



**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