



Novel packaging films and textiles with tailored end of life and performance based on bio-based copolymers and coatings.



D.7.7 Training materials and report



Horizon 2020
European Union Funding
for Research & Innovation



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Grant Agreement No:	837761	Project Acronym:	BIOnTop
Project Title:	Novel packaging films and textiles with tailored end of life and performance based on bio-based copolymers and coatings		
Funding scheme:	BBI-JU-Horizon 2020 – Research & Innovation Action		
Project Coordinator:	AIMPLAS		
Lead Beneficiary	European Bioplastics e.V. (EUBP)		
Start date of the project:	01.06.2019	Duration of the project:	48 months
Deliverable:	D.7.7 Training materials and report		
Contractual delivery date:	31.05.2023 (deadline as stated in the DoA)		
Actual delivery date:	31.03.2023		
Type of Deliverable	R (Document, Report)		
Dissemination level:	PU (Public)		
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Version:	1.0		

History of changes

Version	Author	Date	Comments
0.1	EUBP	7 March 2023	First version made available internally
1.0	EUBP	30 March 2023	Final version with integrated comments



Acronyms

WP	Work Package
D	Deliverable
EU	European Union
EC	European Commission
BBI-JU	Bio-Based Industries Joint Undertaking
H2020	Horizon 2020
EUBP	European Bioplastics e.V. (DE)
INSTM	Consorzio Interuniversitario Nazionale per la Scienza e Tecnologia dei Materiali (IT)
ASU	Hochschule Albstadt-Sigmaringen (DE)



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Executive summary

A set of training modules and lectures were prepared by the BIONTop project partners and delivered throughout the lifespan of the project. Some of these training modules were more aligned to the concept of disseminating results (mid-term, final) and were aimed at facilitating acceptance, uptake and exploitation of results. Feedback from these modules and activities have been used to feed the project and post-project improvements. Other training modules were integrated in curricula of the academic partners, as lectures for both undergraduates and master students and were more targeted at educating, facilitating understanding, and sharing knowledge (capacity building).

The audiences covered by the BIONTop external training sessions were academia, the scientific community, end-user industrial operators, but also policy makers and NGOs.

The materials of the trainings have been uploaded to the BIONTop community in Zenodo, to facilitate the uptake by larger number of users after the end of the project and in the years to come.

Please note that this specific report is focusing on the training delivered by consortium partners to users outside the consortium. AIMPLAS will report instead on the internal training measures in the final progress report of the project.



Introduction

This deliverable is a report of the knowledge transfer activities targeting audiences outside the project consortium. This specific report is focusing on the training delivered to actors outside the consortium, while AIMPLAS will report on internal training measures in the final progress report of the project.

The report provides an overview of the external trainings, information about the audiences reached out to, and information on the training materials for each training module.



1. Trainings held.

The project held several trainings throughout its lifetime. An overview is provided in the table below.

The single files of the trainings are available in the Annex to this deliverable, with links pointing at long-term repositories where the training materials have been archived for facilitating uptake and re-use.

ID	Title	Audience	Type of training	Comments	Partner in lead
EXT1	Bio-based packaging: Overview of bio-based packaging and innovative techniques for bio-based barrier improvement	Academia	Lecture	Recurring activity integrated in the curriculum at ASU	ASU
EXT2	Sustainable Food Packaging Technology	Academia	Lecture	Recurring activity integrated in the curriculum at ASU	ASU
EXT3	Biobased Materials Research: Advances from ECOFUNCO And BIONtop European-funded Projects	Academia, industry, NGOs, policy making	Workshop	One time event	Centexbel, ASU and EUBP
EXT4 a	Bioplastics	Academia	Lecture	Recurring activity integrated in the curriculum at	INSTM
EXT5	Processing and recycling of bioplastic blends and composites	Academia	Lecture	Recurring activity integrated in the curriculum at INSTM	INSTM
EXT6	BIONtop Meet the experts	Industry, NGOs, policy makers	Interactive training format	One time event	ASU, EUBP, ENCO
EXT8	Bioplastics: the BIONtop approach	Academia	Lecture	Recurring activity integrated in	INSTM



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				the curriculum at	
EXT12	Principle of chemical grafting and effect of fatty acid grafting onto whey protein-based films	Academia	Lecture	Recurring activity integrated in the curriculum at ASU	ASU
EXT13	Workshop on Biobased, compostable and recyclable packaging films and textiles	Academia, industry, policy making	Workshop	One time event	INSTM
EXT14	Safety and risk management for novel products and processes	Academia, industry	Training	One time event split in two sessions	ARCHA and EUBP

Table 1: BIONtop Trainings delivered, overview.

