

Moldmaking Silicone Rubbers



Bluestar RTV Silicone Rubber

(also known as Rhodorsil®) is used extensively in applications where a flexible, self-releasing mold material is required, specifically rapid prototype tooling, polyurethane casting, and general silicone mold-making. This top quality line of silicone systems offers high accuracy, high heat resistance, and excellent tear strength and elongation properties.

Bluestar silicone rubbers are available in two chemistries—addition cure formulations that feature a platinum-based catalyst and condensation cure silicones that feature a tin-based catalyst.



Bluestar Addition Cure Silicone Rubber

Bluestar Addition Cure Silicone Rubbers offer unlimited shelf life (in the cured state), higher durometers for increased mold stability, and do not inhibit the curing of urethanes when in the cured state.

V-240 Silicone Rubber

- 60A Shore Hardness
- 100,000 cps Viscosity
- 74 ppi Tear Strength

This extremely durable and accurate silicone rubber features a high platinum content, which offers excellent resistance to cure inhibition.

Catalog Number	Description	Availability	Net Wt (Lbs.)
054834	V-240	Gallon	11
054846	V-240 – Base Only	5 Gallon	50
054847	V-240 – Catalyst Only	1/2 Gallon	5
054819	V-240 – Base Only	55 Gallon	400
054820	V-240 – Catalyst Only	5 Gallon	40

V-330 Silicone Rubber

- 25A or 33A Shore Hardness
- 10,000 cps Viscosity
- 180 ppi (CA35) or 170 ppi (CA45) Tear Strength

This addition cure silicone offers the flexibility of two different cured hardnesses depending on the catalyst used. V-330/CA-35 cures to a 25A Shore hardness while V-330/CA-45 results in a slightly harder compound of 33A. Both systems have high tear strengths and excellent detail reproduction.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054809	V-330/CA-45	Quart	2.75
054810	V-330/CA-35	Gallon	11
054808	V-330/CA-45	Gallon	11
054805	V-330 Base Only	5 Gallon	50
054218	CA-35 Catalyst Only	1/2 Gallon	5
055203	CA-45 Catalyst Only	1/2 Gallon	5
054804	V-330 Base Only	55 Gallon	450
054219	CA-35 Catalyst Only	5 Gallon	45
055206	CA-45 Catalyst Only	5 Gallon	45

Silicone Rubber Accessories

Bluestar 47V-50 Silicone Fluid - Non-reactive silicone fluid to thin the viscosity of silicone rubbers

Bluestar V-04 Silicone Adhesion Primer - Primer which promotes silicone adhesion to various substrates.

Bluestar V-06 Silicone Adhesion Primer - Primer which promotes silicone adhesion with Bluestar aerospace and industrial grade silicones.

PT Accelerator - An accelerator for Bluestar Addition cure silicones that provides an accelerated gel time in as short as two hours.

Bluestar VICURE #2 Catalyst - Fast reacting catalyst and accelerator for Bluestar condensation cure silicones.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054924	47V-50 Silicone Liquid	Quart	2
054832	47V-50 Silicone Liquid	Gallon	8
054833	47V-50 Silicone Liquid	5 Gallon	40
054925	47V-50 Silicone Liquid	55 Gallon	440
054816	V-04 Blue Primer	Pint	0.75
054920	V-04 Blue Primer	Gallon	6
054929	V-04 Clear Primer	Gallon	6
054828	V-06R Primer	Pint	0.75
054839	PT Accelerator	Pint	1
054829	#2 Catalyst	4 oz bottle	0.25

V-340 Silicone Rubber

- 40A, 45A or 55A Shore Hardness
- 25,000 cps Viscosity
- 180 ppi (CA35), 150 ppi (CA45) or 75 ppi (CA55) Tear Strength

One of our most popular silicone rubber systems for prototype molding applications, V-340 is a versatile system which offers the flexibility of three different cured hardnesses depending on the catalyst used.

This is a very low viscosity silicone that offers high strength.

