



**Product Data Sheet &  
General Processing Conditions**

**RTP 2099 X 124789 B  
Bio-Based Polylactic Acid (PLA)  
Impact Modified  
Transparent  
89% Renewable Resource Content**

Not optically transparent. Thick wall sections can be hazy.

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Specific Gravity	1.23	1.23	D 792
<b>MECHANICAL</b>			
Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.9 ft-lbs/in	48 J/m	D 256
unnotched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 4812
Tensile Strength	8000 psi	55 MPa	D 638
Tensile Elongation	8.0 %	8.0 %	D 638
Tensile Modulus	0.47 x 10 <sup>6</sup> psi	3241 MPa	D 638
Flexural Strength	11000 psi	76 MPa	D 790
Flexural Modulus	0.44 x 10 <sup>6</sup> psi	3034 MPa	D 790
<b>THERMAL</b>			
Deflection Temperature @ 66 psi (455 kPa)	124 °F	51 °C	D 648

**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.

**GENERAL PROCESSING FOR INJECTION MOLDING**

	<b>English</b>	<b>SI Metric</b>
Injection Pressure	8000 - 15000 psi	55 - 103 MPa
Melt Temperature	340 - 370 °F	171 - 188 °C
Mold Temperature	50 - 75 °F	10 - 24 °C
Drying	2 - 6 hrs @ 120 °F	2 - 6 hrs @ 49 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-40 °F	-40 °C