

Medalist® MD-150

Thermoplastic Elastomer

Teknor Apex Company

Message:

This compound is intended for use in medical and healthcare applications including high clarity tubing.

General Information	
Features	Radiation disinfection
	Pressure cooker disinfection
	Ethylene oxide disinfection
Uses	Drug
	Medical/nursing supplies
Agency Ratings	ISO 10993 Part 5
Appearance	Clear/transparent
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)	6.0	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	3.3	%	ASTM D955
Transverse flow	2.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	55		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	2.41	MPa	ASTM D412
200% strain	2.96	MPa	ASTM D412
300% strain	3.59	MPa	ASTM D412
Tensile Strength (Break)	7.93	MPa	ASTM D412
Tensile Elongation (Break)	700	%	ASTM D412
Tear Strength	41.2	kN/m	ASTM D624
Compression Set			ASTM D395
23°C, 22 hr	18	%	ASTM D395
70°C, 22 hr	95	%	ASTM D395
Aging	Nominal Value	Unit	Test Method

Continuous Upper Temperature Resistance	85	°C	SAE J2236
Thermal	Nominal Value	Unit	Test Method
Brittleness Temperature	-60.0	°C	ASTM D746
Injection	Nominal Value	Unit	
Rear Temperature	138 - 160	°C	
Middle Temperature	160 - 182	°C	
Front Temperature	171 - 193	°C	
Nozzle Temperature	193 - 216	°C	
Processing (Melt) Temp	193 - 216	°C	
Mold Temperature	21.1 - 37.8	°C	
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.	138 - 149	°C
Cylinder Zone 2 Temp.	149 - 160	°C
Cylinder Zone 3 Temp.	160 - 182	°C
Cylinder Zone 5 Temp.	171 - 193	°C
Die Temperature	182 - 204	°C

Extrusion instructions

螺杆转速30 - 100 rpm

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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