Goals

- Ensuring the education and the training of the next generation of scientists and technologists needed in Europe to foster the future of circular bioeconomy and maximise the creativity and innovation potential.
- Ensuring the dissemination of results (mid-term, final), facilitating acceptance, uptake and exploitation of results.
- Getting feedback from the training modules to feed the project and post-project improvements and adjustments.

Formats

- Lectures: Lectures integrated in academic curricula.
- Trainings: More formal training modules, organised and split over more than one day, specifically set up by one or two partners only.
- Workshop: More interactive formats, run over one day, with contributions from several partners.

Audiences

- Academia: This audience is including the scientific community, from undergraduates to senior scientists.
- Industry stakeholders: operating in the field of bioplastics, biobased products, but also in the production and application of novel biobased materials and products. It also included technologists and scientists working in research in the private sector.



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- NGOs and policy makers: focused on topics such as bioplastics, biobased products, bioeconomy, circular economy.

2. Training materials

For each training delivered, we have mapped out the materials and recordings available in the files in the annex.

- All training materials have been made available in Zenodo <https://zenodo.org/communities/biontop>, in open access, in the forms of documents and PowerPoints. Zenodo is a long-term repository made available by CERN and the European Commission.
- For the video recordings, the materials are uploaded to YouTube, in the playlist of the BIONTop projects. We have set up different playlists for the different events. See the files of each training for more information on the single recordings.



Conclusions

By the time the project finalizes its final report, EUBP will monitor again the use of the material and report in the final progress report on the performance (e.g., views, downloads).

Planning a long-term access to the materials, EUBP will set up a specific section related to capacity building on its website (www.european-bioplastics.org) and ensure that the training materials can be taken up by large audiences in the future years, after the project closure.

**Annex: Detailed files on the BIONtop trainings**

EXT1 TRAINING Report

Training title	Bio-based packaging: Overview of bio-based packaging and innovative techniques for bio-based barrier improvement
Training type	Lecture
Date and location	Every winter semester, Albstadt-Sigmaringen University.
Organised by	Albstadt-Sigmaringen University.
Goals of the training session	This workshop's goals were: <ul style="list-style-type: none">– Lecture to introduce innovative technologies.– Broaden the mindset of master students.– Lecture on relevant technologies applicable in industry in the future.– Lecture on alternative (hopefully more sustainable) technologies.
Training participants	Academia: Master students.
Outcomes of the training	The outcomes of the workshops are: <ul style="list-style-type: none">– Increased knowledge of biobased packaging.– Increased knowledge of results of BIONtop.
Summary of the training materials	In this lecture, the topic of packaging was introduced by showing key advantages and disadvantages of material such as natural materials, ceramics, glass, paper-paperboard, cardboard, metal, and plastics. The functions of packaging and the most used plastics were presented. Afterwards the wording of bioplastics and the difference between biobased and biodegradable was explained. The categories of bioplastics describe either biobased or biodegradable or both characteristics. The main properties of the most studied and market available poly lactic acid (PLA) as bioplastic as well as poly hydroxyl alcanoate (PHA) were presented regarding raw material, synthesis, chemical structure, barrier properties, physical characteristics and current end of life scenarios. Afterwards common multilayer (petrochemical) packaging is shown, and the function of each layer was explained (gas barrier layer, layer for mechanical properties, adhesive layer, printable layer, etc.). The key message here is



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that the packaging has a specific function to protect the packaged goods and for these individual parameters such as mechanical and barrier properties are necessary. An alternative to highly functional multilayer packaging for sensitive foods is not market available yet.

