

BLUESIL™ RTV 3240 – CATA N

GOMMA SILICONICA RTV 3240 + CAT N



ANDREA GALLO DI LUIGI S.r.l.
azienda fondata nel 1892
Via Erzelli, 9 - 16152 Genova (Italy)
Tel. 010.650.29.41 - Fax 010.650.38.88
www.andreagallo.it

Description

BLUESIL RTV 3240 is a silicone elastomer which, after the addition of **BLUESIL CATA N**, cures at room temperature and leads to flexible and elastic material.

The crosslinking reaction occurs, without release of heat, the formation of isopropanol, whose dispersion is required before used of the mould or the protected object

Examples of applications

Moulding and reproduction

BLUESIL RTV 3240 enables mass reproduction of shapes, particularly in the following fields:

- Rigid PUR items of furniture or decoration.
- Automobile industry accessories (dashboards, armrests, etc.) in expanded semi-rigid PUR, with self-formed or pressure-particle applied skin.
- Plaster decorative elements (cornices, ceiling roses, etc.).
- Jewellery and decorative items using wax moulding techniques.

Note: BLUESIL RTV 3240 cannot be used for polyester mouldfill, as these material's properties are inhibited on mould contact.

Electronics and electronic technology

Protection, by filling or coating, of modules or electric technology assemblies.

Characteristics

1. Characteristics of the non cured product

Properties	BLUESIL RTV 3240	BLUESIL CATA N
Appearance	Liquid viscous	Liquid
Color	Beige to brown	Translucent
Density (at 23°C, approx)	1.11	0.945
Viscosity (at 23°C, mPa.s, approx)	40 000	/

2. Polymerization

BLUESIL RTV 3240 100 parts
BLUESIL CATA N 4 parts

Properties	BLUESIL RTV 3240
Color	Beige to brown
Pot life (minutes, at 23 °C, approx.)	120
Demolding time (hours, at 23 °C 50 %H.R. approx.)	24



Characteristics (cont')

3. Characteristics of the cross linked product

Measured after curing for 24 hours at 23 °C and 50 % H.R

Properties	BLUESIL RTV 3240
Hardness Shore A (On a 6 mm thick specimen, approx.)	40
Tensile strength at break (1) (MPa, approx.)	2
Elongation at break (1) (% , approx.)	240
Tear strength (KN/m, approx.)	5

On a 2 mm thick specimen

Note: The values quoted hereunder are indicative and cannot be used to draw up specifications. To provide such documents, please contact us.

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 3240** add 4 parts by weight of the selected catalyst. The two components are thoroughly mixed either 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

After mixing base and catalyst, it is recommended to eliminate entrapped air.

If the processing is done with the help of a machine both parts are degassed before mixing.

The **BLUESIL RTV 3240** is degassed under a vacuum of 30 to 50 mbar. Under vacuum pressure, the product will expand 3 at 4 times its initial volume and forms bubbles on its surface.

These bubbles will disappear gradually and the mixture will sink back down to its initial volume within 5 minutes. Release the vacuum and repeat the operation a few minutes later.

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

When taking a print or a particularly rough or porous surface (wood plaster, stone), gripping or suction may hamper mould release, although **BLUESIL RTV 3240** is anti-adhesive by nature.

To forestall any difficulties, a separating agent (Vaseline or acrylic varnish, depending on the nature of the moulded material), should be applied in a layer fine enough not to reduce the relief to be reproduced.

BLUESIL RTV 3240 should be introduced into the lowest part or deepest part of the mould. Slow mouldfill will avoid inclusion of air.

For imprinting of models of very fine contour, mouldfill should be preceded by a paintbrush application of a fine layer of RTV.

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Processing (cont')

4. Viscosity

The viscosity of **BLUESIL RTV 3240** can be reduced by using **BLUESIL FLD 47V50**, added up to 10% with respect to **BLUESIL RTV 3240**. This will improve flowing of the mixed product without causing significant changes of the mechanical properties of the elastomer.

5. Adhesion

BLUESIL RTV 3240 may bond to metal, glass stratified materials, etc. if these substrates receive prior primer applications. Please do contact us for any question concerning primers.

In cases where it is wished to bond the cross-linked **BLUESIL RTV 3240** onto a substrate or onto itself, the surface should be abraded with an emery cloth and covered with a fine layer of CAF. The substrate will be primer treated as shown above, and the bonded joint held in place for 24 hours.

Note: Adhesion problems are by nature complex, and the user is advised to carry out preliminary tests.

Part used drums should be resealed between each use.

Packaging

BLUESIL RTV 3240 and **BLUESIL CATA N** are delivered in the following packaging:

- 1 kg RTV + 40 g catalyst.

- **BLUESIL RTV 3240**: 20 kg plastic drums, with appropriate quantities of **BLUESIL CATA N**.

Storage and shelf life

When stored in their original unopened packaging at a temperature of between – 5°C and +30°C, **BLUESIL RTV 3240** and **BLUESIL CATA N** may be stored for up to 18 months, from their date of manufacture.

Comply with the storage instructions and expiry date marked on the packaging.

Beyond this date, Bluestar Silicones no longer guarantees that the products meet the sales specifications.

Safety

Consult the Safety Data Sheets for **BLUESIL RTV 3240** and **BLUESIL CATA N**.

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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