

Medalist® MD-34445 NAT XRD1

Thermoplastic Elastomer

Teknor Apex Company

Message:

This material adheres to LLDPE.

General Information			
Uses	Safety equipment		
	Drug		
	Medical/nursing supplies		
Appearance	Opacity		
Forms	Particle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.928	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/21.6 kg)	35	g/10 min	ASTM D1238
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shaw A	45		ASTM D2240
Shaw A, 5 seconds	43		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	6.89	MPa	ASTM D412
Tensile Elongation (Break)	700	%	ASTM D412
Additional Information	Nominal Value		
Adhesion to LLDPE			
Injection	Nominal Value	Unit	
Rear Temperature	127 - 149	°C	
Middle Temperature	138 - 160	°C	
Front Temperature	149 - 171	°C	
Nozzle Temperature	171 - 193	°C	
Processing (Melt) Temp	171 - 193	°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

Screw Speed: 30 to 100 rpm

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Recommended distributors for this material

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