

Ingeo™ 6202D

Polylactic Acid
NatureWorks® LLC

Message:

NatureWorks® PLA polymer 6202D, a NatureWorks LLC product, is a thermoplastic fiber-grade resin derived primarily from annually renewable resources. Available in pellet form, 6202D is designed for extrusion into mechanically drawn staple fibers using conventional fiber spinning and drawing equipment. NatureWorks® PLA 6202D can be converted into a broad range of fiber products and is recommended for non-dyed fiber applications. Potential applications for PLA polymer 6202D include:

- Fiberfill
- Non-wovens
- Agricultural woven and nonwoven fabrics
- Articles for household disposal

General Information			
Features	Biodegradable		
	Compostable		
	Food Contact Acceptable		
	Renewable Resource Content		
Uses	Fabrics		
	Household Goods		
	Staple Fibers		
	Textile Applications		
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 ³	ASTM D792
Melt Mass-Flow Rate (MFR) (210°C/2.16 kg)	15 to 30	g/10 min	ASTM D1238
Relative Viscosity	3.10		Internal Method
Shrinkage - Hot Air ¹ (130°C)	< 8.0	%	ASTM D2102
Modulus of Elasticity	30.0 to 40.0	g/denier	ASTM D2256
Denier - per filament	> 0.500		
Elongation of Fibers	10 to 70	%	ASTM D2256
Tenacity of Fibers	2.50 to 5.00	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)	155 to 170	°C	ASTM D3418

Fill Analysis	Nominal Value	Unit	Test Method
Melt Density (230°C)	1.08	g/cm ³	
Extrusion	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 5.0E-3	%	
Melt Temperature	220 to 240	°C	
NOTE			
1.	10 min		

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

