

# BLUESIL V-340

**Description** **Bluesil V-340** is a two component, addition reaction, room temperature or heat accelerated cure silicone rubber compound. It is designed as a variable hardness rubber with high strength properties, long library life, excellent detail reproduction, excellent release characteristics, and improved resistance to inhibition. The specific hardness is dependent on which curing agent is used. **Bluesil V-340** is an excellent choice for pattern shop, model shop, and Stereolithography service bureau mold making and tooling applications.

- Examples of applications**
- Conventional production and prototype molds
  - Finished rubber parts
  - Stereolithography (SLA) molds
  - Casting Architectural moldings

**Key benefits** Please consult your local ELKEM SILICONES sales office.

**Typical properties**

TYPICAL PROPERTIES - AS SUPPLIED		
<b>Part A - Base Component</b>		
<b>Color</b>	Beige	
<b>Consistency</b>	Pourable	
<b>Viscosity, cP. (mPa.s)</b>	45,000	
<b>Part B – Curing Agent</b>		
<b>Color</b>	CA-35	Blue
	CA-45	Blue
	CA-55	Black

<b>TYPICAL CATALYZED PROPERTIES</b>	Mixed at 24°C (75°F) and 50% R.H.
<b>Mix Ratio, A:B (Parts by weight)</b>	10:1
<b>Viscosity, cP. (mPa.s)</b>	25,000
<b>Pot Life, minutes (1)</b>	100
<b>Temperature Range, °C (°F)</b>	-54 to 204 (-65 to 400)
<b>Coefficient of Thermal Expansion, in/in/°C</b>	2.5 x 10 <sup>-4</sup>

TYPICAL PROPERTIES OF CURED RUBBER		cured 24 hours at 25°C (77°F)		
Property	Test Method	Value		
		CA-35	CA-45	CA-55
<b>Mix Ratio, A:B</b>		10:1	10:1	10:1
<b>Color</b>		Blue	Blue	Gray
<b>Specific Gravity</b>		1.33	1.33	1.33
<b>Hardness (Shore A)</b>	ASTM D2240	40	47	53

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<b>Tensile Strength, psi (N/mm<sup>2</sup>)</b>	ASTM D412	870 (6)	800 (5.5)	700 (4.8)
<b>Elongation (%)</b>	ASTM D412	500	400	340
<b>Tear Resistance, ppi (N/mm)</b>	ASTM D624, Die B	180 (31.6)	150 (26.3)	75 (13.2)

**NOTE:** Cure time may be accelerated by oven curing at 49-65°C (120-150°F) for 2-3 hours. HEAT CURING WILL EFFECT PHYSICAL PROPERTIES

TYPICAL ELECTRICAL PROPERTIES		
Property	Test Method	Value
<b>Dielectric Constant, 1kHz</b>	ASTM D150	3.4
<b>Dissipation Factor, 1kHz</b>	ASTM D150	0.007
<b>Dielectric Strength, 75 mil V/mil</b>	ASTM D149	550
<b>Volume Resistivity, ohm-cm</b>	ASTM D257	1 x 10 <sup>15</sup>

(1) Time at which material gels.

Please note: The typical properties are not intended for use in preparing specifications. Please contact our local Sales Department for assistance in writing specifications.

## Instruction of use

### MIXING GUIDELINES FOR BLUESIL PLATINUM CURE MOLDMAKING SYSTEMS

1. Stir the base (Part A) well before use (except when machine dispensing).
2. Shake the curing agent 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 curing agent from being absorbed into the container. Do not fill the container more than 1/3 full to allow sufficient room for expansion during the deaeration procedure.
4. Weigh the proper amount of curing agent into the container.
5. Mix the base and curing agent together by stirring with a stiff, flat ended metal spatula until a uniform color is obtained. Scrape the container walls and bottom to assure a thorough mix. If mechanical mixer is used, do not exceed 150 rpm.
6. 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 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 a full vacuum for 5-10 minutes after the material has receded in the container.
7. Bleed air slowly into the vacuum chamber. When the chamber is at atmospheric equilibrium, remove the cover plate and take out the container.
8. Pour the deaired material slowly in a steady stream from one end of the mold box so that the material flows

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evenly over the pattern. This will minimize the entrapment of air bubbles under the flowing rubber. A "print" coat may be poured first over the pattern, which will also reduce the possibility of entrapping air in the cured rubber. A mold release (petroleum jelly) may be applied on the pattern first to improve release if desired.

