

Ingeo™ 3251D

Poly(lactic Acid)
NatureWorks® LLC

Message:

Ingeo biopolymer 3251D is designed for injection molding applications. This polymer grade has a higher melt flow capability than other Ingeo resin grades currently in the marketplace. The higher flow capability allows for easier molding of thin-walled parts. It is designed for injection molding applications, both clear and opaque, requiring high gloss, UV resistance and stiffness.

General Information			
Features	Biodegradable		
	Compostable		
	Food Contact Acceptable		
	Good Stiffness		
	Good UV Resistance		
	High Flow		
	High Gloss		
	Renewable Resource Content		
Uses	Thin-walled Parts		
Agency Ratings	ASTM D 6400		
	EN 13432		
	EU 10/2011		
	EU 94/62/EC		
	FDA Food Contact, Unspecified Rating		
Appearance	Clear/Transparent		
	Opaque		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
190°C/2.16 kg	35	g/10 min	
210°C/2.16 kg	80	g/10 min	
Molding Shrinkage - Flow	0.30 to 0.50	%	
Relative Viscosity	2.50		
Clarity	Transparent		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Tensile Elongation (Break)	3.5	%	ASTM D638

Flexural Strength	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	16	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	55.0 to 65.0	°C	ASTM D3417
Peak Crystallization Temperature (DSC)	155 to 170	°C	ASTM D3418
Injection	Nominal Value	Unit	
Suggested Max Moisture	< 0.010	%	
Rear Temperature	166 to 177	°C	
Middle Temperature	182 to 193	°C	
Front Temperature	188 to 205	°C	
Nozzle Temperature	188 to 205	°C	
Processing (Melt) Temp	188 to 210	°C	
Mold Temperature	25.0	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	100 to 200	rpm	

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