

(+) 18816996168

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**Product Data Sheet &  
General Processing Conditions**

**RTP 2099 X 124790 A  
Bio-Based Polylactic Acid (PLA)  
Impact Modified  
Mineral  
Fast Cycle Nucleator  
78% Renewable Resource Content**

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

| <b>PERMANENCE</b> | <b>English</b> | <b>SI Metric</b> | <b>ASTM<br/>TEST</b> |
|-------------------|----------------|------------------|----------------------|
| Primary Additive  | 10 %           | 10 %             |                      |
| Specific Gravity  | 1.28           | 1.28             | D 792                |

**MECHANICAL**

|                                   |                            |          |        |
|-----------------------------------|----------------------------|----------|--------|
| Impact Strength, Izod             |                            |          |        |
| notched 1/8 in (3.2 mm) section   | 1.8 ft-lbs/in              | 96 J/m   | D 256  |
| unnotched 1/8 in (3.2 mm) section | 15.0 ft-lbs/in             | 801 J/m  | D 4812 |
| Tensile Strength                  | 7000 psi                   | 48 MPa   | D 638  |
| Tensile Elongation                | 8.0 %                      | 8.0 %    | D 638  |
| Flexural Strength                 | 11000 psi                  | 76 MPa   | D 790  |
| Flexural Modulus                  | 0.60 x 10 <sup>6</sup> psi | 4137 MPa | D 790  |

**THERMAL**

|                                              |        |       |       |
|----------------------------------------------|--------|-------|-------|
| Deflection Temperature<br>@ 66 psi (455 kPa) | 195 °F | 91 °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            |