**9. CURING:**

**A. ROOM TEMPERATURE CURING SYSTEMS:** Allow the rubber to cure for 16-24 hours at 75°F (24°C) before removing the cured rubber from the pattern. For best results, allow the mold to air cure an additional 24 hours after the initial overnight cure before putting mold into production. Room temperature curing assures the lowest possible shrinkage. If cure acceleration is desired, mild heat may be employed. To minimize shrinkage, cure rubber at 100-130°F (38-54°C) for 4-6 hours. Higher temperatures may cause excessive shrinkage to occur.

**B. HEAT CURING SYSTEMS:** BLUESTAR SILICONES heat-curing systems are primarily used for roll and transfer print pad applications where long work life and pot life are needed. FOLLOW THE SUGGESTED PRODUCT CURE SCHEDULE GUIDE LISTED ON FRONT OF SPECIFIC PRODUCT INFORMATION SHEET.

10. For bonding to wood or metals, use **BLUESIL V-04** primer. Follow recommendations on the **BLUESIL V-04** primer technical data sheet for best results.

**MIXED PROCESSING PROPERTIES WILL BE AFFECTED BY TEMPERATURE VARIATIONS**

A decrease in work life and pot life may be expected to occur at temperatures exceeding 75°F (24°C). Room temperature curing moldmaking rubbers are particularly sensitive to higher temperatures. Refrigeration of the base (Part A) prior to use in hot environments has shown to improve the handling properties of these materials.



Lower temperatures will increase the work life and pot life of this material. Cure temperatures below 68°F (20°C) are not recommended, and have been found to cause a reduction in final cure hardness and physical properties.



This system contains a platinum catalyst, which may be inhibited by materials found in some organic polymer systems, chlorinated solvents, and some substrates. Especially troublesome materials are: amine cured epoxies, sulfur cured organic rubber systems such as natural rubber, polysulfide rubber, latex rubber and adhesives, sulfur containing modeling clays, PVC coated surfaces, and tin catalyzed silicone RTV rubbers. A patch test to determine compatibility is recommended when doubt exists.

<b>Regulation</b>	Please consult your local ELKEM SILICONES sales office.
<b>Limitations</b>	Please consult your local ELKEM SILICONES sales office.
<b>Packaging</b>	<ul style="list-style-type: none"> <li>• BLUESIL V-340 is available in                             <ul style="list-style-type: none"> <li>○ Drum of 200 KG (441 LB)</li> <li>○ Tote bin of 1000 KG (2205 LB)</li> <li>○ Pail of 20 KG (44.1 LB)</li> </ul> </li> </ul>
<b>Storage and shelf life</b>	When stored in its original packaging: BLUESIL V-340 may be stored for up to 24 months from its date of manufacturing. Comply with the storage instructions and expiration date marked on the packaging. Beyond this date, Elkem Silicones no longer guarantees that the product meets the sales specifications.
<b>Safety</b>	Please consult the Safety Data Sheet of:

# BLUESIL V-340

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BLUESIL V-340

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**Warning to the users**

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# BLUESIL CA-35 BLUE

**Description** Used primarily with **BLUESIL V-330** and **BLUESIL V-340**, **CA-35** provides variable hardness of curing for these products.

**BLUESIL™ V-330** is a two component, addition cure, room temperature or heat accelerated cure silicone rubber compound. It is designed as a variable hardness rubber with high strength properties, long library life, excellent detail reproduction, excellent release characteristics, and improved resistance to inhibition. The specific hardness is dependent on which curing agent is used. **BLUESIL™ V-330** is an excellent choice for pattern shop, model shop, and Stereolithography service bureau mold making and tooling applications.

