



BLUE CAST ORIGINAL FOR FORMLABS 3DP

PRODUCT FEATURES

Minimal residue after burnout process (0.003%)

Low-exhaust emission during the burnout process

Virtually no expansion of resin during burnout process

Extreme castability

Ultra-fast burnout cycle available (1 hour)

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

No UV post-curing necessary

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

Less irritation, free of toxic substances

Low deformation post-printing

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

Exceptional weldability with wax sprues

Exceptional hand workability (UV post-curing needed to harden big models)

High definition of details and consistency of surfaces

Perfect for Chevalier-style jewelry and micro-signet designs

Two years of testing and development, resulting in a superior product to currently available resins for the jewelry, dentistry, and other casting

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 new resin tank, or one that has been thoroughly cleaned.

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.

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

In PreForm, choose the Castable v2 setting, or Gray v2 profile for more detailed pieces. Upload the file to the printer (The choice of profile depends also on the functionality and on the year of manufacture of the machine).

On the Form 2, use the Settings menu to choose Open Mode. The wiper and heater will be disabled.

Fill the tank to the maximum fill line, or to the appropriate amount needed.

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 not necessary, unless the pieces require hand-finishing.

Invest the pieces as usual and burn out.

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

FAST BURNOUT

The ideal temperature for burnout of BlueCast resin is 850°C or 1560°F.

For fast burnout it is necessary to use an investment able to work over 850°C. We recommend the use of high quality investment.

For a fast burnout schedule, let the flask/investment stand for at least 60-90 minutes, preheat the kiln to 850-860°C (1560-1580°F), then insert the cylinder and keep the temperature constant for 60-90 minutes. Reduce the temperature to your casting temperature and hold for 60 minutes before casting as usual.

During initial burnout, turn the flask on its side, then turn with the button facing up for the rest of the cycle to ensure good air flow.

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.

For optimum results, do not crowd the build platform. Six or seven pieces at a time works well.

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 ISSUES

- check Z offset and if necessary let the platform push more on PDMS (-0.2, -0.3)
- 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.