

Ingeo™ Biopolymer 6201D Technical Data Sheet

Fiber Melt Spinning

Ingeo biopolymer 6201D, a NatureWorks LLC product, is a thermoplastic fiber-grade resin derived primarily from annually renewable resources. Available in pellet form, 6201D is designed for extrusion into mechanically drawn staple fibers or continuous filament, using conventional fiber spinning and drawing equipment. 6201D is typically well suited for fiber processes where lower fiber shrinkage is desired: partially orientated yarn (POY), fully drawn yarn (FDY), staple fibers, and continuous filament. Ingeo biopolymer 6201D can be converted into a broad range of fiber products. See table at right for typical properties.

Typical Material & Application Properties ¹		
Physical Properties	Ingeo 6201D	ASTM Method
Specific Gravity	1.24	D792
Relative Viscosity	3.1	CD Internal Viscotek Method
Melt Index, g/10 min (210°C)	15-30	D1238
Melt Density (230°C)	1.08	
Glass Transition Temperature (°C)	55-60	D3417
Crystalline Melt Temperature (°C)	155-170	D3418
Typical Fiber Properties		
Denier per Filament	≥0.5 dpf	g/9000 m
Tenacity (g/d)	2.5-5.0	D2256/D3822
Elongation (%)	10-70	D2256/D3822
Modulus (g/d)	30-40	D2256-D3822
Boiling Water Shrinkage (%)	5-15	D2102
Hot Air Shrinkage (%) (130°C, 10 min)	5-15	D2102

(1) Typical properties; not to be construed as specifications.

Applications

Potential applications for Ingeo biopolymer 6201D include:

- Woven and knitted 100% continuous filament apparel
- Woven and knitted, intimate
- Staple blend fabrics including blends with cotton, wool, and other fibers
- Woven and knitted fabrics and netting for civil engineering applications
- Home furnishings

Processing Information

Ingeo 6201D grade will process on conventional extrusion spinning and drawing equipment with thorough cleaning since PLA is not compatible with a wide variety of polymers.

Machine Configuration

General-purpose screws with L/D ratios of 24:1 to 30:1 and 3:1 compression ratios are recommended.

However, screws with mixing sections or shallow metering channels may overheat the melt at high screw

speeds. Typical melt spinning temperatures are 220-240°C. Like PET, Ingeo 6201D requires either high filament velocity or drawing and controlled heat setting to control shrinkage.

Drying

In-line drying capabilities are essential to process Ingeo biopolymer 6201D, which is supplied with moisture content of less than 0.040% (400 ppm). The recommended moisture content to prevent viscosity degradation and potential loss of properties is less than 0.005% (50 ppm). Typical drying conditions are 4-6 hours at 80°C [176°F] or to a dew point of -35°C [-30°F], with an airflow rate of greater than 0.5 cfm/lbs per hour of resin throughput. To prevent moisture regain, the resin should not be exposed to atmospheric conditions after drying.

Compostability

Composting is a method of waste disposal that allows organic materials to be recycled into a product that can

be used as a valuable soil amendment. Ingeo biopolymer is made of polylactic acid, a repeating chain of lactic acid, which undergoes a 2-step degradation process. First, the moisture and heat in the compost pile attack the polymer chains and split them apart, creating smaller polymers, and finally, lactic acid. Microorganisms in compost and soil consume the smaller polymer fragments and lactic acid as nutrients. Since lactic acid is widely found in nature, a large number of organisms metabolize lactic acid. At a minimum, fungi and bacteria participate in this degradation process. The end result of the process is carbon dioxide, water and also humus, a soil nutrient. This degradation process is temperature and humidity dependent. Regulatory guidelines and standards for composting revolve around four basic criteria: Material Characteristics, Biodegradation, Disintegration, and Ecotoxicity. Description of the requirements of these testing can be found in the appropriate geographical area: DIN V 54900-1 (Germany), EN 13432 (EU), ASTM D 6400 (USA), GreenPla (Japan).

