



NATURE OF COMPONENTS		
Prepolymer nature	Nature of chain extender and other components	
MDI-Ester	BAYTEC® XL B	Alcohol chain extender

CHARACTERISTICS OF COMPONENTS								
	Unit	CS-MD1657	DESMODUR® MD1663	DESMODUR® MD1665	DESMODUR® MD1680	DESMODUR® MD1684	DESMODUR® MD1693	BAYTEC® XL B
% NCO	%	5.7 (± 0.2)	6.3 (± 0.2)	6.7 (± 0.2)	8.0 (± 0.2)	8.4 (± 0.2)	9.3 (± 0.2)	-
Physical appearance at room temperature	-	solid	solid	solid	solid	solid	solid	solid
Processing temperature	°C	65	70	80	80	70	70	45
Viscosity at processing temperature	cps	1700	1800	1700	840	1640	1100	30
Specific gravity at processing temperature	-	1.12	1.13	1.18	1.16	1.14	1.15	1.01

ELASTOMER TYPICAL PROPERTIES (DATA GIVEN AS AN INDICATION)								
Prepolymer			CS-MD1657	DESMODUR® MD1663	DESMODUR® MD1665	DESMODUR® MD1680	DESMODUR® MD1684	DESMODUR® MD1693
Chain extender			BAYTEC® XL B					
Hardness at 23°C	ISO 48-4	Shore	75 A	80A	85 A	90A	92A	95A
10% Modulus	DIN 53504	MPa	1.3	1.6	2.1	2.5	3.5	4.9
100% Modulus	DIN 53504	MPa	3.8	4.9	6.1	8.0	9.5	11.6
200% Modulus	DIN 53504	MPa	5.3	6.9	8.8	11.5	13.2	15.6
300% Modulus	DIN 53504	MPa	7.6	9.8	12.7	15.5	18.4	21.1
Tensile strength	DIN 53504	MPa	49	50	50	52	50	52
Elongation	DIN 53504	%	700	640	630	620	610	590
Tear strength : without nick	ISO 34-1	kN/m	92	104	110	125	159	181
Tear strength : with nick	ISO 34-1	kN/m	46	56	60	73	76	96
Resilience	DIN 53512	%	54	43	38	30	33	30
Abrasion loss	ISO 4649	mm³	31	28	25	35	25	24
Compression set (deflection / 22 h / 70 °C)	ISO 815-1	%	23	33	30	30	30	32
Hardness at -5°C	ISO 48-4	Shore	80 A	83A	90 A	93A	94A	96A
Hardness at 80°C	ISO 48-4	Shore	68 A	72A	80 A	84A	88A	91A
Specific gravity			1.24	1.24	1.21	1.24	1.25	1.25

Depending on process conditions. curing and post curing temperature. hardness may vary from ± 2 Shore.

Labelling : This system data sheet is only valid in combination with the corresponding components current safety data sheets ! Any updating of safety relevant information – in accordance with EU directives – will only be reflected in the Safety Data Sheets. copies of which will be revised and distributed. For further technical information relating to safety. the Safety Data Sheets should be consulted.



STORAGE AND USE PRECAUTIONS								
	Unit	CS-MD1657	DESMODUR® MD1663	DESMODUR® MD1665	DESMODUR® MD1680	DESMODUR® MD1684	DESMODUR® MD1693	BAYTEC® XL B
Optimal storage temperature of the drums	°C	< 30						< 30
Storage time (sealed drum)	Month	6						12
PREPARATION BEFORE PROCESSING								
Preheating time / preheating temperature	hr / °C	24 / 70	24 / 70	12 / 80	24 / 80	24 / 70	24 / 70	12 / 45
Homogenization before processing required	-	no						no
Degassing required	-	yes	yes	yes	yes	yes	yes	no

Keep from heat and protect against moisture.

PROCESSING							
Prepolymer		MD1657	DESMODUR® MD1663	DESMODUR® MD1665	DESMODUR® MD1680	DESMODUR® MD1684	DESMODUR® MD1693
Chain extender		BAYTEC® XL B					
Hardness	Shore	75 A	80A	85A	90A	92A	95A
Prepolymer processing temperature	°C	65	70	80	80	70	70
BAYTEC® XL B processing temperature	°C	45					
Parts by weight of prepolymer		100	100	100	100	100	100
Parts by weight of BAYTEC® XL B		6.0	6.6	6.8	8.4	8.8	9.7
SD2.4% / total (by weight) (catalyst at the head)		0.4	0.2	-	0.05	-	-

MOLDING AND CURING							
Mold temperature	°C	100	110	110	110	110	110
Pot life (400g mixture)	min	1'30	3'	5'	3'	5'	5'
Demolding time	min	20'	30'	45'	30'	45'	30'
Post-curing	hr / °C	24 - 100	24 - 100	24 - 100	24 - 100	24 - 100	24 - 100

Use of degassing agent is recommended for hand casting.

A one week aging at room temperature is required to obtain the optimal properties of the elastomer.

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