

Ingeo™ 3001D

Polylactic Acid
NatureWorks® LLC

Message:

Ingeo 3001D is a product from NatureWorks LLC. The biopolymer, is designed for injection molding applications. It is designed for clear applications with heat deflection temperatures lower than 120°F (49°C).
The variety of products made with 3001D is growing every day. Applications include cutlery, cups, plates, cosmetics, and outdoor novelties.

General Information			
Features	Biodegradable		
	Crystalline		
	High Clarity		
	Renewable Resource Content		
Uses	Cosmetics		
	Cups		
	Disposable Tableware		
	Outdoor Applications		
Agency Ratings	EU 10/2011		
	FDA Food Contact, Unspecified Rating		
Appearance	Clear/Transparent		
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) (210°C/2.16 kg)	22	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	62.1	MPa	ASTM D638
Tensile Elongation (Yield)	3.5	%	ASTM D638
Flexural Modulus	3550	MPa	ASTM D790
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
Heat Distortion	55	°C	ASTM E2092
Injection	Nominal Value	Unit	
Suggested Max Moisture	0.025	%	

Rear Temperature	149 to 166	°C
Middle Temperature	193	°C
Front Temperature	204	°C
Nozzle Temperature	204	°C
Processing (Melt) Temp	199	°C
Mold Temperature	23.9	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	100 to 175	rpm

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