press particleboards are increased surface soundness percentage 18,81 % and withdrawal of

441 screw resistance percentage 14 %. The remarkable increase in surface soundness and
442 withdrawal of screw resistance was observed when particleboard production using to
443 continuous hot press.

444 The remarkable decreased formaldehyde content was analysed when using
445 continuous hot press than multiday hot press particleboards test results. In the result of
446 working was a decreased percentage of 57,12 %. According to the formaldehyde emission
447 analysis results, it is seen that low analysis of formaldehyde emission is very important
448 to use continuous presses in particleboard manufacture.

449

450 **ACKNOWLEDGMENTS**

451 The authors would like to thank Enus KOC and the director of the Kastamonu
452 Integrated Wood Inc.

453

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