

Baydur® 661 IBS (45 pcf)

Polyurethane (MDI)

Covestro - PUR

Message:

Baydur 661 IBS is a gray-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 661 IBS system is used in transportation, 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 661 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		
	Excellent appearance		
Uses	Structural Foam		
	Industrial application		
Appearance	Grey		
Processing Method	Reaction Injection Molding (RIM)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.718	g/cm ³	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	71		ASTM D2240
Shaw D, 12.7mm	74		ASTM D2240
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Fracture, 6.35mm	26.9	MPa	ASTM D638
Fracture, 12.7mm	25.5	MPa	ASTM D638
Tensile Elongation			ASTM D638
Fracture, 6.35mm	7.0	%	ASTM D638
Fracture, 12.7mm	7.0	%	ASTM D638
Flexural Modulus			ASTM D790
6.35 mm	1460	MPa	ASTM D790
12.7 mm	1240	MPa	ASTM D790
Flexural Strength			ASTM D790
6.35 mm	51.7	MPa	ASTM D790
12.7 mm	47.6	MPa	ASTM D790
Compressive Strength			ASTM D695

6.35 mm	31.0	MPa	ASTM D695
12.7 mm	26.9	MPa	ASTM D695
Impact	Nominal Value	Unit	Test Method
Charpy Unnotched Impact Strength ¹	16	kJ/m ²	Internal method
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.35mm	90.0	°C	ASTM D648
0.45 MPa, unannealed, 12.7mm	108	°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: 31.5 wt% Part B Type: Polyol Appearance: Medium gray liquid Specific Gravity @ 25°C: 1.11 Viscosity @25°C: 1800 cps Flash Point PMCC: 117°C Water: 0.35 wt% Material Temperatures: 32 to 35°C Mold Temperature: 55 to 66°C Hand Mix Reactivity at 25°C Cream Time: 16 to 26 sec Gel Time: 30 to 40 sec Tack Free Time: 50 to 60 sec Free-Rise Density: 13 to 15 lb/ft ³ Polyol Nucleation Specific Gravity: 0.85 to 0.95 0 Recommended Shot Time: 5 to 6 sec Typical cure Time, 0.500 in Thickness: 5 sec			
NOTE			
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