



**Product name:**  
INGEO™ BIOPOLYMER

**Product code:** 3D300      **Revision Number:** 2.01      **Revision date:** 01/12/2026      **Print date:** 01/12/2026

**SAFETY DATA SHEET**

Applicable regulations:

US OSHA Hazard Communication Standard 2024 (29 CFR 1910.1200), Canada WHMIS 2015 which includes the amended Hazardous Products Act (HPA) and the Hazardous Products Regulation (HPR)

**1. IDENTIFICATION OF THE SUBSTANCE/PREPARATION AND THE COMPANY/UNDERTAKING**

**Product name:** INGEO™ BIOPOLYMER  
**Product code:** 3D300  
**Product Use:** A biopolymer to be used in 3D printing applications

**Supplier:**  
NatureWorks  
17400 Medina Rd, Suite# 800  
Plymouth, MN 55447  
sdsinquiry@natureworksllc.com  
+1-952-562-3450

**Emergency telephone numbers (24 hours a day):**  
Health services: +1-(651)-632-9273  
Transport Information: CHEMTREC (Chemical Transportation Emergency Center)  
United States of America +1-(800)-424-9300 International +1-(703)-527-3887

**2. HAZARDS IDENTIFICATION**

**GHS Classification:** US OSHA Hazard Communication Standard (29 CFR 1910.1200) and Canada WHMIS which includes the amended Hazardous Products Act (HPA) and the Hazardous Products Regulation (HPR)

**Classification:** Not classified

**Signal word:** None

**Hazard Statements:** None

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**Precautionary Statements:** None

**Potential health effects:** See Section 11 for more information

**Environmental precautions:** See Section 12 for more information

**Other hazards:** May form combustible dust concentrations in air if small particles are generated during further processing, handling or by other means. Refer to protective measures listed in Sections 7 and 8

### 3. COMPOSITION/INFORMATION ON INGREDIENTS

Chemical name and CAS	Weight-%	OSHA Exposure Limits:	ACGIH Exposure Limits:
1,4-Dioxane-2,5-dione, 3,6-dimethyl-, (3R,6R)-, polymer with rel-(3R,6S)-3,6-dimethyl-1,4-dioxane-2,5-dione and (3S,6S)-3,6-dimethyl-1,4-dioxane-2,5-dione (Polylactide) 9051-89-2	>98	None	None

All ingredients in quantities > 1.0% (0.1% for carcinogens) that are potentially hazardous per OSHA definitions.

Other Standards: This material can generate Particulates Not Otherwise Classifiable (PNOC). The Occupational Safety and Health Administration (OSHA) PEL/TWA for PNOC is 15 mg/m<sup>3</sup> for total dust and 5 mg/m<sup>3</sup> for the respirable fraction. The American Conference of Governmental Industrial Hygienists (ACGIH) TLV/TWA for PNOC is 10 mg/m<sup>3</sup> for inhalable particulates and 3 mg/m<sup>3</sup> for respirable particulates.

### 4. FIRST AID MEASURES

**Emergency telephone numbers (24 hours a day):**

**Health services:** +1-(651)-632-9273

**Transport Information:** CHEMTREC (Chemical Transportation Emergency Center)  
United States of America +1-(800)-424-9300 International +1-(703)-527-3887

**Eye contact:** Rinse immediately with plenty of water, also under the eyelids, for at least 15 minutes. Call a physician immediately.

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**Skin contact:** Adverse human health effects and symptoms, Not expected, After contact with skin, wash immediately with plenty of water, If skin irritation persists, call a physician, After contact with molten product, cool skin area rapidly with cold water, Do not try to remove solidified material from the skin, Do not remove clothing if adhering to skin, Call a physician immediately

**Inhalation:** Move to fresh air in case of accidental inhalation of vapors. Call a physician immediately.

**Ingestion:** Clean mouth with water and drink afterwards plenty of water. Never give anything by mouth to an unconscious person. Do not induce vomiting without medical advice. Call a physician immediately.

