

DOCUMENT CONTROL & CORPORATE IDENTIFIERS				
Platform Designation:	Hempoxies Dynamic Vit-rimer Platform	Operating Entity:	Hempoxies Division, Landry Industries	
Web Domains:	landryindustries.ca marielandryspyshop.com	Operations Base:	Moncton, New Brunswick, Canada	
Document Version:	LI-HEMP-BP-2026-V1.0	Scale-Up Focus:	TRL 1–2 to TRL 10 (Series Export)	
Publication Date:	August 2026	Lead Director:	Marie-Soleil Seshat Landry (CEO)	

Executive Governance & Sign-Off Matrix

Governance Role	Designated Name / Title	Corporate Entity	Status	Date
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Regulatory Affairs Lead	CTLS Compliance Liaison	Landry Regulatory Group	IN PROGRESS	Aug 2026
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1. Executive Summary & Corporate Architecture

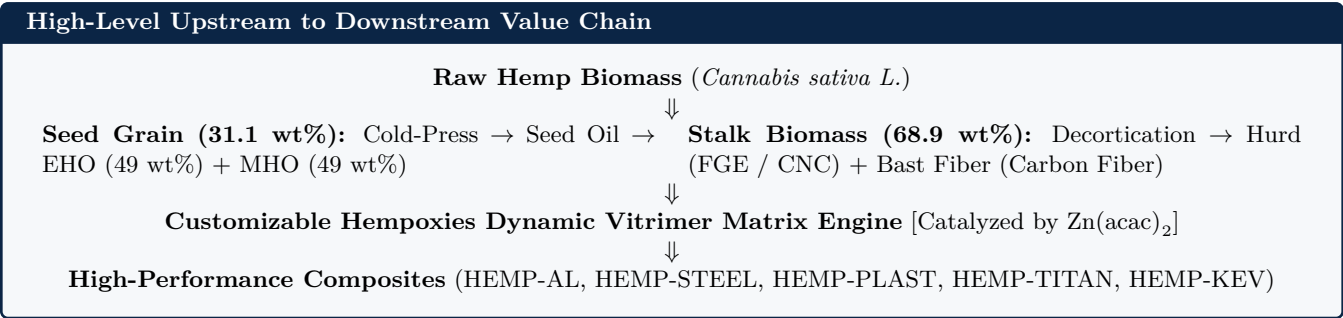
1.1 Strategic Mission & Corporate Positioning

The Hempoxies Division of Landry Industries (landryindustries.ca) commercializes a > 99% bio-based dynamic covalent vitrimer composite platform derived exclusively from *Cannabis sativa L.* monoculture biomass. The corporate mission is to advance this biomaterial platform from Technology Readiness Level (TRL) 1–2 (analytical proof-of-concept) to TRL 10 (multi-site continuous biorefining and global export) within a 36-to-60 month time-frame.

By displacing petroleum-derived diglycidyl ether of bisphenol A (DGEBA) matrices, non-recyclable fiberglass, and structural engineering metals (Aluminum 6061-T6, Titanium Ti-6Al-4V, Structural Steel), Hempoxies eliminates toxic chemical precursors (e.g., bisphenol A, epichlorohydrin, aromatic amines), solves end-of-life composite disposal, and lowers industrial Scope 1, 2, and 3 carbon compliance costs.

1.2 Asset-Light Corporate Structure & Operating Model

- Operating from Moncton, New Brunswick, the operational model integrates three functional tiers:
- Upstream Agricultural Supply Tier:** Multi-year contract-farming off-take agreements across Western and Atlantic Canada securing hempseed oil and dry stalk biomass without real estate CapEx.
 - Midstream Biorefinery Hub (Moncton, NB):** Centralized chemical synthesis of Epoxidized Hempseed Oil (EHO), Maleinized Hempseed Oil (MHO), and Furfuryl Glycidyl Ether (FGE); nanomaterial processing suites (HGO, CNC, Biochar); continuous twin-screw compounding; and hot-melt prepreg production.
 - Downstream Commercial Deployment:** Direct delivery to Tier-1 automotive, marine, aerospace, and civil infrastructure OEMs; joint ventures; and IP licensing across North America, Europe, and Asia-Pacific.



1.3 Platform Modularity & Comparative Benchmarks

Unlike traditional bio-resins that rely on rigid, static polymer networks, the Hempoxies platform utilizes dynamic β -hydroxy ester network chemistry catalyzed by zinc acetylacetonate [Zn(acac)₂]. This enables associative transesterification above the topology freezing transition temperature ($T_v \approx 138.5^\circ\text{C}$), permitting solid-state welding, thermal repairability, and true circular recycling.

Table 1: Flagship Performance Comparison vs. Incumbent Engineering Materials						
Material Designation	Density ρ [g/cm ³]	Tensile σ_t [MPa]	Modulus E [GPa]	Specific Mod. [GPa · cm ³ /g]	Biogenic Carbon	End-of-Life Circularity
DGEBA/Amine Epoxy	1.28	80	3.4	2.66	0.0%	Non-Recyclable (Landfill)
Aluminum 6061-T6	2.70	310	68.9	25.5	0.0%	Energy-Intensive Melt
Structural Steel A36	7.85	400	200.0	25.5	0.0%	Energy-Intensive Melt
HEMP-AL (LI)	1.35	280	38.0	28.1	> 99.0%	100% Dynamic Vitrimer
HEMP-TITAN (LI)	1.38	310	42.0	30.4	> 99.0%	100% Dynamic Vitrimer

1.4 Phased Commercialization & Financial Trajectory

- **Phase 1 (Months 1–12):** Validate TRL 4–5; commission 100 L pilot synthesis reactors in Moncton; produce initial tooling resins and adhesives; reach \$7.50M CAD in revenue.
- **Phase 2 (Months 13–24):** Advance to TRL 6–8; contract 6,500 agricultural acres; launch continuous PFR synthesis and automated prepreg coating; achieve \$27.00M CAD ARR (30.4% EBITDA).
- **Phase 3 (Months 25–36):** Commission 1,000-tonne demonstration biorefinery to full throughput (TRL 9); deploy structural variants (HEMP-TITAN, HEMP-KEV); reach \$67.50M CAD ARR.
- **Phases 4 & 5 (Months 37–60):** Scale Moncton hub and international joint ventures to 18,000 tonnes/year (TRL 10); achieve \$270.00M CAD revenue and \$128.00M CAD EBITDA (47.4% margin).