In the second part of this lecture the BIONtop approach is presented by explaining the project overview, objectives, and activities. One approach that is focused by the researchers of the Sustainable Packaging Institute of the Albstadt-Sigmaringen University is the use of a protein layer which is biobased and biodegradable as an alternative to other oxygen barrier layer such as ethylene vinyl alcohol (EVOH). Based on the hydrophilic nature of the protein layer, an innovative nanoscale hydrophobization technique, the fatty acid grafting was introduced. The principle of fatty acid grafting and how this decreases the water/water vapor sensitivity of the protein layer was explained. The fatty acids are attached covalently to the surface of the protein layer. This technique is influenced by different grafting parameters that are type and concentration of fatty acid/fatty acid chloride used, type of substrate, temperature, technique, and solvent if needed. The transfer method and an up scalable technique the gravure printing technique have been shown. Current results from the scientific literature regarding fatty acid grafting of EVOH films are presented. The optimization of the grafting parameters is key to inducing great effect towards the grafted surface. Grafted surfaces obtain a water repellency, dissolve slower, and possibly obtain lower water vapor transmission rates. Opportunities and limitations of fatty acid grafting technology are summarized and discussed. In the end, application scenarios of the fatty acid grafting technology were summarized, and a discussion was set up to discuss the topic of bioplastics from different perspectives (e.g., from an environmental activist, politician, entrepreneur of a packaging company, and a scientist).



EXT2 TRAINING Report

Training title	Sustainable Food Packaging Technology
Training type	Lecture
Date and location	Series of lectures during the winter term 2022 / 2023, hybrid (Albstadt-Sigmaringen University, in Sigmaringen & online).
Organised by	Albstadt-Sigmaringen University.
Goals of the training session	The goal was to: <ul style="list-style-type: none">– Provide a basic overview of food packaging technology with emphasis on packaging sustainability.– Lecture on real challenges on an EU scale, enabling them to interact with other qualified actors in an international environment.– Enable participants to design effective and efficient packaging concepts for the food industry.
Training participants	Academia: National (German) and international (Indonesia, Mexico and others), bachelor students.
Agenda of the training	<ul style="list-style-type: none">– Background of BIONtop project / State of the art: Advantages of petrochemical-based plastics such as their barrier properties, flexibility, easy handling, low price but also disadvantages such as limited recyclability as well as bio-based alternatives and their barriers and opportunities.– Objective of BIONtop: Development of cost-efficient bio-based plastic concepts that also offer sufficient barrier properties for sensitive foodstuffs and are at the same time recyclable.– BIONtop project as an example for the sustainability strategy consistency.
Outcomes of the training	Train students in the topics presented during the workshop with an examination at the end of the semester.
Summary of the training materials	Sustainability is a multifaceted concept that can be defined in many ways. Several dimensions of sustainability (typically environmental, economic and social) can be defined where there may be trade-offs between social, economic and environmental concerns. For example, product protection through multi-layer packaging vs. recyclability, use of renewable raw



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materials in paper carrier bags vs. sufficient functionality and more frequent reusability of plastic carrier bags.

To achieve sustainability, two economic forms are assumed: circular economy and bioeconomy. The combination of these two strategies is the circular bioeconomy, the most promising approach to a more sustainable way of life and economy due to the shortcomings of the two concepts. There are three main strategies for achieving sustainability objectives, and it is assumed that a combination of these is required to achieve the objectives: efficiency, consistency and sufficiency.

Biopolymers are an example of the consistency strategy and bioeconomy and a promising alternative to petrochemical-based plastics for more sustainable food packaging. Biopolymers can be biobased and or biodegradable. The potential environmental impacts of biopolymers can be more beneficial than those of their petrochemical counterparts, for example in the case of climate change (global warming potential, GWP), with a shift in potential environmental impacts often occurring. However, there is often a so-called shift of burden (shift in the potential environmental impacts), for example, biopolymers often perform worse in the environmental impact category eutrophication potential (EP) and land use and land use change (LULUC). Polylactic acid (PLA) is a biobased polymer that is becoming increasingly popular in the packaging industry. It is derived from renewable resources such as corn-starch, sugar cane, or cassava roots. PLA can be used in a variety of packaging applications, including food packaging and other consumer goods. It is also compostable, which allows for end-of-life options such as industrial composting. However, there are still challenges to overcome, some of which are being addressed in the BIONtop project.

