Ingeo™ 6752D

Polylactic Acid

NatureWorks® LLC

Message:

Ingeo biopolymer 6752D, a NatureWorks LLC product, is a thermoplastic fiber-grade resin derived from annually renewable resources. Available in pellet form, 6752D is designed for extrusion into mechanically drawn staple fibers using conventional fiber spinning and drawing equipment. Ingeo biopolymer 6752D can be converted into a broad range of un-dyed products. See table at right for typical properties.
Applications
Potential applications for Ingeo biopolymer 6752D include:
Non-woven (spunlace wipes)
Multi filament twine
Various bicomponent fibers

General Information	
Additive	Lubricant
Features	Comstable Updatable resources Lubrication Biodegradable Compliance of Food Exposure
Uses	Twine Non-woven fabric Filament Fiber
Agency Ratings	ASTM D 6400 EN 13432 FDA Food Exposure, Not Rated Europe 10/1/2011 12:00:00 AM European 2002/72/EC
Forms	Particle
Processing Method	Fiber (spinning) extrusion

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)	15	g/10 min	ASTM D1238
Contractility-Hot Air [1] (120°C)		%	ASTM D2102
Relative Viscosity	3.30		Internal method
modulus of elasticity	20.0 - 40.0	g/denier	ASTM D2256
Denier - per filament [2]	> 1.50		
Elongation of Fibers	10 - 70	%	ASTM D2256

Tenacity of Fibers	2.50 - 4.00	g/denier	ASTM D2256
Thermal	**Nominal Value**	**Unit**	**Test Method**
Glass Transition Temperature	55.0 - 60.0	°C	ASTM D3417
Peak Crystallization Temperature (DSC)	145 - 160	°C	ASTM D3418
Fill Analysis	**Nominal Value**	**Unit**	**Test Method**
Melt Density (230°C)	1.08	g/cm³	
Extrusion	**Nominal Value**	**Unit**	
Drying Temperature	70.0 - 80.0	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	< 5.0E-3	%	
Melt Temperature	220 - 240	°C	
Extrusion instructions			
L/D Ratio: 24:1 to 30:1Compression Ratio: 3:1			
NOTE			
1.	10 min		
2.	g/9000m		

Recommended distributors for this material

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