**Notes to physician** Treat symptomatically.

## 5. FIRE-FIGHTING MEASURES

**Flammability:**

**Autoignition temperature:** 730°F / 388°C

**Flammability Limits in Air:**

**Flammable limits in air - lower (%):** Not applicable

**Flammable limits in air - upper (%):** Not applicable

**Suitable extinguishing media:** Foam, Water, Carbon dioxide (CO<sub>2</sub>), Dry chemical, Preferably extinguish with alcohol-resistant foam. If alcohol-resistant foam is not available, use normal foam.

**Unsuitable extinguishing media:** None known

**Special protective equipment for firefighters:** As in any fire, wear self-contained breathing apparatus pressure-demand, MSHA/NIOSH (approved or equivalent) and full protective gear.

**Specific hazards:** None known.

**Under fire conditions:** Cool containers / tanks with water spray. Water mist may be used to cool closed containers. Dust deposits should not be allowed to accumulate on surfaces, as these may form an explosive mixture if they are released into the atmosphere in sufficient concentration. Avoid dispersal of dust in the air (i.e., clearing dust surfaces with compressed air).

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## 6. ACCIDENTAL RELEASE MEASURES

**Personal precautions:** Use personal protective equipment. Avoid contact with skin and eyes. Avoid dust formation. Remove all sources of ignition. Sweep up to prevent slipping hazard.

**Environmental precautions:** Do not flush into surface water or sanitary sewer system. Do not allow to enter into surface water or drains.

**Methods for cleaning up:** Eliminate all ignition sources. Use explosion-proof equipment. Dust can be a fire or explosion hazard. Vacuum or sweep material and place in a disposal container. Keep in suitable, closed containers for disposal.

## 7. HANDLING AND STORAGE

**Safe handling advice:** Use personal protective equipment as required. Ensure adequate ventilation. Avoid contact with skin and eyes. Low hazard for usual industrial or commercial handling. After contact with molten product, cool skin area rapidly with cold water. Do not try to remove solidified material from the skin. Do not remove clothing if adhering to skin. Avoid dust formation. May form combustible dust concentrations in air if small particles are generated during further processing, handling or by other means.

**Storage:** Store at temperatures not exceeding 50 °C/ 122 °F. Keep cool. No special restrictions on storage with other products.

**Precautions:** No special precautions required.

## 8. EXPOSURE CONTROLS/PERSONAL PROTECTION

**Exposure controls:**

**Engineering measures:** Where reasonably practicable this should be achieved by the use of local exhaust ventilation and good general extraction. Provide appropriate exhaust ventilation at places where dust is formed.

**Exposure limits:** Not Established. This material can generate Particulates Not Otherwise Classifiable (PNOC). The Occupational Safety and Health Administration (OSHA) PEL/TWA for PNOC is 15 mg/m<sup>3</sup> for total dust and 5 mg/m<sup>3</sup> for the respirable fraction. The American Conference of Governmental Industrial Hygienists (ACGIH)

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TLV/TWA for PNO is 10 mg/m<sup>3</sup> for inhalable particulates and 3 mg/m<sup>3</sup> for respirable particulates.

**Personal protective equipment:**

**Eye protection:** Safety glasses with side-shields; Goggles

**Skin and body protection:** Impervious clothing

**Hand protection:** Preventive skin protection.

**Hygiene measures:** Avoid contact with eyes, skin and clothing.

**Respiratory protection:** Respirator must be worn if exposed to dust. Wear respirator with dust filter. Respiratory protection is needed if any of the exposure limits in Section 3 are exceeded. Consult an industrial hygiene professional prior to respirator selection and use. Use a positive-pressure air supplied respirator if there is any potential for an uncontrolled release, exposure levels are not known, or any other circumstances where air-purifying respirators may not provide adequate protection. **WARNING:** Air purifying respirators do not protect workers in oxygen-deficient atmospheres.

