

Ingeo™ 3260HP

Polylactic Acid

NatureWorks® LLC

Message:

Ingeo 3260HP is a low viscosity product from NatureWorks, designed for high flow injection molding applications. It is designed to crystallize during processing, leading to higher heat deflection temperatures in opaque applications.

The variety of products made with 3260HP is widely varied and growing. Applications include disposables such as cutlery, cups, plates, cosmetic packaging, and durables such as electronics housings.

General Information			
Features	Low viscosity Crystallization Comstable Updatable resources Compliance of Food Exposure		
Uses	Cup Outdoor application Disposable tableware		
Agency Ratings	EU 94/62/EC FDA Food Exposure, Not Rated Europe 10/1/2011 12:00:00 AM		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)	65	g/10 min	ASTM D1238
Molding Shrinkage - Flow			
-- ¹	0.20 - 0.40	%	
-- ²	1.7 - 1.8	%	
Relative Viscosity ³ (30°C)	2.50		ASTM D5225
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ⁴ (Yield)	63.4	MPa	ASTM D638
Tensile Elongation			ASTM D638
Fracture ⁵	3.0	%	ASTM D638
Fracture ⁶	1.3	%	ASTM D638
Flexural Modulus			ASTM D790
-- ⁷	3590	MPa	ASTM D790
-- ⁸	4300	MPa	ASTM D790

Flexural Strength ⁹	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ¹⁰	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM E2092
0.45 MPa, not annealed ¹¹	56.0	°C	ASTM E2092
0.45 MPa, not annealed ¹²	151	°C	ASTM E2092
Peak Crystallization Temperature (DSC) ¹³	165 - 180	°C	ASTM D3418
Injection	Nominal Value	Unit	
Suggested Max Moisture	0.025	%	
Rear Temperature	175	°C	
Middle Temperature	185	°C	
Front Temperature	190	°C	
Nozzle Temperature	190	°C	
Processing (Melt) Temp	199	°C	
Mold Temperature	120	°C	
Back Pressure	1.72	MPa	
Screw Speed	200	rpm	

NOTE

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|-----|-------------------------------------|
| 1. | Amorphous, 26°C Mold Temperature |
| 2. | Crystalline, 120°C Mold Temperature |
| 3. | 1.0 g/dL in chloroform |
| 4. | Amorphous, 26°C Mold Temperature |
| 5. | Amorphous, 26°C Mold Temperature |
| 6. | Crystalline, 120°C Mold Temperature |
| 7. | Amorphous, 26°C Mold Temperature |
| 8. | Crystalline, 120°C Mold Temperature |
| 9. | Amorphous, 26°C Mold Temperature |
| 10. | Amorphous, 26°C Mold Temperature |
| 11. | Amorphous, 26°C Mold Temperature |
| 12. | Crystalline, 120°C Mold Temperature |
| 13. | Crystalline, 120°C Mold Temperature |

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