Bayflex® 110-35 IMR (15% Glass)

Polyurethane (Polyether, MDI)

Covestro - PUR

Message:

Bayflex 110-35 IMR system produces a solid urethane elastomer which has a flexural modulus of approximately 33,500 psi* at room temperature. This system is used to provide multiple releases of large reaction injection molding (RIM) parts, such as automotive fascias. The system contains internal mold release (IMR) and is used with milled glass fiber or mineral reinforcements.
Bayflex 110-35 IMR is a formulated 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 110-35 IMR system in a given application must be tested (including field testing, etc.) in advance by the user to determine suitability.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Uses	Application in Automobile Field Strap		
Forms	Liquid		
Processing Method	Reaction Injection Molding (RIM)		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.14	g/cm³	ASTM D792, ASTM D1622
Molding Shrinkage - Flow (3.18 mm)	0.70	%	Internal method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break, 3.18 mm)	22.1	MPa	ASTM D638
Tensile Elongation (Break, 3.18 mm)	75	%	ASTM D638
Flexural Modulus			ASTM D790
-30°C, 3.18 mm	1900	MPa	ASTM D790
23°C, 3.18 mm	1030	MPa	ASTM D790
65°C, 3.18 mm	689	MPa	ASTM D790
Elastomers	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength (Break, 3.18 mm)	22.1	MPa	ASTM D412
Tensile Elongation (Break, 3.18 mm)	75	%	ASTM D412
Tear Strength [1] (3.18 mm)	105	kN/m	ASTM D624
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (3.18 mm)	160	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**
CLTE - Flow (3.18 mm)	5.0E-5	cm/cm/°C	ASTM D696
Thermoset	**Nominal Value**	**Unit**	**Test Method**
Thermoset Components [2]			
Component a	Mixing ratio by weight: 53		
Component B	Mixing ratio by weight: 100		
Demold Time	0.50	min	
Additional Information	**Nominal Value**	**Unit**	**Test Method**

Heat Sag - 6 in Overhang [3] (121°C, 3.18 mm)	4.06	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: Pale yellow liquid
Specific Gravity @ 25°C: 1.1
Viscosity @25°C: 1250 mPa-s
Flash Point PMCC: 160 °C
Molding Parameters
Material Temperature - Component A: 38 °C
Material Temperature - Component B: 43 to 49 °C
Mold Temperature: 66 °C

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

Recommended distributors for this material

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