

Medalist® MD-135

Thermoplastic Elastomer

Teknor Apex Company

Message:

This compound is designed for medical and healthcare applications including blow molded parts.

General Information			
Uses	Drug		
	Medical/nursing supplies		
Agency Ratings	ISO 10993 Part 5		
Appearance	Translucent		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.878	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	4.4	%	ASTM D955
Transverse flow	3.7	%	ASTM D955

Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	45		ASTM D2240

Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	1.03	MPa	ASTM D412
200% strain	1.48	MPa	ASTM D412
300% strain	2.14	MPa	ASTM D412
Tensile Strength (Break)	2.83	MPa	ASTM D412
Tensile Elongation (Break)	650	%	ASTM D412
Tear Strength	33.3	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	17	%	ASTM D395

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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