

BLUESILTM RTV V-1065 S – CATA HI-PRO GREEN

Description **BLUESIL RTV V-1065 S** is a two component silicone elastomer which, after the addition of catalyst **BLUESIL CATA HI-PRO GREEN**, cures at room temperature by a polycondensation reaction. It is designed as a 25 Shore A providing excellent physical properties.

Examples of applications

- Figurine and giftware casting using polyurethane, polyester, plaster and gypsum cements.
- Moulding of complex parts with deep undercuts and fine details.
- Building: prefabrication of decorative features.

Advantages

- Flexible - good dimensional stability.
- High Elongation and Tear Strength.
- Colour contrast to visually ensure thorough mixing.
- Excellent for use with polyester resins.
- Low density.
- Polyvalent material.

Characteristics **1. Characteristics of the non cured product**

<i>Properties</i>	BLUESIL RTV V-1065 S	CATA HI PRO GREEN
Appearance	viscous liquid	fluid liquid
Colour	white	green
Viscosity (<i>mPa.s, at 23 °C, approx</i>)	60 000	-

2. Polymerization

BLUESIL RTV V-1065 S 100 parts

BLUESIL CATA HI PRO GREEN 10 parts

<i>Properties</i>	BLUESIL RTV V-1065 S
Viscosity (<i>at 23 °C, mPa.s, ISO 3219, approx.</i>)	45 000
Color	green
Pot life (<i>at 23°C, hours</i>)	5
Demolding time (<i>at 23°C, hours, approx.</i>)	16

BLUESIL™ RTV V-1065 S – CATA HI-PRO GREEN**Characteristics (Cont')****3. Characteristics of the cross-linked product**

Cured 7 days at 23 °C and 50 % R.H.

<i>Properties</i>	BLUESIL RTV V-1065 S
Color	Green
Specific Gravity	1.10
Hardness Shore A (ASTM D 2240)	25
Tensile Strength (MPa, ASTM D412)	4.5
Elongation (% , ASTM D412)	450
Tear Resistance (kN/m, ASTM D 624, Die B, approx)	22
Linear Shrinkage (% , approx.)	0.4

Processing**Remix each of the 2 components (base and catalyst) every time before using.****1. Mixing of the two components**

To 100 parts of **BLUESIL RTV V-1065 S** add 10 parts of **BLUESIL CATA HI PRO GREEN**.

The two components are thoroughly mixed either by hand or using an electrical or pneumatic mixer, on a low speed setting so as to limit the inclusion of air in the mixture as well as the temperature rise.

2. Degassing

The mixture is degassed under a vacuum of 30 to 50 mbar. The product will expand under the action of the vacuum to between 3 and 4 times its initial volume and bubbles form on its surface. These bubbles will disappear gradually and the mixture will sink back down to its initial volume within 5 to 10 minutes. Releasing the vacuum once or twice during the operation will improve and facilitate gas removal.

Remark: release the vacuum several times improves the degassing. For easier degassing only fill a recipient to 1/3 of its height.

3. Cross linking

The best curing conditions are at 23°C and 50 % relative humidity. The use of the products at higher temperatures and / or relative humidity levels will reduce the pot life and increase the setting rate. However, the temperature must not exceed 50°C; beyond this temperature there is risk of the product reverting. As opposed to this, lower temperatures and relative humidity levels will increase the pot life and decrease the setting rate. It is recommended not to use the product at temperatures below 20°C; under these conditions, the final product performance levels will be difficult to achieve.

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Processing (cont')

At 23 °C and 50 % relative humidity, the membranes can be demoulded after 16 h-24 h. In order to achieve the best possible performance levels from the membranes, it is preferable to wait for 24 h before using them. The definitive properties will be acquired after 3-7 days.

The recipient containing the catalyst must be carefully closed after use; air moisture causes a reduction in its reactivity over time.

Packaging

BLUESIL RTV V-1065 S is available in 25 kg drums.

BLUESIL CATA HI PRO GREEN is available in a 5 l plastic pot filled with 2.5 kg.

Storage and shelf life

When stored in their original unopened packaging, at a temperature of between –5°C and + 30°C, **BLUESIL RTV V-1065 S** and **BLUESIL CATA HI PRO GREEN** may be stored for up to 18 months from the date of manufacture marked clearly on the packaging.

Beyond this date, Bluestar Silicones no longer guarantees the conformity of the product with the sales specifications.

Safety

Consult the Safety Data Sheets for **BLUESIL RTV V-1065 S** and **BLUESIL CATA HI PRO GREEN**.

Visit our website www.bluestarsilicones.com

EUROPE

Bluestar Silicones France
21 Avenue Georges Pompidou
F69486 Lyon Cedex 03
FRANCE
Tel. (33) 4 72 13 19 00
Fax (33) 4 72 13 19 88

NORTH AMERICA

Bluestar Silicones USA
2 Tower Center Boulevard
Suite 1601
East Brunswick, NJ 08816-1100
United States
Tel. (1) 732 227-2060
Fax. (1) 732 249-7000

LATIN AMERICA

Bluestar Silicones Brazil Ltda.
Av. Maria Coelho Aguiar, 215
Bloco G – 1º andar
05804-902-Sao Paulo – SP-
Brazil
Tel. (55) 11 37477887

ASIA PACIFIC

Bluestar Silicones Hong Kong
Trading Co. Ltd
29th Floor, 88 Hing Fat Street
Causeway Bay
Hong Kong
Tel. (852) 3106 8200
Fax (852) 2979 0241

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