Bayfill® 369 (46.9:100)

Polyurethane (MDI)

Covestro - PUR

Message:

Bayfill 369 is a semi-rigid polyurethane foam system designed for automotive interior applications. The Bayfill 369 system is an excellent choice for the production of soft-touch panels, such as instrument panels, door trim, and center consoles. The foam is typically molded in a back-filling process between a soft, exterior skin and a rigid, thermoplastic substrate.
The Bayfill 369 system is supplied as two components. Component A is a polymeric diphenylmethane diisocyanate (PMDI). Component B is a polyol mixture. As with any product, use of the Bayfill 369 system in a given application must be tested (including but not limited to field testing) in advance by the user to determine suitability.

General Information	
Uses	Foam
	Application in Automobile Field
	Car interior parts
	Car interior equipment
	Car dashboard

Physical	Nominal Value	Unit	Test Method
Molded Density	147	kg/m³	ASTM D3574A
Compression Force Deflection			ASTM D3574C
-- [1]	0.117	MPa	ASTM D3574C
-- [2]	0.0483	MPa	ASTM D3574C
Compression Set			ASTM D3574D
Cd [3]	54	%	ASTM D3574D
Cd [4]	33	%	ASTM D3574D
Ct [5]	17	%	ASTM D3574D
Ct [6]	27	%	ASTM D3574D
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength			
-- [7]	0.165	MPa	ASTM D3574K
--	0.317	MPa	ASTM D3574E
Tensile Elongation			
Fracture [8]	44	%	ASTM D3574K
Fracture	54	%	ASTM D3574E
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tear Strength	0.175	kN/m	ASTM D3574F
Thermoset	**Nominal Value**		
Thermoset Components			
Component a	Mixing ratio by weight: 42		
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: 60 cps
Flash Point PMCC: 149°C
NCO: 32.2 wt%
Part B
Type: Polyol
Appearance: Colorless to light tan viscous liquid
Specific Gravity @ 25°C: 1.03
Viscosity @25°C: 1100 cps
Flash Point PMCC: 117°C
Water: 2 wt%
Hydroxyl Number: 70 KOH/g
Mold Temperature: 38 to 43°CDemold Time: >90 secHand Mix Reactivity at 25°C
Cream Time: 9 to 17 sec
Top of Cup Time: 36 to 50 sec
Gel Time: 39 to 53 to sec
Rise Time: 67 to 83 sec
Free-Rise Density: 4.90 to 5.70 lb/ft^3
Machine Reactivity at 27 to 32°C
Cream Time: 6 to 10 sec
Top of Cup Time: 20 to 22 sec
Gel Time: 27 to 31 sec
Rise Time: 44 to 48 sec
Free-Rise Density: 4.00 to 5.00 lb/ft^3
Molded Density: 7 to 10.5 lb/ft^3

NOTE	
1.	0.5
2.	After J2 Autoclave
3.	After J2 Autoclave, Cd=compression set as a percentage of the original deflection
4.	50, Cd=compression set as a percentage of the original deflection
5.	50%, Ct=compression set as a percentage of the original thickness
6.	After J2 Autoclave, Ct=compression set as a percentage of the original thickness
7.	Dry Heat Aged at 140°C
8.	Dry Heat Aged at 140°C

Recommended distributors for this material

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