2. Technology Readiness Level (TRL 1–10) Progression Roadmap

The Hempoxies commercialization trajectory advances through a 5-phase stage-gate progression model governing technical validation, process scale-up, and risk mitigation.

2.1 TRL Stage-Gate Governance Matrix

TRL	Stage Designation		Key Technical & Operational Scope	Quantitative Criteria	Stage-Gate	Exit
TRL 1	Basic Principles		Ab-initio molecular modeling of ester exchange; screening of triglyceride unsaturation profiles.	Theoretical proof of dynamic β -hydroxy ester bond stability.		
TRL 2	Concept	Formulation	Formulating stoichiometric ratios of EHO:MHO:FGE; selecting $\text{Zn}(\text{acac})_2$ catalyst.	Laboratory gel point confirmation; reproducible cross-linking at 120°C.		
TRL 3	Analytical	Proof-of-Concept	10 L glass synthesis batches; ultrasonic HGO/CNC dispersion; dynamic mechanical analysis (DMA).	Tensile modulus > 35 GPa; bio-based carbon > 99% (ASTM D6866); $\tau^* < 300$ s at 180°C.		
TRL 4	Lab Validation	in Matrix	100 L batch pilot synthesis; peracetic acid exotherm mitigation (55–60°C); coupon mechanicals.	Residual solvent < 0.1 wt%; oxirane content 7.0–7.5 wt%; exotherm controlled $\pm 1.5^\circ\text{C}$.		
TRL 5	Demo in Industrial Environment		Continuous plug flow reactor (PFR) epoxidation; twin-screw compounding; closed solvent loops.	72-hour continuous PFR run (10 tonnes base resin); solvent recovery > 98.5%.		
TRL 6	Prototype	Component Demo	Hot-melt prepreg production (1,200 mm width); composite molding of automotive/marine test parts.	Automotive floorpan prototypes passing ISO 16750 thermal shock (−40°C to +120°C).		
TRL 7	System Integration & Pilot		High-pressure RTM (< 30 s wet-out); solid-state thermal joint welding; CTLS licence execution.	Welded joint lap-shear strength > 28 MPa; Tier-1 PPAP Level 3 documentation delivered.		
TRL 8	Pre-Series Qualification	Line	High-speed prepreg coating (15 m/min); aerospace structural testing; AS9100 quality audit.	AS9100 / ISO 9001 certification; $C_{pk} \geq 1.67$ across 500 pre-series production parts.		
TRL 9	Commercial Production	Series	4,500 t/year full capacity deployment; pan-Canadian supply chains active; inter-modal export.	Moncton facility operating at > 85% capacity; unit direct COGS $\leq$ \$4.60 CAD/kg confirmed.		

TRL	Stage Designation		Key Technical & Operational Scope	Quantitative Criteria	Stage-Gate	Exit
TRL 10	Global Expansion	Multi-Site	Biorefinery expansion; technology licensing to Western Canada and Europe (> 18,000 t/year).	Multi-site licensing agreements active; recurring royalty lines generating sustained cash flows.		

2.2 Stage-Gate Transition Protocols

- **Gate 1 (TRL 2 → 3):** Molecular confirmation via ¹H-NMR, ¹³C-NMR, and FTIR verifying oxirane oxygen content (7.0–7.5 wt%) and epoxy equivalent weight (220–230 g/eq).
- **Gate 2 (TRL 4 → 5):** Validation of continuous solvent stripping (< 0.05 wt% residual ethanol), exotherm control (±1.5°C), and dynamic relaxation (τ* < 300 s at 180°C).
- **Gate 3 (TRL 6 → 7):** Regulatory sign-off from NB DELG (EIA registration), Health Canada CTLS Standard Processing approval, and NFPA 30 Class I Div 1 containment commissioning.
- **Gate 4 (TRL 8 → 9):** Verified manufacturing direct cost (≤ \$4.60 CAD/kg base resin) and signed OEM off-take contracts covering ≥ 60% of Phase 1 plant capacity.

3. Core Chemical Architecture, Dynamic Vitrimer Networks & IP Defense

3.1 Dynamic β-Hydroxy Ester Network Synthesis

The matrix comprises cold-pressed hempseed oil derivatives: Epoxidized Hempseed Oil (EHO, 49.0 wt%) as the polyfunctional epoxide monomer and Maleinized Hempseed Oil (MHO, 49.0 wt%) as the polyanhydride dynamic cross-linker.

Primary Vitrimer Cross-Linking Mechanism

Oxirane Ring (EHO) + Cyclic Anhydride (MHO) $\xrightarrow[120-140^{\circ}\text{C}]{\text{Zn}(\text{acac})_2 \text{ (2.0 wt\%)}}$ Dynamic β-Hydroxy Ester Network

1. **Epoxidized Hempseed Oil (EHO):** Hempseed oil contains 54–57% linoleic acid (18:2) and 16–20% α-linolenic acid (18:3), providing an average functionality of 5.6 to 6.2 double bonds per triglyceride molecule. In-situ peracetic acid epoxidation converts these double bonds into oxirane rings with minimal oxirane degradation.
2. **Maleinized Hempseed Oil (MHO):** Synthesized via the ene-addition reaction of maleic anhydride with unconjugated double bonds of hempseed oil triglycerides at 200–210°C, yielding succinic anhydride functional groups along the fatty acid chains.
3. **Dynamic Transesterification Catalyst (Zn(acac)₂):** Zinc acetylacetonate (2.0 wt% / 2.0–3.0 phr) catalyzes the ring opening of oxirane groups by anhydride moieties at 120–140°C. Above the topology freezing transition temperature (*T_v* ≈ 138.5°C), the Zn²⁺ complex coordinates with ester carbonyls and free β-hydroxyl groups, driving associative transesterification.

3.2 Dynamic Transesterification Kinetics & Maxwell Relaxation

Above *T_v*, transesterification allows stress relaxation while maintaining cross-link density:

$$\sigma(t) = \sigma_0 \cdot \exp\left(-\frac{t}{\tau^*}\right)$$

(1)

Where the characteristic relaxation time τ^* follows the Arrhenius relation:

$$\tau^*(T) = \tau_0 \cdot \exp\left(\frac{E_a}{R \cdot T}\right)$$

(2)

Empirical activation energy $E_a = 82.4$ kJ/mol; $\tau^* = 180$ s at 180°C , and $\tau^* = 45$ s at 200°C . Below $T_v = 138.5^\circ\text{C}$, the material exhibits creep-resistant thermoset behavior ($\eta > 10^{12}$ Pa · s).

