



**Product Data Sheet &
General Processing Conditions**

**RTP 2099 X 124790 B
Bio-Based Polylactic Acid (PLA)
Impact Modified
Mineral
Fast-Cycle Nucleator
68% Renewable Resource Content**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	10 %	10 %	
Specific Gravity	1.25	1.25	D 792
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	3.5 ft-lbs/in	187 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	5500 psi	38 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Flexural Strength	9500 psi	66 MPa	D 790
Flexural Modulus	0.50 x 10 ⁶ psi	3448 MPa	D 790
THERMAL			
Deflection Temperature @ 66 psi (455 kPa)	160 °F	71 °C	D 648

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	8000 - 15000 psi	55 - 103 MPa
Melt Temperature	340 - 380 °F	171 - 193 °C
Mold Temperature	180 - 220 °F	82 - 104 °C
Drying	2 - 6 hrs @ 130 °F	2 - 6 hrs @ 54 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-40 °F	-40 °C

PROCESSING NOTES

Desiccant Type Dryer Required.
Nucleated for high heat exposure. For detailed processing information regarding this, see the PLA Molding Guide on the RTP Company website. www.rtpcompany.com/pla

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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