

# Ingeo™ 7032D

Poly(lactic Acid)

NatureWorks® LLC

## Message:

Ingeo biopolymer 7032D is a bottle grade resin designed for injection stretch blow molded applications where heat setting is needed. Ingeo biopolymer 7032D can be run on conventional and heat set ISBM equipment typically used for PET. Ingeo biopolymer 7032D is run at lower processing temperatures than PET.

Injection stretch blow molded bottles (ISBM) for single- and two-stage operations. Ideal for applications where heat setting is required, such as:

Fruit juices

Sports drinks

Oils, jams, non-beverage

General Information			
Features	Biodegradable		
	Food Contact Acceptable		
	Heat Sealable		
	High Clarity		
	Renewable Resource Content		
Uses	Bottles		
	Food Containers		
	Fruit Juice Bottles		
Agency Ratings	EU 10/2011		
	FDA Food Contact, Unspecified Rating		
Appearance	Clear/Transparent		
Forms	Pellets		
Processing Method	Injection Blow Molding		
	Stretch Blow Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.50	%	ASTM D955
Films	Nominal Value	Unit	Test Method
Carbon Dioxide Transmission Rate	2850	cm <sup>3</sup> /m <sup>2</sup> /24 hr	Internal Method
Oxygen Permeability	675	cm <sup>3</sup> /m <sup>2</sup> /24 hr	ASTM D1434
Water Vapor Transmission Rate	380	g · mm/m <sup>2</sup> /atm/24 hr	ASTM F1249
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	12.8 to 15.6	°C	ASTM D3417

Peak Crystallization Temperature (DSC)	155 to 170	°C	ASTM D3418
Injection	Nominal Value	Unit	
Drying Temperature	65.0 to 85.0	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.010	%	
Rear Temperature	180	°C	
Middle Temperature	210	°C	
Nozzle Temperature	210 to 220	°C	
Processing (Melt) Temp	200 to 220	°C	
Mold Temperature	21.0 to 38.0	°C	
Back Pressure	0.689 to 1.38	MPa	

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### 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

