



**Product Data Sheet &  
General Processing Conditions**

**RTP 2099 X 124790 D  
Bio-Based Polylactic Acid (PLA)  
Impact Modified  
Mineral  
Standard Nucleator  
68% Renewable Resource Content**

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

<b>PERMANENCE</b>	<b>English</b>	<b>SI Metric</b>	<b>ASTM TEST</b>
Primary Additive	10 %	10 %	
Specific Gravity	1.25	1.25	D 792

**MECHANICAL**

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	3.4 ft-lbs/in	182 J/m	D 256
unnotched 1/8 in (3.2 mm) section	20.0 ft-lbs/in	1068 J/m	D 4812
Tensile Strength	5200 psi	36 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Flexural Strength	9500 psi	66 MPa	D 790
Flexural Modulus	0.50 x 10 <sup>6</sup> psi	3448 MPa	D 790

**THERMAL**

Deflection Temperature @ 66 psi (455 kPa)	150 °F	66 °C	D 648
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**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 - 380 °F	171 - 193 °C
Mold Temperature	180 - 220 °F	82 - 104 °C
Drying	2 - 6 hrs @ 130 °F	2 - 6 hrs @ 54 °C
Moisture Content	0.02 %	0.02 %
Dew Point	-40 °F	-40 °C