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This grade of Ingeo biopolymer (in its resin form) does meet the requirements of these four standards however; it does not currently have certification due to the number of fiber production and downstream processes that can have a significant impact on final fabric performance. Such variables include, but are not limited to, specific fiber geometry, additives incorporated into the fiber, surface treatments and lubricants as well as final fabric/article physical construction.

Please remember it is the responsibility of the end producer to test and certify their final products regardless if the raw material is certified. Should you need further clarification, please do not hesitate to contact NatureWorks LLC.

Food Packaging Status

U.S. Status

On January 3, 2002 FCN 000178 submitted by NatureWorks LLC to FDA became effective. This effective notification is part of list currently maintained on FDA's website at

<http://www.fda.gov/food/ingredientpackaginglabeling/packagingfcs/notifications/default.htm>

This grade of Ingeo biopolymer may therefore be used in food packaging materials and, as such, is a permitted component of such materials pursuant to section 201(s) of the Federal, Drug, and Cosmetic Act, and Parts 182, 184, and 186 of the Food Additive Regulations. All additives and adjuncts contained in the referenced Ingeo biopolymer formulation meet the applicable sections of the Federal Food, Drug, and Cosmetic Act. The finished polymer is approved for all food types and B-H use conditions.

Migration testing for this product was done using rolled sheet with an approximate thickness of 0.020 inches. Depending on the application, the surface area of a fiber article may

differ from the sheet sample tested. It is therefore the responsibility of the manufacturer of the finished food-contact article to determine that the use of a product is safe, lawful, and technically suitable for the intended application. We urge all of our customers to perform GMP (Good Manufacturing Procedures) when constructing a package so that it is suitable for the end use. For any application, should you need further clarification, please do not hesitate to contact NatureWorks LLC.

European Status

This grade of Ingeo biopolymer complies with Regulation 10/2011, which applies to all EU member states. Substances used in the manufacturing of this product which are not yet regulated by EU Plastics Directive 2002/72/EC, as amended, are in compliance with appropriate EU national regulations. No SML's for the above referenced grade exist in Regulation 10/2011. NatureWorks LLC would like to draw your attention to the fact that 10/2011, which applies to all EU-Member States, includes a limit of 10 mg/dm² of the overall migration from finished plastic articles into food. In accordance with Regulation 10/2011 the migration should be measured on finished articles placed into contact with the foodstuff or appropriate food simulants for a period and at a temperature which are chosen by reference to the contact conditions in actual use, according to the rules laid down 10/2011.

OML testing for this product was done using rolled sheet. Depending on the application, the surface area of a fiber article may differ from the sheet sample tested. While the above referenced NatureWorks LLC product is permitted by the listing of its components in Regulation 10/2011, the finished food-contact article must meet any applicable limitations and specifications described in that legislation.

This grade as supplied meets European Parliament and Council Directive 94/62/EC of 20 December 1994 on packaging and packaging waste heavy metal content as described in Article 11. It is recoverable in the form of material recycling, energy recovery, composting, and biodegradable per Annex II point 3, subject to the standards of the local community.

Please note that it is the responsibility of both the manufacturers of finished food contact articles as well as the industrial food packers to make sure that these articles in their actual use are in compliance with the imposed specific and overall migration requirements. Again, for any application, should you need further clarification, please do not hesitate to contact NatureWorks LLC.

Bulk Storage Recommendations

The resin silos recommended and used by NatureWorks LLC are designed to maintain dry air in the silo and to be isolated from the outside air. This design would be in contrast to an open, vented to atmosphere system that we understand to be a typical polystyrene resin silo. Key features that are added to a typical (example: polystyrene) resin silo to achieve this objective include a cyclone and rotary valve loading system and some pressure vessel relief valves. The dry air put to the system is sized to the resin flow rate out of the silo. Not too much dry air would be needed and there may be excess instrument air (-30°F dew point) available in the plant to meet the needs for dry air. Our estimate is 10 scfm for a 20,000 lb/hr rate resin usage. Typically, resin manufacturers specify aluminum or stainless steel silos for their own use and avoid epoxy-lined steel.

