

(+) 18816996168

Ponciplastics.com



**Product Data Sheet &
General Processing Conditions**

**RTP 2099 X 126218 C
Bio-Based Polylactic Acid (PLA)
Impact Modified
84% Renewable Resource Content**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.20	1.20	D 792

MECHANICAL

Impact Strength, Izod			
notched 1/8 in (3.2 mm) section	3.5 ft-lbs/in	187 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	6400 psi	44 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.38 x 10 ⁶ psi	2620 MPa	D 638
Flexural Strength	10000 psi	69 MPa	D 790
Flexural Modulus	0.39 x 10 ⁶ psi	2689 MPa	D 790

THERMAL

Deflection Temperature @ 66 psi (455 kPa)	124 °F	51 °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 - 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