

PORTFOLIO

**DESIGN
INNOVATION**

**MATERIAL
DRIVEN**

Francesca
Perona

2017

TEXTILE CHEMISTRY

Leading scientists in the research for **circular fibres** solutions and **non-toxic chemical** treatments for the textile industry

LIQUID FACTORIES

A **new paradigm** for textile fibers production and **post-consumer waste** recycling

RESPONSIVE HYDROGELS

Designing **bio-inspired** macro and micro-patterned sensing materials for future skin-care products

CERAMICS FABRICATION

Igniting **innovation** in the local industry by blending **robotics** and **traditional craftsmanship**

SHAPE MEMORY POLYMERS

Collaborating with industry to identify and test smart materials to **enhance packaging** solutions and **manufacturing processes**

ARTIFICIAL MINERALISATION

Harnessing biomineralisation through **microfluidics** to **sequester CO₂** and produce safe materials

TEXTILE CHEMISTRY

Deep Science Ventures

5 months project
2017

Only designer in a community of top scientists and engineers brought together to rapidly explore huge challenges in industry, discover opportunities and build the next generation of high growth science-based ventures.

I teamed up with polymer chemist Dr. Sandra Amaral and synthetic biologist Dr. Vivek Raj Senthivel to leverage their scientific know-how for the design of more sustainable textile fibres.

I reached out to industry leaders to discuss feasibility of the proposed solutions and understand challenges in the adaptation of the supply chain.

1 Problem framing

Fire Retardant chemicals are applied to home furniture, children products, bedding, mattresses and children nightwear to improve fire safety and meet strict regulations.

However, various studies have demonstrated that chemicals sprayed on and embedded in these products, since not chemically bound to the substrates, can mobilise and escape into the local environment and accumulate in house dust.

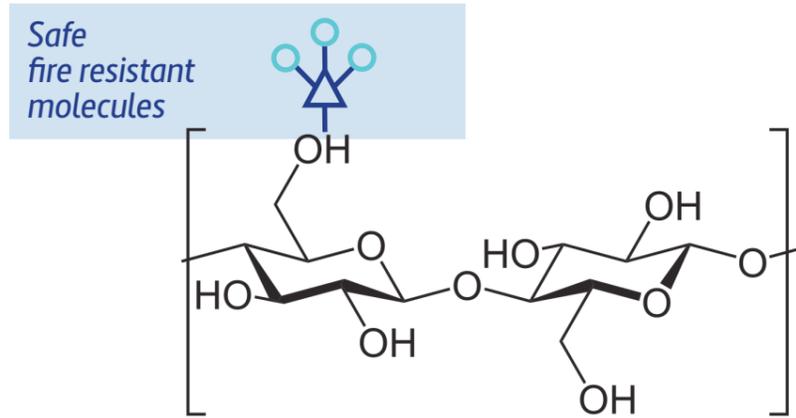
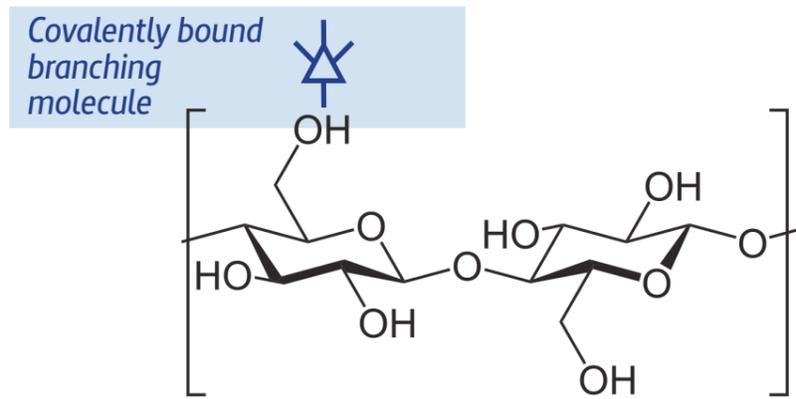
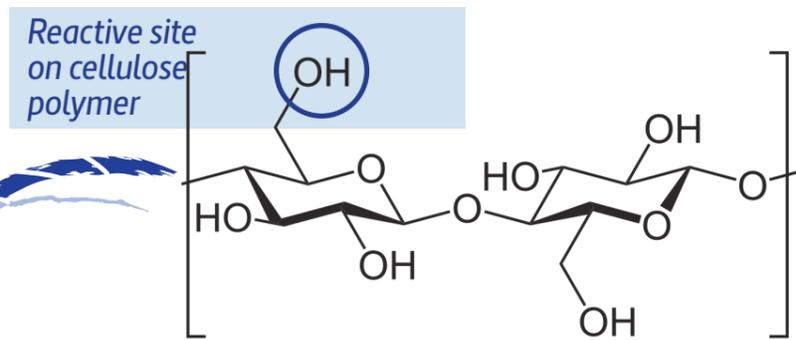
Once in the dust, these toxic chemicals are ingested and build up in the body. They have carcinogenic and neurotoxic effects, act as endocrine disruptors, and are linked to decreasing male and female fertility.

2 Research

We researched:

- most widely used chemicals
- supply chain processes
- costs to industry (home textiles, children nightwear, contract textiles)
- solutions implemented by industry leaders (IKEA, Camira UK, MADE.com, Matalan, Centre for Textile Excellence, MADE.com, Debenhams, Huddersfield University, De Montfort University)
- material innovation in research phase

From toxic fire retardant chemicals to safe fire resistant fibres



3 Material Innovation

We investigated how to move from toxic fire retardant chemicals to safe fire resistant fibres, focusing on the enhancement of cellulosic fibres.

Based on the Phd research of my chemistry collaborator in the field of drug delivery, we adapted particular molecule structures used in her work to bind covalently to cellulose, creating a chemical bond with the fibre.

These molecules are able to bear (n) active compounds that in contact with fire release substances that can block the development of the flame.

Our solution:

- is based on safe molecules
- the active compounds are strongly bound to the fabric
- we can customise the molecules to hold more particles to achieve increased fire retardancy

1

Problem framing

Mechanical recycling of plastic bottles in polyester textile fibres (rPET) is a commercially available option.

The main limitations of this recycling technology are:

- the colour of the raw material: only light blue and light green bottles can be recycled into fibres, since the textile industry requires to easily dye the resulting in any colour
- this process can only be performed once, since recycling of coloured fibres presents similar challenges

Few companies undertake polyester chemical recycling, de-polymerising the material into the original monomers.

Although this process allows to produce a higher value fibre, it is an expensive process, and few companies in the world claim they can actually separate the monomers from the contaminants (dyes) present in the polymer mix.

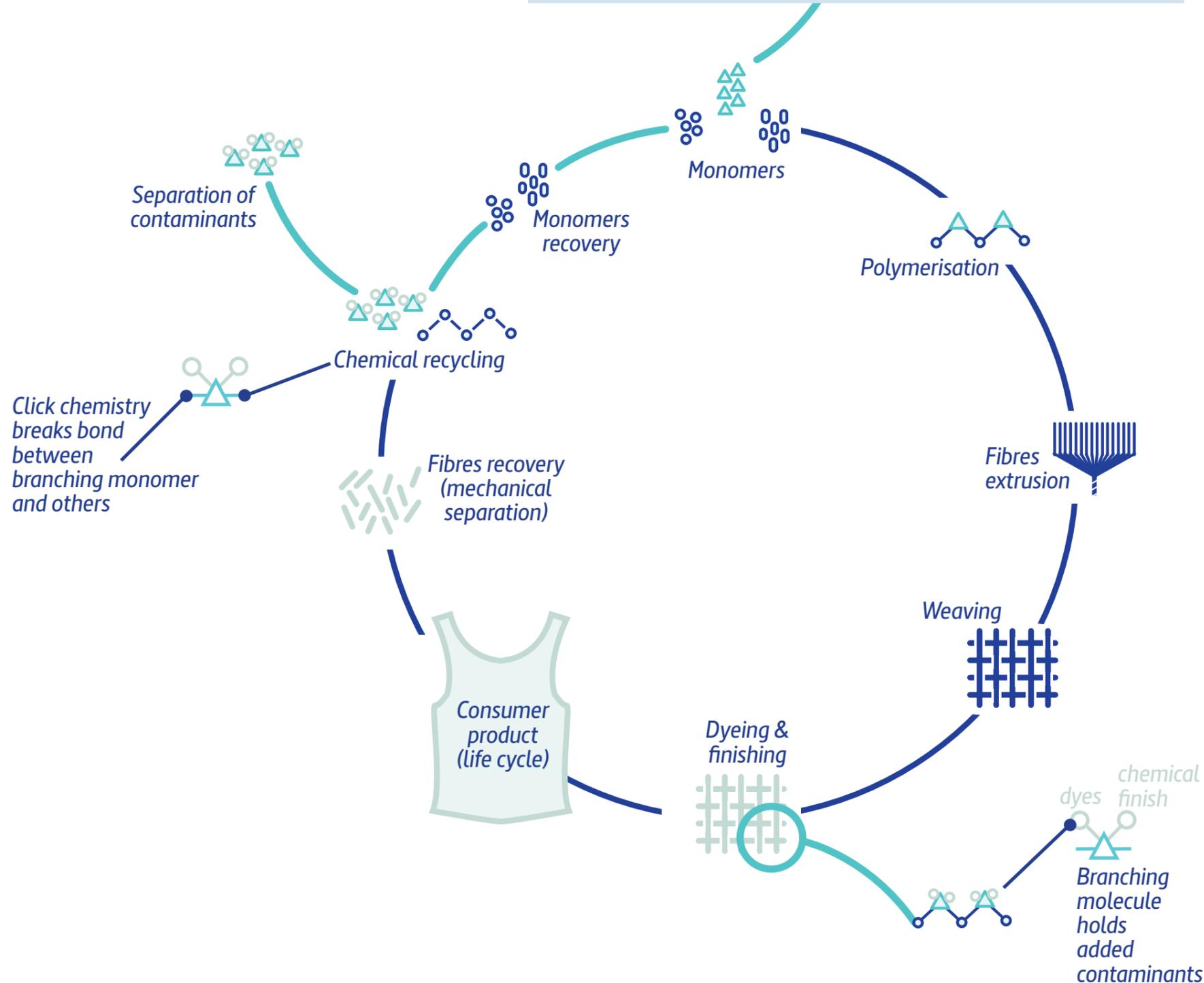
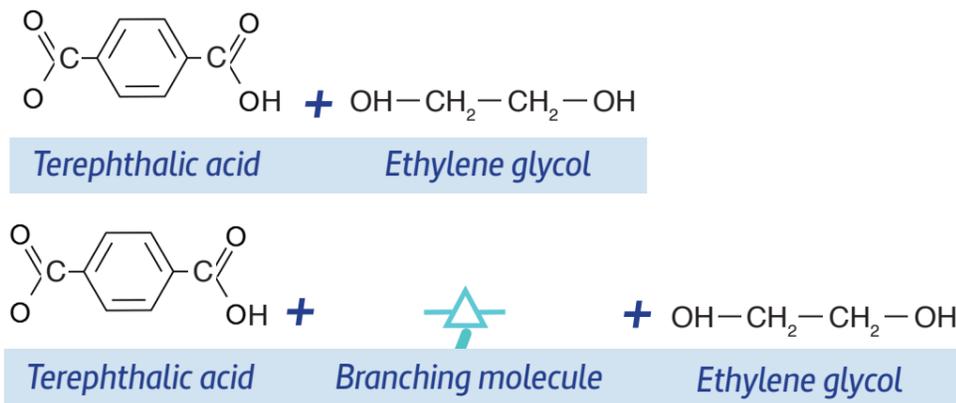
2

Research

We researched:

- the polyester supply chain (raw materials to post-consumer waste recycling)
- material life cycle
- costs to industry
- solutions implemented by industry leaders (I:CO, Camira UK, Huddersfield University, Centre for Textile Excellence)
- chemical recycling processes in research phase

Transforming polyester in a modular polymer for infinite recyclability of dyed textile fibres



3

Material Innovation

We designed a modular polyester polymer for easier chemical recyclability of coloured and finished polyester fibres.

We propose to add a monomer in the polyester polymerisation process that can link the 2 original monomers without compromising the material properties.

Instead of dyeing the polymer with hydrophobic dyes, hydrophilic dyes would attach to the particular structure of the added monomers, as well as the added textile finishes.

At the end of the life cycle, the modular polyester would be returned to the chemical recycling company that would be able to target the chemical bonds between the 3 monomers to separate them and obtain the original polyester monomers.

This process can be repeated multiple times, preserving the properties of the material, and allowing to remove the contaminants attached.

LIQUID FACTORIES

1 Problem Framing

The water footprint of cotton is huge. 1kg of cotton lint requires 9.000 liters of water.

Although only 2.4% of the world's crop land is planted with cotton, it accounts for the 24% global insecticides and 11% pesticides sales respectively.

The run-off of pesticides, fertilisers and insecticides contaminates rivers, lakes and wetlands, altering the ecosystem.

21.3 million tons of cotton were produced in 2017. 73% of post-consumer cotton waste ends in landfills.



1kg cotton = 9.000 lt water

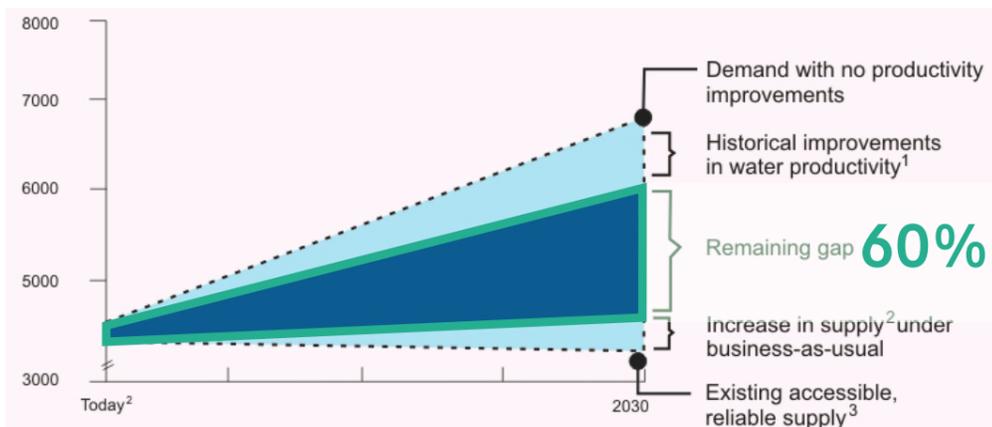
Current plantation practices

- Although GM pest-resistant cotton strains have been implemented, studies have shown that farmers have used the same amounts of pesticides as with the non-gmo plantations.
- Global brands have invested in initiatives for sustainable sourcing of raw materials. Promoting better farming practices, they have positively impacted workers' conditions and reduced the usage of pesticides and water.
- Wood pulp is an alternative source of cellulosic fibers. Lenzing is the world's leader in this field, with sustainably processed pulps resulting in high quality lyocell and viscose. Unfortunately most of the lyocell production is still extremely polluting, and dangerous for both factory workers and the environment.

Alternative solutions to cotton plantations are needed

Meeting the needs of the growing human population in the next 50 years will require increasing availability of land and water for food crops.

Although sustainably sourced cotton and man made cellulosic fibers are valid approaches, alternative solutions to cotton and wood plantations are needed.



Water demand projections for 2030

Barriers to recycling

Considering the annual cotton waste production figures and the growing interest in circular models, cotton recycling would seem an effective solution.

However, one of the major barriers to the implementation of alternative solutions is the very competitive price of virgin cotton (in particular when exploitative approaches are still in use and when the environmental and human costs are not considered).



73% cotton waste ends in landfills

Can we make textile recycling economically competitive?