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Safety and Handling Considerations

Safety Data Sheets (SDS) for Ingeo biopolymers are available from NatureWorks LLC. SDS's are provided to help customers satisfy their own handling, safety, and disposal needs, and those that may be required by locally applicable health and safety regulations, such as OSHA (U.S.A.), MAK (Germany), or WHMIS (Canada). SDS's are updated regularly; therefore, please request and review the most current SDS before handling or using any product.

The following comments apply only to Ingeo biopolymers; additives and processing aids used in fabrication and other materials used in finishing steps have their own safe-use profile and must be investigated separately.

Hazards and Handling Precautions

Ingeo biopolymers have a very low degree of toxicity and, under normal conditions of use, should pose no unusual problems from incidental ingestion, or eye and skin contact. However, caution is advised when handling, storing, using, or disposing of these resins, and good housekeeping and controlling of dusts are necessary for safe handling of product. Workers should be protected from the possibility of contact with molten resin during fabrication. Handling and fabrication of resins can result in the generation of vapors and dusts that may cause irritation to eyes and the upper respiratory tract. In dusty atmospheres, use an approved dust respirator. Pellets or beads may present a slipping hazard. Good general ventilation of the polymer processing area is recommended. At temperatures exceeding the polymer melt temperature (typically 170°C), polymer can release fumes, which may contain fragments of the polymer, creating a potential to irritate eyes and mucous membranes. Good general ventilation should be sufficient for most conditions.

Local exhaust ventilation is recommended for melt operations. Use safety glasses if there is a potential for exposure to particles which could cause mechanical injury to the eye. If vapor exposure causes eye discomfort, use a full-face respirator. No other precautions other than clean, body-covering clothing should be needed for handling Ingeo biopolymers. Use gloves with insulation for thermal protection when exposure to the melt is localized.

Combustibility

Ingeo biopolymers will burn. Clear to white smoke is produced when product burns. Toxic fumes are released under conditions of incomplete combustion. Do not permit dust to accumulate. Dust layers can be ignited by spontaneous combustion or other ignition sources. When suspended in air, dust can pose an explosion hazard. Firefighters should wear positive-pressure, self-contained breathing apparatuses and full protective equipment. Water or water fog is the preferred extinguishing medium. Foam, alcohol-resistant foam, carbon dioxide or dry chemicals may also be used. Soak thoroughly with water to cool and prevent re-ignition.

Disposal

DO NOT DUMP INTO ANY SEWERS, ON THE GROUND, OR INTO ANY BODY OF WATER. For unused or uncontaminated material, the preferred options include recycling into the process or sending to an industrial composting facility, if available; otherwise, send to an incinerator or other thermal destruction device. For used or contaminated material, the disposal options remain the same, although additional evaluation is required. (For example, in the U.S.A., see 40 CFR, Part 261, "Identification and Listing of Hazardous Waste.") All disposal methods must be in compliance with Federal, State/Provincial, and local laws and regulations.

Environmental Concerns

Generally speaking, lost pellets are not a problem in the environment except under unusual circumstances when they enter the marine environment. They are benign in terms of their physical environmental impact, but if ingested by waterfowl or aquatic life, they may mechanically cause adverse effects. Spills should be minimized, and they should be cleaned up when they happen. Plastics should not be discarded into the ocean or any other body of water.

Product Stewardship

NatureWorks LLC has a fundamental duty to all those that make and use our products, and for the environment in which we live. This duty is the basis for our Product Stewardship philosophy, by which we assess the health and environmental information on our products and their intended use, then take appropriate steps to protect the environment and the health of our employees and the public.

Customer Notice

NatureWorks LLC encourages its customers and potential users of its products to review their applications for such products from the standpoint of human health and environmental quality. To help ensure our products are not used in ways for which they were not intended or tested, our personnel will assist customers in dealing with ecological and product safety considerations. Your sales representative can arrange the proper contacts. NatureWorks LLC literature, including Safety Data sheets, should be consulted prior to the use of the company's products. These are available from your NatureWorks LLC representative.

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