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Product Data Sheet &
General Processing Conditions

RTP 2099 X 121249 C
Bio-Based Polylactic Acid (PLA)
Standard Nucleator
Glass Fiber
68% Renewable Resource Content

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Primary Additive	30 %	30 %	
Specific Gravity	1.48	1.48	D 792
Molding Shrinkage			
1/8 in (3.2 mm) section	0.0020 - 0.0040 in/in	0.20 - 0.40 %	D 955
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	7.0 ft-lbs/in	374 J/m	D 4812
Tensile Strength	17000 psi	117 MPa	D 638
Tensile Elongation	1.5 %	1.5 %	D 638
Tensile Modulus	1.57 x 10^6 psi	10825 MPa	D 638
Flexural Strength	23000 psi	159 MPa	D 790
Flexural Modulus	1.54 x 10^6 psi	10618 MPa	D 790
THERMAL			
Deflection Temperature			
@ 264 psi (1820 kPa)	300 °F	149 °C	D 648
@ 66 psi (455 kPa)	320 °F	160 °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	340 - 380 °F	171 - 193 °C
Mold Temperature	180 - 220 °F	82 - 104 °C
Drying	4 - 6 hrs @ 130 °F	4 - 6 hrs @ 54 °C
Moisture Content	< 0.02 %	< 0.02 %
Dew Point	-40 °F	-40 °C