The true price of cotton from India - IDH & True Price report 2016

In addition, fast fashion consumers are not ready to spend more for more sustainable or recycled materials, meaning that any innovation has to be as cost-effective as current fibers and easy to integrate in the current supply chain.

Innovative materials also need to prove as easily dyeable, resistant to wear and as comfortable as the current fibers, which also requires research and development efforts.

Post-consumer textile waste collection, sorting and mechanical recycling also prove economically challenging, although brand initiatives exist.

Mechanical fiber separation technologies also compromise fiber length and as a result, recycled fibers quality is lower.

In addition, the majority of post-consumer textile waste is mixed, with separation of different fibers also proving expensive.

How can we transform recycling processes in economically sustainable solutions?

NEW APPROACH

From liquid collagen produced by yeast and coiled and spun into leather, to sustainable materials grown at increasing speed by waste-degrading mycelium, to chemically recycled post-consumer textiles dissolved and spun for a second life,

the new frontier of textile production is a **liquid revolution**.

In which ways can we take advantage of precipitation, dispersion, binding, compression, molding and drying processes to create

new and sustainable **forms of materiality?**



Can we produce plant-free cellulosic fibers, reducing water consumption and nutrients foot-print?

1 Bacterial cellulose

Acetobacter Xilinum is the most prolific bacterium at producing cellulose found in nature. It transforms the sugars dissolved in the liquid medium in tiny cellulose fibrils.

Could we engineer this natural mechanism to produce wearable cellulosic fibers?

2 Bottle-necks

The perceived issues with bacterial cellulose for textile applications are:

- production yield (slow process)
- identification of low-cost feed (waste sugars)
- fiber properties (the material tends to absorb the 94% of its weight in liquid)
- bioreactor optimisation for scale-up

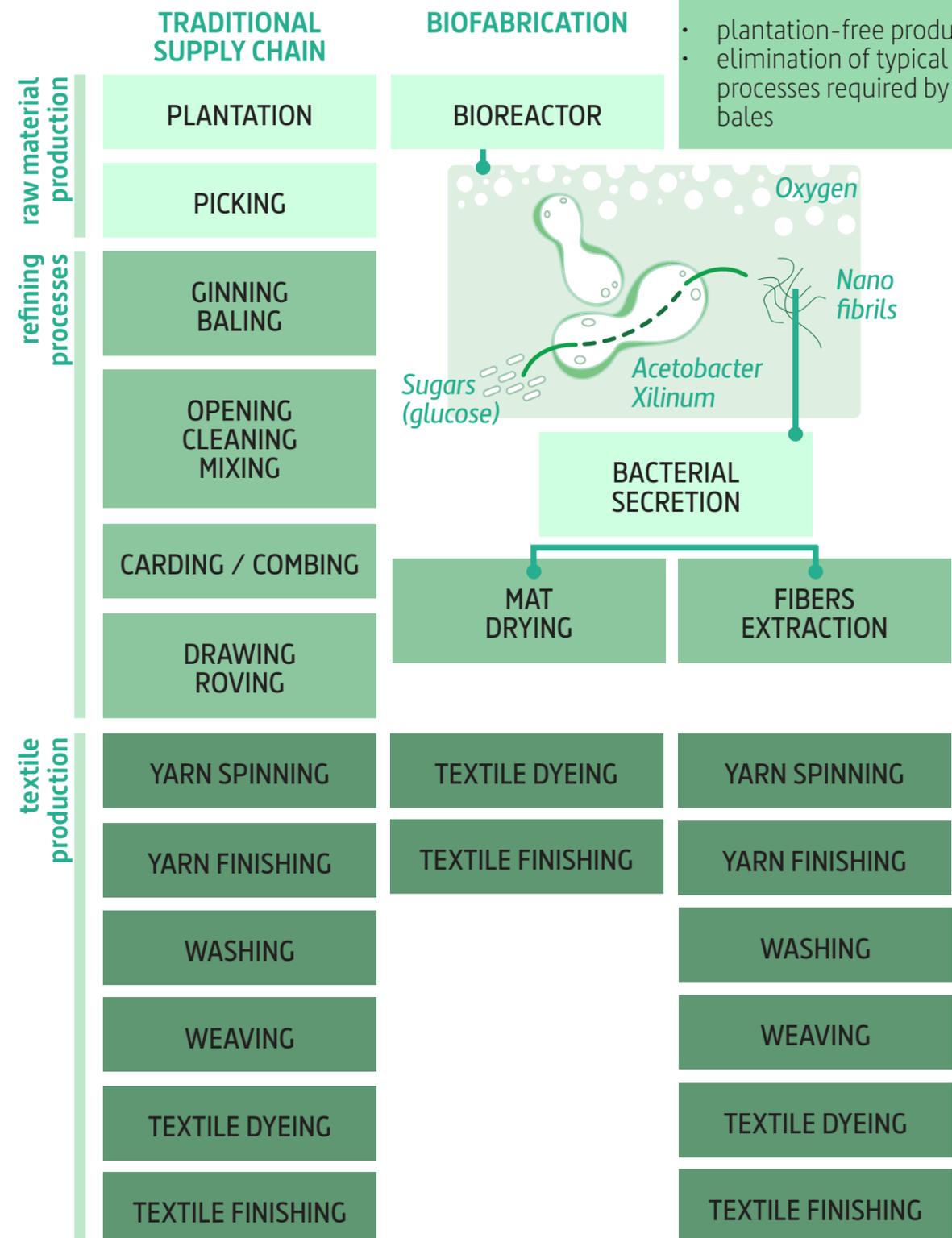
We have found that the cristallinity of the nano-fibrils can be controlled. Average cristallinity seems to be between 2.500 and 9.000 DPE, with wood-derived cellulose being around 10.000 DPE.

Question remaining open is the water demand for the production of the same quantities of dry cellulose.

3 Advantages

The advantages are:

- plantation-free production
- elimination of typical cleaning processes required by cotton bales



4 Opportunities

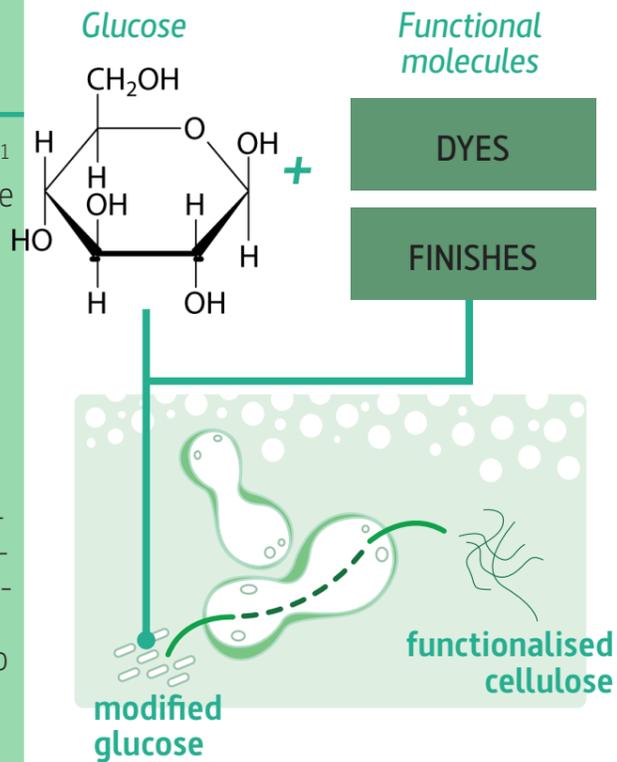
Single-step fibers production and functionalisation

Modified growth medium for synthesis of functional fibers and materials

A recent study published in Nature¹ has demonstrated that it is possible to grow cotton in petri dishes, feeding its ovule directly with modified glucose molecules. The study used glucose linked to fluorescent molecules, and showed how resulting cotton fibers grew with fluorescent properties.

Inspired by this study, we hypothesise that it could be possible to dissolve in the growing medium functional molecules, which absorbed by the bacterium, would allow it to synthesise 'functionalised' fibers, potentially eliminating steps such as traditional dyeing and finishing processes.

¹Biological fabrication of cellulose fibers with tailored properties - 2017. Natalio, F. et al.



Photosynthetic and cell-free cellulosic production

The advancement of research in the field of synthetic biology is also highlighting the possibility of:

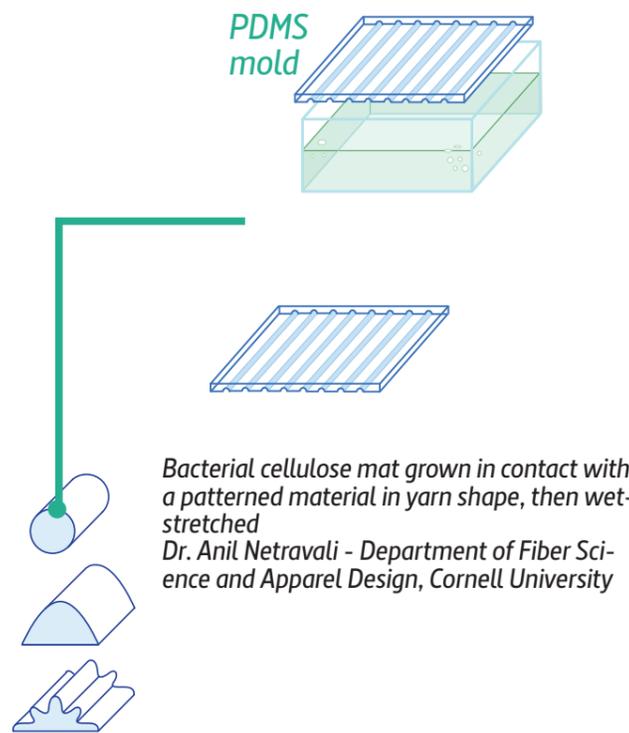
- transferring cellulose production mechanisms to photosynthetic organisms such as cyanobacteria² to eliminate need of sugars
- engineering cell-free systems to improve yield
- recognising strains of carbohydrates from complex molecules, therefore potentially being able to feed cellulosic waste rather than sugars to the bacterial culture

²"The Brown lab has achieved a functional transfer of *Acetobacter xylinum* cellulose synthase genes into cyanobacteria."

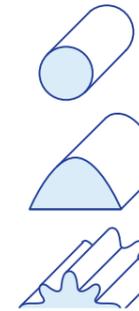
Synthetic approaches for increased efficiency

Direct yarn and non-wovens production

Current research in bacterial cellulose fabrication methods also shows how specific static bioreactor designs can directly form macro-fibers from bacterial cellulose mats, although both processes illustrated below are hardly scalable.



Bacterial cellulose mat grown in contact with a patterned material in yarn shape, then wet-stretched
Dr. Anil Netravali - Department of Fiber Science and Apparel Design, Cornell University

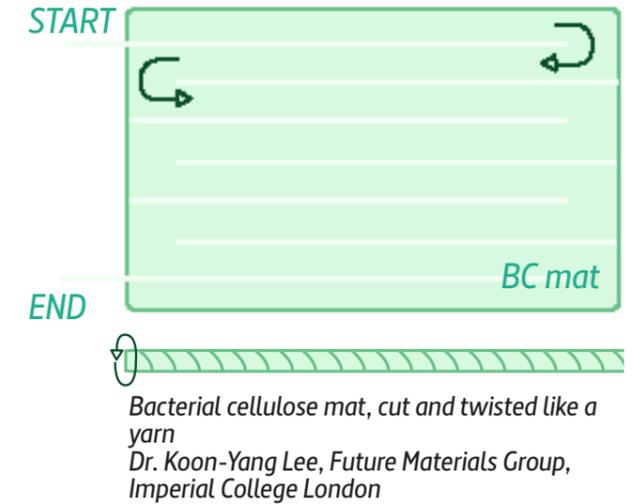


This second method allows to reach a greater alignment of the microfibrils by restraining the space for the bacteria to move freely in the tank, as well as a variety of fiber section designs.

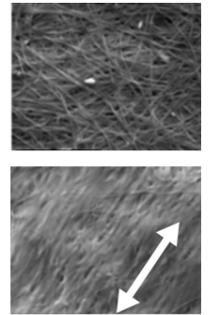
What different properties would moulded threads have?

Could we engineer different fiber directionalities?

'Growing' yarns and non-wovens



Bacterial cellulose mat, cut and twisted like a yarn
Dr. Koon-Yang Lee, Future Materials Group, Imperial College London



Artist Diana Scherer has been exploring for years the possibilities afforded by growing plant root systems on templates, training them to produce lace-like fabrics.

Taking advantage of the pdms mold method, would it be possible to create similarly complex non-woven and finished designs?



Exercises in root system domestication
Diana Scherer

Can we up-cycle mixed post-consumer waste in an economically sustainable way through bacteria?

1 Fibers recycling state-of-the-art

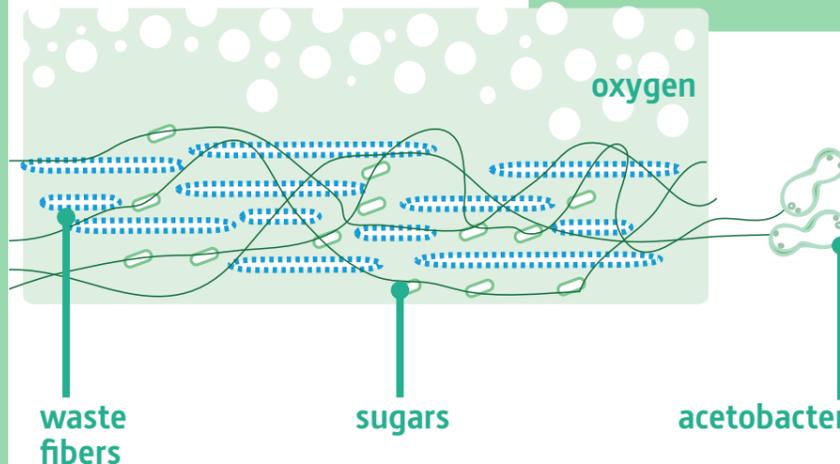
A number of companies working in the field of textile recycling have recently made huge progress in both chemically recycling cotton and preserving its properties, as well as chemically separating polyester from cellulosic waste.

In the cotton chemical recycling process ionic liquids seem to be the most effective. Although environmentally sustainable, the cost of these green chemicals is still high.

In general, although these recycling initiatives receive funds to support lab scale research, few companies are actually ready to scale-up their production at competitive prices.

Although cotton and polyester dominate the textile fibers market, collecting and sorting companies such as H&M partner I:CO highlight the huge challenge in separating fiber types, since most garments are produced with mixes of 3+ fibers.

In addition, separation of contaminants such as textile finishes and dyes from the used fibers also proves challenging. Most of the recycled materials are in fact white, leaving out the majority of the available quantities.



2 Opportunities

Bacterial cellulose as binder

Since bacterial cellulose production is slow, would the dissolution of post-consumer textile waste in the growth medium speed up the mat formation?

Could we take advantage of bacterial movement in the bioreactor as a 'binder' compacting and tying existing fibers together?

Could we tune the material properties with different waste sources?

Digestion and binding processes borrowed from Nature

Mixed waste digestion processes

Recent innovation in fields such as architecture have taken advantage of bacterial secretions in new, unexpected ways. For example, biomason is a brick whose sand dust has been set in the solid form by a binding agent produced at room temperature by bacterial colonies.

Mycelium has also been used to digest various forms of waste. If the mycelium is seeded in a mixture with textile waste sources, it will grow in the interstices, while also digesting the compounds. Once the process is over, the mycelium can be baked for a short time, and the final material consolidated.

Few conversations with industry experts emphasized how pulling post-consumer waste streams together could be key to developing effective recycling strategies.

How could we take advantage of natural binding and digestion processes to process mixed textile waste?

Could we co-culture different bacterial colonies and organisms to obtain different material properties?

