

Bluesil™ RTV 3625

October 2017

Condensation Cure Silicone Elastomer

Description **Bluesil™ RTV 3625** is a low viscosity, 25 Durometer (Shore A), two component, tin catalyzed, room temperature curing silicone elastomer. It is designed as a high strength elastomer with good cured rubber properties, long library life and accurate detail reproduction. **Bluesil™ RTV 3625** can be catalyzed with **Bluesil™ HI-PRO GREEN**, fast setting **Bluesil™ HI-PRO BLUE**, or **Bluesil™ CATA 58R**.

- Applications**
- Casting of polyester or polyurethane resins for figurine, giftware and decorative accessories
 - Architectural and furniture parts and accessories
 - Statuary and collectibles

Typical Properties

TYPICAL PROPERTIES – AS SUPPLIED		TYPICAL CATALYZED PROPERTIES, mixed at 24°C (75°F) and 50% R.H.	
PART A – Base Component		• Mix Ratio, A:B (Parts by weight)	
• Color	White		10:1
• Consistency	Pourable	• Viscosity, cP. (mPa.s)	44,000
• Viscosity, cP. (mPa.s)	40,000	• Pot Life, Hours⁽¹⁾	4
PART B – Catalyst Component		• Demold Time, hrs at RT	16
• Color		• 24 Hour Thick Section	
HI-PRO GREEN	Green		
HI-PRO BLUE	Blue		
CATA 58R	Clear		
• Viscosity, cP. (mPa.s)	90		

TYPICAL PROPERTIES OF CURED RUBBER, Cured 7 days at 24°C (75°F) and 50% R.H.				
Properties	Test Method	Value		
		HI-PRO GREEN	HI-PRO BLUE	CATA 58R
• Specific Gravity		1.12	1.10	1.10
• Hardness (Shore A)	ASTM D2240	25	27	30
• Tensile Strength, psi (N/mm ²)	ASTM D412	660 (4.6)	620 (4.2)	732 (5.1)
• Elongation (%)	ASTM D412	390	390	277
• Tear Resistance, ppi (N/mm)	ASTM D624, Die B	132	120 (21.1)	62 (10.9)
• Linear Shrinkage ⁽³⁾ , %				
24 Hours		0.2	0.4	0.4
7 Days		0.4	0.6	0.6
• Temperature Range °C(°F)		-50 to 150 (-58 to 302)		

(1) Time at which material gels.

(2) 8x8x0.25in (20.2x20.3cm) molded sheet, cured at room temperature

Please note: the typical properties in this bulletin are not intended for use in preparing specifications for any particular application of **Bluesil™** silicone materials. Please contact our Technical Service Department for assistance in writing specifications.

Processing

1. Stir the base (Part A) well before use (except when machine dispensing).
2. Shake the catalyst container (Part B) well before use.
3. Weigh the desired amount of base into a clean mixing container. Tip the container and roll the base all the way around the side wall up to two inches from the top. This will prevent the catalyst from becoming absorbed into the container. It is recommended that the container be filled to not more than 1/3 the container depth to allow sufficient room for expansion during the deaeration procedure.
4. Weigh the proper amount of catalyst into the container. Mix the base and catalyst together by stirring with a stiff, flat ended metal spatula until a uniform color is obtained. Scrape the container walls and bottom well to insure a thorough mix.
5. Place the container into a vacuum chamber and evacuate the entrapped air from the mixture using a vacuum pump capable of achieving 29 inches of mercury vacuum. The mixture will rise, crest and then collapse in the container. Interruption (bumping) of the vacuum may be necessary to prevent overflowing the container. Keep the mixture under full vacuum for 2- 3 minutes after the material has receded in the container.
6. Bleed air slowly into the vacuum chamber. When the chamber is at atmospheric equilibrium, remove the cover plate and take out the container.
7. Pour the deaired material slowly in a steady stream from one end of the mold box so that the material flows evenly over the pattern. This should minimize entrapment of air bubbles under the flowing material. A "print" coat may be poured first over the pattern which will also help reduce the possibility of entrapping air on the pattern and in the cured rubber. A mold release (petroleum jelly) may be applied on the pattern first to improve release.
8. Allow the rubber to cure for 16-24 hours at 75±5°F (24°C) before removing the cured rubber mold from the pattern. Heat acceleration is not recommended with this product.
9. For best results, allow the mold to air cure an additional 24 hours before using it in production. Full cure is achieved in 3-7 days.
10. For bonding to wood or metals, use **Bluesil™ V-04** primer. Follow recommendations on the **Bluesil™ V-04** technical data sheet for best results.

PROCESSING INFORMATION
CATALYZED PROCESSING PROPERTIES ARE AFFECTED BY
TEMPERATURE AND HUMIDITY VARIATION

1. For best results, mix and cure the material at 75°F (24°C) and 50% relative humidity.
2. Higher temperature and humidity will decrease the work life and pot life of the material. The faster cure will also affect the flow properties. Refrigeration of the base prior to use in hot environments has shown to improve the handling properties of this material.
3. Lower temperatures and humidity will increase the work life and pot life of the material. The slower cure will increase the flow time. Cure temperatures below 68°F (20°C) are not recommended and have been found to cause a reduction in final cure hardness and properties.
4. It is important that the catalyst containers are tightly closed after use. Catalyst exposed to air for extended periods of time will hydrolyze (cure). An indication of hydrolysis is a film or crust formation on the surface of the catalyst. The use of hydrolyzed catalyst is not recommended and may cause incomplete cure.

Storage and shelf life

Bluesil™ RTV 3625 when stored in its original unopened packaging, at a temperature of 24°C (75°F), may be stored for 545 days from the date of manufacture. Beyond this date, Elkem Silicones no longer guarantees that the product meets the sales specifications.
Bluesil™ HI-PRO GREEN, Bluesil™ HI-PRO BLUE, and Bluesil™ CATA 58R when stored in its original unopened packaging, at a temperature of 24°C (75°F), may be stored for 24 months from the date of manufacture. Beyond this date, Elkem Silicones no longer guarantees that the product meets the sales specifications.


Safety

Please consult the Safety Data Sheet of **Bluesil™ RTV 3625**.

Packaging

Bluesil™ RTV 3625 is available in 20 kg and 200 kg containers. **Bluesil™ HI-PRO GREEN and Bluesil™ HI-PRO BLUE** are available in 2 kg and 20 kg containers. **Bluesil™ CATA 58R** is available in 10 kg containers.

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Warning to the users

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