Medalist® MD-12350

Thermoplastic Elastomer

Teknor Apex Company

Message:

This compound is intended for use in medical and healthcare applications, particularly for extruded medical tubing and molding applications

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Tensile Elongation (Break)	690	%	ASTM D412
Tear Strength	35.9	kN/m	ASTM D624
Compression Set			ASTM D395
23°C, 22 hr	17	%	ASTM D395
70°C, 22 hr	87	%	ASTM D395
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Legal statement

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Injection	Nominal Value	Unit
Rear Temperature	149 - 171	°C
Middle Temperature	171 - 193	°C
Front Temperature	193 - 227	°C
Nozzle Temperature	193 - 227	°C
Processing (Melt) Temp	193 - 227	°C
Mold Temperature	21.1 - 51.7	°C
Back Pressure	0.345 - 1.03	MPa
Screw Speed	50 - 100	rpm
Cushion	3.56 - 25.4	mm

Injection instructions

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.	171 - 188	°C
Cylinder Zone 2 Temp.	182 - 196	°C
Cylinder Zone 3 Temp.	185 - 204	°C
Cylinder Zone 5 Temp.	204 - 227	°C
Die Temperature	204 - 227	°C
Extrusion instructions		

Screw Speed: 30 to 100 rpmScreen Pack Recommendation: 60/200/200/60 to 60/200/400/400/200/60 mesh size

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