Could partnerships with companies such as Ecovative and Biomason allow to explore this space?



Liquid Mycelium



Biomason bacterial brick



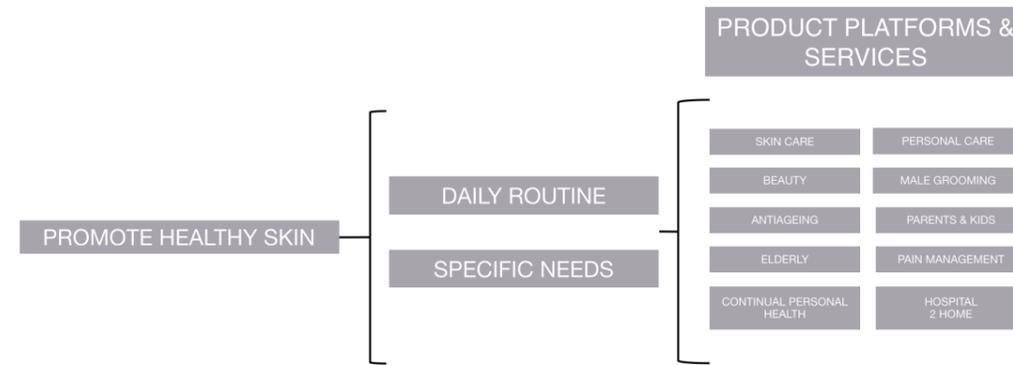
Bacterial cellulose mat



Mycelium leather



Human-centric design approach for the identification of consumer needs within stakeholders business platforms



RESPONSIVE HYDROGELS

Horizon 2020 materials for consumer products

Northumbria University
5 months project
2014

This design research project was developed for Philips Design & Innovation, in collaboration with their Design and Research Departments.

Our team was brought in to explore the current consumer products landscape and identify innovative material platforms that could be integrated to enhance product functionalities (Horizon 2020), as well as to identify applications that could open new business opportunities.

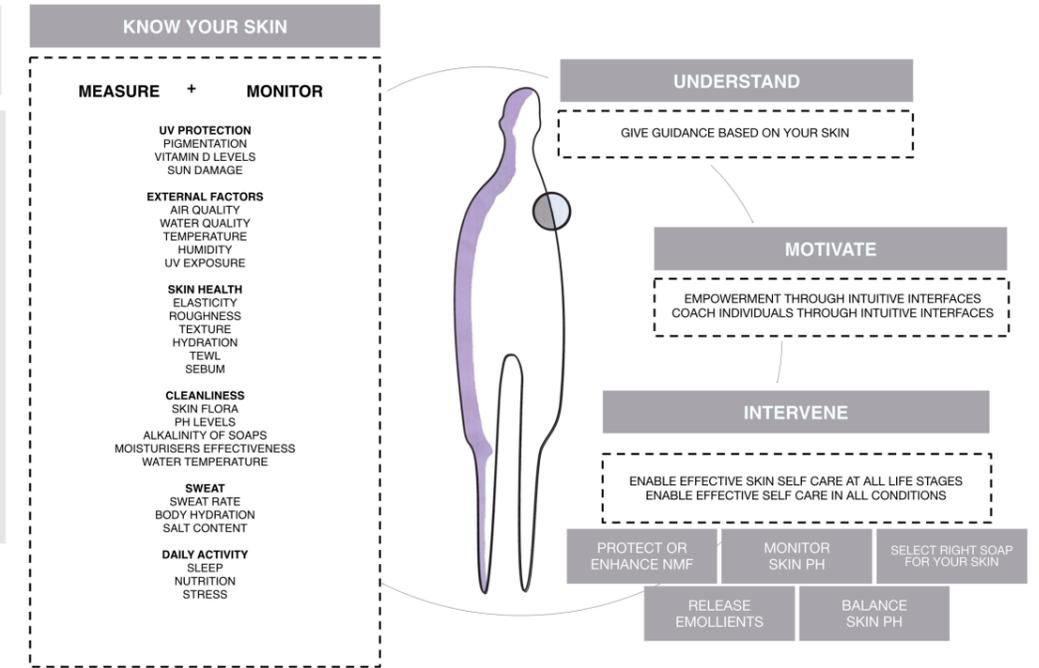
As research assistant, I developed the design concepts and the prototypes from conception to fabrication.

1 Identify needs

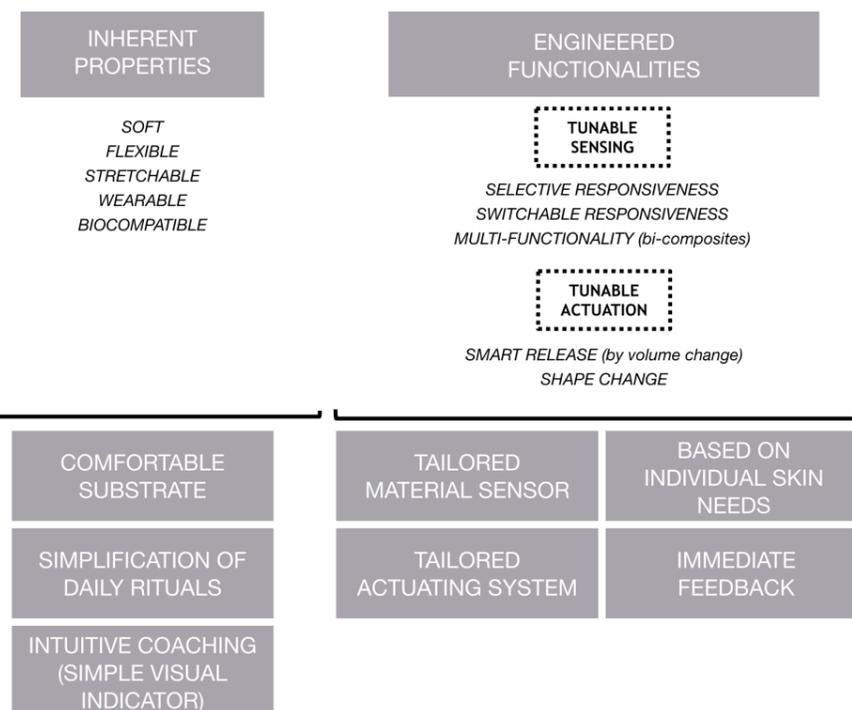
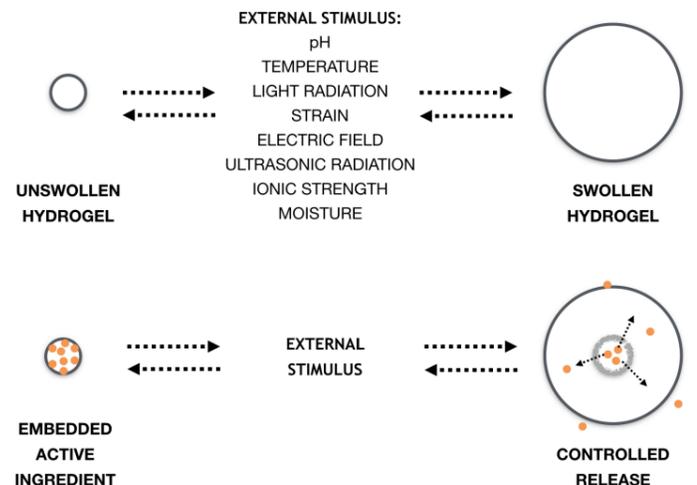
Our team mapped consumer needs across different business areas and through different age lenses.

I focused on skin-related issues, both in terms of daily routine and specific skin conditions.

Working with our stakeholder we identified opportunities in the development of a monitoring platform for skin health.



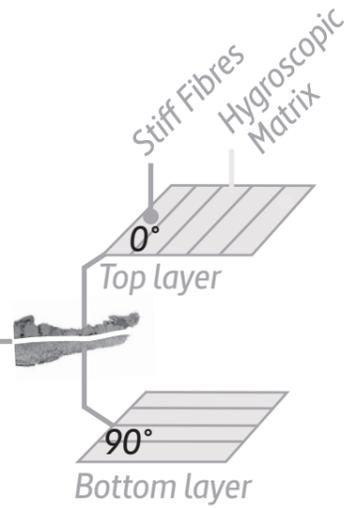
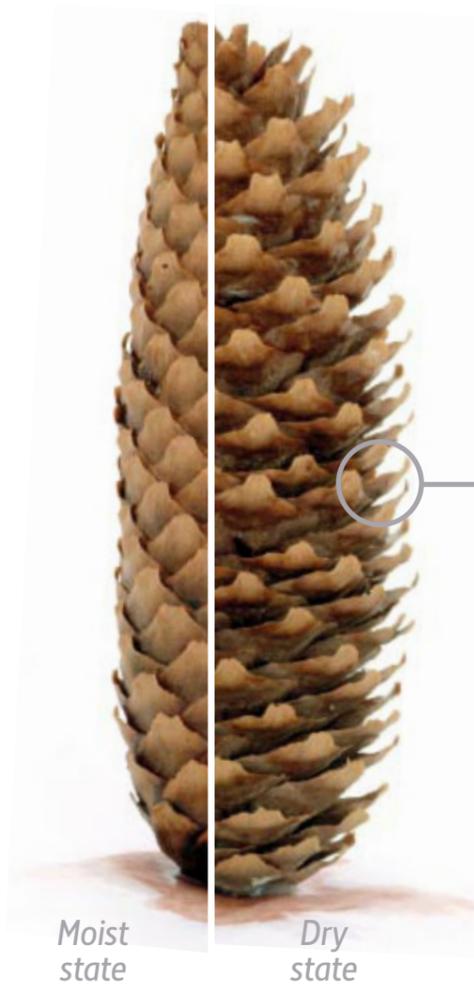
Identification of material platform from literature review



2 Materials research

Having scoped the scientific literature for innovative materials, we identified responsive hydrogels as ideal responsive material interface for the project development.

We mapped and discussed the material properties we considered relevant for skin-based products with our stakeholder.



3 Nature-inspired material development

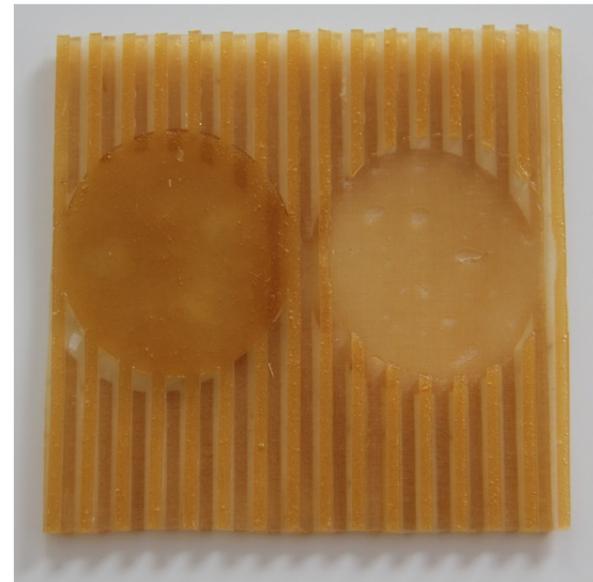
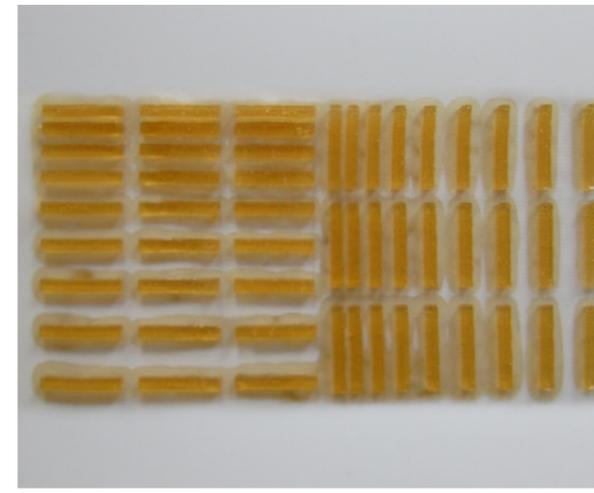
In charge of prototypes development, I took inspiration from the dynamic hygroscopic behaviour of the pine cone.

Each pine scale is composed of 2 layers, both made of a soft matrix and stiff cellulosic fibres, differently orientated.

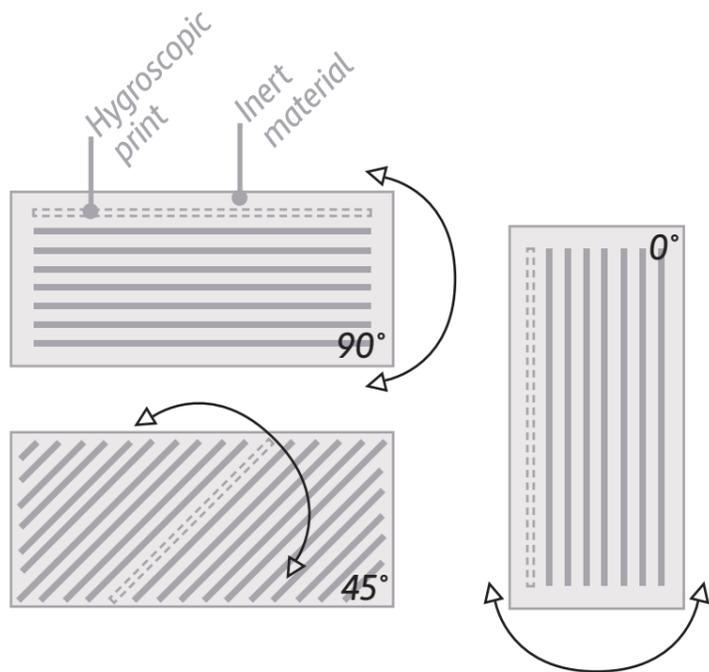
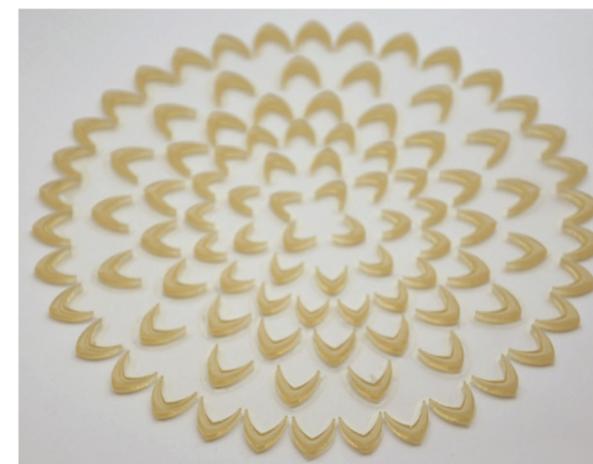
Changes in environmental moisture activate the dynamic behaviour. The bottom layer soft matrix swells and shrinks in response to these stimuli, forcing the whole scale to adapt and bend.

Drawing on these biomimicry principles I explored how moisture responsive materials similar to hydrogels could be used in conjunction with specifically designed geometric patterns to generate reversible 4D shape change behaviours on 2D printed surfaces.

In humid conditions the hygroscopic materials swell, forcing on the inert bases to bend and fold in a matter of 2 to 5 minutes.

