



**Product Data Sheet &  
General Processing Conditions**

**RTP 2099 X 126216 C  
Bio-Based Polylactic Acid (PLA)  
Fast-Cycle Nucleator  
Glass Fiber  
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	30 %	30 %	
Specific Gravity	1.48	1.48	D 792

**MECHANICAL**

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	1.0 ft-lbs/in	53 J/m	D 256
unnotched 1/8 in (3.2 mm) section	6.0 ft-lbs/in	320 J/m	D 4812
Tensile Strength	16500 psi	114 MPa	D 638
Tensile Elongation	1.5 %	1.5 %	D 638
Tensile Modulus	1.48 x 10 <sup>6</sup> psi	10205 MPa	D 638
Flexural Strength	21000 psi	145 MPa	D 790
Flexural Modulus	1.63 x 10 <sup>6</sup> psi	11239 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

**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