The BIONtop project aims to develop cost-effective and sustainable packaging concepts for sensitive foods that offer sufficient barrier properties with circular End-of-Life (EoL) Options like recyclability and biodegradability. Current research on biobased plastics lacks sufficient barrier properties to protect sensitive foods. The goal is to address the environmental impacts of plastic waste by developing more sustainable packaging solutions. The project focus on the further development of polymers such as PLA, as well as more sustainable EoL Options.



EXT3 TRAINING Report

Training title	Biobased Materials Research: Advances from ECOFUNCO And BIONTop European-funded Projects
Training type	Workshop
Date and location	16 June 2021.
Organised by	Ecofunco and BIONTop project.
Other partners of BIONTop involved in the training	ASU, Centexbel, and EUBP.
Goals of the training session	This workshop goal was to: <ul style="list-style-type: none">– Disseminate BionTOP - Waterbased PHA dispersions for coatings and prints.– Disseminate on the state of the art in chemical fatty acid and the results of chemical fatty acid grafting.
Training participants	Academia and industry
Agenda of the training	Three interventions by BIONTop: <ul style="list-style-type: none">– Erik Sauter (ASU), BionTOP - Principle of chemical grafting and effect of fatty acid grafting onto whey protein-based films.– Willem Uyttendaele (Centexbel), BionTop - Waterbased PHA dispersions for coatings and prints.– Christian Schulz (EUBP), BIONTop - Introduction and overview on BionTop activities and expected results.
Outcomes of the training	The outcomes of the workshops are: <ul style="list-style-type: none">– Increased knowledge of results related to the chemical fatty acid grafting.– Increased knowledge of results of waterbased PHA dispersions for coatings and prints.– Increased knowledge of BIONTop results.
Training materials	<ul style="list-style-type: none">– Intervention Nr. 1 ASU: Principle of chemical grafting and effect of fatty acid grafting onto whey protein-based films



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	<p>Video recording</p> <ul style="list-style-type: none">– Intervention Nr. 2 Centexbel: Waterbased PHA dispersions for coatings and prints <p>Presentation: https://zenodo.org/record/7684321</p> <p>Video recording: https://www.youtube.com/watch?v=gecvE4Kriw4</p> <ul style="list-style-type: none">– Intervention Nr. 3 European Bioplastics: BIONtop mid-term results <p>https://www.youtube.com/watch?v=1m-lu6epX_o</p>
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EXT4 TRAINING Report

Training title	Introduction to Bioplastics
Training type	Lecture
Date and location	In 2021, at the Consorzio Interuniversitario Nazionale per la Scienza e Tecnologia dei Materiali (INSTM).
Organised by	INSTM.
Goals of the training session	The training was held in the framework of the course on Reactive processing and recycling of polymers of the University of Pisa. This training's goal was to: <ul style="list-style-type: none">– Lecture on bioplastics and compostability of bioplastics.– Lecture on the processing and recycling of polymers.
List of contents	Bioplastics, biodegradable polymers, PLA, PHA, PHB, blends and their properties, composting, biodegradability, technology, standards, BIONtop.
Outcomes of the training	Informing, facilitating understanding, and raising awareness and sharing knowledge (capacity building).
Training materials	Available on https://zenodo.org/communities/biontop
Recordings	https://www.youtube.com/playlist?list=PL55WHEvTORx5d6PYc3SkJkQNA8i640CQ



EXT5 TRAINING Report

Training title	Processing and recycling of bioplastic blends and composites
Training type	Lecture
Date and location	In 2021, at the Consorzio Interuniversitario Nazionale per la Scienza e Tecnologia dei Materiali (INSTM).
Organised by	INSTM.
Goals of the training session	The training was held in the framework of the course on Reactive processing and recycling of polymers of the University of Pisa. This training's goal was to: <ul style="list-style-type: none">– Lecture on bioplastics and compostability of bioplastics.– Lecture on the processing and recycling of polymers.
Training participants	Academia.
List of contents	Four innovative projects / initiatives showcasing the recycling of polymers: PolyBioSkin, Biorepack, BIONTPp, ECOFUNCO. For each project: objective, methodology, technology, main scientific results, mid-term outcomes.
Outcomes of the training	Informing, facilitating understanding, and raising awareness and sharing knowledge (capacity building).
Training materials	Available on https://zenodo.org/communities/biontop
Recordings	https://www.youtube.com/playlist?list=PL55WHEvTORx5d6PYc3SkJkQNA8i640CQ



