



K0334  
North America

**KRATON® D2104 DI-N Compound**

**Data Document**

Identifier : K334DDe15U

**Description**

Kraton D2104 DI-N is an easy processing, general purpose material designed for a wide variety of applications. It is supplied from North America in the physical form identified below:

- Kraton D2104 DI-N - supplied as a translucent dense pellet

**Sales Specifications**

<u>Property</u>	<u>Test Method</u>	<u>Units</u>	<u>Sales Specification Range</u>	<u>Notes</u>
Melt Flow, 200C/5000g	ASTM D1238	g/10 min	14.00 TO 24.00	
Hardness, Shore A	BAM 1003		30 TO 40	a
Specific Gravity	BAM 1014		0.900 TO 0.940	

**a** Value on product extruded at 175C.

**Typical Properties** (These are typical values and may not routinely be measured on finished product)

<u>Property</u>	<u>Test Method</u>	<u>Units</u>	<u>Typical Value</u>	<u>Notes</u>
300% Modulus	ASTM D 412	psi	350	b
Elongation at Break	ASTM D 412	%	1200	b
Tensile Strength	ASTM D 412	psi	1400	b
100% Modulus	ASTM D 412	psi	75	c
100% Modulus	ASTM D 412	psi	220	b
Elongation at Break	ASTM D 412	%	1300	c d
Tensile Strength	ASTM D 412	psi	1150	c d
300% Modulus	ASTM D 412	psi	150	c

**b** Machine Direction; Injection molded sample tested at 10 in/min with Die D.  
**c** Transverse Direction; Injection molded sample tested at 10 in/min with Die D.  
**d** Sample did not break at maximum travel.

**Packaging**

Kraton Polymers are available in a number of different package types. For information specific to this grade, please contact your local Kraton Polymers representative.

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Kraton D2104 DI-N can be processed by injection molding, extrusion, thermoforming, and other thermoplastic fabricating techniques.

Typical starting conditions for a reciprocating screw injection molding machines are as follows:

**Barrel temperatures**, deg. F

Rear 340 - 360

Front 370 - 390

Nozzle 350 - 380

**Mold temperature**, deg. F 50 - 100

**Injection pressure**, psig 500 - 700

**Back pressure**, psi 40 - 60

**Injection speed** Medium to fast

These values are intended only as guidelines, and the optimum conditions will vary from machine to machine.

Normal mold shrinkage for Kraton D2104 DI-N is about 0.025 - 0.027 in/in in the direction of flow.

Since Kraton D2104 DI-N conducts heat well compared to polyolefins, molded parts cool quickly and relatively short cycle times are obtained. Scrap is 100% recyclable.

Polystyrene, low density polyethylene (LDPE), or poly (ethylene-vinyl acetate) color concentrates can be used to color Kraton D2104 DI-N.