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Thermoplastic powerRibs
Processing guide

Play naturally smart

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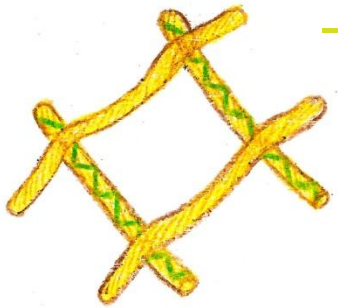
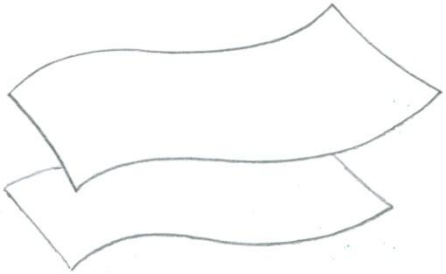
You will need...

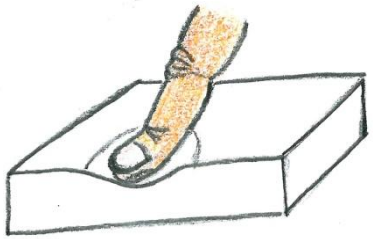
INGREDIENTS



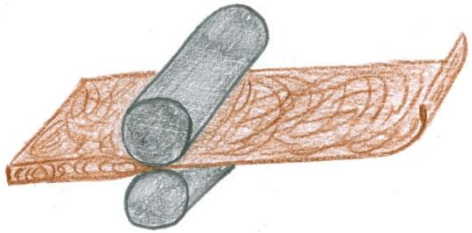
- powerRibs



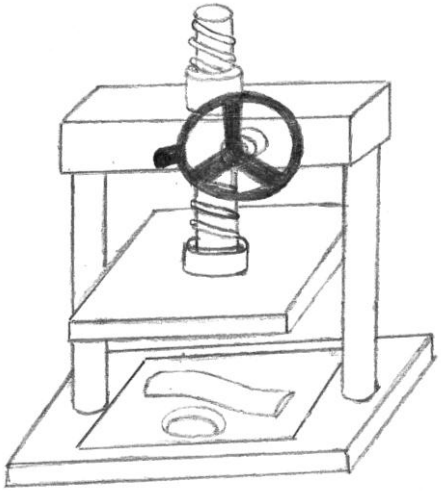
- PP films, ideally 2x100 g/m^2



- A soft stamp (max. 30 Shore hardness, approx. 2-3 mm)



- A **pre-consolidated** substrate



- A press

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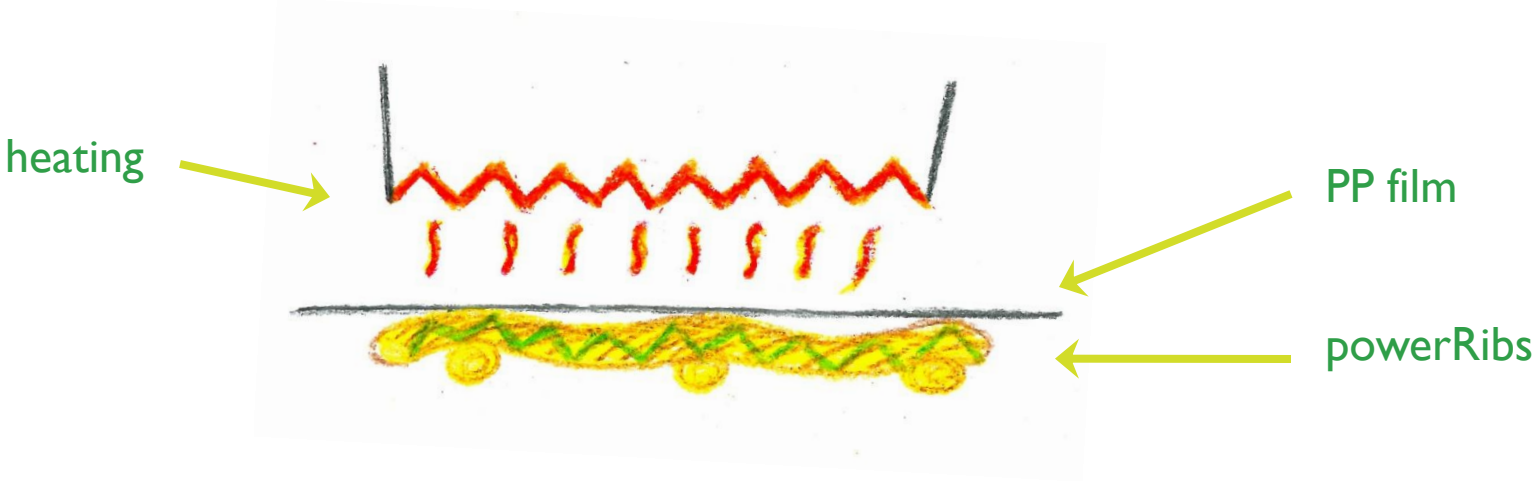
Step 1:
Impregnate the powerRibs

