

Medalist® MD-305

Thermoplastic Elastomer

Teknor Apex Company

Message:

This compound is designed for overmold to polycarbonate (PC), ABS and blends of PC and ABS.

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	1.02	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage			ASTM D955
Flow	3.2	%	ASTM D955
Transverse flow	2.8	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A)	50		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
100% strain	1.97	MPa	ASTM D412
200% strain	2.62	MPa	ASTM D412
300% strain	3.38	MPa	ASTM D412
Tensile Strength (Break)	5.17	MPa	ASTM D412
Tensile Elongation (Break)	650	%	ASTM D412
Tear Strength	26.3	kN/m	ASTM D624
Compression Set (23°C, 22 hr)	32	%	ASTM D395
Additional Information	Nominal Value		
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			
Injection	Nominal Value	Unit	
Drying Temperature	60.0	°C	

Drying Time	2.0 - 4.0	hr
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

Moisture can degrade the material. Drying is suggested. This can be accomplished by placing the material in a desiccant dryer for 2 to 4 hours at 140°F.

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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