

# Baydur® 684 (30 pcf)

Polyurethane  
Covestro - PUR

Message:

Baydur 684 is a rigid polyurethane structural foam system used in the reaction injection molding (RIM) process. The system is supplied as two reactive liquid components. Component A is a polymeric diphenylmethane diisocyanate (PMDI), and Component B is a formulated polyol system containing no CFC- or HCFC-blowing additives.

The Baydur 684 system is used for applications requiring high compression strength foams,filling cavities and/or producing foam cores for overmolding. As with any product, use of the Baydur 684 system in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

General Information			
Uses	Structural Foam		
	Foam		
Forms	Liquid		
Processing Method	Reaction Injection Molding (RIM)		
Hardness	Nominal Value		Test Method
Durometer Hardness (Shore D, 12.7 mm)	55		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 12.7 mm)	9.17	MPa	ASTM D638
Flexural Modulus (12.7 mm)	595	MPa	ASTM D790
Flexural Strength (12.7 mm)	18.6	MPa	ASTM D790
Compressive Strength (12.7 mm)	14.0	MPa	ASTM D695
Thermoset	Nominal Value		
Thermoset Components			
Component a	Mixing ratio by weight: 130		
Component B	Mixing ratio by weight: 100		
Additional Information			

Part A  
Type: Isocyanate  
Specific Gravity @ 25°C: 1.24  
Viscosity @25°C: 200 cps  
Part B  
Type: Polyol  
Specific Gravity @ 25°C: 1.08  
Viscosity @25°C: 900 cps  
Machine Reactivity at 80°F  
Cream Time: 16 sec  
Gel Time: 55 sec  
Tack Free Time: 80 sec  
Free Rise Density: 5.6 pcf

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