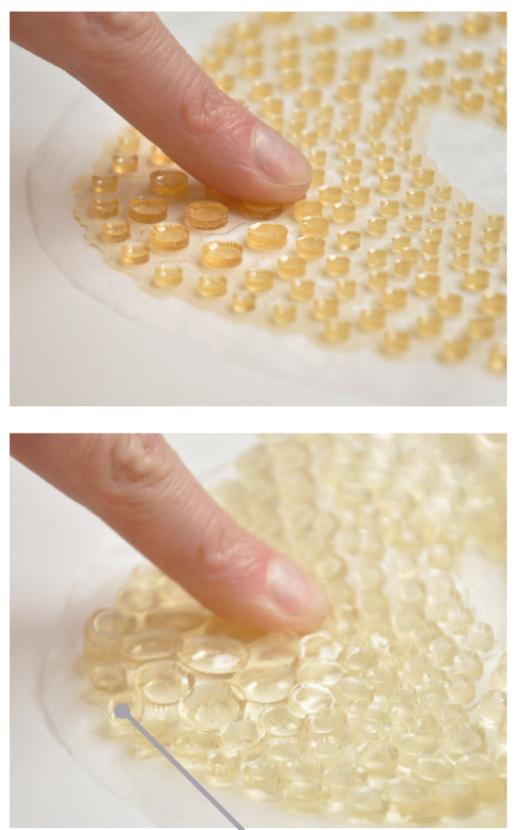
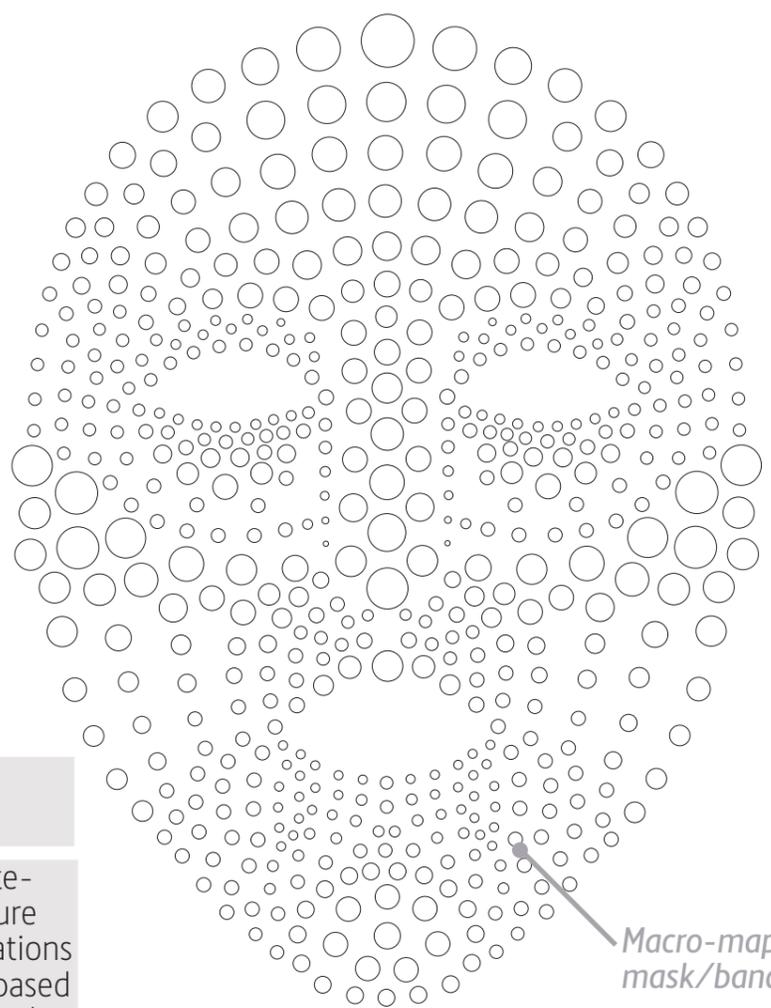


Moisture-actuated layered structures for reversible 4D shape change



4 Product scenarios

Building on the first-hand material exploration and the literature review of cutting-edge applications of hydrogels, I designed skin-based product scenarios exemplifying the potential applications of this soft material in existing consumer products and future products.



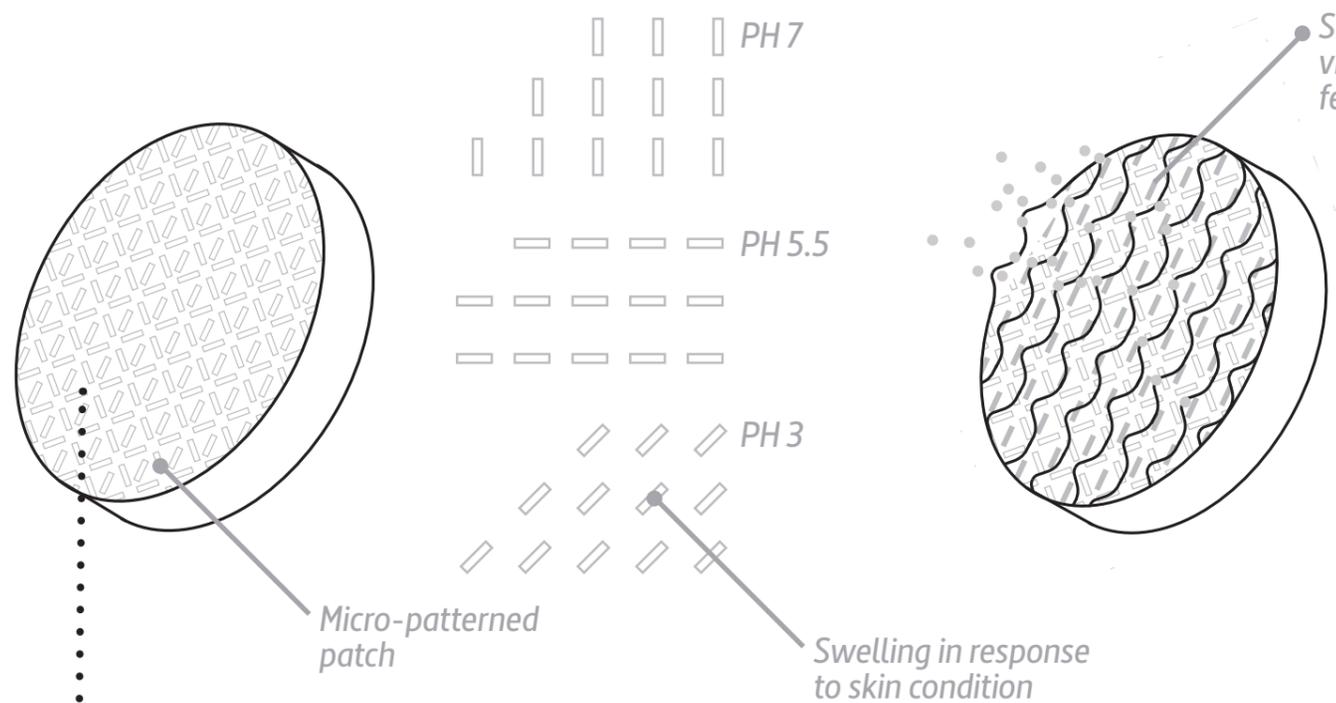
Macro-patterned hydrogel mask
 designed to sense skin dehydration levels on a wide surface area.
 Hydrogel swells according to the sensitivity of different areas, releasing appropriate amount of emollients on skin.

Macro-mapping mask/bandage

Swelling in response to sensitive area

Controlled release

Macro and micro patterned surfaces for skin-care products



Micro-patterned hydrogel patch
 Each of the 3 patterns composing the patch respond to different skin conditions.
 By swelling in response to the detected condition the patterns will modify the structure of the surface, giving a simple visual feedback on the particular condition.

Micro-patterned patch

Swelling in response to skin condition

SHAPE MEMORY POLYMERS

Testing material properties

Improved packaging solutions

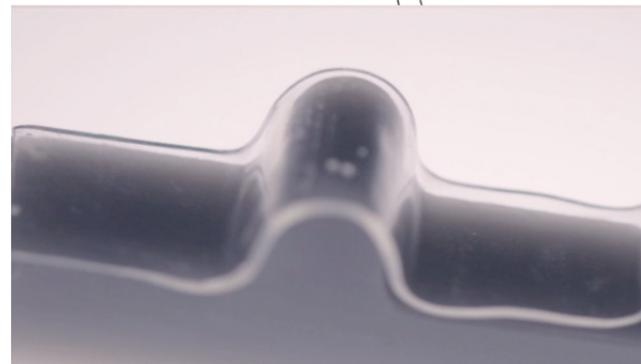
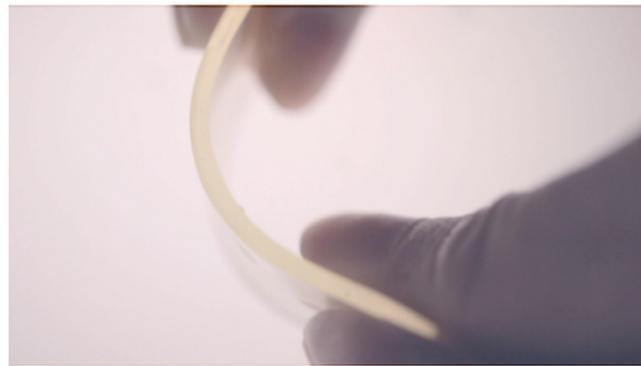
Northumbria University
5 months project
2015

This design research project was developed for Unilever, in collaboration with the Packaging Area Managers (hard and flexible plastics).

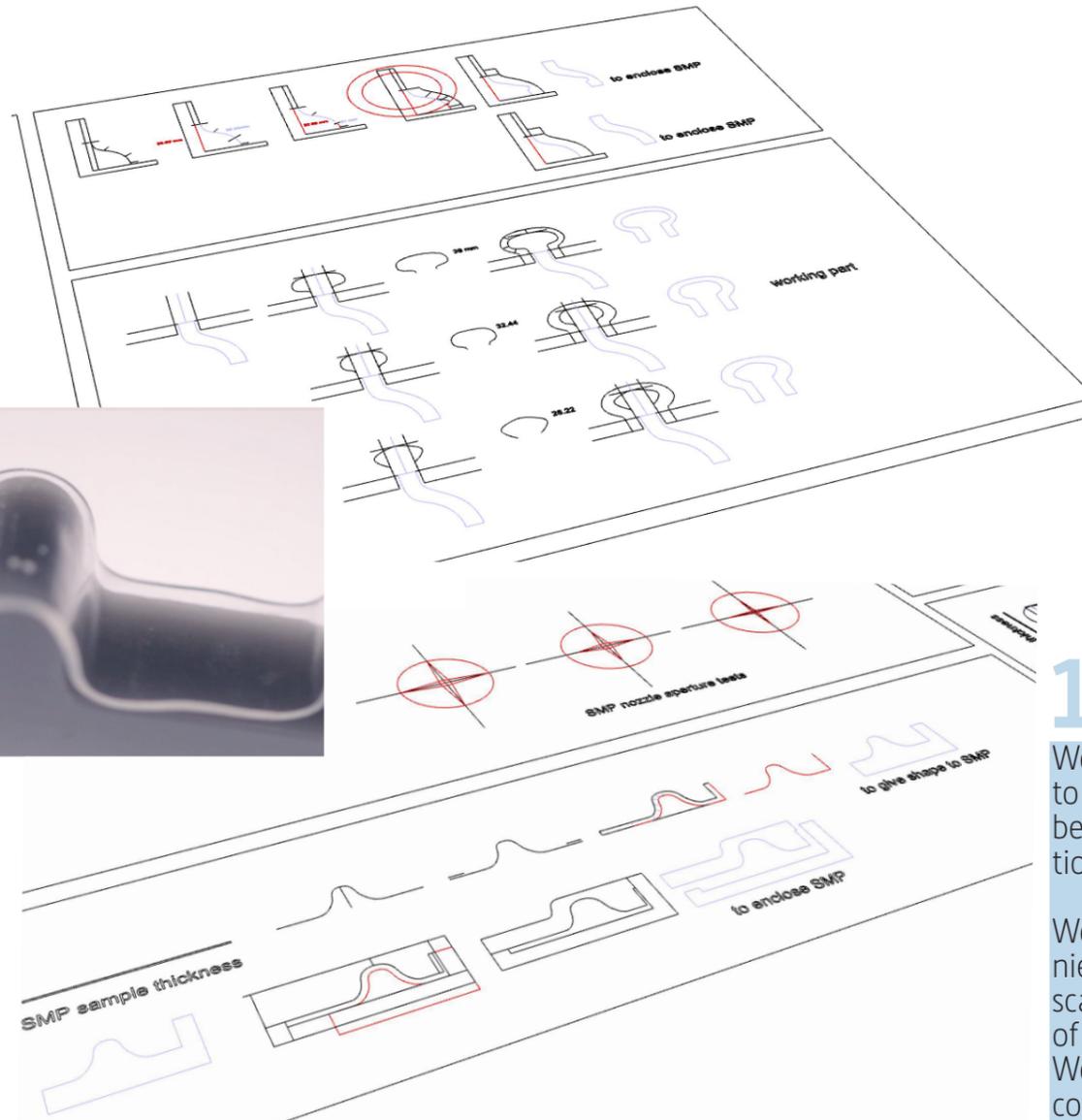
Our team was brought in to identify innovative material platforms that could be integrated in packaging solutions to enhance product functionalities (Horizon 2020).

As Senior Research Assistants, my colleague Niam O'Connor and I worked on the Shape Memory Polymers (SMPs) platform with Unilever Packaging Managers.

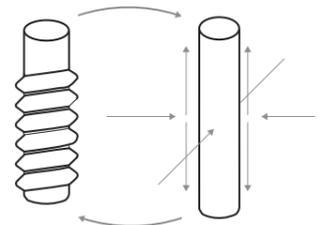
We conducted the research and design development, also collaborating with a film-maker and animator to script and produce a video animation illustrating the design scenarios. I was in charge of the fabrication of the prototypes.



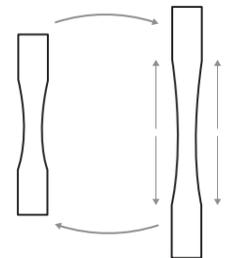
Pictures courtesy of Sapphire Goss



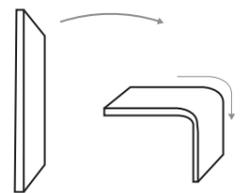
Shape Memory behaviours



Reversible Texture



Elongation & Contraction



Shape Change

1 Studying material behaviours

We scoped the literature on SMPs to understand their responsive behaviour under different conditions.

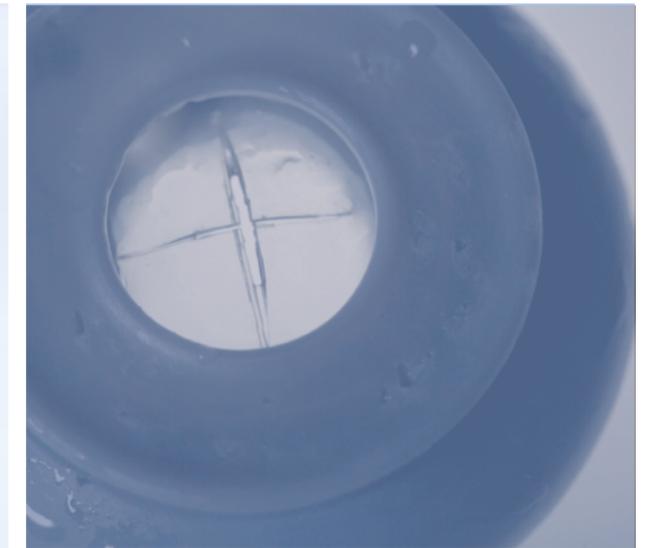
We then got in touch with companies producing SMPs at industrial scale to understand the tunability of the temperature responses. We receive samples from these companies for properties testing and prototype development.

2 Collaborative research

Workign with the Unilever packag-
ing engineering managers we
explored issues in current packag-
ing production, potential consumer
benefits and sustainability chal-
lenges.

We identified the potential for
SMPs to:

- enhance consumer experience
- improve current manufacturing processes
- ligh-weight packaging



Closed nozzle

3 Product Scenarios and prototypes

We designed scenarios and proto-
typed product applications to com-
municate to our stakeholders the
identified benefits.