3.3 Furan-Based Reactive Diluent Chemistry (Bio-FGE)

Hemp stalk hurd hemicellulose is hydrolyzed to furfural, hydrogenated to furfuryl alcohol, and glycidylated with epichlorohydrin to yield Furfuryl Glycidyl Ether (FGE, 8.0–12.0 phr).

- **Viscosity Reduction:** Lowers precursor viscosity from 1,100 mPa · s to < 180 mPa · s at 80°C for HP-RTM processing.
- **Aromatic Interfacial Coupling:** Furan rings establish non-covalent π – π stacking interactions with graphitic nanocarbons and carbon fibers, increasing interfacial shear strength (IFSS) by > 42%.

3.4 5-Tier Hierarchical Reinforcement Framework

Table 3: 5-Tier Length-Scale Reinforcement Architecture

Length Scale	Material Reinforcement Class	Loading	Primary Functional Mechanics
Molecular (0.1–1 nm)	Furfuryl Glycidyl Ether (FGE)	8.0–12.0 phr	Viscosity depression; aromatic π – π interfacial matrix anchoring.
Nano-2D (1–100 nm)	Hemp Graphene Oxide (HGO/HrGO)	0.2–1.0 phr	Tortuous moisture barrier; electrical percolation; crack deflection.
Nano-1D (1–100 nm)	Cellulose Nanocrystals (CNC)	1.0–2.0 phr	Matrix rigidification; rod-like crack pinning; increases T_g .
Micro-0D (1–100 μm)	Hemp Biochar (< 250 μm)	3.0–5.0 phr	Compressive support; micro-void filling; cures resin shrinkage.
Macro-1D (mm to m)	Chopped / Continuous Carbon Fiber	15.0–45.0 phr	Primary tensile, flexural, and structural load-bearing frame.

4. Programmable Variant Library & Target Incumbent Benchmarking

4.1 Formulation Control Knobs & Micromechanics

Formulations are programmed using four variables:

1. **EHO:MHO Stoichiometry:** Epoxide-rich (55:45) yields ductile matrices (> 12% elongation); anhydride-rich (40:60) maximizes cross-linking and elevates T_g to > 125°C .
2. **Diluent Loading (FGE):** Modulates viscosity from 120 mPa · s to 850 mPa · s for process optimization.
3. **Multiscale Reinforcement Mix:** Programs tensile modulus ($E_{\text{composite}}$) using the modified Cox-Krenchel model:

$$E_{\text{composite}} = V_m E_m + \eta_L \eta_O V_f E_f$$

(3)

4. **Catalyst Concentration $[\text{Zn}(\text{acac})_2]$:** Dosing from 1.0 to 4.0 phr tunes stress relaxation (τ^*) between structural creep resistance and rapid remolding.

4.2 Flagship Variant Mechanical Profiles

Table 4: Standard Hempoxies Platform Variants vs. Target Incumbents						
Variant ID	Target Incumbent Benchmark	Density [g/cm ³]	σ_{tensile} [MPa]	E [GPa]	Spec. Mod. [GPa · cm ³ /g]	Core Value Proposition vs. Incumbent
HEMP-AL	Aluminum 6061-T6	1.35	280	38.0	28.1	+10% spec. modulus; 50% mass savings.
HEMP-STEEL	Mild Steel (A36)	1.32	220	28.0	21.2	+193% spec. strength; 83% mass reduction.
HEMP-PLAST	ABS / PA-6 Plastic	1.18	85	5.5	4.66	+113% strength vs. ABS; 100% circular.
HEMP-CRETE	C30 Concrete	1.45	35*	8.0	5.52	Hydrophobic; ductile (*Comp: 55 MPa).
HEP-OXY	Neat DGEBA Epoxy	1.28	140	12.0	9.38	+100% tensile strength; dynamic vitrimer.
HEMP-KEV	Kevlar-49 Composite	1.42	420	52.0	36.6	Impact resistant; solid-state weldable.
HEMP-TITAN	Ti-6Al-4V Grade 5	1.38	310	42.0	30.4	+18% spec. modulus; 69% mass reduction.
HEMP-GFRP	E-Glass / Epoxy	1.30	200	26.0	20.0	28% lighter than GFRP; closed-loop recovery.

5. Agricultural Supply Chain & Pan-Canadian Contract Farming

5.1 Dual-Crop Agronomic Model & Feedstock Mass Balance

The agricultural model utilizes approved Canadian *Cannabis sativa L.* cultivars (e.g., Finola, Katani, CFX-2, Anka), capturing seed grain and stalk biomass simultaneously from each acre.

Per-Acre Industrial Hemp Mass Balance	
1 Acre Industrial Hemp Cultivation	
↓	
Seed Grain Harvest (900 lbs / acre):	Dry Baled Straw Harvest (5,500 lbs / acre):
• Cold-Pressed Seed Oil: 280 lbs (31.1%) → Matrix	• Clean Bast Fiber: 1,100 lbs (20.0%) → Carbon Fiber
• Seed Press Cake: 620 lbs (68.9%) → Animal Feed	• Hurd Biomass: 4,400 lbs (80.0%) → FGE / CNC / Biochar

5.2 Pan-Canadian Sourcing Acreage Projections

Table 5: 3-Phase Pan-Canadian Sourcing Projections

Agricultural Zone	Target Sourcing Focus	Phase 1 (Yr 1)	Phase 2 (Yr 2)	Phase 3 (Yr 3)
Western Grain Belt (SK, AB, MB)	High-density grain & seed oil	1,200 acres	5,000 acres	18,000 acres
Atlantic Maritime Zone (NB, NS, PEI)	Dual fiber & regional Moncton straw	300 acres	1,500 acres	4,500 acres
Total Contract Acreage	Pan-Canadian Supply Network	1,500 acres	6,500 acres	22,500 acres
Total Feedstock Yield	Seed Oil / Dry Straw Output	592 t / 1,795 t	2,555 t / 7,845 t	8,890 t / 26,925 t

5.3 Contract Structuring & Agronomic Economics

- **Multi-Year Take-or-Pay Agreements:** 3-to-5 year fixed-margin contracts guaranteeing \$0.75–\$0.85 CAD/lb for seed grain and \$120–\$150 CAD/tonne for baled dry straw (< 12% moisture).
- **Farm-Gate Revenue Impact:** Dual-crop harvesting generates \$650–\$850 CAD/acre in gross revenue, outperforming conventional canola (\$480–\$550/acre) and spring wheat (\$380–\$440/acre).
- **Feedstock Quality Thresholds:** Oil inputs must exhibit Free Fatty Acids (FFA) < 1.5 wt%, Iodine Value 160–180 g I₂/100g, and moisture < 0.1 wt%; stalk biomass requires bast/hurd decortication purity > 92%.