Please note: Urethane parts produced from molds using V-3038 catalyst can not be painted.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
055209	V-340/CA-45	Quart	2.75
055217	V-340/CA-35	Gallon	11
055200	V-340/CA-45	Gallon	11
055201	V-340/CA-55	Gallon	11
055202	V-340 Base Only	5 Gallon	50
055218	CA-35 Catalyst Only	1/2 Gallon	5
055203	CA-45 Catalyst Only	1/2 Gallon	5
055204	CA-55 Catalyst Only	1/2 Gallon	5
055205	V-340 Base Only	55 Gallon	450
055219	CA-35 Catalyst Only	5 Gallon	45
055206	CA-45 Catalyst Only	5 Gallon	45
055207	CA-55 Catalyst Only	5 Gallon	45

V-3040 Clear Silicone Rubber

- 39A Shore Hardness
- 40,000 cps Viscosity
- 135 ppi Tear Strength

Specifically formulated to make clear rubber molds, V-3040 features the high strength and excellent clarity required in rapid prototyping applications. V-3040 offers the choice of two hardeners. Both hardeners feature excellent clarity permitting the easy creation of parting lines. The V-3038 catalyst features a "self bleed" additive to aid in part demolding and improve the polyurethane resistance of this rubber for a longer mold life.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054903	V-3040	Quart	2.2
054823	V-3040	Gallon	11
054857	V-3040 Base Only	5 Gallon	50
054858	V-3040 Catalyst Only	1/2 Gallon	5
054931	V-3038 Catalyst Only	1/2 Gallon	5
054871	V-3040 Base Only	55 Gallon	440
054872	V-3040 Catalyst Only	5 Gallon	44

RTV-3460 Silicone Rubber

- 60A Shore Hardness
- 85,000 cps Viscosity
- 140 ppi Tear Strength

RTV-3460 is a two component, addition cure, room temperature curing, 60 Shore A silicone rubber. It is designed for the prototype and architectural industries where urethane elastomers and foams are commonly used. Molds made from RTV-3460 feature high tear strength, excellent dimensional stability in high pressure applications, and improved release characteristics for long mold life. Because of the relatively short working time, meter mix equipment is mandatory for medium to large molds.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054936	RTV-3460	Gallon	11
054934	RTV-3460 Base Only	5 Gallon	50
054935	RTV-3460 Catalyst Only	1/2 Gallon	5
054932	RTV-3460 Base Only	55 Gallon	450
054933	RTV-3460 Catalyst Only	5 Gallon	45

Bluestar Condensation Cure Silicone Rubber

Bluestar Condensation Cure Silicone Rubbers offer softer cured hardness for molds with deep undercuts and a create a more inhibition resistant material (when cured may inhibit the curing of urethanes).

V-1062 Silicone Rubber

- 14A or 15A Shore Hardness
- 27,000 or 32,000 cps Viscosity
- 120 ppi or 110 ppi Tear Strength

V-1062 is a high-performance, tin-catalyzed, room temperature curing silicone. The V-1062 base may be used with the Hi-Pro Green Catalyst at a ratio of 10:1 (base to catalyst) to produce a low shrink, 14 Shore A rubber with a 16 hour demold time.

The V-1062 base may also be used with Hi-Pro Blue catalyst at a ratio of 10:1 (base to catalyst). This faster curing system is able to be demolded in 6 hours and produces a slightly harder, 15 Shore A rubber.

Both rubbers are commonly used for production of polyester figurines, giftware casting, and production molding applications.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054836	V-1062/Hi-Pro Green	Gallon Unit	8.8
054837	V-1062 Base Only	5 Gallon	40
055213	Hi-Pro Green Catalyst Only	1/2 Gallon	4
054878	Hi-Pro Blue Catalyst Only	1/2 Gallon	4

V-1065 Silicone Rubber

- 25A or 30A Shore Hardness
- 45,000 or 43,000 cps Viscosity
- 120 ppi or 100 ppi Tear Strength

V-1065 is a high-performance, tin-catalyzed, room temperature curing silicone. This popular rubber may be used with the Hi-Pro Green Catalyst at a ratio of 10:1 (base to catalyst) to produce a low shrink, 25 Shore A rubber with a 16 hour demold time.

The V-1065 base may also be used with Hi-Pro Blue catalyst at a ratio of 10:1 (base to catalyst). This faster curing system is able to be demolded in 6 hours and produces a slightly harder, 30 Shore A rubber.