I was in charge of the product pro-
totyping, which involved experi-
menting with selected materials in
the lab, modeling and 3D printing
demonstration pieces, integrating
SMP samples obtained from indus-
try to demosntrated the behaviours.

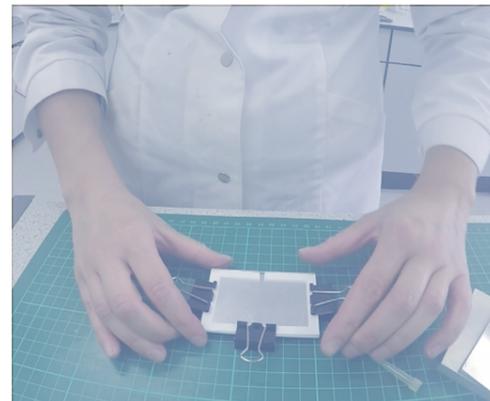
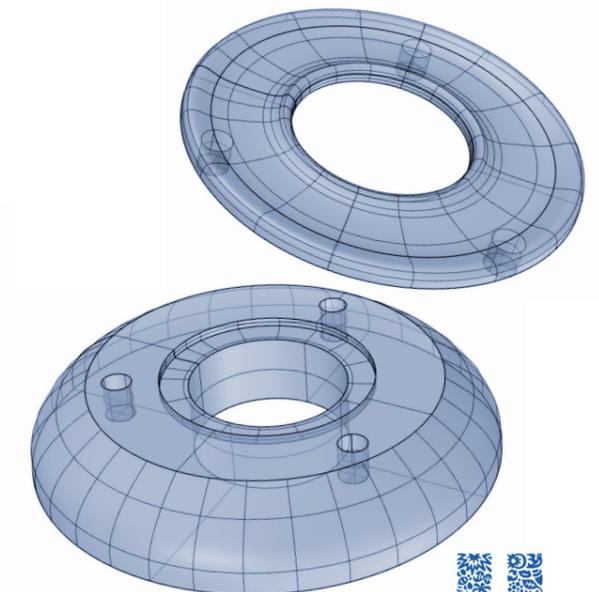


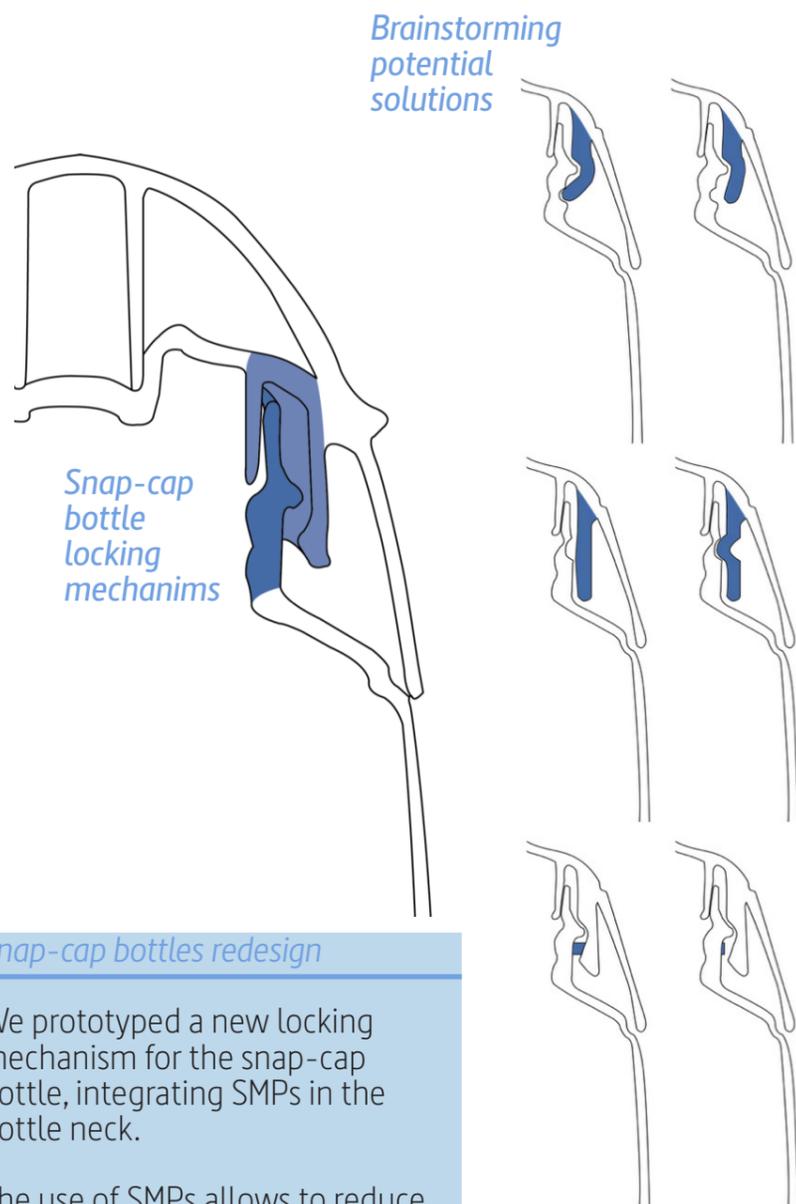
Open nozzle

Heat-activated features for better packaging experience

Heat-activated self-opening nozzles

We prototyped a nozzle that
would open-up like a flower in the
shower when under the hot water,
for a effortless shower experience.





Snap-cap bottles redesign

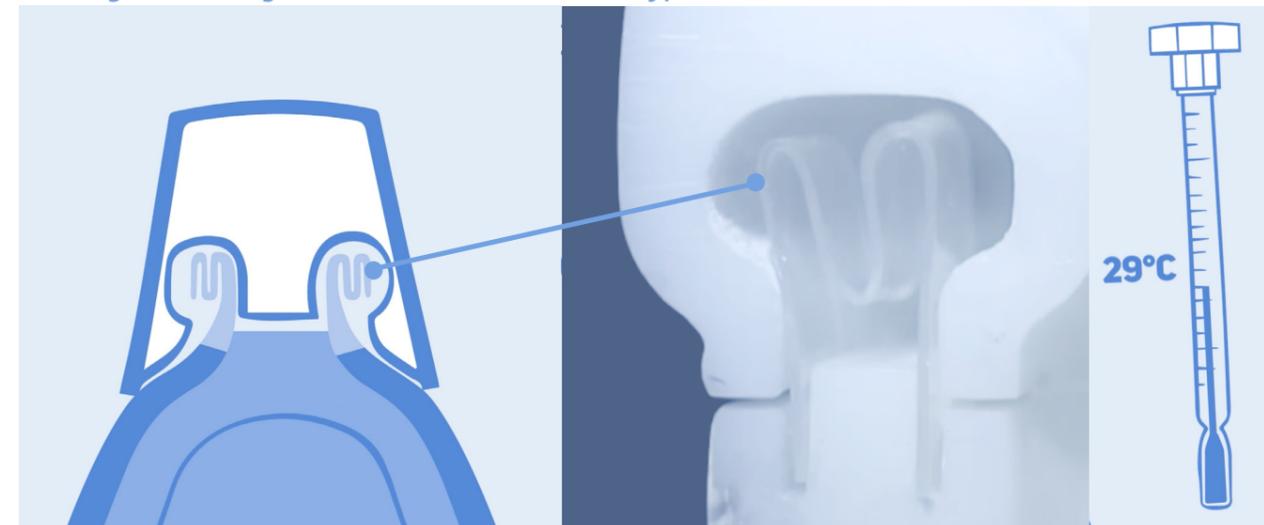
We prototyped a new locking mechanism for the snap-cap bottle, integrating SMPs in the bottle neck.

The use of SMPs allows to reduce the capping force applied during manufacturing, as well as improve the sealing system overall.

When the bottle is produced the SMP neck moulded in a particular shape. When heated once capped, it springs back, filling the gaps in the mechanism, locking the bottle.

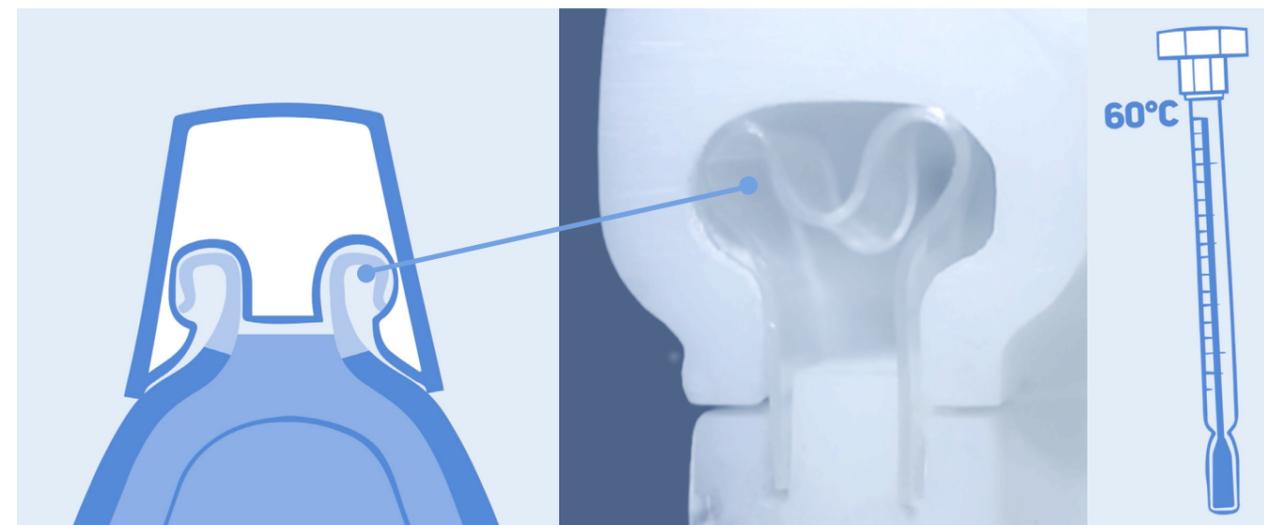
Redesigned locking

Prototype



Un-locked bottle

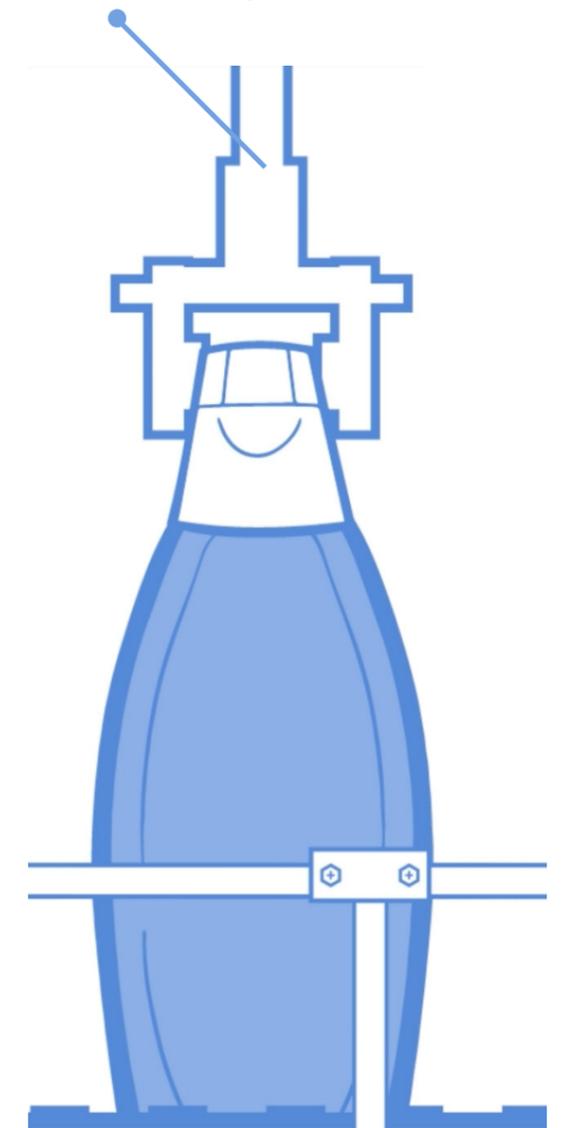
Compressed SMP layer allows easy positioning of cap



Locked bottle

Compressed SMP layer springs back locking the cap

Reduced capping force during manufacturing



Illustrations by animator Nicholas Waterton

Shape Change behaviour for faster manufacturing

CERAMICS FABRICATION

Ceramics for the Anthropocene

European Residency commission
4 months project
2017

I was commissioned to develop a project that would ignite innovation in the long-standing (but fading) artisanal ceramics industry of Albisola (IT).

The project framework involved the community of ceramicists of Albisola, the Engineering Department of the University of Genova and the digifabTURING robotic fabrication research lab based at FabLab Turin.

I led the project from conception to realisation, drawing on the expertise of my collaborators.

1 Historical and Ethnographic Research

Having engaged in in-depth discussions with ceramics historians, museum collections managers and the local community of ceramicists and clay technologists, I built a thorough understanding of the unfolding of the Albisoles ceramics production over 900 centuries.

Although the rich tradition started because of the particular qualities of the local clay, I observed how contemporary craftsmen had become completely oblivious in regards to the origin of the raw materials used in their practice.

The industrial clay they use functioned as a blank canvas for complex pictorial glaze decorations. None of the craftsmen I interviewed created unglazed objects nor knew the origins of the clays they were working with.

“I observed how local ceramicists are completely oblivious in regards to the origins of the raw materials”

2 Developing material know-how

I formed a team of collaborators that helped me to rediscovered the locally available clays. We visited and collected materials from forgotten caves, abandoned areas and geological landmarks.

We then learnt how to work with these materials and create mixes that would perform as the industrial counterparts and produce a beautiful colour palette.

