Baydur® 660 IBS (35 pcf)

Polyurethane (MDI)

Covestro - PUR

Message:

Baydur 660 IBS is a black-pigmented, rigid polyurethane structural foam system used in the reaction injection molding (RIM) process. This system incorporates a specially engineered interactive blowing system (IBS) and is supplied as two reactive liquid components. Component A is a polymeric diphenylmethane diisocyanate (PMDI), and Compo- nent B is a formulated polyol system containing no CFC- or HCFC-blowing additives. Note: Component B should be agitated thoroughly prior to delivery of contents of the drum to the day tank due to possible pigment settling.
The Baydur 660 IBS system was designed for general-purpose applications and is used in industrial and recreational markets. The applications typically take advantage of the material's strength, excellent surface finish, and large part capability. As with any product, use of the Baydur 660 IBS system in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

General Information			
Features	Good strength General Excellent appearance		
Uses	Structural Foam Industrial application General		
Appearance	Black		
Processing Method	Reaction Injection Molding (RIM)		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	0.399	g/cm³	ASTM D792
Molding Shrinkage - Flow (6.35 mm)	0.30 - 0.50	%	ASTM D955
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shaw D, 6.35mm	46		ASTM D2240
Shaw D, 12.7mm	49		ASTM D2240
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength			ASTM D638
Fracture, 6.35mm	8.27	MPa	ASTM D638
Fracture, 12.7mm	7.58	MPa	ASTM D638
Tensile Elongation			ASTM D638
Fracture, 6.35mm	7.0	%	ASTM D638
Fracture, 12.7mm	9.0	%	ASTM D638
Flexural Modulus			ASTM D790
6.35 mm	462	MPa	ASTM D790
12.7 mm	441	MPa	ASTM D790
Flexural Strength			ASTM D790
6.35 mm	13.8	MPa	ASTM D790

12.7 mm	16.5	MPa	ASTM D790
Compressive Strength			ASTM D695
6.35 mm	7.93	MPa	ASTM D695
12.7 mm	7.58	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Unnotched Impact Strength			Internal method
-- [1]	8.0	kJ/m^2	Internal method
-- [2]	7.4	kJ/m^2	Internal method
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (0.45 MPa, unannealed, 12.7mm)	104	°C	ASTM D648
Thermoset	**Nominal Value**		
Thermoset Components			
Component a	Mixing ratio by weight: 120		
Component B	Mixing ratio by weight: 100		

Additional Information

Part A
Type: Isocyanate
Appearance: Dark brown liquid
Specific Gravity @ 25°C: 1.24
Viscosity @25°C: 200 cps
Flash Point PMCC: 199°C
NCO: 31.0 min wt%
Part B
Type: Polyol
Appearance: Black liquid
Specific Gravity @ 25°C: 1.05
Viscosity @25°C: 2000 cps
Flash Point PMCC: 131°C
Water: 0.64 wt%
Material Temperatures: 32 to 35°CMold Temperature: 55 to 66°CHand Mix Reactivity at 25°C
Cream Time: 22 to 34 sec
Gel Time: 46 to 58 sec
Tack Free Time: 58 to 80 sec
Free-Rise Density: 7.5 to 9.0 lb/ft^3
Polyol Nucleation Specific Gravity: 0.85 to 0.95 0Recommended Shot Time: 5 to 6 sec

NOTE	
1.	0.5
2.	0.25 in

Recommended distributors for this material

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