

BLUESIL RTV 3621 A/B

Description	Bluesil™ RTV 3621 A&B is a two component silicone elastomer that cures at room temperature by polyaddition reaction, at a 1:1 ratio. It is designed to be used for molding in a variety of applications and particularly for those requiring realistic skin feel.
Examples of applications	<ul style="list-style-type: none"> • Molding life like parts • Animatronics; special effect skins • Props for the film industry • Theme park props and reproduction molds
Key benefits	<ul style="list-style-type: none"> • Easy to use viscosity • Translucent – can be pigmented • Excellent reproduction of details • Excellent mechanical properties • Low linear shrinkage • High resistance to inorganic chemicals and ultraviolet rays

Typical properties	As Supplied			
	Property	Test Method, CTM	BLUESIL RTV 3621 A	BLUESIL RTV 3621 B
	Appearance	TP 038	Low viscosity liquid	Low viscosity liquid
	Color	TP 038	Translucent	Transparent
	Viscosity, cps		6,00	6,000
	Specific Gravity	TP 013	1.1	1.1

Property	Test Method	Unit	Value
Mix Ratio			1:1
Pot Life, 23° C	NM 128	Minutes	60
Hardness ¹	D 2240	Shore A	20
Tensile strength	D 412	psi (N/mm ²)	580 (4)
Elongation	D 412	%	500
Tear Strength	D 624, Die B	ppi (N/mm)	86 (15)

(1) 6mm thick disk

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	<p>1. Mixing the two components</p> <p>The components A and B are mixed by weight in the above indicated ratio. The mixing can be carried out either by hand or using a low-speed electric or pneumatic mixer to minimize the introduction of air and to avoid any temperature increase. It is also possible to use a special mixing and dispensing machine for the two silicone components. Further information is available upon request.</p> <p>2. Degassing</p> <p>The mixture should be degassed preferably at 30 to 50 mbar to eliminate any entrapped air. If a dispensing machine is used, the two components are degassed separately prior to mixing. The silicone mixture expands to 3 to 4 times of its initial volume and bubbles rise to the surface. The bubbles progressively disappear and the mixture returns to its initial volume after 5 to 10 minutes.</p> <p>Wait a few minutes to complete the degassing and then flash the vacuum. The silicone is ready for pouring, either by gravity or under low pressure.</p>
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Note: Flashing the vacuum once or twice accelerates the degassing. It is recommended to use a container with a high diameter / height ratio.

3. Polymerization

The system polymerizes at 23 °C. The curing may be slowed down by lowering the temperature and accelerated by adding heat.

4. Inhibition

Contact with certain materials can inhibit the crosslinking. See list below:

- Natural rubbers vulcanized with sulphur,
- RTV 2 silicone elastomers catalyzed with metal salts, e.g. tin-compounds,
- PVC stabilized with tin salts and additives,
- Epoxy resins catalyzed with amines,
- Certain organic solvents, e.g. ketones, alcohols, ether etc.

In case of doubts, it is recommended to test the substrate by applying a small quantity of the mixed silicone on a restricted area.

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 RTV 3621 A is available in <ul style="list-style-type: none"> ○ Drum of 200 KG (441 LB) ○ Pail of 18 KG (39.69 LB) • BLUESIL RTV 3621 B is available in <ul style="list-style-type: none"> ○ Drum of 200 KG (441 LB) ○ Pail of 18 KG (39.69 LB)
Storage and shelf life	When stored in its original packaging: BLUESIL RTV 3621 A may be stored for up to 6 months from its date of manufacturing. BLUESIL RTV 3621 B may be stored for up to 6 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 RTV 3621 A and BLUESIL RTV 3621 B

Visit our website www.elkem.com/silicones/

Warning to the users

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