



**Product Data Sheet &  
General Processing Conditions**

**RTP 2099 X 121235 D  
Bio-Based Polylactic Acid (PLA)  
PC-PLA Blend  
31% Renewable Resource Content**

**PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS**

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.18	1.18	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0050 - 0.0070 in/in	0.50 - 0.70 %	D 955
<b>MECHANICAL</b>			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	16.0 ft-lbs/in	854 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	7000 psi	48 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.30 x 10 <sup>6</sup> psi	2068 MPa	D 638
Flexural Strength	12000 psi	83 MPa	D 790
Flexural Modulus	0.35 x 10 <sup>6</sup> psi	2413 MPa	D 790
<b>THERMAL</b>			
Deflection Temperature @ 264 psi (1820 kPa)	130 °F	54 °C	D 648
@ 66 psi (455 kPa)	240 °F	116 °C	D 648
Ignition Resistance* Flammability**	HB @ 1/16 in	HB @ 1.5 mm	D 635

**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.  
 \* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.  
 \*\* Values per RTP Company testing.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	8000 - 15000 psi	55 - 103 MPa
Melt Temperature	430 - 470 °F	221 - 243 °C
Mold Temperature	75 - 160 °F	24 - 71 °C
Drying	4 hrs @ 175 °F	4 hrs @ 79 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-40 °F	-40 °C

**PROCESSING NOTES**

Desiccant Type Dryer Required.  
 For detailed processing information, see the PLA Molding Guide on the RTP Company website. [www.rtpcompany.com/pla](http://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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