



BLUE CAST LCD/DLP

This resin can work with LCD printers 405nm like Wanaho D7 (min. 30 watt LED power) and all DLP machines like 3DS Project 1200, Miicraft, Kudo Titan 2, Moonray,etc (HD LED Projector 385 - 405 nm)

PRODUCT FEATURES

Very low shrinkage and High Accuracy

Minimal residue after burnout process (0.005%)

Low-exhaust emission during the burnout process

Virtually no expansion of resin during burnout process

Compatible with all investments (Tested with Kerr® Satincast, R&R PlastiCast, Optima Prestige, Omega Plus). Very good castability.

Washable with 90%/99% denatured alcohol (IPA) or ethyl alcohol 90%/99%

Less irritation, free of toxic substances

Very low deformation during post-printing

Direct casting of models with no need for lacquer or Teflon® (PTFE) spray

Exceptional weldability with wax sprues - Exceptional hand workability

High definition of details and consistency of surfaces

Remarkable definition of micro-incisions and micro-reliefs, including the ability to create watermarks with a minimum thickness of 0.2mm

Suitable for all kind of jewel design, micropavè, engravings, filigree, Engagement ring, chevalier etc

Created for professional use only. Keep out of reach of children. Do not ingest or allow contact with eyes, mouth, and other membranes. Always use proper safety protection while handling any resin materials.

Although BlueCast resin contains no toxic or irritating substances, care should always be exercised when working with chemicals. For more information, please



refer to the MSDS from the manufacturer.

QUICK START GUIDE

Use a resin tank provided with high quality FEP (127 HD, 150)

Preheat the resin to 40°C (104°F) for best results with printing details.

Before use, shake the resin container for 60 seconds. If the resin has been sitting in the tank, use the putty knife to ensure it's thoroughly mixed.

On the LCD printers like Wanaho D7 (30 / 40 watt) start from this settings:

0,05 mm z Resolution

5 bottom layers - exp time 60 seconds

Other layers - from 10 to 14 seconds (depend on geometry)

Z lift - 5mm

Z lift speed -40 mm/min

Antialiasing - Off

0,03 mm z Resolution

5 bottom layers - exp time 60 seconds

Other layers - from 7 to 10 seconds (depend on geometry)

Z lift - 5mm

Z lift speed - 40 mm/min

Antialiasing – Off

For DLP machine, start using the standard castable resin exposure time reduced of 20%

POST-PRINTING CLEANUP

Clean the prints by pouring 91%/99% denatured alcohol (IPA) or ethyl alcohol



90%/99% over the prints instead of the usual cleaning process of dipping.

Dry and clean the pieces using a can of compressed air for best results.

UV post-curing is needed (approx 30 min). The color of prints change to white when ok.

Invest the pieces as usual and burn out.

Follow the manufacturer's burnout cycle for your chosen investment.

IMPORTANT TIPS

Check resin tank before EVERY print. BlueCast is not liable for any damage caused to the printer by cracking or leakage of the resin tank / fep.

We recommend printing large rings horizontally.

DO NOT store the resin for more than 24 hours in the resin tank. BlueCast is highly hygroscopic, and will absorb moisture from the air. It is advisable to filter the resin after each print cycle and store it in its original container for optimal preservation and to prevent alteration of its characteristics.

Do not store the resin in clear containers, as it is highly light-sensitive and will damage the resin.

HOW TO FIX PLATFORM ADHESION ISSUE

- check Z offset and if necessary do the calibration
- use sand paper (200 400 grain) to abrade alu plate to promote adhesion
- use corners of table instead central position
- use bigger base into 3D model
- use a drop of uv glue well massaged on plate onto printing position (Loca UV glue, Ebay) (pay attention that will be very hard to remove part from plat.
- try our special primer: Primer Cat

If you have again problem....please advise us.