

# Baydur® 665 IBS (35 pcf)

Polyurethane (MDI)

Covestro - PUR

## Message:

Baydur 665 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 Component B is a formulated polyol system containing no CFC- or HCFC-blowing additives. Note: Component B should be agitated thoroughly prior to delivery of drum contents to day tank due to possible pigment settling.

The Baydur 665 IBS system is used for general-purpose applications that require injection times longer than 10 seconds. The applications, typically found in the construction, furniture, and transportation markets, take advantage of the material's strength as well as its excellent surface finish, large part capability, and good flowability. As with any product, use of the Baydur 665 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 liquidity		
	Good strength		
	General		
	Excellent appearance		
Uses	Structural Foam		
	Furniture		
	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 (12.7 mm)	0.30 - 0.50	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D, 12.7 mm)	70		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 12.7 mm)	19.3	MPa	ASTM D638
Tensile Elongation (Break, 12.7 mm)	7.0	%	ASTM D638
Flexural Modulus (12.7 mm)	779	MPa	ASTM D790
Flexural Strength (12.7 mm)	34.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength <sup>1</sup>	13	kJ/m²	Internal method
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, unannealed, 12.7mm)	100	°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 max wt% Part B Type: Polyol Appearance: Black liquid Specific Gravity @ 25°C: 1.05 Viscosity @25°C: 2000 cps Flash Point PMCC: 130°C Water: 0.4 wt% Hydroxyl Number: 465 KOH/g Material Temperatures: 32 to 38°C Mold Temperature: 60 to 70°C Hand Mix Reactivity at 25°C Cream Time: 45 sec Gel Time: 90 sec Tack Free Time: 115 sec Free-Rise Density: 12 lb/ft <sup>3</sup> Polyol Nucleation Specific Gravity: 0.80 to 0.85 0 Typical cure Time, 0.250 in Thickness: 4 to 5	
NOTE	
1.	0.5 in

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