6. Centralized Biorefinery Architecture & Operations (Moncton Hub)

6.1 Site Selection & Intermodal Logistics

The centralized biorefinery is sited on a 10-acre parcel in the Caledonia Industrial Park, Moncton, New Brunswick.

- **Transportation Infrastructure:** Immediate access to Trans-Canada Route 2 and direct rail siding connection to the CN Moncton Intermodal Terminal, enabling 12-hour container freight transit to the Port of Halifax for European export.
- **Utilities Infrastructure:** 12.5 kV high-voltage electrical drops, industrial natural gas, and municipal industrial effluent hookups.

6.2 Facility Zoning & Major Equipment Specifications

Table 6: Moncton Facility Zoning and Primary Equipment Specifications

Facility Zone	Operational Scope	Primary Equipment	Nameplate Capacity
Zone 1	Raw Feedstock & Solvent Storage	4× 100,000 L passivated stainless tanks; Class I Div 1 solvent bays.	400,000 L bulk oil; 5,000 t baled straw.
Zone 2	Chemical Synthesis Suite	10,000 L glass-lined Pfaudler reactors; continuous PFR epoxidation loops.	1,200 t/year EHO/MHO; 120 t/year FGE diluent.
Zone 3	Nanomaterials & Biochar Suite	Hydrothermal carbonization (HTC) units; 20 kHz / 1.5 kW sonication cells.	15 t/year exfoliated HGO; 25 t/year CNC whiskers.
Zone 4	Compounding & Prepreg Lines	40 mm twin-screw extruder ($L/D = 48$); 1,200 mm hot-melt prepreg coater.	1,500 t/year compounded resin; 800,000 m ² /yr prepreg.

7. Standard Operating Procedures (SOPs) & Chemical Process Engineering

7.1 Master Chemical Synthesis Procedures

7.1.1 SOP-EHO-001: In-Situ Peracetic Acid Epoxidation of Hempseed Oil

- **Reactor Charge:** 10,000 L glass-lined reactor charged with cold-pressed hempseed oil (100 phr), glacial acetic acid (0.20 eq relative to unsaturation), and Amberlite IR-120 cation exchange resin catalyst (5.0 wt%).
- **Dosing & Temperature Control:** Stirred at 350 RPM and heated to 50°C. Hydrogen peroxide (50 wt%, 1.10 eq) is metered at < 2.5 L/min over 4.0 hours, maintaining temperature between 55.0°C and 60.0°C via automated glycol cooling jackets.
- **Isolation:** Held at 60°C for 3.0 hours until oxirane oxygen reaches 7.0–7.5 wt%. Catalyst is filtered; organic phase is washed with demineralized water and vacuum stripped at 80°C (10 mbar) to yield clear EHO (EEW: 220–230 g/eq).

7.1.2 SOP-MHO-001: Maleinization of Hempseed Oil via Ene-Addition

- **Reactor Charge:** Nitrogen-purged 10,000 L reactor charged with refined hempseed oil (100 phr) and maleic anhydride briquettes (30.0 phr).
- **Thermal Cycle:** Heated under nitrogen blanket to 200–210°C over 2.5 hours under 400 RPM agitation; held at 205°C for 6.0 hours until unreacted maleic anhydride drops below 0.5 wt%.
- **Product Specifications:** Cooled to 80°C and filtered (Acid Value: 100–110 mg KOH/g; Viscosity: 1,400–1,800 mPa·s at 25°C).

7.1.3 SOP-FGE-001: Furfuryl Glycidyl Ether Synthesis

Acid-hydrolyzed hurd furfural is hydrogenated to furfuryl alcohol. Furfuryl alcohol (1.0 eq) is reacted with epichlorohydrin (1.5 eq) and NaOH (1.1 eq) with tetrabutylammonium hydrogen sulfate (1.0 mol%) at 40°C for 4.0 hours, followed by vacuum distillation (85–90°C, 5 mbar) to isolate pure bio-FGE (> 98% purity; viscosity: 3.0–5.0 mPa·s).

7.2 Critical Process Parameters (CPP) & Quality Attributes (CQA)

Table 7: CPP and CQA Manufacturing Acceptance Limits

SOP Identifier	Critical Parameter (CPP)	Operating Range	Critical Attribute (CQA)	Acceptance Target
SOP-EHO-001	H ₂ O ₂ Metering Rate	< 2.5 L/min (55–60°C)	Oxirane Oxygen Content	7.0–7.5 wt%
SOP-MHO-001	Reaction Temperature	205.0 ± 2.5°C (400 RPM)	Acid Value Number	100–110 mg KOH/g
SOP-FGE-001	Vacuum Distillation	5.0 ± 0.5 mbar (85–90°C)	Monomer Purity	≥ 98.0% Purity
SOP-CNC-001	Acid Hydrolysis Residence	45.0 ± 2.0 min (64 wt% H ₂ SO ₄)	Whisker Aspect Ratio (<i>L/D</i>)	30–50 L/D
SOP-SCF-001	Carbonization Atmosphere	1,100 ± 10°C (N ₂ > 99.999%)	Fiber Tensile Modulus	> 180.0 GPa

8. Pilot-Scale Lab Validation, Exotherm Mitigation & Testing (TRL 3–4)

8.1 100 L Pilot Batch Exotherm Control

Peracetic acid epoxidation releases substantial enthalpy ($\Delta H \approx -250$ kJ/mol oxirane). In the 100 L pilot glass-lined reactor, thermal runaway is mitigated by:

- **Dual-Circuit Glycol Chilling:** A closed-loop 15 kW chiller circulates coolant at -5°C through the reactor jacket, maintaining inner wall temperatures capable of absorbing peak exothermic loads.
- **DCS Automated Quench Safeguard:** Automated dump valves flood the reactor with cold demineralized water and sodium bicarbonate solution if core reaction temperatures exceed 68.0°C .

8.2 Ultrasonic Nanocarbon Dispersion & Solvent Stripping

Nanofillers (HGO, CNC) are dispersed in anhydrous ethanol (1:10 w/v) and cycled through a continuous 20 kHz / 1.5 kW ultrasonic flow cell at 5.0 L/min for 60 minutes. The ethanolic slurry is mixed into the EHO/MHO/FGE resin and stripped in a wiped-film vacuum evaporator (75°C , 10 mbar), reducing residual solvent to < 0.05 wt%.