EXT6 TRAINING Report

Training title	BIONtop Breakfast with the expert
Training type	Informal training
Date and location	6 December 2022, Berlin (DE), alongside the European Bioplastics Association annual event.
Organised by	European Bioplastics together with Albstadt-Sigmaringen University and ENCO Consulting.
Goals of the training session	Transfer expertise to the participants. Allow uptake.
Training participants	Industry, NGOs, policy makers
List of contents	Overview of the main results of the project The development of biopolymers coatings in BIONtop.
Outcomes of the training	Raise awareness on potential uptake and timeline for the uptake.
Training materials	https://zenodo.org/record/7347740#.ZBGMyezML0o



EXT8 TRAINING Report

Training title	Bioplastics: Approach of BIONtop for biobased, biodegradable and recyclable materials for packaging
Training type	Lecture
Date and location	29 November 2022, at the Consorzio Interuniversitario Nazionale per la Scienza e Tecnologia dei Materiali (INSTM).
Organised by	INSTM.
Goals of the training session	This training's goals were to: <ul style="list-style-type: none">– Lecture on bioplastics.– Lecture on the importance of PLA, its synthesis and properties– Lecture on the role of BIONtop in improving PLA based materials properties.
Training participants	Academia: students of second year of Chemical Engineering degree course. The course is Materials Science and Engineering (9 CFU), including lectures and exercise training about metal, ceramics, polymers, composites and structure/properties of materials
Agenda of the training	This training was carried out at the end of the explanation of polymers in the course to make students able of understanding the topic
Outcomes of the training	The outcomes of the training: <ul style="list-style-type: none">– Increased knowledge of bioplastics– Increased knowledge of the importance of PLA and BIONtop scientific results.
Training materials	Available on https://zenodo.org/communities/biontop
Recordings	https://www.youtube.com/playlist?list=PL55WHEvTORx5d6PYc3SkJkQNA8i640CQ



EXT12 TRAINING Report

Training title	Technology of fatty acid grafting: Principle of chemical grafting and effect of fatty acid grafting onto whey protein-based films
Training type	Lecture
Date and location	06 October 2021.
Organised by	Albstadt-Sigmaringen University.
Goals of the training session	This workshop goals were to: <ul style="list-style-type: none">– Train on the state of the art in chemical fatty acid.– Disseminate the results of chemical fatty acid grafting.
Training participants	Early career researchers
Contents	<ul style="list-style-type: none">– Principle of chemical grafting.– Methods of chemical grafting.– Research results of chemical grafting.
Outcomes of the training	The outcomes of the workshops are: <ul style="list-style-type: none">– Increased knowledge of the principles of chemical fatty acid grafting.– Increased knowledge of current results of chemical fatty acid profiling of WPI films, together with the effects of hydrophobization of hydrophilic substrates.
Summary of the training materials	In this lecture, the Sustainable Packaging Institute of the Albstadt-Sigmaringen University was introduced showing the location, subject areas, and main research and development focus. A deeper look into the research performed within the BIONtop project was done by starting to present the principle of the chemical fatty acid grafting technique. This technique provides an innovative and nanoscale biobased approach to hydrophobized surfaces. This can be for instance useful for hydrophilic material. The chemical reaction(s), conditions and grafting parameters are illustrated, and their influence is shown exemplarily. Market available and affordable fatty acid chlorides needed for the hydrophobization of surfaces by the grafting technique are quite limited. In fact, myristic acid chloride, palmitoyl chloride, stearoyl chloride, and palmitoyl anhydride are fatty acids that are suitable reagents. On lab scale, commonly the transfer method is used for the grafting process, however, there are several steps needed because the



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grafting reagents are transferred by a transmitter paper towards the substrate surface. In comparison, the gravure printing technique was shown as potential up scalable method for the grafting process. The gravure printing method was tested for its applicability to transfer the grafting reagents which was a main point being addressed within BIONtop. The gravure printing method has some advantages over the transfer method. For instance, no solvent is needed and there are different printing plates available to adjust the amount of fatty acid reagents being transferred by the gravure printing device. Images of the practical processing in the lab are presenting illustrating how the fatty acid reagents are transferred via the transfer versus the gravure printing method.

