

Ingeo™ 2003D

Polylactic Acid

NatureWorks® LLC

Message:

Ingeo biopolymer 2003D, a NatureWorks LLC product, is a thermoplastic resin derived from annually renewable resources and is specifically designed for use in fresh food packaging and food service ware applications. Ingeo biopolymer 2003D is a transparent general purpose extrusion grade that is used naturally or as part of a formulated blend. This is a high molecular weight biopolymer grade that processes easily on conventional extrusion equipment. Extruded roll stock is readily thermoformable.

Applications

Potential applications for Ingeo biopolymer 2003D include:

Dairy containers

Food service ware

Transparent food containers

Hinged-ware

Cold drink cups

General Information	
Features	High molecular weight Comstable Updatable resources Definition, high Biodegradable Compliance of Food Exposure
Uses	Cup Container Food packaging Food service sector Food container General
Agency Ratings	ASTM D 6400 EN 13432 FDA Food Exposure, Not Rated Europe 10/1/2011 12:00:00 AM
Appearance	Clear/transparent
Forms	Particle
Processing Method	Extrusion Thermoforming

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)	6.0	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Elastic Modulus - MD	3450	MPa	ASTM D882
Tensile Strength - MD			ASTM D882
Yield	60.0	MPa	ASTM D882
Fracture	53.1	MPa	ASTM D882
Tensile Elongation - MD (Break)	6.0	%	ASTM D882
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	16	J/m	ASTM D256
Optical	Nominal Value		
Clarity	Transparent		
Extrusion	Nominal Value	Unit	
Drying Temperature	90.6	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	< 0.025	%	
Hopper Temperature	45.0	°C	
Cylinder Zone 1 Temp.	179	°C	
Cylinder Zone 2 Temp.	191	°C	
Cylinder Zone 3 Temp.	199	°C	
Adapter Temperature	199	°C	
Melt Temperature	210	°C	
Die Temperature	191	°C	
Extrusion instructions			

Screw Speed: 20-100 rpm

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