

# BOOSTER PO

## GENERAL OPERATING INSTRUCTIONS

### IN RAFFIA PRODUCTION:

- Preparation:** If using a 95% PP/ 5% HDPE raffia blend, change to:
    - 91% (weight) PP
    - 5% (weight) HDPE
    - 4% (weight) Booster POOptimize results by using LLDPE instead of HDPE (optional).
  - The temperature setting should remain unchanged, as long as the temperature zone directly behind the hopper is at least 220°C
  - Start production under standard conditions for about 15-30 minutes, for the mix to be fully introduced into the system.
  - After 15-30 minutes, the following will be observed:
    - The raffia directly behind the slitler will be significantly more flexible.
    - The power consumption of your extruder will visibly decrease (amperage down)
  - At this point, **two options** are available:
    - 5.1 Improve tenacity with unchanged material quantity/smaller fibre diameter.**

Action:

      - leave screw RPM of extruder unchanged
      - increase RPM filament winding equipment
      - increase oven temperature by approx. 10°C
      - continue this process until an “optimal improvement” in tenacity has been accomplished by gradually stepping up the stretch ratio.
    - 5.2 Improve tenacity with increased material quantity/standard fibre diameter.**

Action:

      - increase screw RPM of extruder
      - increase RPM of filament winding equipment
      - increase oven temperature by approx. 10°C
      - continue this process until an “optimal improvement” in tenacity has been accomplished by gradually stepping up the stretch ratio
- Notes:
- steps 5.1 and 5.2 can be performed in sequence, with the same feedstock
  - depending on the starting point, stretch ratios can be increased by 20-40% typical bottleneck: max speed fibre winding equipment
  - results using LLDPE in the mix tend to yield better performance than with HDPE.