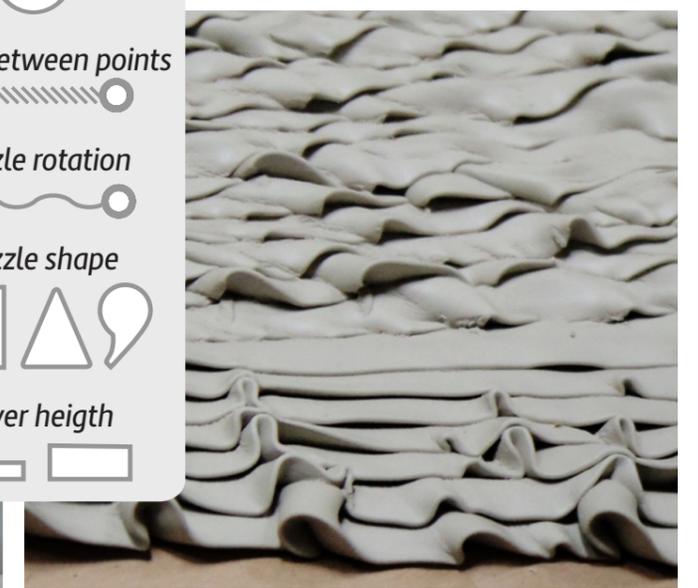
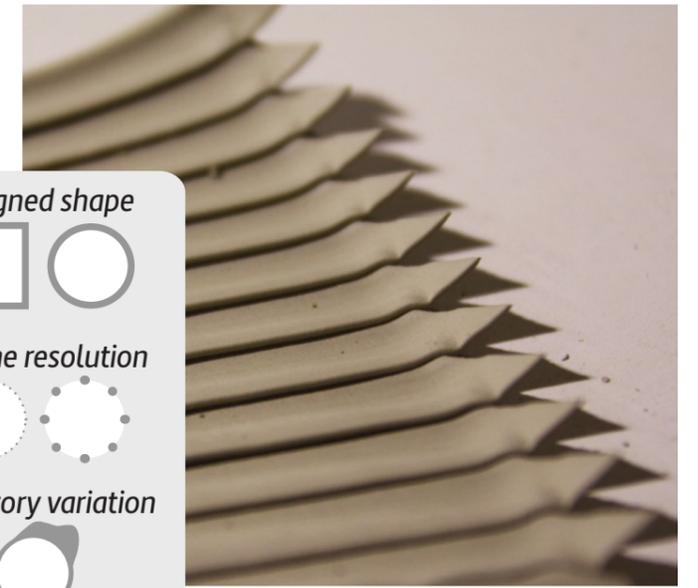
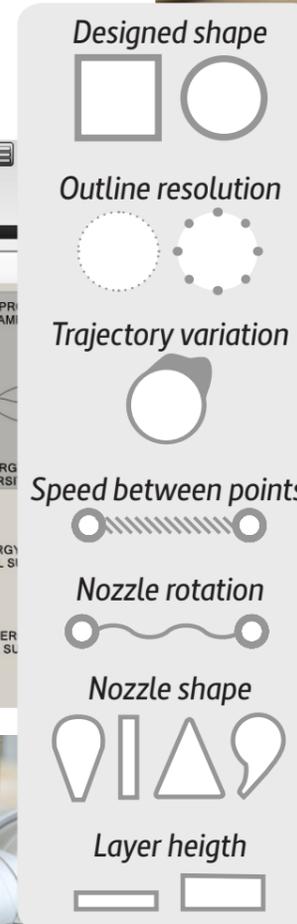
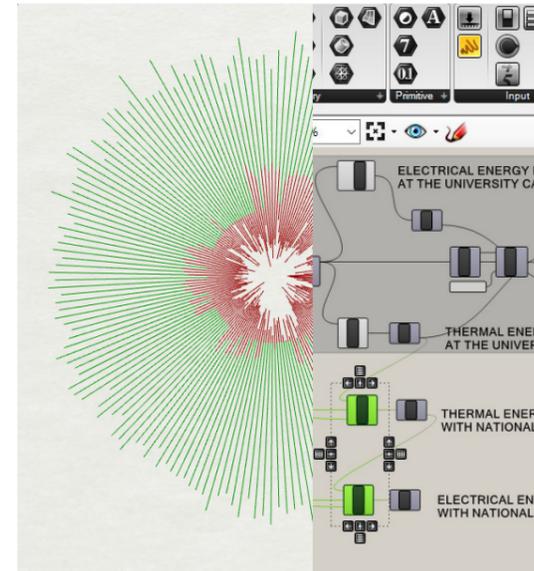


3 Melding digital and traditional techniques

I led the fabrication experimentation through a highly collaborative approach.

We explored the full expressive potential of the raw materials, crafted data-driven computational designs through extensive exploration of the combinations of the robotic platform parameters.

I led the experimental fabrication exploring the full potential of digital and traditional tools and techniques



We successfully cross-pollinated digital and traditional know-how.

I pushed the team to work at a big, challenging scale.

I encouraged the exploration of new tools, bringing in a series of haute patisserie nozzles that allowed us to achieve material structures never seen before in the field of digital clay fabrication.

By leading and facilitating the collaboration, we successfully cross-pollinated the traditional know-how with cutting-edge digital fabrication techniques. Both partners have since integrated in their own practice the new approach to materials and crafting tools.



The artwork is hosted at the prestigious Museo della Ceramica in Savona (IT)

ARTIFICIAL MINERALISATION

Carbon Positive

Bio Art & Design Award proposal
6 months project
2016

Selected as finalist of the prestigious Bio Art and Design Award, I collaborated with the Mycosystems group at Technische University of Eindhoven on a project proposal for a 6 months residency.

Inspired by marine biomineralisation processes and natural carbon capture strategies, I asked the team of scientists if we could take advantage of microfluidics to mimic these natural processes and sequester environmental CO₂.

Can we mimic shells biomineralisation to capture environmental CO₂ and transform it in a usable material?

The experimental work presented in 'Self-assembly of amorphous calcium carbonate microlens array', paper published by Lee et al. in 2012 was instrumental for the development of the project proposal,

The team was able to self-assemble CaCO₃ microlens spheres with uniform size, at ambient temperature, by reacting a specific liquid with CO₂ present in the local environment.

The reaction happens at the interface between liquid and air.

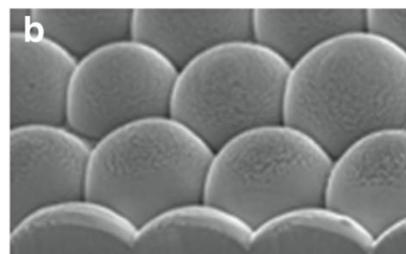
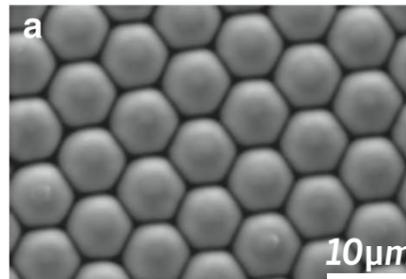


Image from paper: Self-assembly of amorphous calcium carbonate microlens array

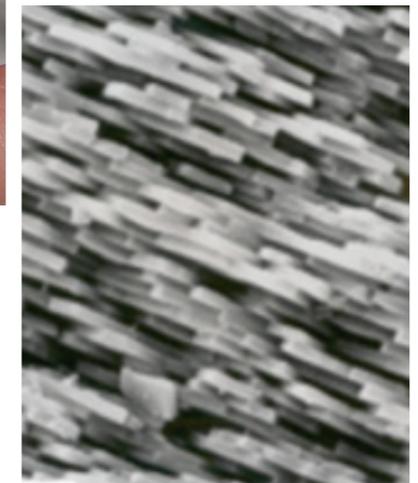


1 Biomimicry research

I was inspired by marine organisms that use biomineralisation processes at ambient temperature to sequester CO₂ dissolved in marine water and transform it in a building block for their shells.

I asked a simple question: could these strategies be adapted to sequester CO₂ from the urban environment and build useful materials?

I investigated the literature for proof of concept experiments in this area.

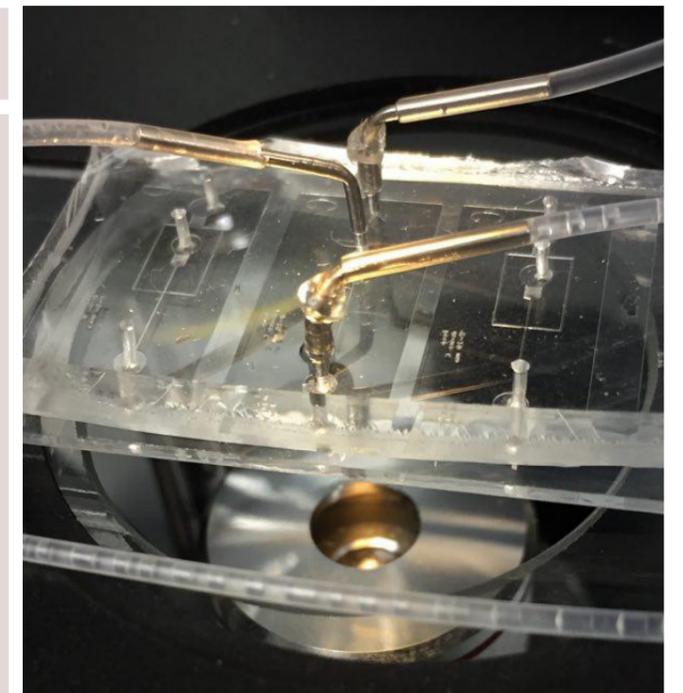


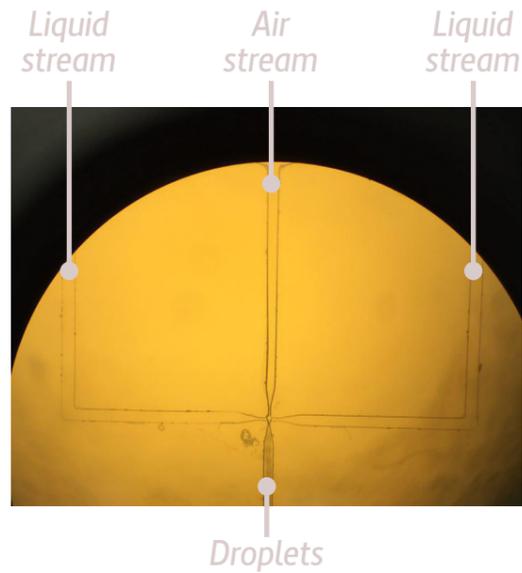
2 Collaborative experiment design

I proposed my collaborators to follow the chemistry of this experiment, and transfer it to a microfluidic system.

Over a period of 2 months, I held weekly meetings with Assistant Professor Regina Lutge, in which we discuss the mineralising reaction conditions and perfected the microfluidic prototype design.

Regina also tested in her lab and demonstrated the workings of the self-pumping liquid and air system proposed in the final design.





The device takes advantage of micro-fluidic precision to maximise the material conversion efficiency

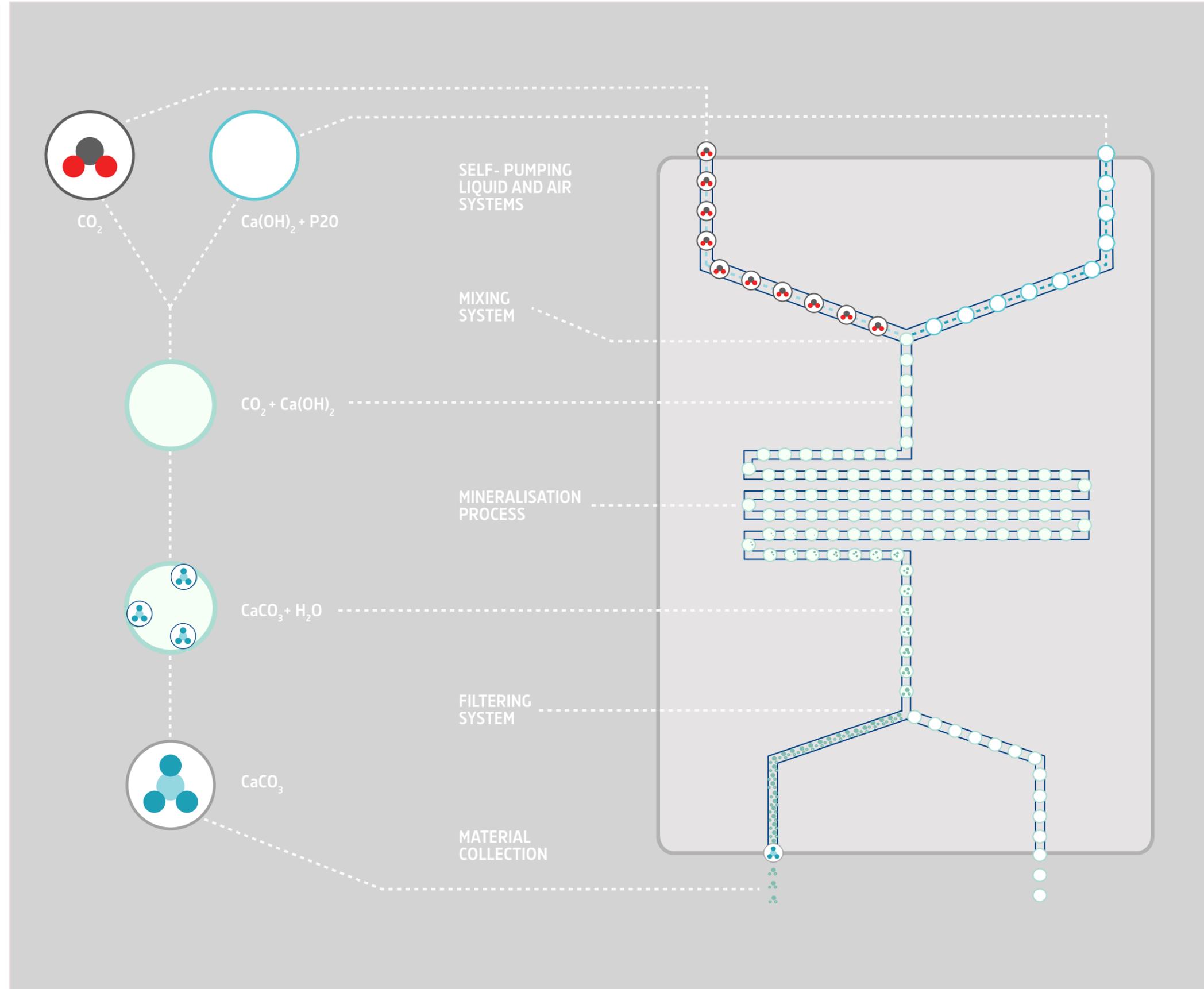
3 Proof of concept prototype

We designed an energy-efficient, self-propelled microfluidic device that harnesses natural bio-mineralisation reactions.

The device captures CO₂ and transforms the particles in a safe material form through an engineered precipitation process.

The device aims to take advantage to the micro-fluidic precision to maximise the efficiency of the biochemical process.

The resulting material is the same material of marine shells, calcium carbonate, but obtained in perfect spherical forms that can be used for other purposes.



