# Ingeo™ 6260D

### Polylactic Acid

NatureWorks® LLC

#### Message:

Ingeo biopolymer 6260D, a NatureWorks product, is a thermoplastic fiber-grade resin derived primarily from annually renewable resources. Available in pellet form, 6260D is designed for melt blown fiber processing or extrusion into mechanically drawn staple fibers, using conventional fiber spinning and drawing equipment. 6260D is well suited for fiber processes where low boiling water fiber shrinkage and higher dimensional stability is required, in addition to low extrusion pressure. Ingeo biopolymer 6260D can be converted into a broad range of fiber products. Potential applications for Ingeo biopolymer 6260D include: Melt blown fiber Staple fiber Nonwovens Agricultural woven and nonwoven fabrics Articles for household disposal Textiles Spunbond fabrics

General Information			
Features	High Dimensional Stability		
	Comstable		
	Updatable resources		
	Compliance of Food Exposure		
Uses	Meltblown Nonwovens		
	staple fiber		
	Spunbond nonwoven fabric		
	Agricultural application		
	Non-woven fabric		
	Fiber		
Agency Ratings	FDA Food Exposure, Not Rated		
	Europe 10/1/2011 12:00:00 AM		
Forms	Particle		
Processing Method	Meltblown Nonwovens		
	Fiber (spinning) extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (210°C/2.16			
kg)	65	g/10 min	ASTM D1238
Relative Viscosity <sup>1</sup> (30°C)	2.50		ASTM D5225
Tensile Elongation <sup>2</sup>	10 - 70	%	ASTM D2256
Hot air contraction-10 min <sup>3</sup> (130°C)	4.00 - 5.00		ASTM D2101

Boiling Water Shrinkage <sup>4</sup>	3.0 - 4.0	%	ASTM D2102
Denier per Filament <sup>5</sup>	> 0.500	dpf	
Modulus <sup>6</sup>	30.0 - 55.0	g/denier	ASTM D2256
Tenacity <sup>7</sup>	2.00 - 4.00	g/denier	ASTM D2256
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	55.0 - 60.0	°C	ASTM D3418
Peak Crystallization Temperature (DSC)	165 - 180	°C	ASTM D3418
Fill Analysis	Nominal Value	Unit	Test Method
Melt Density (210°C)	1.08	g/cm³	
Extrusion	Nominal Value	Unit	
Drying Temperature	80	°C	
Drying Time	4.0 - 6.0	hr	
NOTE			
1.	41.0 g/dL in chloroform		
	Spun at 225°C melt temp at 1500		
2.	at 150°C		
	Spun at 225°C melt temp at 1500		
3	mpm, drawn 2.7x at 95°C, heat set at 150°C		
	Spun at 225°C melt temp at 1500		
	mpm, drawn 2.7x at 95°C, heat set		
4.	at 150°C		
	g/9000m , Spun at 225°C melt temp at 1500 mpm, drawn 2 7x at		
5.	95°C, heat set at 150°C		
	Spun at 225°C melt temp at 1500		
6.	mpm, drawn 2.7x at 95°C, heat set at 150°C		
	Spun at 225°C melt temp at 1500		
_	mpm, drawn 2.7x at 95°C, heat set		
7.	at 150°C		

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