Baydur® 661 IBS (45 pcf, 20% Wollastocup)

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/cm³	ASTM D792
Hardness	**Nominal Value**	**Unit**	**Test Method**
Durometer Hardness			ASTM D2240
Shaw D, 6.35mm	70		ASTM D2240
Shaw D, 12.7mm	73		ASTM D2240
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength			ASTM D638
Fracture, 6.35mm	20.0	MPa	ASTM D638
Fracture, 12.7mm	20.0	MPa	ASTM D638
Tensile Elongation			ASTM D638
Fracture, 6.35mm	5.0	%	ASTM D638
Fracture, 12.7mm	5.0	%	ASTM D638
Flexural Modulus			ASTM D790
6.35 mm	2090	MPa	ASTM D790
12.7 mm	1550	MPa	ASTM D790
Flexural Strength			ASTM D790
6.35 mm	44.1	MPa	ASTM D790
12.7 mm	37.2	MPa	ASTM D790
Compressive Strength			ASTM D695
6.35 mm	31.7	MPa	ASTM D695

12.7 mm	22.1	MPa	ASTM D695
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Unnotched Impact Strength			Internal method
-- [1]	6.3	kJ/m^2	Internal method
-- [2]	8.4	kJ/m^2	Internal method
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.35mm	83.0	°C	ASTM D648
0.45 MPa, unannealed, 12.7mm	97.0	°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°CMold Temperature: 55 to 66°CHand 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 0Recommended Shot Time: 5 to 6 secTypical cure Time, 0.500 in Thickness: 5 sec

NOTE	
1.	0.5
2.	0.25 in

Recommended distributors for this material

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