

properties. The lowest strength decrease was obtained with beetroot pieces; using beetroot pulp achieved a similar strength to the reference pulps. The worst results (i.e. the highest decrease of strength properties) were obtained by the application of beer fines.

The strength properties were also considered in relationship to sheet formation. Unfortunately, some of the applied alternative pulps were not well bonded to the reference pulp, i.e. their particles were only partly retained in the fibre mat - as a result they were visible on the paper surface. The best aesthetic impression of handsheets (without specks, discoloration, stains, etc.) was received with Betacal, sawdust C100, beer fines dried and beetroot pieces.

The general reduction of paper properties was an expected result, because none of the raw materials has been pre-treated with a chemical or mechanical pulping method to make the materials more available for bonding. The technical potential of the unconventional alternatives is expected to be significantly improved when they undergo pre-treatment.

### Conclusions

It can be shown that there is a certain papermaking potential in all the unconventional raw materials used in these experiments.

It was found these alternative materials changed dewatering ability in different ways. Some showed promise for the improvement of pulp dewatering and thus the improvement of quality in paper or board production. According to all tests, pulp dewatering could be improved by the application of sawdust C320, Betacal and dried beer fines, but it may be deteriorated by beetroot pieces. Results for the other sub-

stances such as sawdust C100, onion skins, deinking sludge, citrus pulp, apple pulp and beer fines suggest they may improve the pulp dewatering ability; however, this was not clearly shown by all test methods.

Results show that the lowest negative impact on paper strength properties was obtained with beetroot pieces. This alternative additive was also not visible in the paper structure. Acceptable paper sheets (without specks, discolorations, stains, etc.) were also obtained with Betacal, sawdust C100 and dried beer fines.

From these experiments we conclude that in order to make these alternative materials more suitable for papermaking, correct pre-treatment to alter their size, shape and surface character is required. Therefore, further investigations need to be performed to make different organic bio-streams suitable for papermaking.

### Acknowledgements

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