

# Rhodorsil<sup>®</sup> VRM-65

## Condensation Cure Silicone Elastomer

**Description** Rhodorsil<sup>®</sup> VRM-65 is a sprayable or brushable thixotropic moldmaking silicone RTV designed as a 10:1 cure system with high strength rubber properties.

**Applications** • Multi-purpose molding

### Typical Properties

TYPICAL PROPERTIES - AS SUPPLIED		TYPICAL CATALYZED PROPERTIES	
Part A - Base Component		Mixed at 24°C (75°F) and 50% R.H.	
• <b>Color</b>	White	• <b>Mix Ratio</b> , A:B (Parts by weight)	10:1
• <b>Viscosity</b> , cP. (mPa.s)	675,000	• <b>Pot Life</b> , hours <sup>(1)</sup>	4.5
Part B - Catalyst Component (Hi-Pro Green)		• <b>Demold Time</b> , hrs at RT	16
• <b>Color</b>	Green		
• <b>Viscosity</b> , cP. (mPa.s)	90		

TYPICAL PROPERTIES OF CURED RUBBER, Cured 72 hours at 24°C (75°F) and 50% RH		
Property	Test Method	Value
• <b>Color</b>		Green
• <b>Specific Gravity</b>		1.11
• <b>Hardness</b> (Shore A)	ASTM D2240	27
• <b>Tensile Strength</b> , psi (N/mm <sup>2</sup> )	ASTM D412	575 (4)
• <b>Elongation</b> , %	ASTM D412	390
• <b>Tear Resistance</b> , ppi (N/mm)	ASTM D624, Die B	80 (14)
• <b>Temperature Range</b> , °C (°F)		-50 to 150 (-58 to 302)

(1) Time at which material gels.

**Please note:** The typical properties listed in this bulletin are not intended for use in preparing specifications for any particular application of Rhodorsil<sup>®</sup> silicone materials. Please contact our Technical Service Department for assistance in writing specifications.

### Storage and shelf life

When stored in its original unopened packaging, at a temperature of 24°C (75°F), Rhodorsil<sup>®</sup> VRM-65 may be stored for 18 months from the date of manufacture. Beyond this date, Bluestar Silicones no longer guarantees that the product meets the sales specifications.

### Safety

Please consult the Safety Data Sheet. The curing agent for this material can generate a flammable gas upon contact with acidic, basic, or oxidizing materials. Precautions to avoid contact of this curing agent with these materials should be exercised. Keep product away from children. To obtain a material safety data sheet for this product contact Bluestar at 800-356-7560.

# Rhodorsil® VRM-65

## Mixing Guidelines

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 **RHODORSIL® V-04** primer. Follow recommendations on the **RHODORSIL® 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.

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#### Warning to the users

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# Rhodorsil<sup>®</sup> Hi-Pro Green

## Catalyst

### Description

**Rhodorsil<sup>®</sup> Hi-Pro Green** is an organotin carboxylate with additives. It is the standard catalyst for most of the **Rhodorsil<sup>®</sup> V-1060** and **V-1080** series of moldmaking rubber compounds. **Rhodorsil<sup>®</sup> Hi-Pro Green** provides deep section cure capability, fast hardness development and long library life to rubber.

### Applications

- Standard catalyst for condensation cure rubber compounds, specifically **Rhodorsil<sup>®</sup> V-1060** and **V-1080** series

### Typical Properties

<u>TYPICAL PROPERTIES - AS SUPPLIED</u>		<u>TYPICAL CATALYZED PROPERTIES</u>	
		Mixed at 24°C (75°F) and 50% R.H. with <b>Rhodorsil<sup>®</sup> V-1065A</b>	
• <b>Color</b>	Green	• <b>Color</b>	Green
• <b>Consistency</b>	Pourable	• <b>Mix Ratio</b> , A:B (by weight)	10:1
• <b>Viscosity</b> , cP. (mPa.s)	90	• <b>Pot Life</b> , hours <sup>(1)</sup>	3
• <b>Specific Gravity</b>	1.00	• <b>24 Hour Thick Section Hardness</b> , Shore A <sup>(2)</sup>	27
• <b>Flash Point</b> , closed cup	>204°F(96°C)	• <b>Viscosity</b> , cp. (mPa.s)	45,000

<u>EXAMPLE OF CURED RUBBER, with Rhodorsil<sup>®</sup> V-1065A, cured 7 days at 24°C (75°F) and 50% RH</u>		
<u>Property</u>	<u>Test Method</u>	<u>Value</u>
• <b>Color</b>		Green
• <b>Specific Gravity</b>		1.11
• <b>Hardness</b> , Shore A	ASTM D2240	25
• <b>Tensile Strength</b> , psi (N/mm <sup>2</sup> )	ASTM D412	670 (4.6)
• <b>Elongation</b> , %	ASTM D412	480
• <b>Tear Resistance</b> , ppi (N/mm)	ASTM D624, Die B	140 (24.6)

(1) Time at which material gels.