- Examples of applications**
- Conventional production and prototype molds
  - Finished rubber parts
  - Stereolithography (SLA) molds

**Key benefits** Please consult your local ELKEM SILICONES sales office.

**Typical properties**

TYPICAL PROPERTIES - AS SUPPLIED		
<b>Part A - Base Component</b>		
Color	Beige	
Consistency	Pourable	
Viscosity, cP. (mPa.s)	20,000	
<b>Part B – Curing Agent</b>		
Color	CA-35	Blue
	CA-45	Blue

<b>TYPICAL CATALYZED PROPERTIES</b>	Mixed at 24°C (75°F) and 50% R.H.
Mix Ratio, A:B (Parts by weight)	10:1
Viscosity, cP. (mPa.s)	10,000
Pot Life (1), min.	100
Coverage, in <sup>3</sup> /lb. (cc/kg)	21.3 (769)
Temperature Range, °C (°F)	-54 to 204(-65 to 400)

TYPICAL PROPERTIES OF CURED RUBBER			
Property	Test Method	CA-35	CA-45
Color		Blue	Blue
Specific Gravity		1.3	1.3
Hardness (Shore A)	ASTM D2240	25	33
Tensile Strength, psi (N/mm <sup>2</sup> )	ASTM D412	640 (4.4)	650 (4.5)
Elongation (%)	ASTM D412	510	500
Tear Resistance, ppi (N/mm)	ASTM D624, Die B	180 (31.6)	170 (29.8)

# BLUESIL CA-35 BLUE

**NOTE:** V-330 cure time may be accelerated by oven curing at 120-150°F (49-65°C) for 2-3 hours. HEAT CURING WILL EFFECT PHYSICAL PROPERTIES

(1) Time at which material gels.

Please note: The typical properties are not intended for use in preparing specifications. Please contact our local Sales Department for assistance in writing specifications.

## Instruction of use

### MIXING GUIDELINES FOR BLUESIL™ PLATINUM CURE MOLDMAKING SYSTEMS

1. Stir the base (Part A) well before use (except when machine dispensing).
2. Shake the curing agent 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 curing agent from being absorbed into the container. Do not fill the container more than 1/3 full to allow sufficient room for expansion during the deaeration procedure.
4. Weigh the proper amount of curing agent into the container.
5. Mix the base and curing agent together by stirring with a stiff, flat ended metal spatula until a uniform color is obtained. Scrape the container walls and bottom to assure a thorough mix. If mechanical mixer is used, do not exceed 150 rpm.
6. 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 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 a full vacuum for 5-10 minutes after the material has receded in the container.
7. Bleed air slowly into the vacuum chamber. When the chamber is at atmospheric equilibrium, remove the cover plate and take out the container.
8. 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 will minimize the entrapment of air bubbles under the flowing rubber. A "print" coat may be poured first over the pattern, which will also reduce the possibility of entrapping air in the cured rubber. A mold release (petroleum jelly) may be applied on the pattern first to improve release if desired.
9. CURING:
  - A. ROOM TEMPERATURE CURING SYSTEMS:** Allow the rubber to cure for 16-24 hours at 75°F (24°C) before removing the cured rubber from the pattern. For best results, allow the mold to air cure an additional 24 hours after the initial overnight cure before putting mold into production. Room temperature curing assures the lowest possible shrinkage. If cure acceleration is desired, mild heat may be employed. To minimize shrinkage, cure rubber at 100-130°F (38-54°C) for 4-6 hours. Higher temperatures may cause excessive shrinkage to occur.
  - B. HEAT CURING SYSTEMS:** BLUESTAR SILICONES heat-curing systems are primarily used for roll and transfer print pad applications where long work life and pot life are needed. FOLLOW THE SUGGESTED PRODUCT CURE SCHEDULE GUIDE LISTED ON FRONT OF SPECIFIC PRODUCT INFORMATION SHEET.
10. For bonding to wood or metals, use **BLUESIL™ V-04 PRIMER**. Follow recommendations on the **BLUESIL™ V-04 PRIMER** technical data sheet for best results.