IMPREGNATION



- Place a PP film on each side of the powerRibs
- Heat up to approx 180-190°C in an infrared or hot air oven. The PP film will melt and be absorbed into the ribs
- You will get the best results by impregnating each side of the ribs separately
- However, impregnating both films on one side at the same time will also work

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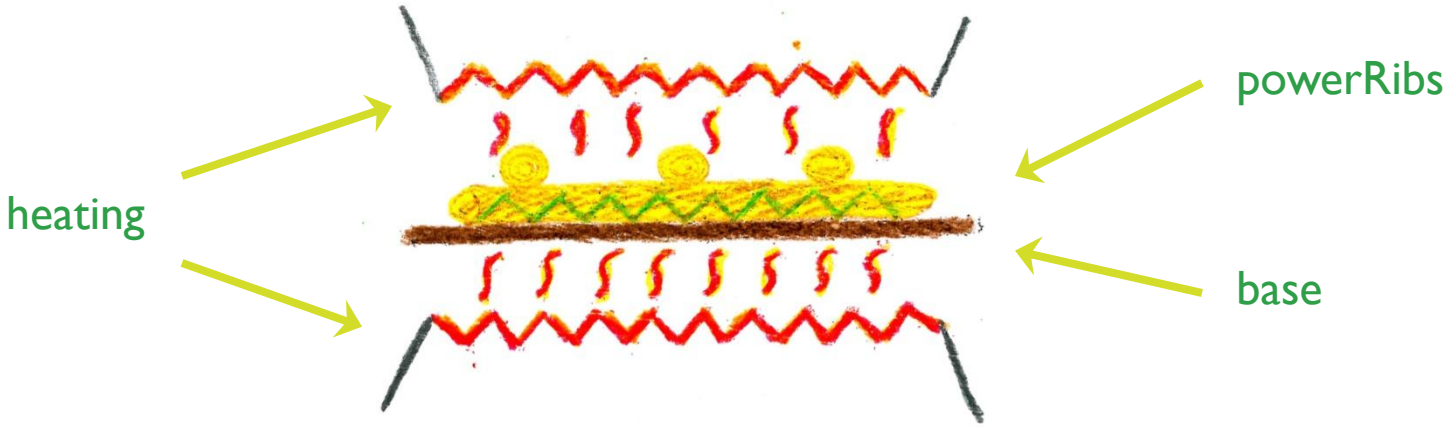
Step 2:
Warm up your layup

LAYUP HEATING



- Place the impregnated powerRibs on the preconsolidated base of your choice in an oven, and heat up to approx. 180-190°C for 5-10 min in a hot air oven. In infrared oven, the time has to be carefully controlled in order to melt the PP without burning it and the flax.

