



BLUE CAST CLEAR D

FORMLABS

PRODUCT FEATURES

High dimensional accuracy

Heat resistant

Very smooth surface after printing and excellent hardness

Suitable for silicone and rubber molds (120 °C)

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.

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.

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

Make the printing files starting from this preform profile:

- Open Mode
- Clear V2
- Thickness: 0.05 mm

POST-PRINTING CLEANUP

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



90%/99%: usual cleaning process of dipping for 10 mins.

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

UV post-curing is needed, 90 min with 40 Watt uv system (405nm – 40 °C)

IMPORTANT TIPS

Check resin tank before EVERY print. BlueCat 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.

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

The resin can cause the oxidation of build platform. This don't affect the printing quality or lower the life time of platform. For clean the platform use a tissue paper, and alcohol for 2 or 3 times.

HOW TO FIX PLATFORM AHESION IUSSE

- 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 - strongly recommended

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