

Information Notice, applicable to the European open tender for a Clam-shell Twin-Screw Compounding line, Ref. WS3069455653, dated 12 May 2026

Date Information Notice: 11 June 2026

No.	Section nr. / subject	Questions Tenderer	Answers TNO
1	Online process monitoring clarification	Could you please clarify what is meant by “online process monitoring”?	Online monitoring for us means that it is possible to have the Operating Software connected to our internal network to follow the process online via Wifi-connection and/or ethernet cable.
2	Online process monitoring clarification	Which process parameters are expected to be monitored?	The process parameters to be monitored depends on the offered functionalities of your OS of the compounder. But to name a few standard parameters are melt temperature, melt pressure, barrel temperature settings, RPM, Torque/Motor power, throughput of the feeders and alarms.
3	Online process monitoring clarification	Are there any specific requirements regarding the implementation or a preferred software solution?	Specific requirements regarding the implementation are mentioned in requirement 8.10.10 and 8.10.11. A preferred software solution is not required other than what is mentioned in the Tender documents.
4	Multi-strand operation and pelletizer throughput clarification	Could you please clarify what is meant by “multi-strand operation” (e.g. typical number of strands and their diameters)?	For us it means that the pelletizer can handle chopping multiple strands simultaneously. A typical number of multi-strand for us means somewhere around 2-4 strands. Diameter of the strands are not critical as this is dependent on the throughput, amount of strands and properties of the recipe being processed.
5	Multi-strand operation and pelletizer throughput clarification	Does the required throughput range of 1–20 kg/h also apply to the pelletizer?	Yes, we would like to get a pelletizer that can keep up with the throughput range of the extruder to enable a stable process. That on the maximum and minimal end of the throughput the set pellet size and shape can't be retained is known for us.
6	Requirement 8.8.2	Requirement 8.8.2 refers to "integrated control" for feeders, liquid dosing and pelletizer. Please clearly define the term "integrated control" and specify the minimum functionality required for compliance? For each subsystem, please specify which functions must be available via the Operating and Control System (e.g. start/stop, setpoint entry, calibration, recipe storage, alarm handling, status monitoring, parameter adjustment, etc.).	Gravimetric feeder: start/stop, setpoint entry, calibration, recipe storage, alarm handling, status monitoring, parameter adjustment. Liquid Dosing: Start/stop, setpoint entry, calibration storage, recipe storage, alarm readout handling, status monitoring, parameter adjustment. Pelletizer: alarm readout, status monitoring, setpoint/parameter readout.
7	Requirement 8.8.5	Requirement 8.8.5 states "Possibility to follow process online". Can TNO please clarify what is meant by "online"? For example, does this refer to local real-time process monitoring, remote network access, web-based access, data logging, or another functionality?	Online monitoring for us means that it is possible to have the Operating Software connected to our internal network to follow the process online via Wifi-connection and/or ethernet cable to provide guidance on the workflow.

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8	Requirement 8.3.1	8.3.1 High feeding accuracy at low and high throughput: Please define "high accuracy", "low throughput" and "high throughput".	Low and high throughput refers to the maximum and minimum throughput of the provided feeder. High accuracy means for us that it should become an improvement on our current 32 year old single-screw volumetric feeder. We are aware that if the hopper fill becomes low the inaccuracy increases.
9	Requirement 8.6.3	8.6.3 Ensuring stable temperature of water bath: Please define "stable temperature".	Stable temperature of the waterbath refers to us that we can achieve a stable process, while not jamming the chopper due to smearing of the polymer at throughput higher than 4kg/h. This of course depends on the material being processed as single/or multi-strands and the length of the provided waterbath. For us this is especially the case for POE & PVB due to their viscoelastic behavior on our 0.75m long waterbath with a single guide roll (see the provided appendix "List of Materials".)
10	Requirement 8.8.2	As answer 6 did not unambiguously answer my question regarding integrated control, I would like to ask for a more precise definition, as well as examples of compliance/non-compliance. Requirement 8.8.2 refers to "integrated control" of the feeders, liquid dosing system, and pelletizer. Please clearly and unambiguously define the term "integrated control." It is currently unclear what "integrated control" means and which circumstances or system configurations would result in non-compliance with this requirement. Please specify the minimum functional and technical criteria required for compliance and provide examples of compliant and non-compliant implementations.	The term "integrated control" as referred to in Requirement 8.8.2 shall be understood at system level and does not introduce additional detailed functional requirements beyond those already specified in Answer 6. For the purpose of this tender, "integrated control" means that the feeders, liquid dosing system and pelletizer are operated via a single, unified Operating and Control System, enabling coordinated control, monitoring and operation, without the need for separate, stand-alone control systems for normal operation. The minimum functional scope per subsystem is defined in Answer 6. No additional functional breakdown is introduced. Examples of compliance (non-exhaustive): - All subsystems can be operated, monitored and adjusted through one central control system (e.g. shared HMI/PLC system). - Setpoints, status information and alarms are accessible within the same control environment. Examples of non-compliance (non-exhaustive): - Subsystems can only be operated via separate, independent control systems or software interfaces which are not integrated in a central Operating and Control System. - Lack of central monitoring or coordinated control between subsystems. No further detailed technical or functional criteria are intended beyond the above clarification.