

# Ingeo™ 6060D

Poly(lactic Acid)

NatureWorks® LLC

## Message:

Ingeo biopolymer 6060D, a NatureWorks product, is an amorphous thermoplastic fiber-grade resin derived primarily from annually renewable resources. Available in pellet form, 6060D is designed for extrusion into mechanically drawn staple fibers using conventional fiber spinning and drawing equipment. Ingeo biopolymer 6060D can be used as a low melt binder polymer in a sheath-core configuration. Potential applications for Ingeo biopolymer 6060D include:  
Thermal bonded nonwovens

General Information			
Features	Biodegradable		
	Compostable		
	Food Contact Acceptable		
	Renewable Resource Content		
Uses	Binder		
	Nonwovens		
	Staple Fibers		
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 <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)	8.0 to 10	g/10 min	ASTM D1238
Relative Viscosity	3.30		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 <sup>3</sup>	
Extrusion	Nominal Value	Unit	
Drying Temperature	40.0	°C	
Drying Time	8.0 to 12	hr	

Suggested Max Moisture	< 5.0E-3	%
Melt Temperature	220 to 240	°C

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#### Recommended distributors for this material

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