Both rubbers are commonly used for production of polyester figurines, giftware casting, and production molding applications.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
055210	V-1065/Hi-Pro Green	Quart Unit	2.2
055211	V-1065/Hi-Pro Green	Gallon Unit	8.8
055212	V-1065 Base Only	5 Gallon	40
055213	Hi-Pro Green Catalyst Only	1/2 Gallon	4
054878	Hi-Pro Blue Catalyst Only	1/2 Gallon	4
055214	V-1065 Base Only	55 Gallon	450
055215	Hi-Pro Green Catalyst Only	5 Gallon	45
054879	Hi-Pro Blue Catalyst Only	5 Gallon	45

VRM-65 Brushable Silicone Rubber

- 25A or 27A Shore Hardness
- Thixotropic
- 125 ppi or 120 ppi Tear Strength

A unique RTV brushable silicone rubber, this moldmaking material was designed for creating glove molds and mask molds. Excellent surface detail replication and extremely high tear strength.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054892	VRM-65 Base Only	5 Gallon	40
055213	Hi-Pro Green Catalyst Only	1/2 Gallon	4
054878	Hi-Pro Blue Catalyst Only	1/2 Gallon	4
054891	VRM-65 Base Only	55 Gallon	450
055215	Hi-Pro Green Catalyst Only	5 Gallon	45
054879	Hi-Pro Blue Catalyst Only	5 Gallon	45

V-1067 Silicone Rubber

- 40A or 37A Shore Hardness
- 50,000 cps Viscosity
- 50 ppi or 40 ppi Tear Strength

V-1067 is a high performance, tin-catalyzed, room temperature curing silicone. This rubber may be used with the V-1067B catalyst at a ratio of 100:2.5 (base to catalyst) to produce a low shrink, 40 Shore A rubber with a 16 hour demold.

The V-1067 base may also be used with Hi-Pro Blue catalyst at a ratio of 10:1 (bases to catalyst). This faster curing system is able to be demolded within six to eight hours and produces a slightly softer 37 Shore A rubber. Both systems are ideal for general moldmaking applications.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054883	V-1067 Base	5 Gallon	40
054884	V-1067B Catalyst (Blue)	Pint	1
054878	Hi-Pro Blue Catalyst Only	1/2 Gallon	4
054921	V-1067 Base	55 Gallon	450
054919	V-1067B Catalyst (Blue)	Gallon	12
054879	Hi-Pro Blue Catalyst Only	5 Gallon	45

V-1068 Special Effects Silicone Rubber

- 14A Shore Hardness
- 25,000 cps Viscosity
- 115 ppi Tear Strength
- Translucent

V-1068 is a translucent silicone rubber that may be easily pigmented for making robotic and animatronic skins, prosthetics, and props for theme parks and the film industry.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054888	V-1068A Base	5 Gallon	40
054889	Hi-Pro Clear Catalyst	1/2 Gallon	4

V-1082 Translucent Silicone Rubber

- 10A Shore Hardness
- 25,000 cps Viscosity
- 120 ppi Tear Strength

V-1082 is a slightly softer version of the V-1068. Also translucent, this product may be easily pigmented for making robotic and animatronic skins, prosthetics, and props for theme parks and the film industry.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054904	V-1082 Base Only	5 Gallon	40
054889	Hi-Pro Clear Catalyst	1/2 Gallon	4
054906	V-1082 Base Only	55 Gallon	450
054886	Hi-Pro Clear Catalyst	5 Gallon	45

RTV 3625 Silicone Rubber

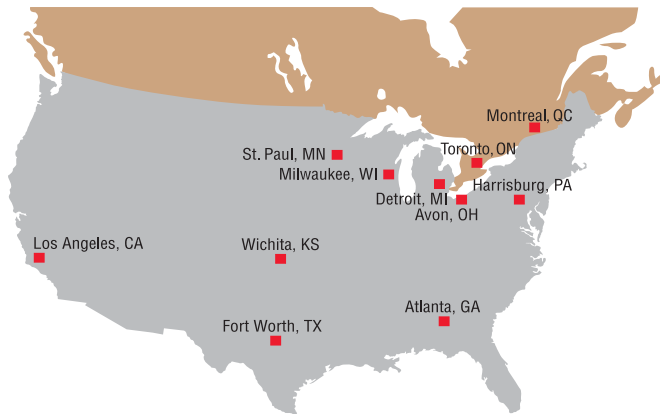
- 25A or 27A Shore Hardness
- 20,000 cps Viscosity
- 120 ppi Tear Strength

RTV-3625 is a low viscosity, 25 Shore A, tin-catalyzed, room temperature curing silicone rubber. It is available with two catalysts. Aqua Cat catalyst will provide very low shrink with a 16 to 18 hour demold, while Fast Cat Blue is able to be demolded in four hours with slightly higher shrink. Available in drums only.

