

# Ingeo™ 6361D

Polylactic Acid

NatureWorks® LLC

## Message:

Ingeo biopolymer 6361D, a NatureWorks LLC product, is a thermoplastic fiber-grade resin derived from annually renewable resources. Available in pellet form, 6361D is designed for specialty fiber products where an amorphous structure is desired. Ingeo biopolymer 6361D can be converted into a broad range of fiber products.

Potential applications for Ingeo biopolymer 6361D include:

Low melt binder fibers/sheath

Low melt coatings

Dissolvable / sacrificial fiber components

General Information			
Features	Comstable		
	Updatable resources		
	Biodegradable		
	Compliance of Food Exposure		
Uses	staple fiber		
	Coating application		
	Fiber		
	Adhesive		
Agency Ratings	ASTM D 6400		
	EEC 94/62/EC Article 11		
	EN 13432		
	FDA Food Exposure, Not Rated		
	Europe 10/1/2011 12:00:00 AM		
	European 2002/72/EC		
Forms	Particle		
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)	70 - 85	g/10 min	ASTM D1238
Relative Viscosity	2.5		Internal method
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	55.0 - 60.0	°C	ASTM D3417
Peak Crystallization Temperature (DSC)	125 - 135	°C	ASTM D3418
Fill Analysis	Nominal Value	Unit	
Melt Density (230°C)	1.08	g/cm <sup>3</sup>	

Additional Information	Nominal Value	Unit
Denier - per filament <sup>1</sup>	1.00 - 2.00	
Extrusion	Nominal Value	Unit
Drying Temperature	40.0	°C
Drying Time	8.0 - 12	hr
Suggested Max Moisture	< 5.0E-3	%
Melt Temperature	220 - 245	°C
Extrusion instructions		
General-purpose screws with L/D ratios of 24:1 to 30:1 and 3:1 compression ratios are recommended.		
NOTE		
1.	g/9000m	

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#### Recommended distributors for this material

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