(2) 0.5 in. (1.27 cm) thick cup specimen

Please note: The typical properties listed in this bulletin are not intended for use in preparing specifications for any particular application of Rhodorsil<sup>®</sup> silicone materials. Please contact our Technical Service Department for assistance in writing specifications.

### Storage and shelf life

When stored in its original unopened packaging, at a temperature of 24°C (75°F), **Rhodorsil<sup>®</sup> Hi-Pro Green** may be stored for 24 months from the date of manufacture. Beyond this date, Bluestar Silicones no longer guarantees that the product meets the sales specifications.

### Safety

Please consult the Safety Data Sheet. The curing agent for this material can generate a flammable gas upon contact with acidic, basic, or oxidizing materials. Precautions to avoid contact of this curing agent with these materials should be exercised. Keep product away from children. To obtain a material safety data sheet for this product contact Bluestar at 800-356-7560.

# Rhodorsil® Hi-Pro Green

## Mixing Guidelines





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 **RHODORSIL® V-04** primer. Follow recommendations on the **RHODORSIL® 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.

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# Rhodorsil<sup>®</sup> Hi-Pro Blue

## Catalyst

**Description** Rhodorsil<sup>®</sup> Hi-Pro Blue is an organotin carboxylate with additives. It is the standard catalyst for the Rhodorsil<sup>®</sup> V-1060 series of moldmaking rubber compounds. Rhodorsil<sup>®</sup> Hi-Pro Blue provides deep section cure capability, extremely fast hardness development and long library life to rubber.

**Applications** • Catalyst for fast demolding of condensation cure rubber compounds, specifically Rhodorsil<sup>®</sup> V-1060 series

### Typical Properties

TYPICAL PROPERTIES - AS SUPPLIED		TYPICAL CATALYZED PROPERTIES	
• <b>Color</b>	Blue	Mixed at 24°C (75°F) and 50% R.H. with Rhodorsil <sup>®</sup> V-1065A	
• <b>Consistency</b>	Pourable	• <b>Color</b>	Blue
• <b>Viscosity</b> , cP. (mPa.s)	90	• <b>Mix Ratio</b> , A:B (by weight)	10:1
• <b>Specific Gravity</b>	1.00	• <b>Pot Life</b> , hours	2
• <b>Flash Point</b> , closed cup	>204°F(96°C)	• <b>24 Hour Thick Section Hardness</b> , Shore A <sup>2</sup>	28
		• <b>Viscosity</b> , cp. (mPa.s)	43,000
		• <b>Demold Time</b> , hrs	6

EXAMPLE OF CURED RUBBER, with Rhodorsil <sup>®</sup> V-1065A, Cured 7 days at 24°C (75°F) and 50% RH		
Property	Test Method	Value
• <b>Color</b>		Blue
• <b>Hardness</b> , Shore A	ASTM D2240	30
• <b>Tensile Strength</b> , psi (N/mm <sup>2</sup> )	ASTM D412	630 (4.3)
• <b>Elongation</b> , %	ASTM D412	430
• <b>Tear Resistance</b> , ppi (N/mm)	ASTM D624, Die B	100 (17.5)

(1) Time at which material gels.

(2) 0.5 in. (1.27 cm) thick cup specimen

Please note: The typical properties listed in this bulletin are not intended for use in preparing specifications for any particular application of Rhodorsil<sup>®</sup> silicone materials. Please contact our Technical Service Department for assistance in writing specifications.

### Storage and shelf life

When stored in its original unopened packaging, at a temperature of 24°C (75°F), Rhodorsil<sup>®</sup> Hi-Pro Blue may be stored for 24 months from the date of manufacture. Beyond this date, Bluestar Silicones no longer guarantees that the product meets the sales specifications.

### Safety

Please consult the Safety Data Sheet. The curing agent for this material can generate a flammable gas upon contact with acidic, basic, or oxidizing materials. Precautions to avoid contact of this curing agent with these materials should be exercised. Keep product away from children. To obtain a material safety data sheet for this product contact Bluestar at 800-356-7560.

# Rhodorsil® Hi-Pro Blue

## Mixing Guidelines





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 **RHODORSIL® V-04** primer. Follow recommendations on the **RHODORSIL® 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.

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