8.3 ASTM/ISO Coupon Testing Matrix

Table 8: ASTM/ISO Coupon Validation Targets (TRL 4 Exit)

Property Evaluated	Standard Specification	Specimen Ge- ometry	TRL 4 Target Result
Tensile Strength & Modulus	ASTM D638 (Type I)	Dog-bone (165 × 19 × 3.2 mm)	Modulus > 38.0 GPa; Tensile > 280 MPa
Flexural Strength & Modulus	ASTM D790 (3-Point)	Bar (127 × 12.7 × 3.2 mm)	Modulus > 35.0 GPa; Flexural > 310 MPa
Glass Transition Temp (T_g)	ISO 11357-2 (DSC)	10 mg encapsulated aluminum pan	$T_g \geq 118.5^\circ\text{C}$ (Anhydride-rich)
Stress-Relaxation Time (τ^*)	ASTM E328 / Rheometry	25 mm parallel plate (180°C)	$\tau^* < 300$ s at 180°C (1% strain)
Biogenic Carbon Content	ASTM D6866-22 / AMS	Solid pulverized composite sample	> 99.0% Biogenic Carbon (^{14}C)

8.4 Catalyst Compensation Algorithm for Nanofiller Adsorption

Active nanocarbon surfaces adsorb dynamic zinc catalyst molecules, lowering bulk concentration. Catalyst dosing is compensated using the surface area equation:

$$\text{Dose}_{\text{Zn(acac)}_2} = \text{Dose}_{\text{base}} + \sum_{i=1}^N (\alpha_i \cdot m_i \cdot \text{SSA}_i)$$

(4)

Where $\text{Dose}_{\text{base}} = 2.0$ phr, m_i is filler weight fraction, SSA_i is specific surface area (m^2/g), and α_i is the empirical adsorption coefficient ($\alpha_{\text{HGO}} = 1.45 \times 10^{-4}$ phr · g/ m^2 ; $\alpha_{\text{Biochar}} = 0.85 \times 10^{-4}$ phr · g/ m^2).

9. Demonstration Plant Engineering & Process Intensification (TRL 5–6)

9.1 Continuous Plug Flow Epoxidation (PFR) Loop

To scale from batch synthesis to a continuous 1,000-tonne demonstration plant, epoxidation is shifted to a multi-stage tubular Plug Flow Reactor (PFR) equipped with static mixer heat exchangers:

- **Staged Metering:** Hydrogen peroxide is injected at four points along the PFR length, preventing local concentration spikes and maintaining uniform reaction rates.
- **Residence Time:** Total liquid residence time is 28.0 minutes at 60°C, achieving > 96.5% double-bond conversion with oxirane yield > 92%.
- **Thermal Pinch Integration:** Exothermic heat (250 kJ/mol) preheats incoming crude hempseed oil from 15°C to 50°C, reducing facility heating loads by 38.2%.

9.2 Demonstration Prepreg Line & Prototype Validation

Compounded resin is processed through a 1,200 mm precision hot-melt prepreg coater (40.0 ± 1.0 wt% resin content) at line speeds up to 15 m/min (800,000 m²/year capacity).

- **EV Battery Floorpan Prototype (TRL 6 Exit):** Molded with HEMP-AL; passed 500 thermal shock cycles (−40°C to +120°C) under ISO 16750-4 and 100 kN side crush testing (FMVSS 305) with zero micro-cracking.
- **Marine Hull Stiffener Prototype (TRL 6 Exit):** Molded with HEMP-KEV; passed 1,000-hour continuous salt spray fog (ASTM B117) with water absorption < 0.38 wt% and > 96% flexural strength retention.

10. Regulatory Compliance, Health Canada Licensing & Permits

10.1 Health Canada CTLS & Industrial Hemp Regulations

- **Industrial Hemp Licences (IHR):** Maintained under the *Cannabis Act*. Mature stalks (free of leaves/flowering heads) and non-viable seeds are legally exempt under Schedule 2.
- **Standard Processing Licence (CTLS):** Maintained for whole biomass processing containing trace cannabinoids, ensuring compliance with the Canadian legal limit of < 0.30% w/w Δ⁹-THC. Sourcing is restricted to Health Canada’s List of Approved Cultivars (LOAC).

10.2 Canadian Environmental Protection Act (CEPA) & NSNR

Modified bio-based prepolymers (EHO, MHO, FGE) are notified under the *New Substances Notification Regulations (Chemicals and Polymers)* [NSNR] via Schedule 5/6 dossiers, supported by OECD 201, 202, 203 ecotoxicity and OECD 301B ready biodegradability test data.

10.3 New Brunswick Provincial Environmental Permitting (DELG)

- **EIA Registration (Schedule A):** Commercial synthesis registration under the NB *Clean Environment Act*, validating containment berms, VOC abatement, and effluent handling.
- **Clean Air Act Approval to Operate:** Class 1 Industrial Air Approval utilizing catalytic oxidizers and wet scrubbers, limiting total VOC emissions to < 5.0 tonnes/year.
- **Wastewater Pre-Treatment:** On-site automated batch neutralization pit (*pH* = 6.5–8.5) discharging to the Greater Moncton Sewerage Commission system.

11. Workplace Health & Safety, HazOp Analysis & Containment

11.1 WorkSafeNB Compliance & Hazard Communication

Operations comply with the New Brunswick *Occupational Health and Safety Act* and *WHMIS 2015*. All chemical precursors feature bilingual GHS Safety Data Sheets (SDSs). Synthesis operators wear positive-pressure or full-face air-purifying respirators with organic vapor/acid gas cartridges, fluoropolymer chemical suits, and anti-static boots.

11.2 Hazard and Operability (HazOp) Engineering Controls

Table 9: HazOp Risk Assessment & Safeguard Protocols				
Process Node	Deviation	Engineering Safeguard	Automated	Emer-
			gency Action	gency
Node 1: EHO Reactor	High Temp (> 65°C)	Dual glycol cooling; auto H ₂ O ₂ shutoff.	Cold-water/carbonate quench at 68°C.	
Node 1: EHO Reactor	High Pressure (> 2.0 bar)	Dual 316L rupture disks (2.0 bar setpoint).	Discharge to sealed blow-down tank.	
Node 2: FGE Distillation	Flammable Leak (> 10% LEL)	Continuous optical LEL IR sensors in Zone 2.	12 ACH emergency exhaust; power trip.	
Node 3: HTC Hydrochar	Over-Pressure (> 30 bar)	Redundant mechanical pressure relief valves.	Venting to water-jacketed quench tank.	
Node 4: Compounding	High Melt Temp (> 180°C)	Automated screw stop; barrel water cooling.	Emergency forward purge; water mist.	