### MIXED PROCESSING PROPERTIES WILL BE AFFECTED BY TEMPERATURE VARIATIONS

1. A decrease in work life and pot life may be expected to occur at temperatures exceeding 75°F (24°C). Room temperature curing moldmaking rubbers are particularly sensitive to higher temperatures. Refrigeration of the base (Part A) prior to use in hot environments has shown to improve the handling properties of these materials.
2. Lower temperatures will increase the work life and pot life of this material. Cure temperatures below 68°F (20°C) are not recommended, and have been found to cause a reduction in final cure hardness and physical properties.
3. This system contains a platinum catalyst, which may be inhibited by materials found in some organic polymer systems, chlorinated solvents, and some substrates. Especially troublesome materials are: amine cured epoxies, sulfur cured organic rubber systems such as natural rubber, polysulfide rubber, latex rubber and adhesives, sulfur containing

# BLUESIL CA-35 BLUE

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modeling clays, PVC coated surfaces, and tin catalyzed silicone RTV rubbers. A patch test to determine compatibility is recommended when doubt exists.

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<b>Regulation</b>	Please consult your local ELKEM SILICONES sales office.
<b>Limitations</b>	Please consult your local ELKEM SILICONES sales office.
<b>Packaging</b>	<ul style="list-style-type: none"><li>• BLUESIL CA-35 BLUE is available in<ul style="list-style-type: none"><li>○ Pail of 20 KG (44.1 LB)</li><li>○ Box of 2 KG (4.41 LB)</li></ul></li></ul>
<b>Storage and shelf life</b>	When stored in its original packaging: BLUESIL CA-35 BLUE may be stored for up to 24 months from its date of manufacturing. Comply with the storage instructions and expiration date marked on the packaging. Beyond this date, Elkem Silicones no longer guarantees that the product meets the sales specifications.
<b>Safety</b>	Please consult the Safety Data Sheet of: BLUESIL CA-35 BLUE

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# BLUESIL CA-45 BLUE

**Description** Used primarily with **BLUESIL V-330** and **BLUESIL V-340**, **CA-45** provides variable hardness of curing for these products.

**BLUESIL™ V-330** is a two component, addition cure, room temperature or heat accelerated cure silicone rubber compound. It is designed as a variable hardness rubber with high strength properties, long library life, excellent detail reproduction, excellent release characteristics, and improved resistance to inhibition. The specific hardness is dependent on which curing agent is used. **BLUESIL™ V-330** is an excellent choice for pattern shop, model shop, and Stereolithography service bureau mold making and tooling applications.

- Examples of applications**
- Conventional production and prototype molds
  - Finished rubber parts
  - Stereolithography (SLA) molds

**Key benefits** Please consult your local ELKEM SILICONES sales office.

**Typical properties**

TYPICAL PROPERTIES - AS SUPPLIED		
<b>Part A - Base Component</b>		
Color	Beige	
Consistency	Pourable	
Viscosity, cP. (mPa.s)	20,000	
<b>Part B – Curing Agent</b>		
Color	CA-35	Bl ue
	CA-45	Bl ue

TYPICAL CATALYZED PROPERTIES	Mixed at 24°C (75°F) and 50% R.H.
Mix Ratio, A:B (Parts by weight)	10:1
Viscosity, cP. (mPa.s)	10,000
Pot Life (1), min.	100
Coverage, in <sup>3</sup> /lb. (cc/kg)	21.3 (769)
Temperature Range, °C (°F)	-54 to 204(-65 to 400)

TYPICAL PROPERTIES OF CURED RUBBER		Cured 24 hours at 24°C (75°F) and 50% RH	
Property	Test Method	C A- 35	C A- 45
Color		Bl ue	Bl ue
Specific Gravity		1. 3	1. 3
Hardness (Shore A)	ASTM D2240	25	33



# BLUESIL CA-45 BLUE

Tensile Strength, psi (N/mm <sup>2</sup> )	ASTM D412	<b>640</b> <b>(4.4)</b>	650 (4.5)
Elongation (%)	ASTM D412	<b>510</b>	500
Tear Resistance, ppi (N/mm)	ASTM D624, Die B	<b>180</b> <b>(31.6)</b>	170 (29.8)

**NOTE:** V-330 cure time may be accelerated by oven curing at 120-150°F (49-65°C) for 2-3 hours. HEAT CURING WILL EFFECT PHYSICAL PROPERTIES

(1) Time at which material gels.

