



K0351  
North America

**KRATON® D2109 DS-N Compound**

**Data Document**

Identifier : K351DDd15U

**Description**

Kraton D2109 DS-N is an easy processing, general purpose 45 Shore A hardness material designed for a wide variety of applications. It is supplied from North America in the physical form identified below.

- Kraton D2109 DS-N - supplied as a 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	15.00 TO 30.00	
Hardness, Shore A	BAM 1003		40 TO 50	a
Specific Gravity	BAM 1014		0.915 TO 0.945	

**a** Value on product compression molded @ 120C.

**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>
Tensile Strength	ASTM D 412	psi	700	c b e
Tensile Strength	ASTM D 412	psi	500	c b d
100% Modulus	ASTM D 412	psi	150	e c b
Elongation at Break	ASTM D 412	%	550	d c b
300% Modulus	ASTM D 412	psi	300	b c d
300% Modulus	ASTM D 412	psi	250	e c b
Tear Strength	ASTM D 624	pli	125	d c b
Tear Strength	ASTM D 624	pli	150	e b c
Elongation at Break	ASTM D 412	%	800	b e c
100% Modulus	ASTM D 412	psi	200	c d b

**b** Die C  
**c** Typical properties based on injection molded plaques.  
**d** Machine Direction  
**e** Transverse Direction

**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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### Processing

Kraton D2109 DS-N can be processed by injection molding, extrusion, thermoforming, and other thermoplastic fabricating techniques.

Typical starting conditions for a reciprocating screw injection molding machine 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 D2109 DS-N is about 0.025-0.027 in/in in the direction of flow.

Since Kraton D2109 DS-N conducts heat well compared to polyolefins, molded parts cool quickly and relatively short cycle times are obtained. Scrap is 100% recyclable.

Polystyrene, polypropylene, or poly(ethylene-vinyl acetate) color concentrates can be used to color Kraton D2109 DS-N.