Catalog Number	Description	Availability	Net Wt. (Lbs.)
054926	RTV 3625 Base	55 Gallon	450
054927	Fast Cat Blue Catalyst	5 Gallon	45
054928	Aqua Cat Green Catalyst	5 Gallon	45

Bluestar Silicone Rubber Specifications

Product Number	Hardness (Shore A)	Viscosity (cps) (Mixed)	Mix Ratio (by wt.)	Gel Time	Demold Time (hours)	Elongation (Percent)	Tear Strength (PPi)	Color	Specific Gravity	Volumetric Yield (cu. in./lb.)
Addition Cure Silicone Rubber										
V-240	60	100,000	10:1	2.5 hrs.	16	160	74	Gray	1.23	22.5
V-330/CA35	25	10,000	10:1	100 min.	16	510	180	Blue	1.30	21.3
V-330/CA45	33	10,000	10:1	100 min.	16	500	170	Blue	1.30	21.3
V-340/CA35	40	25,000	10:1	100 min.	16	500	180	Blue	1.33	21.0
V-340/CA45	45	25,000	10:1	100 min.	16	400	150	Blue	1.33	21.0
V-340/CA55	55	25,000	10:1	100 min.	16	340	75	Gray	1.33	21.0
V-3040/3038B	38	40,000	10:1	2 hrs.	16	325	125	Clear	1.08	25.6
V-3040/3040B	39	40,000	10:1	2 hrs.	16	350	135	Clear	1.08	25.6
RTV-3460	60	85,000	10:1	2 hrs.	12-16	230	140	Gray	1.20	23.1
Condensation Cure Silicone Rubber										
V-1062/Hi-Pro Green	14	27,000	10:1	4.5 hrs.	16	520	120	Green	1.10	25.2
V-1062/Hi-Pro Blue	15	32,000	10:1	90 min.	6	500	110	Blue	1.11	24.9
V-1065/Hi-Pro Green	25	45,000	10:1	3 hrs.	16	440	120	Green	1.11	24.9
V-1065/Hi-Pro Blue	30	43,000	10:1	2 hrs.	6	430	100	Blue	1.11	24.9
VRM-65/Hi-Pro Green	25	Thixotropic	10:1	2-4 hrs.	16	400	125	Green	1.11	24.9
VRM-65/Hi-Pro Blue	27	Thixotropic	10:1	60-90 min.	6	390	120	Blue	1.11	24.9
V-1067/1067B	40	50,000	100:2.5	4-5 hrs.	16	300	50	Blue	1.12	24.7
V-1067/Hi-Pro Blue	37	50,000	10:1	60 min.	6-8	250	40	Blue	1.12	24.7
V-1068/Hi-Pro Clear	14	25,000	10:1	4 hrs.	16	450	115	Translucent	1.10	25.2
V-1082/Hi-Pro Clear	10	35,000	10:1	3.5 hrs.	16	550	120	Translucent	1.10	25.1
RTV-3625/AquaCat	25	20,000	10:1	4 hrs.	16	410	120	Green	1.10	25.2
RTV-3625/Fast Cat Blue	27	20,000	10:1	30 min.	4	390	120	Blue	1.10	25.2



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California
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 City of Industry, CA 91746
 TEL 800-325-2100
 FAX 440-934-7200

Pennsylvania
 909 Strickler Road
 Mt. Joy, PA 17552
 TEL 800-631-4230
 TEL 717-653-5300
 FAX 717-653-7372

Georgia
 Shippers Warehouse of Georgia
 9250 S. Main St.
 Jonesboro, GA 30236
 TEL 800-445-0811
 FAX 440-934-7200

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 Wichita, KS 67215
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 FAX 817-568-0908

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