

Ingeo™ AW 300D

Polylactic Acid
NatureWorks® LLC

Message:

Ingeo biopolymer AW 300D, a NatureWorks LLC product, is a thermoplastic resin derived from annually renewable resources and is specifically designed for use in injection molded food serviceware applications.

This opaque, off-white molding grade creates parts that are rigid and heat resistant for tableware used with hot foods and drinks when injection molded using conventional chilled molds. Ingeo AW 300D is fully formulated to be used naturally, but may be blended with color compounds.

General Information			
Features	Comstable		
	Updatable resources		
	Heat resistance, medium		
	Medium hardness		
Uses	Cup		
	Food service sector		
	Disposable tableware		
Agency Ratings	ASTM D 6400		
	EN 13432		
	EU 94/62/EC		
Appearance	Opacity		
	White-like		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)	27	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 - 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus	2450	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	33	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	50.0	°C	ASTM D648
Vicat Softening Temperature	107	°C	ASTM D1525
Melting Temperature	170	°C	ASTM D3418

Injection	Nominal Value	Unit
Drying Temperature	50.0	°C
Drying Time	> 4.0	hr
Suggested Max Moisture	0.025	%
Nozzle Temperature	190 - 210	°C
Processing (Melt) Temp	190 - 210	°C
Mold Temperature	25.0	°C
Back Pressure	0.345 - 0.689	MPa
Screw Speed	100 - 200	rpm
Injection instructions		

Feed Throat: 20°C Feed Temp: 175-185°C Compression Section: 180-195°C Metering Section: 190-210°C

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