**Special hazard:** Workers should be protected from the possibility of contact with molten material during fabrication. Contact with molten substance may cause severe burns to skin and eyes

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## 9. PHYSICAL AND CHEMICAL PROPERTIES

<b>Physical state:</b>	Solid
<b>Appearance:</b>	pellets
<b>Color:</b>	Clear Translucent Opaque
<b>Odor:</b>	Sweet
<b>pH:</b>	Not applicable
<b>Vapor pressure:</b>	Not determined
<b>Vapor density:</b>	Not determined
<b>Evaporation rate:</b>	Not determined
<b>Partition Coefficient (n-octanol/water):</b>	Not determined
<b>Density:</b>	1.25 g/cm <sup>3</sup> @ 20 °C, 101.3 kPa
<b>Decomposition temperature:</b>	482°F / 250°C @ 101.3 kPa
<b>Boiling point / boiling range:</b>	Not applicable
<b>Melting point / melting range:</b>	150-180°C (302- 356°F), Tg (Glass Transition Temperature): 55-60°C (131-140°F) @ 101.3 kPa
<b>Autoignition temperature:</b>	730°F / 388°C
<b>Flash point:</b>	Not determined
<b>Flammability:</b>	Fine dust dispersed in air may ignite
<b>Flammability Limits in Air:</b>	No information available
<b>Water solubility:</b>	Insoluble
<b>Solubility in other solvents:</b>	Not determined
<b>Solubility:</b>	Not determined

## 10. STABILITY AND REACTIVITY

**Reactivity:** None under normal use conditions.

**Chemical stability:** Stable under recommended storage conditions.

**Conditions to avoid:** Temperatures above 446F (230 °C), Avoid keeping resin molten for excessive periods at temperatures above 230°C, Prolonged exposure above 230°C will cause polymer degradation

**Materials to avoid:** Oxidizing agents, Strong bases

**Hazardous decomposition products:** Burning produces obnoxious and toxic fumes, Aldehydes, Carbon monoxide (CO), Carbon dioxide (CO<sub>2</sub>)

**Possibility of hazardous reactions:** None under normal use conditions.

**Polymerization:** Not applicable

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## 11. TOXICOLOGICAL INFORMATION

**Principle routes of exposure:** Eye contact, Skin contact, Inhalation, Ingestion.

**Acute toxicity:** Based on available data, the classification criteria are not met. There were no target organ effects noted following ingestion or dermal exposure in animal studies.

1,4-Dioxane-2,5-dione, 3,6-dimethyl-, (3R,6R)-, polymer with  
rel-(3R,6S)-3,6-dimethyl-1,4-dioxane-2,5-dione and (3S,6S)-3,6-dimethyl-1,4-dioxane-2,5-dione  
(Polylactide)  
LD50/dermal/rabbit > 2000 mg/kg  
Oral LD50 (rat) >5000 mg/kg

**Skin:** LD50/dermal/rabbit > 2000 mg/kg

**Ingestion:** Oral LD50 (rat) >5000 mg/kg

**Target organ effects:** There were no target organ effects noted following ingestion or dermal exposure in animal studies

**Local effects:** Product dust may be irritating to eyes, skin and respiratory system. Resin particles, like other inert materials, are mechanically irritating to eyes. Ingestion may cause gastrointestinal irritation, nausea, vomiting and diarrhea.

**Specific effects:** May cause skin irritation and/or dermatitis. Ingestion may cause gastrointestinal irritation, nausea, vomiting and diarrhea. Inhalation of dust may cause shortness of breath, tightness of the chest, a sore throat and cough. Burning produces irritant fumes.

**Long term toxicity:** Did not cause skin allergic reactions in skin sensitization studies using guinea pigs.

**Mutagenic effects:** Not mutagenic in AMES Test

**Reproductive toxicity:** Based on available data, the classification criteria are not met

**Carcinogenic effects:** This product does not contain any carcinogens or potential carcinogens as listed by OSHA, IARC or NTP.

