

Medalist® MD-155

Thermoplastic Elastomer

Teknor Apex Company

Message:

This compound is designed for medical and healthcare applications including high-temperature applications.

General Information	
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Uses	Drug Medical/nursing supplies
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Agency Ratings	ISO 10993 Part 5
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Appearance	Translucent
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Forms	Particle
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Processing Method	Extrusion Injection molding
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Physical	Nominal Value	Unit	Test Method
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Specific Gravity	0.898	g/cm ³	ASTM D792
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Melt Mass-Flow Rate (MFR) (200°C/5.0 kg)	0.10	g/10 min	ASTM D1238
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Molding Shrinkage			ASTM D955
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Flow	1.8	%	ASTM D955
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Transverse flow	1.7	%	ASTM D955
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Hardness	Nominal Value	Unit	Test Method
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Durometer Hardness (Shore A)	68		ASTM D2240
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Elastomers	Nominal Value	Unit	Test Method
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Tensile Stress			ASTM D412
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100% strain	2.45	MPa	ASTM D412
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200% strain	3.52	MPa	ASTM D412
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300% strain	4.59	MPa	ASTM D412
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Tensile Strength (Break)	11.7	MPa	ASTM D412
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Tensile Elongation (Break)	750	%	ASTM D412
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Tear Strength	61.3	kN/m	ASTM D624
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Compression Set (23°C, 22 hr)	33	%	ASTM D395
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Injection	Nominal Value	Unit
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Rear Temperature	149 - 171	°C
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Middle Temperature	182 - 204	°C
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Front Temperature	193 - 216	°C
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Nozzle Temperature	216 - 238	°C
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Processing (Melt) Temp	216 - 238	°C
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Mold Temperature	21.1 - 37.8	°C
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Injection Pressure	1.38 - 5.52	MPa
Back Pressure	0.172 - 0.689	MPa
Screw Speed	50 - 100	rpm
Cushion	3.81 - 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.	160 - 171	°C
Cylinder Zone 2 Temp.	171 - 182	°C
Cylinder Zone 3 Temp.	182 - 204	°C
Cylinder Zone 5 Temp.	193 - 216	°C
Die Temperature	204 - 227	°C

Extrusion instructions

螺杆转速30 - 100 rpm

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