

NatureWorks® Ingeo™ 6204D Fiber Grade PLA

Category : Polymer , Renewable/Recycled Polymer , Thermoplastic , Polylactic Acid (PLA) Biopolymer

Material Notes:

NatureWorks® PLA polymer 6204D is a thermoplastic fiber-grade resin derived primarily from annually renewable resources. Available in pellet form, 6204D is designed for extrusion into mechanically drawn staple fibers or continuous filament, using conventional fiber spinning and drawing equipment. 6204D is typically well suited for fiber processes where deeper disperse dyeing in the final product is desired: partially orientated yarn (POY), fully drawn yarn (FDY), staple fibers, and continuous filament. NatureWorks® PLA 6204 can be converted into a broad range of fiber products. Potential applications for PLA polymer 6204D 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

Order this product through the following link:

http://www.lookpolymers.com/polymer_NatureWorks-Ingeo-6204D-Fiber-Grade-PLA.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.24 g/cc	1.24 g/cc	ASTM D792
Melt Density	1.08 g/cc @Temperature 230 °C	0.0390 lb/in³ @Temperature 446 °F	ASTM D1238
Viscosity Measurement	3.1	3.1	Relative Viscosity; CD Internal Viscotek Method
Melt Flow	15 - 30 g/10 min @Load 2.16 kg, Temperature 210 °C	15 - 30 g/10 min @Load 4.76 lb, Temperature 410 °F	ASTM D1238

Mechanical Properties	Metric	English	Comments
Elongation at Break	10 - 70 %	10 - 70 %	Fiber; ASTM D2256/ASTM D3822
Tenacity	0.221 - 0.441 N/tex	2.50 - 5.00 g/denier	ASTM D2256/ASTM D3822

Thermal Properties	Metric	English	Comments
Melting Point	160 - 170 °C	320 - 338 °F	ASTM D3418
Glass Transition Temp, Tg	55.0 - 60.0 °C	131 - 140 °F	ASTM D3417
Shrinkage	5.0 - 15 %	5.0 - 15 %	Boiling Water; ASTM D2102
	5.0 - 15 % @Temperature 130 °C, Time 600 sec	5.0 - 15 % @Temperature 266 °F, Time 0.167 hour	Hot Air; ASTM D2102

Processing Properties	Metric	English	Comments
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Processing Properties	Metric	English	Comments
Drying Temperature	@Time 14400 sec	@Time 4.00 hour	
Dew Point	-35.0 °C	-31.0 °F	
Drying Air Flow Rate	>= 14.2 l/min	>= 0.500 ft³/min (CFM)	

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