Results obtained within BIONtop have been presented: The effect of fatty acid grafting using different reagents on the water vapor transmission rate of whey protein-based films were shown. In addition, the effect of using different temperatures between 60 – 160 °C revealed a strong effect on the water vapor transmission rate of grafted protein film. A trend of increasing temperature affecting decreasing water vapor transmission rate was implied. The water contact angle of the grafted whey protein films was measured, however, no significant differences amongst the different grafting temperatures were detected. Two videos were shown. In the first video a water droplet was placed using a syringe on top of a whey protein film and a direct immersion of this was observed. In the second video, a water droplet was placed on top of a grafted whey protein film and the repellent effect was directly visible. In the end, concluding remarks about fatty acid grafting on whey protein films summarized the lecture up and provided an overview of the potential applicability of the fatty acid grafting technology to hydrophobized materials such as biobased packaging material.



EXT13 TRAINING Report

Training title	Biobased, compostable and recyclable packaging films and textiles
Training type	Workshop
Date and location	14 December 2022.
Organised by	INSTM at the Consorzio Interuniversitario Nazionale per la Scienza e Tecnologia dei Materiali (INSTM).
Other partners of BIONtop involved in the training	INSTM, AIMPLAS, Planet Bioplastics, Centexbel, ASU, European Bioplastics.
Goals of the training session	<ul style="list-style-type: none"> – Share the results of the project. – Present the latest achievement in the project R&D. – Present relevant technologies for industrial applications.
Training participants	Academia and industry
Outcomes of the training	Disseminate and foster uptake.
Training materials and trainers	<ul style="list-style-type: none"> – Introduction to biobased, compostable and recyclable packaging films and textiles https://zenodo.org/record/7468837#.Y6MtwezMJz8 – Results of the EU-funded project BIONtop https://zenodo.org/record/7468750#.Y6Mt-ezMJz8 – Biobased, biodegradable, and recyclable materials for films and trays https://zenodo.org/record/7468805#.Y6Mt0OzMJz8 – Biobased materials for textile packaging and its coating https://zenodo.org/record/7468799#.Y6Mt4OzMJz8 – Surface modification of films – Bioplastics from research to policy: Where is the European policy making heading for? https://zenodo.org/record/7468762#.Y6Mt7ezMJz8 <p>Andrea Lazzeri (Planet Bioplastics, University Pisa), Rafael Alonso (AIMPLAS), Maria Beatrice Coltelli (INSTM and University Pisa), Willem</p>



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	Uyttendaele and Ruben Geerinck (CENTEXBEL), Corina Reichert (Albstadt-Sigmaringen University), Chiara Bearzotti (European Bioplastics).
Recordings	Videorecording is available on the YouTube Playlist of BIONTOP https://www.youtube.com/playlist?list=PL55WHEvTORx5d6PYc3SkJkQNAm8i640CQ





EXT14 TRAINING Report

Training title	Safety and risk management for novel products and processes
Training type	Training
Date and location	Online, 7-14 March 2023.
Organised by	European Bioplastics and ARCHA s.r.l.
Goals of the training session	Provide tools for ensuring compliance to the EU directives and regulations on safety and health at work.
Training participants	Academia and industry
Agenda of the training	<ul style="list-style-type: none">– How to ensure compliance to the EU directives on safety and health at work?– What are the specific legal requirements you need to be aware of?– What is the broader legal and regulatory framework?– How can you focus on the risk management and risk assessment?– How can you ensure the compliance to the EU directives related to health and safety at work (Ref: https://osha.europa.eu/en/safety-and-health-legislation/european-directives)?– How can you ensure compliance to health and safety requirements for novel products, for food contact packaging products?
Outcomes of the training	Train participants on how to ensure compliance with the EU directives and regulations.
Training materials	First set of slides for the training on 7 March 2023: https://zenodo.org/record/7705154#.ZBCIJ-zML0o Second set of slides for the training on 14 March 2023: https://zenodo.org/record/7733631#.ZBCGNOzML0o
Recordings	A playlist with the recording of the training is available: https://www.youtube.com/playlist?list=PL55WHEvTORx5d6PYc3SkJkQNA8i640CQ



BIONtop Training: Safety and risk management for novel products and processes

Legal requirements, legal framework, focus on risk assessment and risk management
online, 7th and 14th March 2023

