

Medalist® MD-115

Teknor Apex Company - Thermoplastic Elastomer

Thursday, June 29, 2017

General Information

Product Description

This compound is designed for medical and healthcare applications including tubing.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Medical/Healthcare Applications • Pharmaceuticals		
Agency Ratings	• ISO 10993 Part 5		
RoHS Compliance	• RoHS Compliant		
Appearance	• Translucent		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

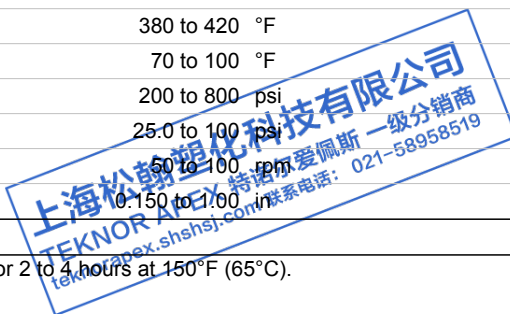
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.880		ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.039	in/in	ASTM D955
Molding Shrinkage - Across Flow	0.034	in/in	ASTM D955
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress (100% Strain)	125	psi	ASTM D412
Tensile Stress (200% Strain)	220	psi	ASTM D412
Tensile Stress (300% Strain)	320	psi	ASTM D412
Tensile Strength (Break)	1080	psi	ASTM D412
Tensile Elongation (Break)	650	%	ASTM D412
Tear Strength	120	lbf/in	ASTM D624
Compression Set (73°F, 22 hr)	13	%	ASTM D395
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	37		ASTM D2240

Processing Information

Injection	Nominal Value	Unit
Rear Temperature	280 to 320	°F
Middle Temperature	320 to 360	°F
Front Temperature	340 to 380	°F
Nozzle Temperature	380 to 420	°F
Processing (Melt) Temp	380 to 420	°F
Mold Temperature	70 to 100	°F
Injection Pressure	200 to 800	psi
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

Injection Notes

Drying is not necessary. However, if moisture is a problem, dry the pellets for 2 to 4 hours at 150°F (65°C).



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Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	280 to 300	°F
Cylinder Zone 2 Temp.	300 to 320	°F
Cylinder Zone 3 Temp.	320 to 360	°F
Cylinder Zone 5 Temp.	340 to 380	°F
Die Temperature	360 to 400	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

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*In U.S. for Vinyls, TPEs, Colorants,
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