

Bayflex® 110-80

Polyurethane (Polyether, MDI)

Covestro - PUR

Message:

The Bayflex 110-80 system produces a solid urethane elastomer which has a flexural modulus of approximately 80,000 psi at room temperature. This system can be used with or without milled glass fiber or mineral reinforcements. It combines rapid demold times, excellent integrity at demold, improved release characteristics, and outstanding physical properties, especially heat sag characteristics. The Bayflex 110-80 system is a formulated elastomeric reaction injection molding (RIM) system supplied as two liquid components. Component A is a diphenylmethane diisocyanate (MDI) prepolymer, and Component B is a polyether polyol system. As with any product, use of the Bayflex 110-80 system in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

General Information			
UL YellowCard	E61384-247032		
Features	Good demoulding performance		
Forms	Liquid		
Processing Method	Reaction Injection Molding (RIM)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792, ASTM D1622
Molding Shrinkage - Flow (3.18 mm)	1.3	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus			ASTM D790
-30°C, 3.18 mm	1380	MPa	ASTM D790
23°C, 3.18 mm	552	MPa	ASTM D790
65°C, 3.18 mm	352	MPa	ASTM D790
Elastomers	Nominal Value	Unit	Test Method
Tensile Strength (Break, 3.18 mm)	24.1	MPa	ASTM D412
Tensile Elongation (Break, 3.18 mm)	140	%	ASTM D412
Tear Strength ¹ (3.18 mm)	82.3	kN/m	ASTM D624
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.18 mm)	270	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
CLTE - Flow (3.18 mm)	1.1E-4	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating (3.18 mm)	HB		UL 94
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components ²			
Component a	Mixing ratio by weight: 69		
Component B	Mixing ratio by weight: 100		
Additional Information	Nominal Value	Unit	Test Method
Heat Sag - 4 in Overhang ³ (121°C, 3.18 mm)	7.87	mm	ASTM D3769

Part A

Type: Isocyanate

Appearance: Light yellow to yellow liquid

Specific Gravity @ 25°C: 1.21

Viscosity @25°C: 700 mPa-s

Flash Point PMCC: 213 °C

Part B

Type: Polyol

Appearance: Dark amber liquid

Specific Gravity @ 25°C: 1.03

Viscosity @25°C: 1200 mPa-s

Flash Point PMCC: 170 °C

Molding Parameters

Material Temperature: 32 °C

Mold Temperature: 60 to 65 °C

Typical Cure Time, 0.125 in: 20 to 30 sec

Polyol Nucleation - Specific Gravity: 0.70 to 0.75 0

NOTE

1.	C mould
2.	105 Index
3.	1 hr

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