

# Ingeo™ 4060D

Polylactic Acid

NatureWorks® LLC

## Message:

Ingeo 4060D, a product from NatureWorks LLC, can be coextruded with other Ingeo resin to form a sealant layer for biaxially oriented Ingeo film. This resin has excellent heat seal and hot tack performance with a seal initiation temperature of 80°C. This sealant does not adversely affect the unique properties of Ingeo biaxially oriented film such as high gloss and transparency, dead-fold or aroma and grease barrier.

General Information			
Features	Highlight		
	Updatable resources		
	Good heat sealability		
	Grease resistance		
	Biodegradable		
	Compliance of Food Exposure		
	Bending and Twist Persistence		
Uses	Bi-axially Oriented Film		
	Sealant		
Agency Ratings	FDA Food Exposure, Not Rated		
	Europe 10/1/2011 12:00:00 AM		
Appearance	Clear/transparent		
Forms	Particle		
Processing Method	Co-extrusion molding		
Physical	Nominal Value	Unit	Test Method
Density	1.24	g/cm <sup>3</sup>	ASTM D1505
Films	Nominal Value	Unit	Test Method
Seal Initiation Temperature	80.0	°C	ASTM F88
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	55.0 - 60.0	°C	ASTM D3417
Optical	Nominal Value	Unit	Test Method
Gloss (20°)	90		ASTM D1003
Haze	2.0	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Drying Temperature	43.3	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.025	%	
Cylinder Zone 1 Temp.	179	°C	
Cylinder Zone 2 Temp.	191	°C	

Cylinder Zone 3 Temp.	199	°C
Adapter Temperature	199	°C
Melt Temperature	210	°C
Die Temperature	191	°C

Extrusion instructions

Screw Speed: 20-100 rpm

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material


## Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



WECHAT