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**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

PERMANENCE	English	SI Metric	ASTM TEST
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 ⁶ 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

	English	SI Metric
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