

BLUESILTM

RTV 3325 P – CATA 83

Description **BLUESIL RTV 3325 P** is a two-component silicone elastomer which upon reaction at room temperature through the addition of **BLUESIL CATA 83** acquires good mechanical and resilient properties.

Examples of applications Taking imprints by impression of vertical or overhanging models or whenever the model is too large to be moved.

Finds application in the following sectors:

- Archaeology: reproduction of bas-reliefs and statues.
- Palaeontology: reproduction of fossils or stones.
- Decorations: cornices, rosettes, statuettes, candles, advertising objects

Advantages

- Easy application
- Low linear shrinkage and good heat seal of the moulds obtained
- Easy release of the copies thanks to the anti-stick property of the silicone elastomers.

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

<i>Properties</i>	BLUESIL RTV 3325 P
Appearance	non-flowing paste
Colour	White grey
Density (at 23°C, approx.)	1.20

<i>Properties</i>	BLUESIL CATA 83
Appearance	Fluid paste
Colour	Lemon yellow

2. Polymerization

BLUESIL RTV 3325 P 100 parts
BLUESIL CATA 83 4 parts
 Working time (at 23 °C, 50 % humidity relative, minutes) 90
 Demoulding time (at 23 °C, 50 % humidity relative, hours) 16

BLUESILTM RTV 3325 P – CATA 83**Characteristics (cont')****3. Characteristics of the cross linked product**

Measures carried out after cross linking over 4 days at 23 °C

<i>Mechanical properties</i>	BLUESIL RTV 3325 P
Shore A hardness (on a 6 mm thick specimen, approx.)	25
Tensile strength (MPa, approx.)	2.5
Elongation at break (% , approx.)	350
Tear strength (KN/m, approx.)	9
Linear shrinkage (%)	0.4

Processing

It is advised to remix both base and catalyst before mixing them together.

1. Mixing of the two components

To 100 parts of **BLUESIL RTV 3325 P** add 4 parts by weight of **BLUESIL CATA 83**. The two components should be mixed by hand. In order to avoid the paste to stick upon the skin it's recommended to wet the hand with water. Mix until perfect dispersion of the catalyst into the silicone paste (no coloured smears in the mixture).

2. Cross linking

The best curing conditions are at 23°C and 50 % relative humidity. The use of products at higher temperatures and/or relative humidity levels will reduce the pot life and increase the setting rate. As opposed to this, lower temperatures and relative humidity levels will increase the pot life and decrease the setting time. 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.

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

3. How to use

Apply directly on the model by hands, be aware to achieve a good contact in order to avoid bubbles and voids.

Models can be made of several materials, stones, concrete, terracotta etc. Even though silicone is naturally no-adhering to most materials is always recommendable to prepare the model to avoid any risk of the silicone sticking and so damaging the model. Remove dust and apply a pore filler like soapy water, waxes diluted in xylene etc.

To improve the quality of the imprint on particularly intricate-shaped model we recommend to apply first by brush several layers of **BLUESIL RTV 3325 P + BLUESIL CATA THIXO** and to fill the more accentuated undercuts with **BLUESIL RTV 3325 P + BLUESIL CATA 83** to better support the final mould.

Packaging

BLUESIL RTV 3325 P is delivered in 25 kg and 5 kg plastic drum with **BLUESIL CATA 83** in appropriate quantities.

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Storage and shelf life

When stored in their original unopened packaging at a temperature of between – 5°C and + 30°C, **BLUESIL RTV 3325 P** and **BLUESIL CATA 83** may be stored for up to 12 months from the date of manufacture clearly marked on the packaging.

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

Safety

Consult the Safety Data Sheet for **BLUESIL RTV 3325 P** and **BLUESIL CATA 83**.

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