

Ingeo™ 6302D

Polylactic Acid
NatureWorks® LLC

Message:

NatureWorks® PLA polymer 6302D, a NatureWorks LLC product, is an amorphous thermoplastic fiber-grade resin derived primarily from annually renewable resources. Available in pellet form, 6302D is designed for extrusion into mechanically drawn staple fibers using conventional fiber spinning and drawing equipment. NatureWorks® PLA 6302D can be used as a low melt binder polymer in a sheath-core configuration. Potential applications for PLA polymer 6302D include:
Thermal bonded nonwovens

General Information			
Features	Biodegradable		
	Compostable		
	Food Contact Acceptable		
	Renewable Resource Content		
Uses	Binder		
	Fabrics		
	Nonwovens		
	Staple Fibers		
	Textile Applications		
Agency Ratings	EU 10/2011		
	EU 2002/72/EC		
	FDA Food Contact, Unspecified Rating		
Forms	Pellets		
Processing Method	Fiber (Spinning) Extrusion		
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)	15 to 20	g/10 min	ASTM D1238
Relative Viscosity	3.00		Internal Method
Denier - per filament	> 4.00		
Elongation of Fibers	50	%	ASTM D2256
Tenacity of Fibers	3.50	g/denier	ASTM D2256
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	55.0 to 60.0	°C	ASTM D3417
Peak Crystallization Temperature (DSC)	125 to 135	°C	ASTM D3418
Fill Analysis	Nominal Value	Unit	Test Method
Melt Density (230°C)	1.08	g/cm ³	
Extrusion	Nominal Value	Unit	

Drying Temperature	40.0 to 50.0	°C
Drying Time	8.0 to 12	hr
Suggested Max Moisture	< 5.0E-3	%
Melt Temperature	220 to 240	°C

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