Please note: The typical properties are not intended for use in preparing specifications. Please contact our local Sales Department for assistance in writing specifications.

## Instruction of use

### MIXING GUIDELINES FOR BLUESIL™ PLATINUM CURE MOLDMAKING SYSTEMS

1. Stir the base (Part A) well before use (except when machine dispensing).
2. Shake the curing agent 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 curing agent from being absorbed into the container. Do not fill the container more than 1/3 full to allow sufficient room for expansion during the deaeration procedure.
4. Weigh the proper amount of curing agent into the container.
5. Mix the base and curing agent together by stirring with a stiff, flat ended metal spatula until a uniform color is obtained. Scrape the container walls and bottom to assure a thorough mix. If mechanical mixer is used, do not exceed 150 rpm.
6. 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 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 a full vacuum for 5-10 minutes after the material has receded in the container.
7. Bleed air slowly into the vacuum chamber. When the chamber is at atmospheric equilibrium, remove the cover plate and take out the container.
8. 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 will minimize the entrapment of air bubbles under the flowing rubber. A "print" coat may be poured first over the pattern, which will also reduce the possibility of entrapping air in the cured rubber. A mold release (petroleum jelly) may be applied on the pattern first to improve release if desired.
9. CURING:

**A. ROOM TEMPERATURE CURING SYSTEMS:** Allow the rubber to cure for 16-24 hours at 75°F (24°C) before removing the cured rubber from the pattern. For best results, allow the mold to air cure an additional 24 hours after the initial overnight cure before putting mold into production. Room temperature curing assures the lowest possible shrinkage. If cure acceleration is desired, mild heat may be employed. To minimize shrinkage, cure rubber at 100-130°F (38-54°C) for 4-6 hours. Higher temperatures may cause excessive shrinkage to occur.

**B. HEAT CURING SYSTEMS:** BLUESTAR SILICONES heat-curing systems are primarily used for roll and transfer print pad applications where long work life and pot life are needed. FOLLOW THE SUGGESTED PRODUCT CURE SCHEDULE GUIDE LISTED ON FRONT OF SPECIFIC PRODUCT INFORMATION SHEET.

# BLUESIL CA-45 BLUE

10. For bonding to wood or metals, use **BLUESIL™ V-04 PRIMER**. Follow recommendations on the **BLUESIL™ V-04 PRIMER** technical data sheet for best results.

## MIXED PROCESSING PROPERTIES WILL BE AFFECTED BY TEMPERATURE VARIATIONS

1. A decrease in work life and pot life may be expected to occur at temperatures exceeding 75°F (24°C). Room temperature curing moldmaking rubbers are particularly sensitive to higher temperatures. Refrigeration of the base (Part A) prior to use in hot environments has shown to improve the handling properties of these materials.
2. Lower temperatures will increase the work life and pot life of this material. Cure temperatures below 68°F (20°C) are not recommended, and have been found to cause a reduction in final cure hardness and physical properties.
3. This system contains a platinum catalyst, which may be inhibited by materials found in some organic polymer systems, chlorinated solvents, and some substrates. Especially troublesome materials are: amine cured epoxies, sulfur cured organic rubber systems such as natural rubber, polysulfide rubber, latex rubber and adhesives, sulfur containing modeling clays, PVC coated surfaces, and tin catalyzed silicone RTV rubbers. A patch test to determine compatibility is recommended when doubt exists.

