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Product Data Sheet &
General Processing Conditions

RTP 2099 X 126211 Z
Bio-Based Polylactic Acid (PLA)
FDA Compliant Ingredients
Impact Modified
Transparent
89% Renewable Resource Content

Not optically transparent. Thick wall sections can be hazy.

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.23	1.23	D 792
MECHANICAL			
Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	0.8 ft-lbs/in	43 J/m	D 256
unnotched 1/8 in (3.2 mm) section	10.0 ft-lbs/in	534 J/m	D 4812
Tensile Strength	6700 psi	46 MPa	D 638
Tensile Elongation	3.0 - 6.0 %	3.0 - 6.0 %	D 638
Flexural Strength	11000 psi	76 MPa	D 790
Flexural Modulus	0.44 x 10^6 psi	3034 MPa	D 790
THERMAL			
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

	English	SI Metric
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