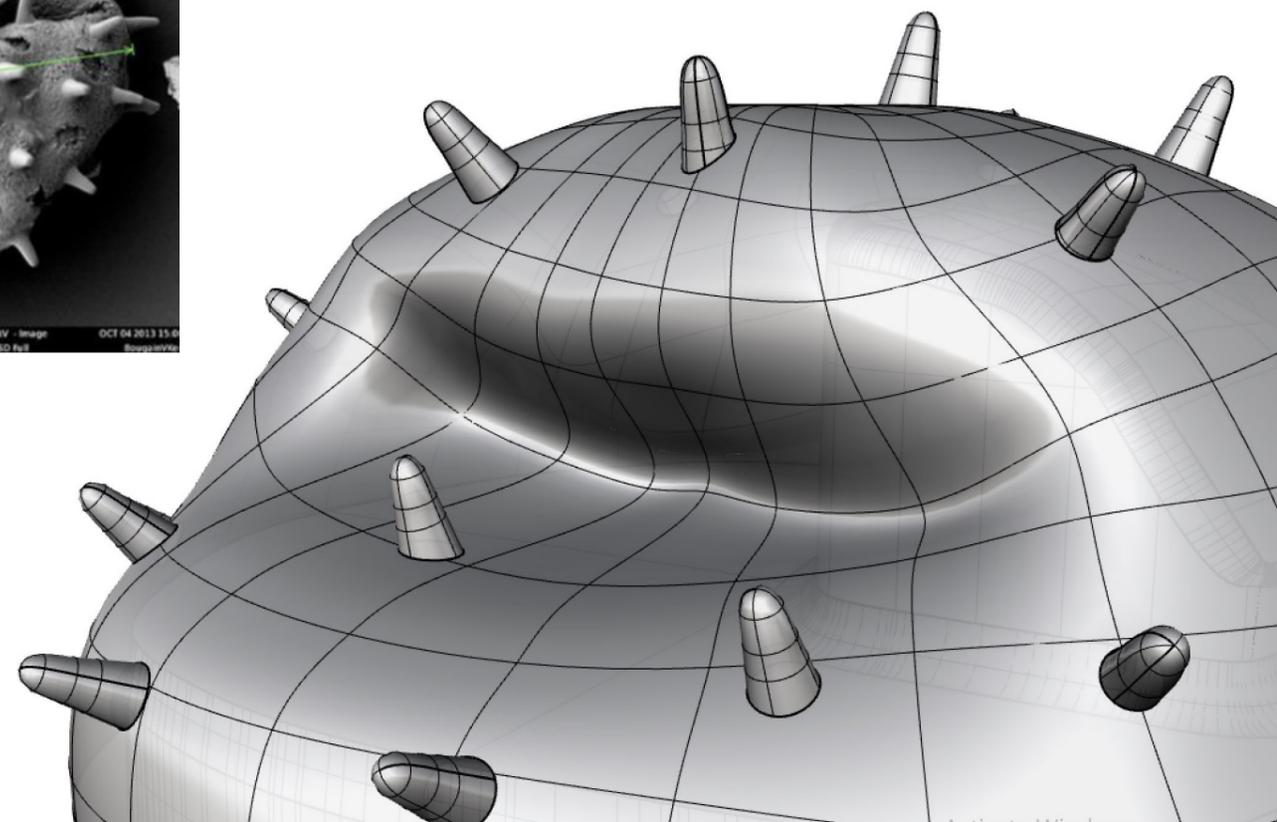
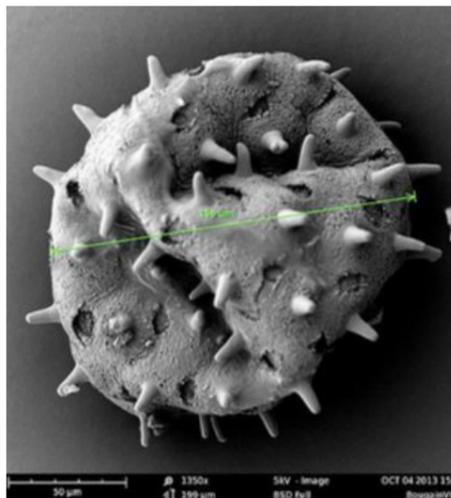
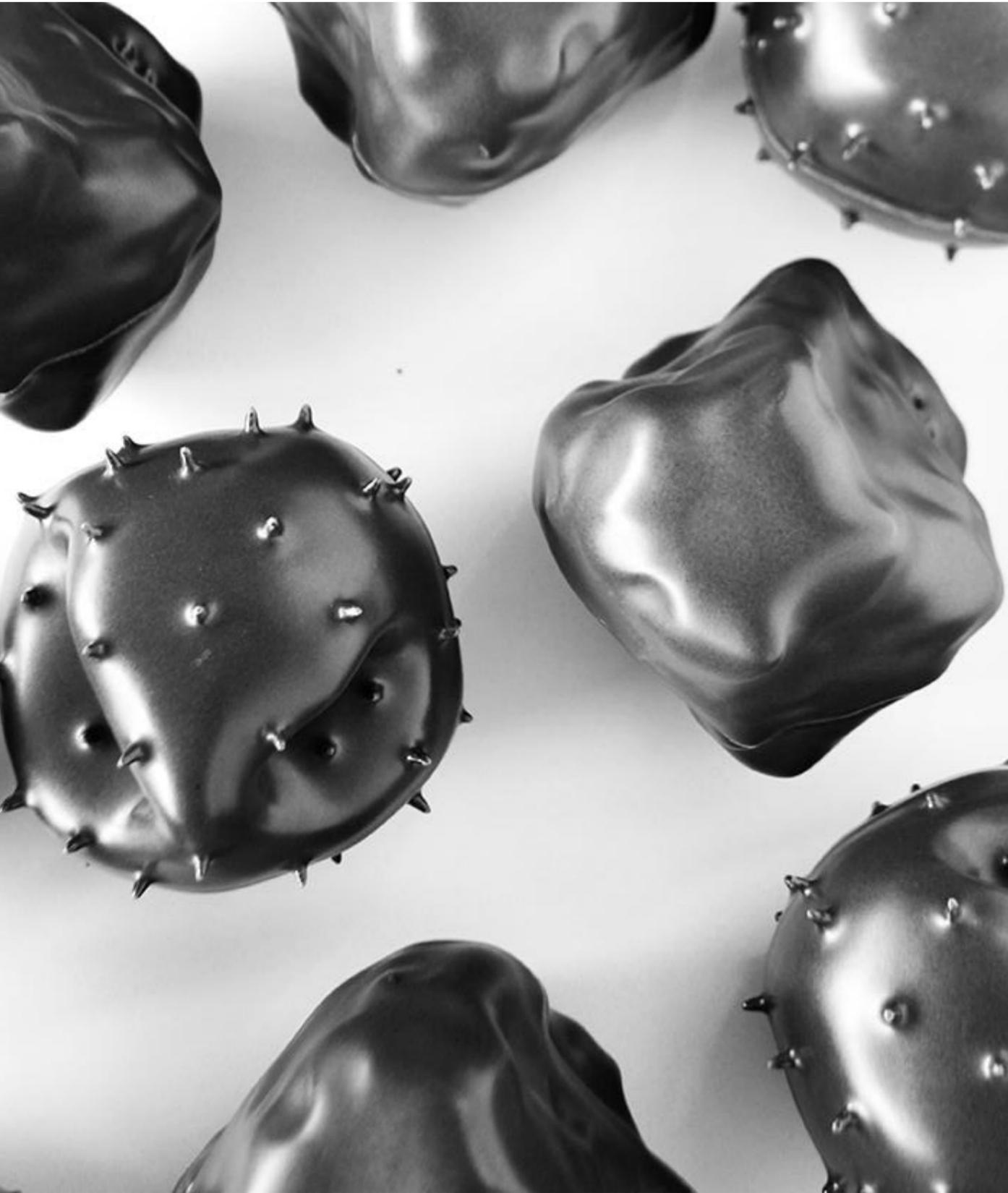
**INTERACTIVE
INSTALLATIONS**