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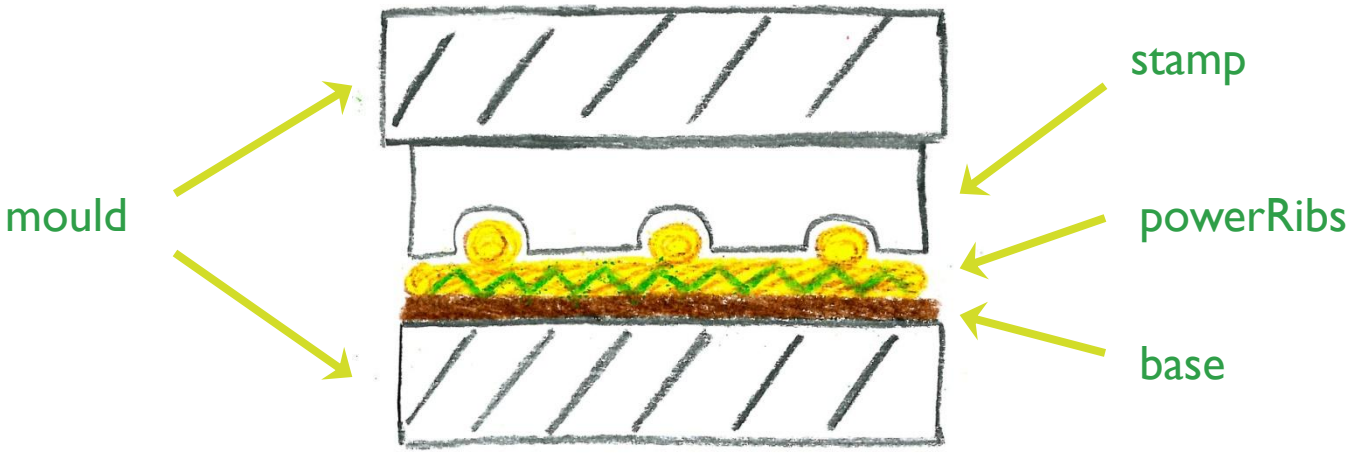
Step 3:
Place the layup in the press

PRESS PREPARATION



- Place your layup in the press
- Place the soft stamp on top of your layup. This stamp of incompressible material will evenly spread the pressure without pushing the powerRibs into the base layer

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Step 4:

Press your part !

The applied pressure should be approximately 10 bars on the part

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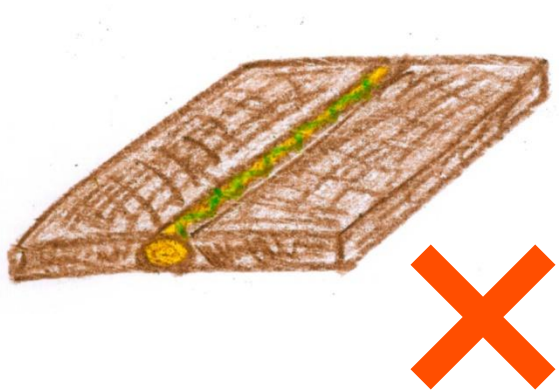
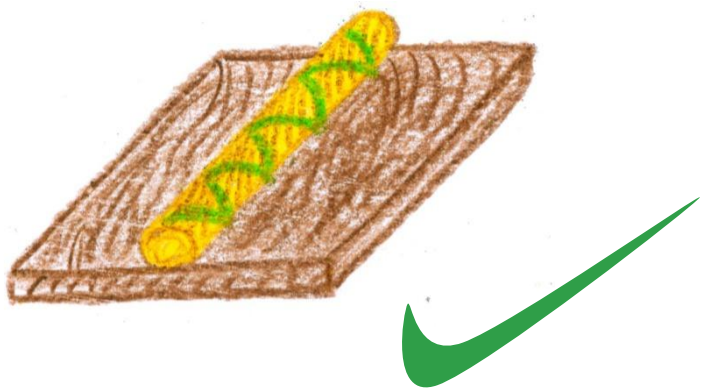
Final recommendations:

FINAL RECOMMENDATIONS





- Your base layer needs to be pre-consolidated, otherwise you will press the powerRibs into your base and you will loose the ribs' 3D effect
- Set the gap between the stiff surfaces of your press to approx. the thickness of your soft stamp
- Be careful with temperatures, flax fibres will start looking toasty at above 190°C (degradation of the cellulose)