



**Product Data Sheet &
General Processing Conditions**

**RTP 2099 X 115382 C
Bio-Based Polylactic Acid (PLA)
PLA-HDPE Blend
39% Renewable Resource Content**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
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Specific Gravity	1.03	1.03	D 792
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MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.2 ft-lbs/in	64 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	4000 psi	28 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.24 x 10 ⁶ psi	1655 MPa	D 638
Flexural Strength	6500 psi	45 MPa	D 790
Flexural Modulus	0.22 x 10 ⁶ psi	1517 MPa	D 790

THERMAL

Deflection Temperature			
@ 66 psi (455 kPa)	130 °F	54 °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

	English	SI Metric
Injection Pressure	8000 - 15000 psi	55 - 103 MPa
Melt Temperature	350 - 400 °F	177 - 204 °C
Mold Temperature	75 - 125 °F	24 - 52 °C
Drying	4 hrs @ 150 °F	4 hrs @ 66 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-40 °F	-40 °C