11.3 Class I Div 1 Explosion Containment Infrastructure

- **Blast-Resistant Architecture:** Glass-lined reactors are housed in reinforced concrete cells with top-venting blast relief panels designed to withstand 0.5 bar overpressure.
- **Secondary Containment:** Foundation pits feature epoxy-coated concrete berms sized for 110% of the largest vessel volume (110,000 L containment capacity).
- **Vapor Scrubbers:** Two-stage packed bed wet scrubbers (NaOH wash followed by activated carbon beds) ensure airborne peracetic acid remains < 0.17 ppm (AEGL-1 limit).

12. Quality Assurance, ASTM/ISO Certification & Metrology

12.1 Integrated Quality Management System (IMS)

The facility operates under an Integrated Management System certified to ISO 9001:2015 (Quality), ISO 14001:2015 (Environmental), and AS9100:Rev D (Aerospace). Every production lot receives a Global Trade Item Number (GTIN) linking finished prepregs back to specific farm seed and straw lots.

12.2 Analytical Quality Control Specifications

Table 10: Analytical Quality Control Release Tolerances			
Material Stream	Quality Control Test	Analytical Instrument	Acceptance Range
Crude Hempseed Oil	Free Fatty Acids / Moisture	Automated Titrator / Karl Fischer	FFA < 1.5%; H ₂ O < 0.10%
Synthesized EHO	Oxirane Content / EEW	HBr Titration / FTIR (822 cm ⁻¹)	7.0–7.5 wt%; EEW 220–230 g/eq
Synthesized MHO	Total Acid Number	Potentiometric Titration	100–110 mg KOH/g
Bio-FGE Diluent	Monomer Purity / Viscosity	GC-FID / Cone-Plate Rheometer	Purity ≥ 98.0%; 3–5 mPa · s
Finished Composites	Radiocarbon Biogenic Content	Accelerator Mass Spectrometry (AMS)	≥ 99.0% Bio-Carbon (ASTM D6866)
Dynamic Network	Stress Relaxation (τ*)	Parallel Plate Rheometer (180°C)	τ* ≤ 300 s at 180°C

13. Commercial System Integration & Pre-Production (TRL 7–8)

13.1 Automated Manufacturing Integration

- **High-Pressure RTM (HP-RTM):** Viscosity < 180 mPa · s at 80°C enables preform mold injection in < 30 seconds and cross-linking in < 180 seconds at 140–160°C for automotive battery trays and structural floorpans.
- **Sheet Molding Compound (SMC):** Compounded short carbon fiber/biochar pre-preg sheets are hot-pressed at 160–180°C (2–5 MPa), cross-linking in 120 seconds for automotive body panels.
- **Out-of-Autoclave (OOA) Prepregs:** Consolidated under vacuum-bag pressure and cured in standard convection ovens (120–140°C) without requiring autoclave CapEx.

13.2 Solid-State Thermal Welding Protocols

- **Mechanism:** Clamping joint interfaces under 0.5–1.0 MPa and heating to 180°C for 60 seconds triggers dynamic transesterification across the contact surface, fusing parts without adhesives.
- **Joint Performance:** Lap-shear strength (ASTM D1002) reaches > 28.0 MPa (> 95% of monolithic base laminate strength).

13.3 Tier-1 Component Qualification Targets

Table 11: Tier-1 OEM Prototype Component Testing Targets

Target Sector	Prototype Component	Qualification Standard	TRL 7/8 Exit Milestone
Automotive / EV	EV Battery Floorpan Tray	ISO 16750 / FMVSS 305	100 kN crush; zero micro-cracks.
Marine / Defense	Hull Bulkhead Stiffeners	ASTM B117 / ASTM D5229	1,000 hrs salt fog; water abs < 0.4%.
Civil Infrastructure	Modular Bridge Deck Beams	ASTM E84 / ASTM G154	Class A flame rating; UL 94 V-0.
Aerospace Interior	Cabin Fairings & Panels	FAR 25.853 / ABD0031	Self-extinguishing in < 15 s.

14. Global Market Analysis, Verticals & Competitive Intelligence

14.1 Addressable Market Sizing & Macro Drivers

- **Total Addressable Market (TAM):** Global Bio-Based Epoxies and Dynamic Vitrimers: \$5.72B CAD (2026), expanding at 28.5% CAGR in the vitrimer sector to reach \$18.3B CAD by 2034.
- **Serviceable Addressable Market (SAM):** North American and European High-Performance Composites in Automotive, Marine, Aerospace, and Civil Infrastructure: \$1.15B CAD.
- **Serviceable Obtainable Market (SOM):** Landry Industries Capture: \$48.5M CAD (Year 3) expanding to \$270.0M CAD (Year 5).

14.2 Competitive Attribute Comparison

Table 12: Head-to-Head Material Attribute Benchmarking

Performance Metric	Petroleum Epoxy	Commercial Bio-Epoxy	Thermoplastic (PA6)	Hempoxies Platform
Biogenic Carbon %	0.0%	20.0–38.0%	0.0%	> 99.0% (ASTM D6866)
Recyclability	Landfill / Incinerate	Landfill / Incinerate	High-Energy Melt	100% Dynamic Vitrimer
Thermal Solid Welding	Impossible	Impossible	Weldable (> 300°C)	Dynamic (180°C, 60 s)
Injection Viscosity	200–500 mPa·s	300–600 mPa·s	> 10,000 mPa·s	< 180 mPa·s at 80°C
Embodied Carbon	+4.80 kg CO ₂ eq	+2.10 kg CO ₂ eq	+8.50 kg CO ₂ eq	−0.62 kg CO ₂ eq (Net-Neg.)

