

# Ingeo™ AW 240D

Polylactic Acid

NatureWorks® LLC

## Message:

Ingeo biopolymer AW 240D, a NatureWorks LLC product, is a thermoplastic resin derived from annually renewable resources and is specifically designed for use in food service ware applications. Ingeo AW 240D is an opaque, off-white extrusion grade that is fully formulated to be used naturally, but may be blended with color compounds. This grade processes readily on conventional extrusion equipment, at low melt temperatures. Extruded roll stock is thermoformable.

| General Information |  |
|---------------------|--|
| Features            | Comstable<br>Updatable resources<br>Workability, good              |
| Uses                | Cup<br>Food service sector<br>Disposable tableware<br>Beverage lid |
| Agency Ratings      | ASTM D 6400<br>EN 13432<br>EU 94/62/EC                             |
| Appearance          | Opacity<br>White-like  |
| Forms               | Particle   |
| Processing Method   | Extrusion<br>Thermoforming   |

| Physical   | Nominal Value | Unit              | Test Method |
|--|---------------|-------------------|-------------|
| Specific Gravity   | 1.48          | g/cm <sup>3</sup> | ASTM D792   |
| Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)                | 6.0           | g/10 min          | ASTM D1238  |
| Mechanical   | Nominal Value | Unit              | Test Method |
| Flexural Modulus   | 1650          | MPa               | ASTM D790   |
| Thermal  | Nominal Value | Unit              | Test Method |
| Deflection Temperature Under Load (0.45 MPa, Unannealed) | 85.0          | °C                | ASTM D648   |
| Vicat Softening Temperature                              | 105           | °C                | ASTM D1525  |
| Extrusion  | Nominal Value | Unit              |             |
| Drying Temperature                                       | 50.0          | °C                |             |

|                        |       |    |
|------------------------|-------|----|
| Drying Time            | > 4.0 | hr |
| Suggested Max Moisture | 0.025 | %  |
| Adapter Temperature    | 185   | °C |
| Melt Temperature       | 185   | °C |
| Die Temperature        | 185   | °C |

#### Extrusion instructions

Feed Throat: 45°C Feed Temperature: 170°C Compression Section: 175°C Metering Section: 185°C Screw Speed: 20-100 rpm Screw L/D Ratio: 24:1 to 32:1 Compression Ratio: 2.5:1 to 3:1 These are starting points and may need to be optimized.

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