Ingeo™ 4032D

Polylactic Acid

NatureWorks® LLC

Message:

Ingeo 4032D can be converted into a biaxially oriented film with use temperatures up to 300°F (150°C). This film has excellent optics, good machinability and excellent twist and deadfold. These properties make 4032D film an ideal product for laminations and other packaging applications. Additional properties include barrier to flavor and grease and oil resistance.

General Information				
Easturas	Ontical			
reatures				
	Machinable			
	Oil resistance			
	Grease resistance			
	Biodegradable			
	Bending and Twist Persistence			
Uses	Bi-axially Oriented Film			
	Packaging			
	Laminate			
Agency Ratings	FDA Food Exposure, Not Rated			
	Europe 10/1/2011 12:00:00 AM			
Forms	Particle			
Processing Method	Film extrusion			
	Extrusion			
Physical	Nominal Value	Unit	Test Method	
Density	1.24	g/cm³	ASTM D1505	
Films	Nominal Value	Unit	Test Method	
Film Thickness - Tested	25	μm		
secant modulus			ASTM D882	
MD : 25 μm	3450	MPa	ASTM D882	
TD : 25 μm	3790	MPa	ASTM D882	
Tensile Strength			ASTM D882	
MD: Yield, 25 µm	103	MPa	ASTM D882	
TD: Yield, 25 μm	145	MPa	ASTM D882	
Tensile Elongation			ASTM D882	
MD: Break, 25 µm	180	%	ASTM D882	
TD: Break, 25 µm	100	%	ASTM D882	

Elmendorf Tear Strength			ASTM D1922
MD : 25 μm	17	g	ASTM D1922
TD : 25 μm	14	g	ASTM D1922
Carbon Dioxide Transmission Rate	2850	cm³/m²/24 hr	Internal method
Oxygen Permeability	675	cm³/m²/24 hr	ASTM D1434
Water Vapor Transmission Rate	380	g·mm/m²/atm/24 hr	ASTM F1249
Spencer Impact	2.50	J	
Thermal	Nominal Value	Unit	Test Method
Peak Crystallization Temperature (DSC)	155 - 170	°C	ASTM D3418
Optical	Nominal Value	Unit	Test Method
Gloss (20°, 25.4 μm)	90		ASTM D2457
Haze (25.4 µm)	2.1	%	ASTM D1003
Extrusion	Nominal Value	Unit	
Drying Temperature	79.4	°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	202 - 218	°C	
Die Temperature	199	°C	
Extrusion instructions			

Screw Speed 20-100 rpm

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