15. Comprehensive Financial Modeling, CapEx & Pro-Forma Statements

15.1 Phase 1 Capital Expenditure Sizing (Moncton Biorefinery)

Table 13: Phase 1 Capital Expenditure (CapEx) Breakdown

CapEx Category	Machinery & Facility Infrastructure Scope	Cost (\$ CAD)	Allocation
Site Retrofit & Safety	12.5 kV upgrades, containment berms, explosion panels	\$4,200,000	17.9%
Zone 2 Synthesis Suite	10,000 L glass reactors, continuous PFR loop, vacuum	\$8,500,000	36.2%
Zone 3 & 4 Compounding	Twin-screw extruder (40 mm), 1,200 mm prepreg coater	\$6,800,000	28.9%
QA/QC Analytical Lab	In-line NIR, FTIR, DSC, DMA, rheometers, Karl Fischer	\$2,100,000	8.9%
Environmental Controls	Catalytic oxidizers, wet scrubbers, neutralization pit	\$1,900,000	8.1%
Total Phase 1 Outlay	Turnkey Moncton Biorefinery Commissioning	\$23,500,000 CAD	100.0%

15.2 Unit Economics & Cost of Goods Sold (COGS)

Basis: 1.00 kg un-filled base Hempoxies vitrimer resin (> 75% capacity utilization):

- **Hempseed Oil Precursors (EHO/MHO, 0.98 kg blend):** \$2.15 CAD
- **Bio-FGE Diluent & Zn(acac)₂ Catalyst System:** \$0.85 CAD
- **5-Tier Nanofiller Package (HGO/CNC/Biochar):** \$0.65 CAD
- **Direct Operations, Energy & Steam Utilities:** \$0.95 CAD
- **Total Direct Matrix COGS:** \$4.60 CAD/kg
- **Wholesale Selling Price:** \$14.00 CAD/kg (Gross Profit Margin: 67.1%)
- **Target Prepreg Selling Price:** \$28.00–\$35.00 CAD/m²

15.3 5-Year Pro-Forma Income Statement (\$ CAD Millions)

Table 14: 5-Year Pro-Forma Income Statement (2027–2031)					
Financial Metrics (\$ CAD M)	Year 1 (TRL 7)	Year 2 (TRL 8)	Year 3 (TRL 9)	Year 4 (Scale)	Year 5 (Export)
Nameplate Volume Output	500 t	1,800 t	4,500 t	10,000 t	18,000 t
Gross Commercial Revenue	\$7.50 M	\$27.00 M	\$67.50 M	\$150.00 M	\$270.00 M
Cost of Goods Sold (COGS)	\$2.47 M	\$8.89 M	\$22.21 M	\$49.35 M	\$88.83 M
Gross Profit	\$5.03 M	\$18.11 M	\$45.29 M	\$100.65 M	\$181.17 M
Gross Margin (%)	67.1%	67.1%	67.1%	67.1%	67.1%
R&D, Laboratory & Pilot Costs	\$2.50 M	\$3.20 M	\$4.50 M	\$6.00 M	\$8.00 M
Sales, Marketing & OEM Qualification	\$1.80 M	\$3.50 M	\$6.20 M	\$12.00 M	\$18.50 M
General, Administrative & Legal	\$1.53 M	\$3.21 M	\$8.09 M	\$14.65 M	\$26.67 M
Operating EBITDA	-\$0.80 M	\$8.20 M	\$26.50 M	\$68.00 M	\$128.00 M
EBITDA Margin (%)	-10.7%	30.4%	39.3%	45.3%	47.4%
Depreciation & Amortization (D&A)	\$2.35 M	\$2.35 M	\$3.10 M	\$4.50 M	\$6.20 M
EBIT	-\$3.15 M	\$5.85 M	\$23.40 M	\$63.50 M	\$121.80 M

15.4 Year 1 Monthly Operating Cash Flows (\$ CAD Thousands)

Table 15: Year 1 Monthly Operational Cash Flow Profile												
Month	M1	M2	M3	M4	M5	M6	M7	M8	M9	M10	M11	M12
Revenue	\$0	\$0	\$150	\$250	\$400	\$550	\$700	\$850	\$1,000	\$1,100	\$1,200	\$1,300
COGS	\$0	\$0	\$49	\$82	\$132	\$181	\$230	\$280	\$329	\$362	\$395	\$428
OpEx	\$450	\$460	\$475	\$480	\$490	\$495	\$500	\$510	\$520	\$525	\$530	\$540
Net Cash	-\$450	-\$460	-\$374	-\$312	-\$222	-\$126	-\$30	+\$60	+\$151	+\$213	+\$275	+\$332
Cum. Cash	-\$450	-\$910	-\$1,284	-\$1,596	-\$1,818	-\$1,944	-\$1,974	-\$1,914	-\$1,763	-\$1,550	-\$1,275	-\$943

15.5 Investment Valuation & DCF Metrics

- **Discounted Cash Flow Parameters:** Discount rate $r = 10.0\%$; Terminal growth rate $g = 3.0\%$.
- **Net Present Value (NPV):** \$182.4M CAD (5-year baseline horizon).
- **Internal Rate of Return (IRR):** 48.6%.
- **Payback Period:** 2.3 Years post-commissioning.
- **Operational Break-Even Volume:** 412 tonnes/year (~ 27.5% of Phase 1 capacity).

16. Enterprise Risk Management & HazMat Mitigation

16.1 Enterprise Risk Mitigation Matrix

Table 16: Enterprise Risk Evaluation and Mitigation				
Risk Category	Risk Event Trigger	Severity	Likelihood	Mitigation Strategy
Agronomic	Drought in Western Canada	High	Low-Med	Dual-region sourcing; 6-month crude oil storage buffer (1,500 t) in Moncton.
Process Safety	Peracetic runaway exotherm	Critical	Low	Dual cooling loops; auto peroxide cut; cold-water quench at 68°C.
Regulatory	CEPA Schedule 5/6 delays	High	Low-Med	Base oils listed on DSL; parallel OECD 201–203 testing completed.
Commercial	Extended OEM PPAP cycles	Medium	Medium	Parallel delivery into fast-adopt civil and marine sectors.
IP Theft	Reverse engineering catalyst	High	Low	Catalyst compensation equations locked in air-gapped DCS systems.

16.2 Drop-In Backup Feedstock Chemistry

If agricultural disruptions occur, SOP-EHO-001 is calibrated to accept industrial flaxseed (linseed) oil or high-oleic canola oil as drop-in triglycerides ($\pm 5\%$ oxirane stoichiometric adjustment), maintaining refinery continuity.

