



Product name:
INGEO™ BIOPOLYMER

Product code: 3D700 **Revision Number:** 3.01 **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: 3D700
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/m³ for total dust and 5 mg/m³ for the respirable fraction. The American Conference of Governmental Industrial Hygienists (ACGIH) TLV/TWA for PNOC is 10 mg/m³ for inhalable particulates and 3 mg/m³ 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 (CO₂), 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/m³ for total dust and 5 mg/m³ for the respirable fraction. The American Conference of Governmental Industrial Hygienists (ACGIH)

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TLV/TWA for PNO is 10 mg/m³ for inhalable particulates and 3 mg/m³ 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

Physical state:	Solid
Appearance:	pellets
Color:	Clear Translucent Opaque
Odor:	Sweet
pH:	Not applicable
Vapor pressure:	Not determined
Vapor density:	Not determined
Evaporation rate:	Not determined
Partition Coefficient (n-octanol/water):	Not determined
Density:	1.25 g/cm ³ @ 20 °C, 101.3 kPa
Decomposition temperature:	482°F / 250°C @ 101.3 kPa
Boiling point / boiling range:	Not applicable
Melting point / melting range:	150-180°C (302- 356°F), Tg (Glass Transition Temperature): 55-60°C (131-140°F) @ 101.3 kPa
Autoignition temperature:	730°F / 388°C
Flash point:	Not determined
Flammability:	Fine dust dispersed in air may ignite
Flammability Limits in Air:	No information available
Water solubility:	Insoluble
Solubility in other solvents:	Not determined
Solubility:	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 (CO₂)

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.

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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: 3D700

Reason for revision: Document Review

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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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