



Medalist® MD-34065

Teknor Apex Company - Thermoplastic Elastomer

General Information

Product Description

Medalist MD-34065 is a high performance thermoplastic elastomer intended for use in medical and healthcare applications, particularly overmolding. Medalist MD-34065 is a medium hardness, low density grade with excellent bonding to PC, ABS, and PC/ABS.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Uses	• Medical/Healthcare Applications • Pharmaceuticals		• Safety Equipment
RoHS Compliance	• RoHS Compliant		
Appearance	• Opaque		
Forms	• Pellets		
Processing Method	• Extrusion	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.00		ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/21.6 kg)	6.4	g/10 min	ASTM D1238
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break)	1300	psi	ASTM D412
Tensile Elongation (Break)	600	%	ASTM D412
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness			ASTM D2240
Shore A	75		
Shore A, 5 sec	73		
Additional Information	Nominal Value	Unit	
Adhesion to ABS			
Adhesion to PC			
Adhesion to PC/ABS			

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	150	°F
Drying Time	2.0 to 4.0	hr
Rear Temperature	260 to 300	°F
Middle Temperature	280 to 320	°F
Front Temperature	300 to 340	°F
Nozzle Temperature	340 to 380	°F
Processing (Melt) Temp	340 to 380	°F

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Injection	Nominal Value	Unit
Mold Temperature	70 to 100	°F
Injection Pressure	200 to 800	psi
Back Pressure	25.0 to 100	psi
Screw Speed	50 to 100	rpm
Cushion	0.150 to 1.00	in

Injection Notes

Drying is suggested for enhanced bondability - Dry the pellets for 2 to 4 hours at 150°F (65°C).

Extrusion	Nominal Value	Unit
Cylinder Zone 1 Temp.	280 to 300	°F
Cylinder Zone 2 Temp.	300 to 320	°F
Cylinder Zone 3 Temp.	320 to 360	°F
Cylinder Zone 4 Temp.	320 to 360	°F
Cylinder Zone 5 Temp.	340 to 380	°F
Die Temperature	360 to 400	°F

Extrusion Notes

Screw Speed: 30 to 100 rpm

Notes

¹ Typical properties: these are not to be construed as specifications.