17. Detailed TRL Scale-Up Timeline & Critical Path

Table 17: Master Scale-Up Milestone Schedule			
Milestone	Target Engineering Focus	Quantitative Exit Criterion	Target Date
M-1.1	Laboratory Chemical Optimization	Oxirane conversion > 95%; reproducible 10 L batches.	Month 3 (TRL 2)
M-2.1	100 L Pilot Synthesis Commissioning	Exotherm controlled (55–60°C); DCS active.	Month 6 (TRL 3)
M-3.1	ASTM Coupon Testing Validation	Tensile modulus > 38 GPa; $\tau^* < 300$ s at 180°C.	Month 9 (TRL 4)
M-4.1	Moncton 1,000 t Facility Retrofit	Class I Div 1 explosion compliance verified.	Month 12 (TRL 5)
M-5.1	Continuous PFR Epoxidation Run	72-hour continuous PFR run (10 tonnes base resin).	Month 16 (TRL 5)
M-6.1	Prototype OEM Component Molding	Passing ISO 16750 thermal shock / FMVSS 305.	Month 20 (TRL 6)
M-7.1	Automotive PPAP Level 3 Delivery	Welded joint lap-shear > 28 MPa; $C_{pk} \geq 1.67$.	Month 26 (TRL 7)
M-8.1	Pre-Series OEM Line Qualification	15 m/min prepreg line speed; AS9100 audit sign-off.	Month 30 (TRL 8)
M-9.1	Commercial 4,500 t Series Release	Moncton plant running at full capacity; COGS verified.	Month 36 (TRL 9)
M-10.1	Global Multi-Site Expansion	First European joint-venture biorefinery active.	Month 48 (TRL 10)

18. Intellectual Property Strategy, Patents & Trade Secrets

18.1 Core Patent Portfolio

Table 18: Master Patent Portfolio Registry

Family ID	Title / Technical Scope	Protected Claims & Innovation	Filing Status
PAT-HEMP-001	Bio-Based Dynamic Vitrimer Resins	Dynamic EHO:MHO:FGE ratios with Zn(acac) ₂ transesterification.	PCT Global (2025)
PAT-HEMP-002	5-Tier Hierarchical Reinforcement	Ultrasonic compounding of HGO/C-NC/biochar/carbon fiber.	National Phase (2026)
PAT-HEMP-003	Solid-State Thermal Welding Method	Dynamic joint transesterification at 180°C (> 28 MPa shear).	PCT Filed (2025)
PAT-HEMP-004	Closed-Loop Solvolytic Recycling	Mild glycolytic depolymerization and non-destructive fiber recovery.	PCT Global (2026)

18.2 Trade Secret Registries

- **Catalyst Compensation Equation:** Weighting parameters (α_{HGO} , α_{Biochar} , α_{CNC}) stored in air-gapped DCS systems and loaded via encrypted firmware.
- **Hydrothermal Carbonization (HTC) Profiles:** Dynamic time-temperature-pressure curves (220°C, 2.5 MPa) to optimize biochar π - π stacking sites.
- **Cavitation Frequency Modulation:** 20 kHz swept-frequency sonication routines (1.5 kW) that exfoliate graphene layers without degrading cellulose crystal lengths.

19. Corporate Exit Horizons, M&A Valuations & Licensing

19.1 3-Horizon Capital Liquidity Strategy

- **Horizon 1 (Years 2–3):** Private placement of a 15–20% growth equity stake to a strategic venture partner (e.g., Evonik Venture Capital, BMW i Ventures) at a \$380M–\$420M CAD post-money valuation.
- **Horizon 2 (Years 4–5):** Full corporate acquisition or merger with a multinational chemical/materials conglomerate (e.g., Huntsman, Arkema, Hexcel, Magna) at a target enterprise valuation of **\$1.50B–\$1.80B CAD** (12.0–14.0× EBITDA).
- **Horizon 3 (Years 6+ Alternative):** Global technology licensing model: \$15.0M–\$25.0M CAD upfront fee per 10,000-tonne facility package, plus a 4.5–6.0% running royalty and mandatory catalyst masterbatch off-take from the Moncton hub.

20. ESG Excellence, ISO 14040/44 LCA & Circular Economy

20.1 ISO 14040/44 Cradle-to-Cradle Life Cycle Assessment (LCA)

The functional unit is defined as **1.0 kg of structural cured vitrimer composite** (50 wt% dynamic matrix / 50 wt% reinforcement).

Table 19: Cradle-to-Cradle Life Cycle Inventory (LCI) Carbon Balance

Life Cycle Stage	Petroleum Epoxy	Commercial Bio-Resin	Hempoxies Platform	Differential Impact
Feedstock & Photosynthesis	+2.40 kg CO ₂ eq	−0.55 kg CO ₂ eq	−1.85 kg CO ₂ eq	Biogenic carbon fixation
Chemical Refining & Synthesis	+1.80 kg CO ₂ eq	+1.45 kg CO ₂ eq	+0.85 kg CO ₂ eq	Low-temp continuous PFR
Compounding & Prepreg	+0.60 kg CO ₂ eq	+0.50 kg CO ₂ eq	+0.38 kg CO ₂ eq	Thermal pinch heat reuse
Net Embodied Carbon	+4.80 kg CO ₂ eq	+1.40 kg CO ₂ eq	−0.62 kg CO ₂ eq	Net-Negative Footprint
Cumulative Energy Demand	110 MJ/kg	78 MJ/kg	34 MJ/kg	69.1% Energy Reduction
Process Water Footprint	42 L/kg	31 L/kg	8.5 L/kg	79.8% Water Reduction

20.2 Closed-Loop Circular Economy Chemistry

- **Pathway A: Solid-State Remolding:** Scrap and end-of-life composites are granulated into flakes and hot-pressed at 180–200°C (2–5 MPa) for 120 seconds. Associative transesterification bond exchange restores 100% of initial tensile and flexural strength across five remolding cycles.
- **Pathway B: Glycolytic Chemical Solvolysis:** Composites undergo mild solvolysis in boiling ethanol or ethylene glycol (120–140°C) with 1.0 wt% triazabicyclodecene (TBD) catalyst. The matrix depolymerizes within 4.0 hours; reclaimed bast and carbon fibers retain > 96.5% of virgin tensile strength, while recovered polyol oligomers are repolymerized into new resins.

20.3 Indigenous Economic Inclusion & CSDS Disclosure

- **TRC Call to Action #92:** Formal partnerships with Atlantic Canadian First Nations communities for biomass harvesting, transport logistics, and technical operations.
- **Sustainability Reporting Frameworks:** Sustainability metrics comply with the Canadian Sustainability Standards Board inaugural standards—**CSDS 1** (*General Requirements for Disclosure of Sustainability-related Financial Information*) and **CSDS 2** (*Climate-related Disclosures*), incorporating IFRS S1 and S2 baselines.