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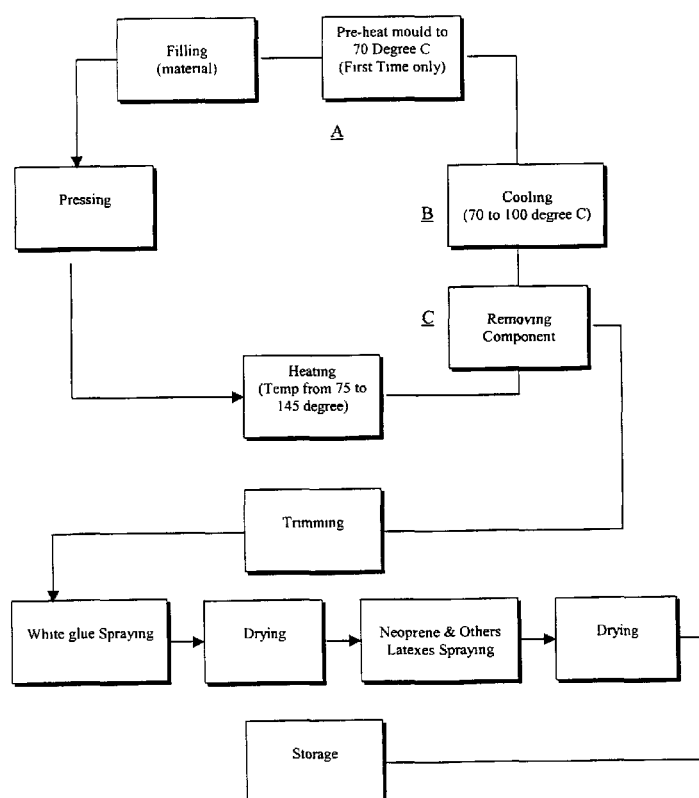
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(54) Title: PROCESS FOR MANUFACTURE OF MOULDABLE PRODUCT AND MOULD FOR USE WITH THIS PROCESS



(57) Abstract: The present invention relates to a moulding mixture, a moulding process and a mould for manufacturing moulded products. The process comprises the following steps: (a) preparing a moulding mixture by: (i) taking 40 to 60 wt% plant fibre pieces and optionally combining added starch with the plant fibre pieces; and (ii) adding thereto 10 to 55 wt% water and 3 to 10 wt% one or more water-soluble binding agents or adhesives; (b) pouring the mixture into a mould the mould being at a temperature of at least 60 °C; (c) subjecting the mixture in the mould to a temperature in the range of 15 to 60 °C and a pressure in the range from 1000 to 7000 PSI for a period of time such that a portion of the water in the mixture is converted to steam which causes the mixture to fill the mould while remaining in a mouldable state; (d) reducing the pressure so that steam continues to form within the mould without causing an explosion whilst maintaining the mixture in a mouldable state; (e) increasing the temperature and pressure to a temperature in the range from 100 to 200 °C and a pressure in the range of 500 to 1500 PSI; (f) removing the steam or allowing the steam to escape until the moulded product is substantially dry; (g) removing the substantially dried and moulded product from the mould; The amount of starch added in between 0 and 10 wt% preferably 0 to 2 wt% or 2 to 10wt%.



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