



**Product Data Sheet &  
General Processing Conditions**

**RTP 2099 X 115375 C  
Bio-Based Polylactic Acid (PLA)  
PLA-PMMA Alloy  
Transparent  
39% 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	1.21	1.21	D 792

**MECHANICAL**

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.7 ft-lbs/in	37 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	10000 psi	69 MPa	D 638
Tensile Elongation	6.0 %	6.0 %	D 638
Tensile Modulus	0.50 x 10 <sup>6</sup> psi	3448 MPa	D 638
Flexural Strength	17500 psi	121 MPa	D 790
Flexural Modulus	0.55 x 10 <sup>6</sup> psi	3792 MPa	D 790

**THERMAL**

Deflection Temperature			
@ 66 psi (455 kPa)	150 °F	66 °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	330 - 430 °F	166 - 221 °C
Mold Temperature	50 - 75 °F	10 - 24 °C
Drying	2 - 6 hrs @ 125 °F	2 - 6 hrs @ 52 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-40 °F	-40 °C