**Further information:** Avoid release to the environment, Harmful to Environment

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## 12. ECOLOGICAL INFORMATION

**Ecotoxicity effects:** EC50/72h/algae > 1100 mg/L

**1,4-Dioxane-2,5-dione, 3,6-dimethyl-, (3R,6R)-, polymer with  
rel-(3R,6S)-3,6-dimethyl-1,4-dioxane-2,5-dione and  
(3S,6S)-3,6-dimethyl-1,4-dioxane-2,5-dione (Polylactide)**

9051-89-2

EC50/72h/algae > 1100 mg/L

**Persistence and degradability:** Inherently biodegradable under industrial composting conditions

**Bioaccumulation:** Not likely to bioaccumulate

**Mobility:** No data available

## 13. DISPOSAL CONSIDERATIONS

**Waste from residues / unused products:** In accordance with local and national regulations. Discharge into the environment must be avoided. Prevent environmental discharge consistent with regulatory requirements. Do not contaminate ponds, waterways or ditches with chemical or used container. Contact manufacturer.

**Contaminated packaging:** Empty remaining contents. Do not re-use empty containers. Empty containers should be transported/delivered using a registered waste carrier to local recyclers for disposal.

THE COMPANY HAS NO CONTROL OVER THE MANAGEMENT PRACTICES OR MANUFACTURING PROCESSES OF PARTIES HANDLING OR USING THIS MATERIAL. THE INFORMATION PRESENTED HERE PERTAINS ONLY TO THE PRODUCT AS SHIPPED IN ITS INTENDED CONDITION.

## 14. TRANSPORT INFORMATION

**U.S. Department of Transportation (DOT):**

**Proper shipping name:** None

**Hazard class:** Not regulated

**UN-No:** None

**Packing group:** None

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**IMDG:**

**Proper shipping name:** None  
**Hazard class:** Not regulated  
**UN/Id No.:** None  
**Packing group:** None

**ICAO/IATA:**

**Proper shipping name:** None  
**Hazard Class:** Not regulated  
**UN-No.:** None  
**Packing group:** None

**15. REGULATORY INFORMATION**

(not meant to be all inclusive - selective regulations represented)

Regulatory requirements are subject to change and may differ between locations. It is the User's responsibility to ensure that all activities comply with all federal, state or provincial and local laws and regulations. The following specific information is made for the purpose of complying with numerous national, federal, state or provincial, and local laws and regulations. See other sections for health and safety information.

**U.S. REGULATIONS**

**US TSCA Inventory listing:** Active Listed

SARA Title III Rules: Not Listed

**STATE REGULATIONS**

California Proposition 65: Not Listed

**INTERNATIONAL INVENTORIES**

**Canada DSL Inventory List :** Listed

**REACH/EU EINECS List :** Compliance with technical regulations

**ENCS (Japan):** Listed

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**Australian Industrial Chemicals Introduction Scheme (AICIS)** Listed  
**Korean chemical inventory:** Listed  
**Philippines (PICCS) inventory:** Contact supplier for inventory compliance status  
**China inventory of existing chemical substances list :** Listed  
**TCSI - Taiwan Chemical Substance Inventory** Listed

## 16. OTHER INFORMATION, INCLUDING DATE OF PREPARATION OF THE LAST REVISION

**Label information:** INGENO™ BIOPOLYMER  
**Product code:** 3D300

**Reason for revision:** New Safety Data Sheet (SDS)

**Revision Number:** 2.01  
**Revision date:** 01/12/2026  
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**Recommended restrictions:** None  
**Prepared by:** NatureWorks LLC Health and Safety

### NOTICE REGARDING APPLICATION RESTRICTIONS:

The company does not recommend any of its products, including samples, for use: (A) in any application which is intended for any internal contact with human body fluids or body tissues (B) as a critical component in any medical device that supports or sustains human life; and (C) specifically pregnant women or in any applications designed specifically to promote or interfere with human reproduction. Components of products intended for human or animal consumption.

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