<b>Regulation</b>	Please consult your local ELKEM SILICONES sales office.
<b>Limitations</b>	Please consult your local ELKEM SILICONES sales office.
<b>Packaging</b>	<ul style="list-style-type: none"><li>• BLUESIL CA-45 BLUE is available in<ul style="list-style-type: none"><li>○ Pail of 20 KG (44.1 LB)</li><li>○ Box of 2 KG (4.41 LB)</li></ul></li></ul>
<b>Storage and shelf life</b>	When stored in its original packaging: BLUESIL CA-45 BLUE may be stored for up to 24 months from its date of manufacturing. Comply with the storage instructions and expiration date marked on the packaging. Beyond this date, Elkem Silicones no longer guarantees that the product meets the sales specifications.
<b>Safety</b>	Please consult the Safety Data Sheet of: BLUESIL CA-45 BLUE

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# BLUESIL CA-55 GREY

<b>Description</b>	<b>Bluesil™ CA-55</b> is a polyaddition catalyst for platinum cure moldmaking products such as <b>Bluesil™ V-340</b> .
<b>Examples of applications</b>	<ul style="list-style-type: none"> <li>• Conventional production and prototype molds</li> <li>• Finished rubber parts</li> <li>• Stereolithography (SLA) molds</li> <li>• Casting Architectural moldings</li> </ul>

<b>Key benefits</b>	Please consult your local ELKEM SILICONES sales office.
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<b>Typical properties</b>	<b>TYPICAL PROPERTIES - AS SUPPLIED</b>	
	<b>Part A - Base Component</b>	
	<b>Color</b>	Beige
	<b>Consistency</b>	Pourable
	<b>Viscosity, cP. (mPa.s)</b>	45,000
	<b>Part B – Curing Agent</b>	
	<b>Color</b>	CA-55

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<b>TYPICAL CATALYZED PROPERTIES</b>	Mixed at 24°C (75°F) and 50% R.H.
<b>Mix Ratio, A:B (Parts by weight)</b>	10:1
<b>Viscosity, cP. (mPa.s)</b>	25,000
<b>Pot Life (1), min.</b>	100
<b>Coefficient of Thermal Expansion, in/in/°C</b>	2.5 x 10 <sup>4</sup>
<b>Temperature Range, °C (°F)</b>	-54 to 204(-65 to 400)

<b>TYPICAL PROPERTIES OF CURED RUBBER</b>		Cured 24 hours at 24°C (75°F) and 50% RH
<b>Property</b>	<b>Test Method</b>	<b>CA - 55</b>
<b>Color</b>		<b>Gr ey</b>
<b>Specific Gravity</b>		<b>1. 3</b>
<b>Hardness (Shore A)</b>	ASTM D2240	<b>53</b>
<b>Tensile Strength, psi (N/mm<sup>2</sup>)</b>	ASTM D412	<b>65 0 (4. 4)</b>
<b>Elongation (%)</b>	ASTM D412	<b>30 0</b>

# BLUESIL CA-55 GREY

Tear Resistance, ppi (N/mm)	ASTM D624, Die B	85 (1 4. 9)
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**NOTE:** V-330 cure time may be accelerated by oven curing at 120-150°F (49-65°C) for 2-3 hours. HEAT CURING WILL EFFECT PHYSICAL PROPERTIES

(1) Time at which material gels.

Please note: The typical properties are not intended for use in preparing specifications. Please contact our local Sales Department for assistance in writing specifications.

## Instruction of use

### MIXING GUIDELINES FOR BLUESIL™ PLATINUM CURE MOLDMAKING SYSTEMS

1. Stir the base (Part A) well before use (except when machine dispensing).
2. Shake the curing agent 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 curing agent from being absorbed into the container. Do not fill the container more than 1/3 full to allow sufficient room for expansion during the deaeration procedure.
4. Weigh the proper amount of curing agent into the container.
5. Mix the base and curing agent together by stirring with a stiff, flat ended metal spatula until a uniform color is obtained. Scrape the container walls and bottom to assure a thorough mix. If mechanical mixer is used, do not exceed 150 rpm.
6. 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 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 a full vacuum for 5-10 minutes after the material has receded in the container.
7. Bleed air slowly into the vacuum chamber. When the chamber is at atmospheric equilibrium, remove the cover plate and take out the container.
8. 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 will minimize the entrapment of air bubbles under the flowing rubber. A "print" coat may be poured first over the pattern, which will also reduce the possibility of entrapping air in the cured rubber. A mold release (petroleum jelly) may be applied on the pattern first to improve release if desired.
9. CURING:

