

BLUESIL V-330

Description **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 | |
|----------------------------------|------------|
| Part A - Base Component | |
| Color | Beige |
| Consistency | Pourable |
| Viscosity, cP. (mPa.s) | 20,000 |
| Part B – Curing Agent | |
| Color | CA-35 Blue |
| | CA-35 Blue |

| | |
|---------------------------------------------|-----------------------------------|
| 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, in³/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 | CA-35 | CA-45 |
| Color | | Clear & Blue | Blue |
| Specific Gravity | | 1.3 | 1.3 |
| Hardness (Shore A) | ASTM D2240 | 25 | 33 |
| Tensile Strength, psi (N/mm²) | 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) |

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.

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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 desired 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:

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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.

Regulation Please consult your local ELKEM SILICONES sales office.

Limitations Please consult your local ELKEM SILICONES sales office.

Packaging

- BLUESIL V-330 is available in
 - Drum of 200 KG (441 LB)
 - Pail of 20 KG (44.1 LB)

Storage and shelf life When stored in its original packaging:
BLUESIL V-330 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.

Safety Please consult the Safety Data Sheet of:
BLUESIL V-330

Visit our website www.elkem.com/silicones/

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 | | |
|-------------------------------------------------|------------------------------------------|-------------------|--------------|
| | Part A - Base Component | | |
| Color | Beige | | |
| Consistency | Pourable | | |
| Viscosity, cP. (mPa.s) | 20,000 | | |
| Part B – Curing Agent | | | |
| Color | CA-35 | Blue | |
| | CA-45 | Blue | |
| 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, in³/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 | CA-35 | CA-45 |
| Color | | Blue | Blue |
| Specific Gravity | | 1.3 | 1.3 |
| Hardness (Shore A) | ASTM D2240 | 25 | 33 |
| Tensile Strength, psi (N/mm²) | 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

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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| Regulation | Please consult your local ELKEM SILICONES sales office. |
| Limitations | Please consult your local ELKEM SILICONES sales office. |
| Packaging | <ul style="list-style-type: none">• BLUESIL CA-35 BLUE is available in<ul style="list-style-type: none">○ Pail of 20 KG (44.1 LB)○ Box of 2 KG (4.41 LB) |
| Storage and shelf life | 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. |
| Safety | 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 | | |
|----------------------------------|----------|----------|
| Part A - Base Component | | |
| Color | Beige | |
| Consistency | Pourable | |
| Viscosity, cP. (mPa.s) | 20,000 | |
| Part B – Curing Agent | | |
| 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 ³ /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 ²) | 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) |

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.

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| Regulation | Please consult your local ELKEM SILICONES sales office. |
| Limitations | Please consult your local ELKEM SILICONES sales office. |
| Packaging | <ul style="list-style-type: none">• BLUESIL CA-45 BLUE is available in<ul style="list-style-type: none">○ Pail of 20 KG (44.1 LB)○ Box of 2 KG (4.41 LB) |
| Storage and shelf life | 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. |
| Safety | Please consult the Safety Data Sheet of: BLUESIL CA-45 BLUE |

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