**MATERIAL
EXPERIMENTATION**

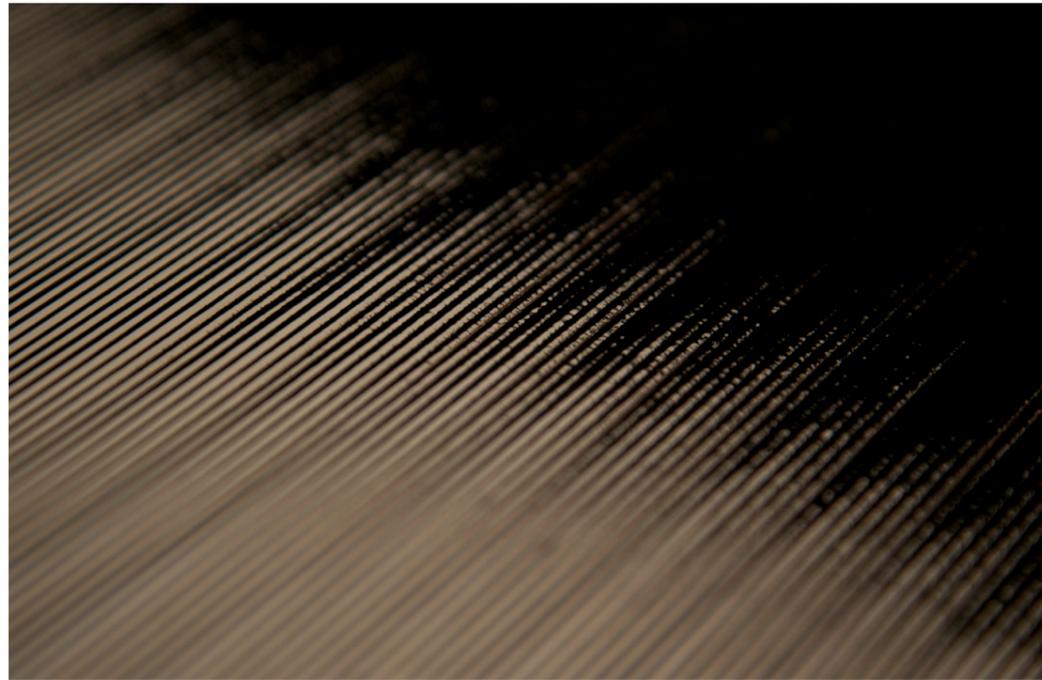
**DIGITAL
FABRICATION**

**TALKS
WORKSHOPS**

**PRODUCT
DEVELOPMENT**



PRODUCT DEVELOPMENT



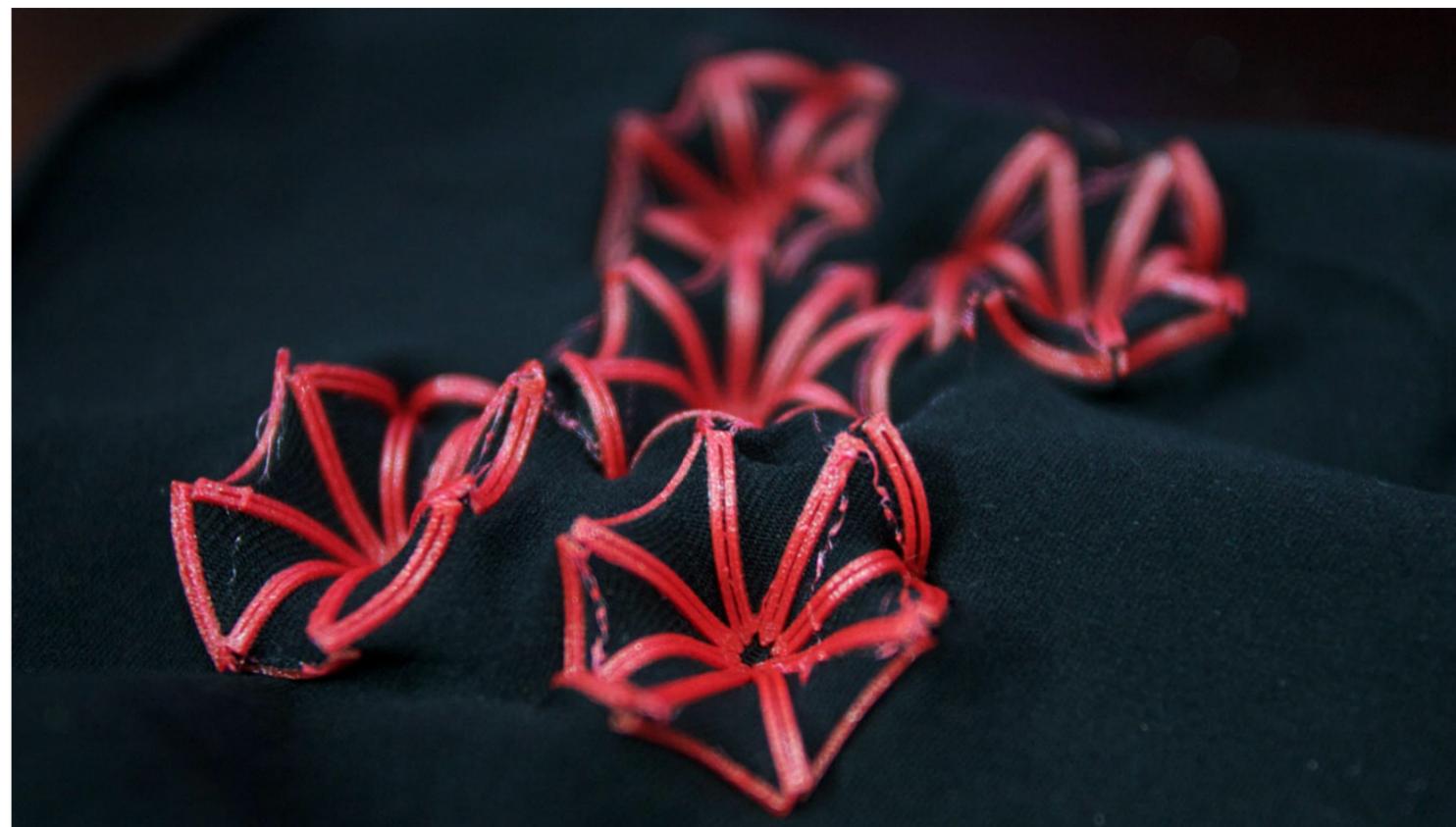
OUTLINES OF INEXISTENCE, 2015



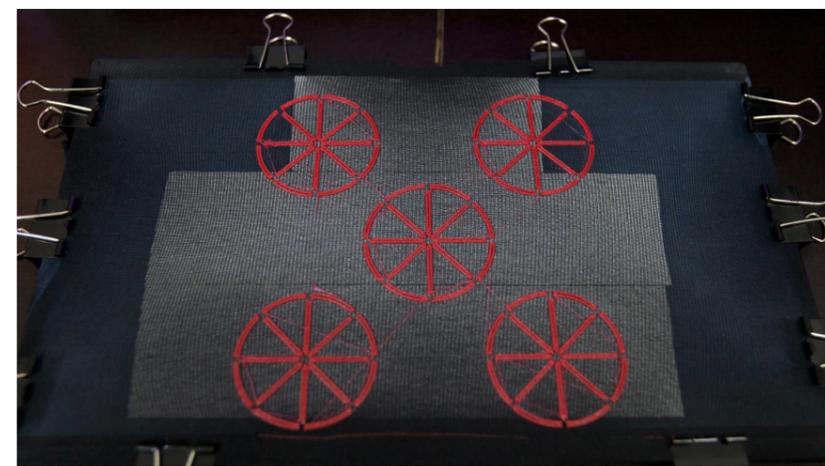
**MATERIAL
EXPERIMENTATION**

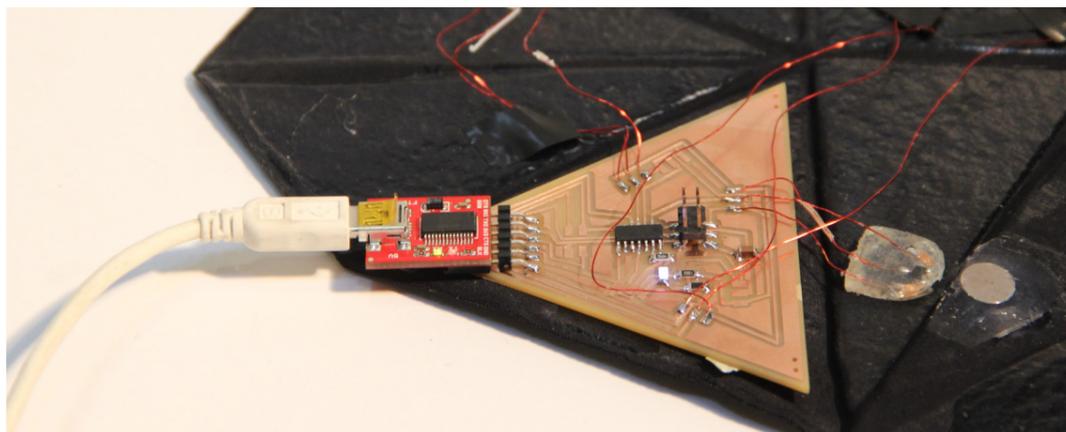
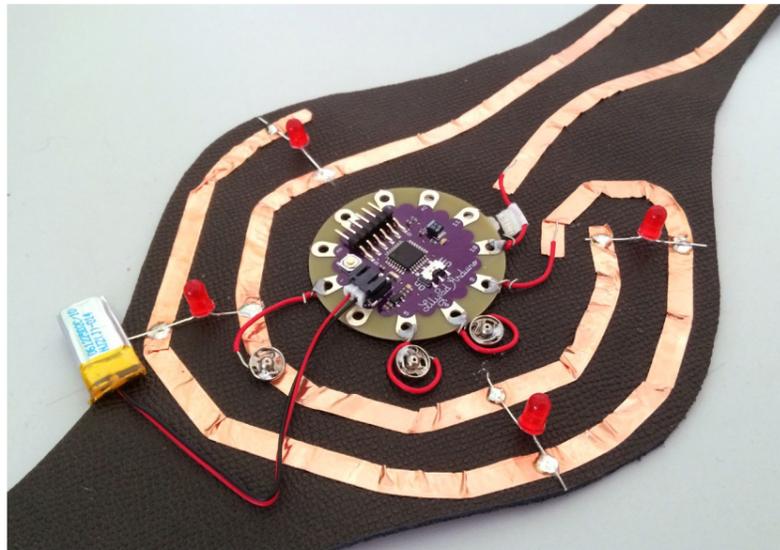
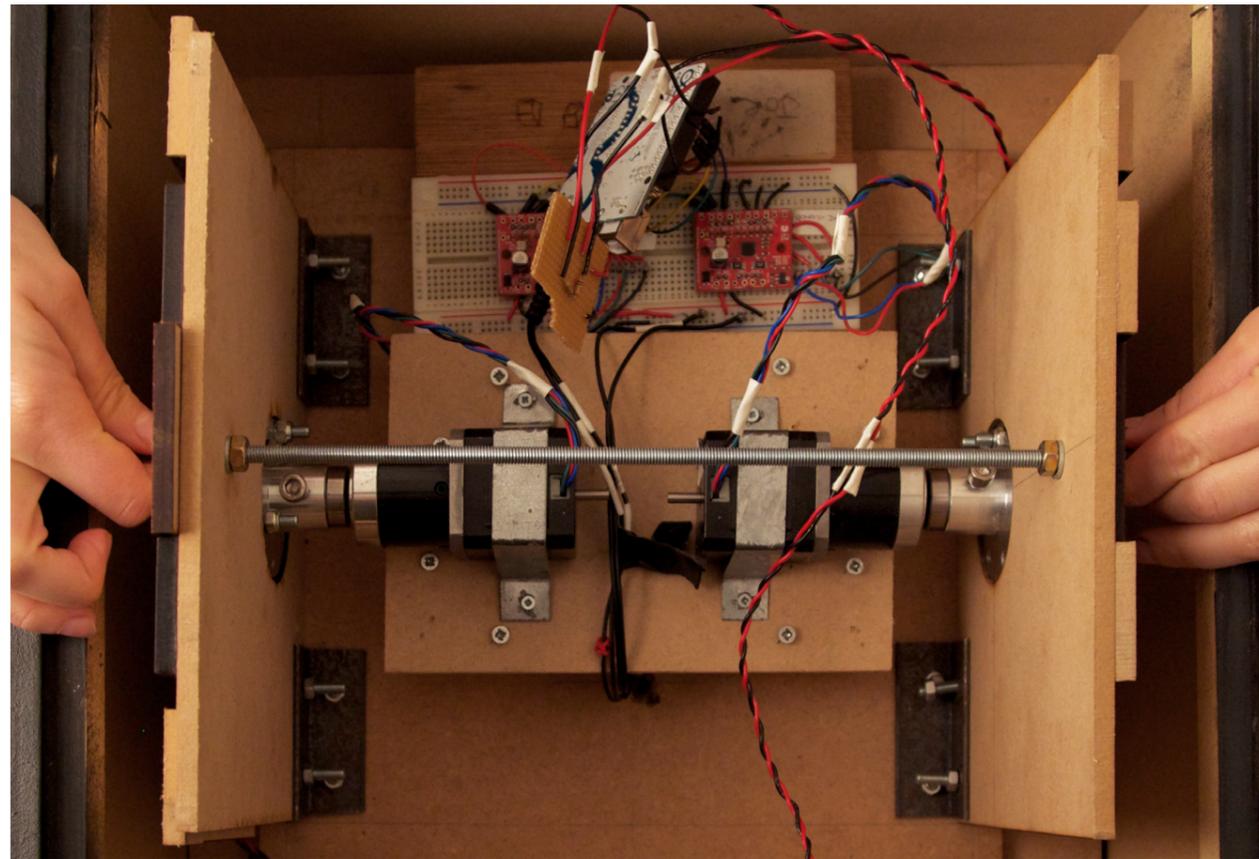


TEXTURAL GRAPHICS, 2014



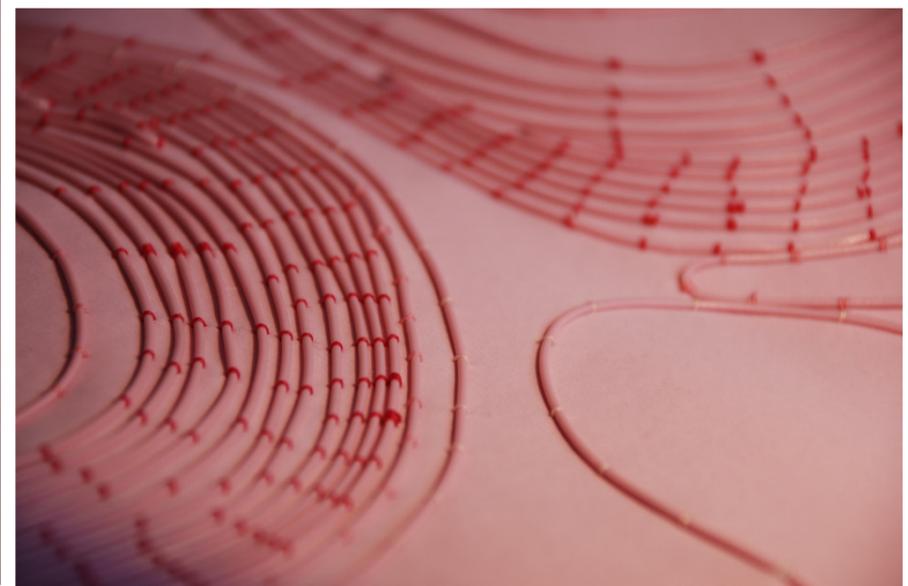
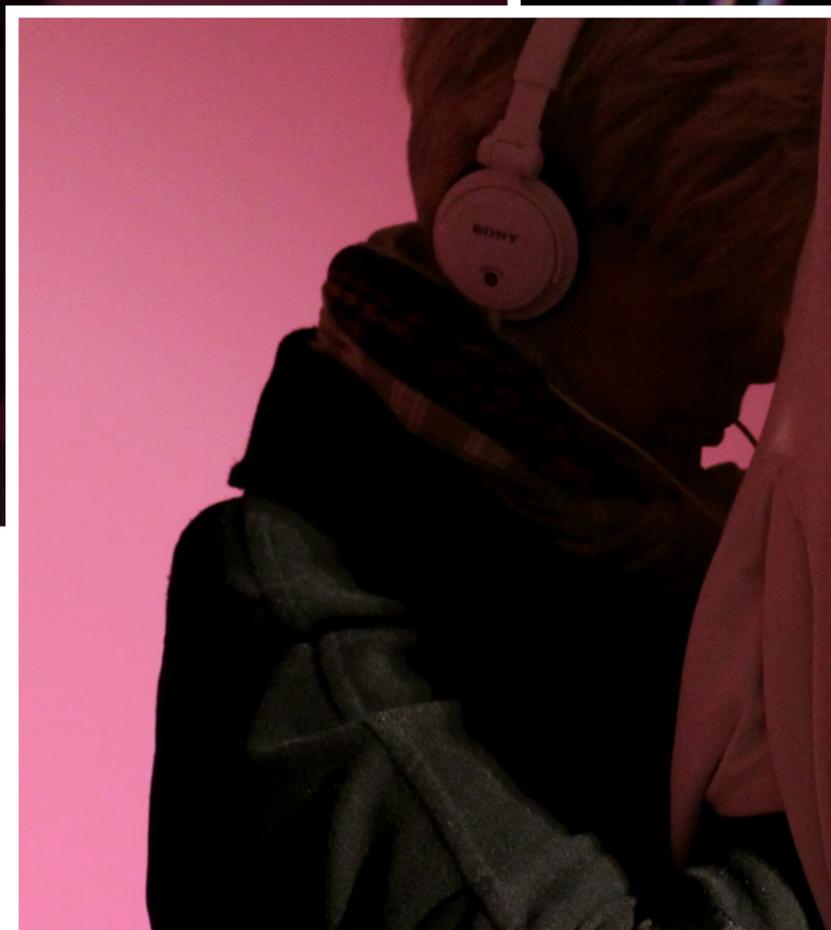
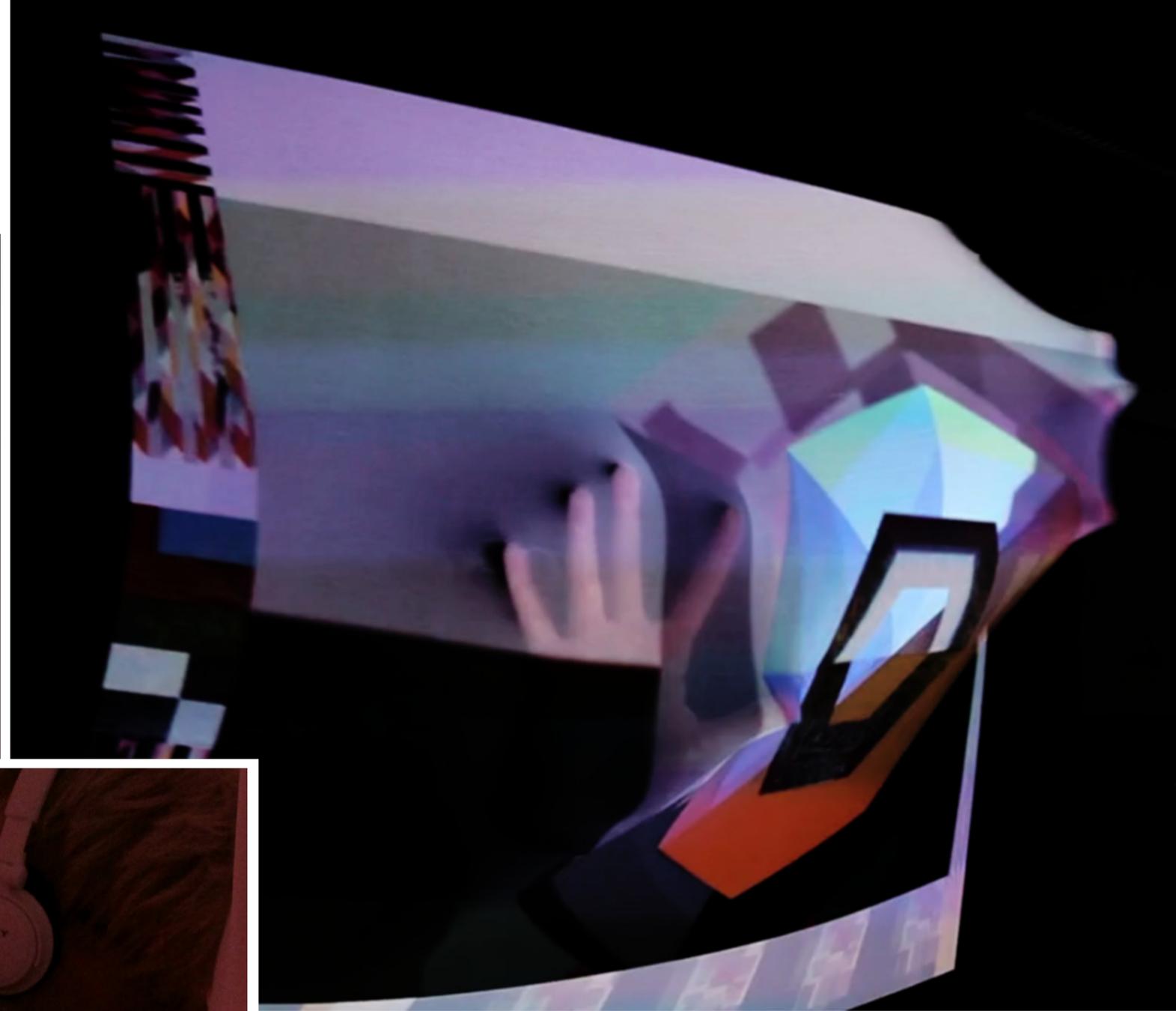
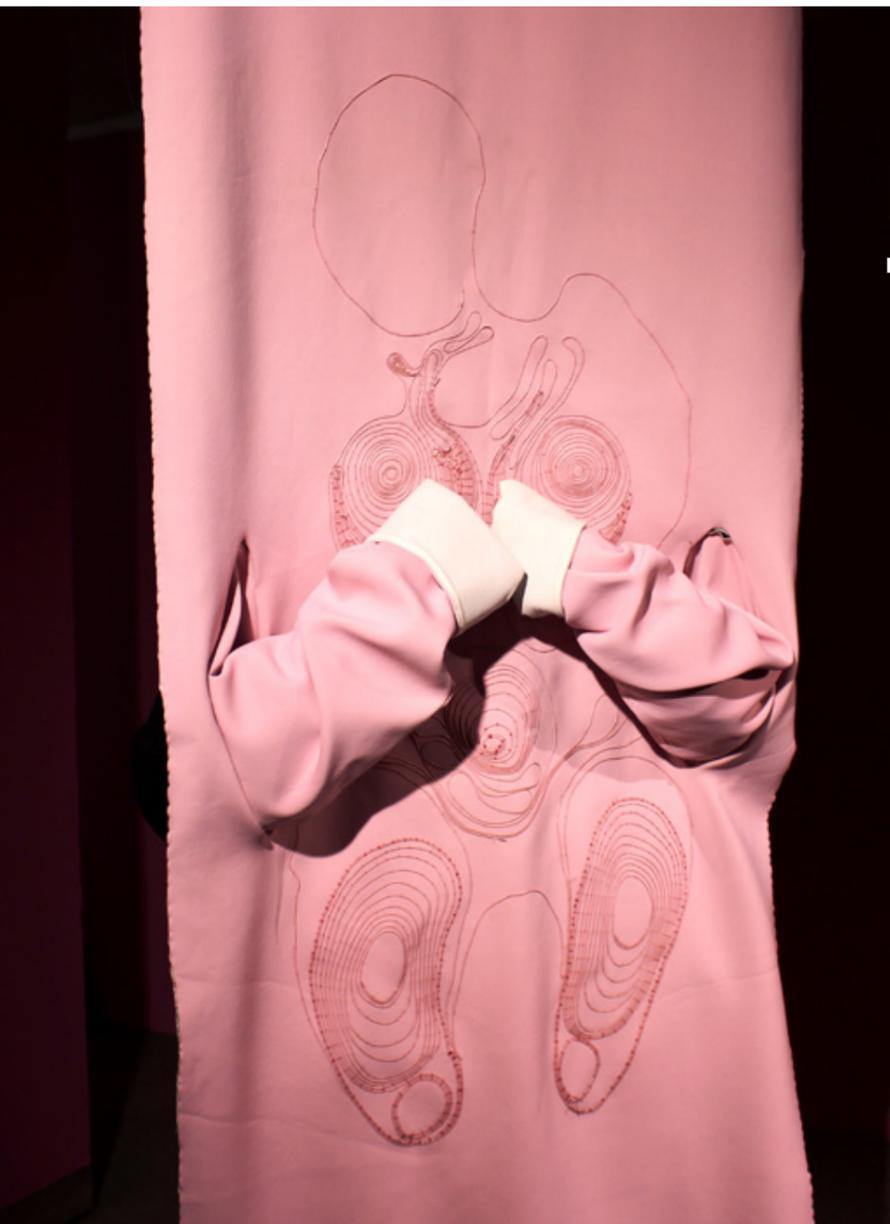
3D PRINTED TEXTILES, 2015





**DIGITAL
FABRICATION**

INTERACTIVE INSTALLATIONS



CRAFTING HUMAN PERCEPTION, 2012



TALKS & WORKSHOPS



SCHOOL OF CREATIVE MEDIA

活化廳
Workshop community Platform

FABLAB LONDON

ual:

KING'S College LONDON

SCIENCE GALLERY

**DESIGN
INNOVATION**

**MATERIAL
DRIVEN**

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