**A. ROOM TEMPERATURE CURING SYSTEMS:** Allow the rubber to cure for 16-24 hours at 75°F (24°C) before removing the cured rubber from the pattern. For best results, allow the mold to air cure an additional 24 hours after the initial overnight cure before putting mold into production. Room temperature curing assures the lowest possible shrinkage. If cure acceleration is desired, mild heat may be employed. To minimize shrinkage, cure rubber at 100-130°F (38-54°C) for 4-6 hours. Higher temperatures may cause excessive shrinkage to occur.

**B. HEAT CURING SYSTEMS:** BLUESTAR SILICONES heat-curing systems are primarily used for roll and transfer print pad applications where long work life and pot life are needed. FOLLOW THE SUGGESTED PRODUCT CURE SCHEDULE GUIDE LISTED ON FRONT OF SPECIFIC PRODUCT INFORMATION SHEET.

10. For bonding to wood or metals, use **BLUESIL™ V-04 PRIMER**. Follow recommendations on the **BLUESIL™ V-04 PRIMER** technical data sheet for best results.

### MIXED PROCESSING PROPERTIES WILL BE AFFECTED BY TEMPERATURE VARIATIONS

1. A decrease in work life and pot life may be expected to occur at temperatures exceeding 75°F (24°C). Room temperature curing moldmaking rubbers are particularly sensitive to higher temperatures. Refrigeration of the base (Part A) prior to use in hot environments has shown to improve the handling properties of these materials.

# BLUESIL CA-55 GREY

2. Lower temperatures will increase the work life and pot life of this material. Cure temperatures below 68°F (20°C) are not recommended, and have been found to cause a reduction in final cure hardness and physical properties.
3. This system contains a platinum catalyst, which may be inhibited by materials found in some organic polymer systems, chlorinated solvents, and some substrates. Especially troublesome materials are: amine cured epoxies, sulfur cured organic rubber systems such as natural rubber, polysulfide rubber, latex rubber and adhesives, sulfur containing modeling clays, PVC coated surfaces, and tin catalyzed silicone RTV rubbers. A patch test to determine compatibility is recommended when doubt exists.

<b>Regulation</b>	Please consult your local ELKEM SILICONES sales office.
<b>Limitations</b>	Please consult your local ELKEM SILICONES sales office.
<b>Packaging</b>	<ul style="list-style-type: none"><li>• BLUESIL CA-55 GREY is available in<ul style="list-style-type: none"><li>○ Pail of 20 KG (44.1 LB)</li><li>○ Box of 2 KG (4.41 LB)</li></ul></li></ul>
<b>Storage and shelf life</b>	When stored in its original packaging: BLUESIL CA-55 GREY may be stored for up to 24 months from its date of manufacturing. Comply with the storage instructions and expiration date marked on the packaging. Beyond this date, Elkem Silicones no longer guarantees that the product meets the sales specifications.
<b>Safety</b>	Please consult the Safety Data Sheet of: BLUESIL CA-55 GREY

Visit our website [www.elkem.com/silicones/](http://www.elkem.com/silicones/)

#### Warning to the users

The information contained in this document is given in good faith based on our current knowledge. It is only an indication and is in no way binding, particularly as regards infringement of or prejudice to third party rights through the use of our products. ELKEM SILICONES guarantees that its products comply with its sales specifications. This information must on no account be used as a substitute for necessary prior tests which alone can ensure that a product is suitable for given use. Determination of the suitability of product for the uses and applications contemplated by users and others shall be the sole responsibility of users. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorisations. Users are requested to check that they are in possession of the latest version of this document and ELKEM SILICONES is at their disposal to supply any additional information.