



## BLUE CAST LS FOR FORMLABS 3DP

### PRODUCT FEATURES

Very low shrinkage and High Accuracy

Minimal residue after burnout process (0.003%)

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 micropavè, engravings, filigree, Engagement ring, 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 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 needed. The color of prints change 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.

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 ISSUE

- 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.