

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

General Information			
Features	High purity		
	Pressure cooker disinfection		
	Ethylene oxide disinfection		
	Anti-gamma radiation		
	Workability, good		
	Kink resistance		
	No kinetic components		
Uses	Safety equipment		
	Drug		
	Medical/nursing supplies		
Agency Ratings	ISO 10993 Part 5		
	ISO 13485		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.888	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	1.0	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A, 1 sec	53		ASTM D2240
Shaw A, 5 seconds	50		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
50% strain	1.21	MPa	ASTM D412
100% strain	1.59	MPa	ASTM D412
300% strain	3.59	MPa	ASTM D412
Tensile Strength (Break)	13.0	MPa	ASTM D412

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

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).

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 rpm
Screen Pack Recommendation: 60/200/200/60 to 60/200/400/400/200/60 mesh size

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