



# BLUE CAST X10

## PRODUCT FEATURES

- Castable resin based on the experience of BlueCast X5.
- Excellent casting of small engravings both positive and negative.
- Suitable for all jewelry needs: from filigree to medals, as well from chaton settings to signet rings.
- Excellent for stones presetting (improved elasticity).
- No smell.
- Negligible shrinkage (0.7% after 7 days).
- Easy welding with wax.
- Excellent yield of details with all investments. No chemical aggression of the investment during burnout cycle.
- Possible manual refinishing (post cure is needed).
- Monomers absence.
- Extremely detailed.
- Smooth surfaces.
- Burnout cycle improved.
- Suitable for all fast burnout cycles.
- Full burnout also at lower temperature (740°C, flask).
- Excellent dimensional stability in time.



## **QUICK START GUID FOR LCD PRINTERS**

Blue Cast LCD/DLP resin is fully compatible with all LCD printers like Phrozen Shuffle, XL, Wahnaho D7, D8, Micromake 2017 L2, EAST Micromake L2, X-CUBE LCD, Vodainfo Tech. LCD, Xayav Model V, etc (405nm \_ min. 30 watt LED power).

Use a resin tank provided with high quality FEP(FEP 100 OR 127 HD are suggested).

Before use, shake the resin container.

In case of particular climatic conditions (such as in case of room temperature inferior to 20°C) it is suggested to preheat the resin. If the resin has been sitting in the tank, use the putty knife to ensure it is thoroughly mixed.

It is suggested to filter the resin before each use, in order to avoid any damage to LCD screen.

Use the adapt PrimerCat primer to improve the resin adhesion to the platform. Put 2 or 3 drops on the print platform and spread them with the help of a spatula until an invisible and homogeneous film is achieved.

On the LCD printers like Wanaho D7 and Anycubic Photon (30 / 40 watt) start from these settings:

### **0,05 mm z Resolution**

5 bottom layers - exposure time 60 seconds

Other layers - from 15 to 20 seconds (depend on geometry)

Z lift - 5mm

Z lift speed - 40 mm/min

Antialiasing - Off

### **0,03 mm z Resolution**

5 bottom layers - exposure time 80 seconds

Other layers - from 12 to 15 seconds (depend on geometry)

Z lift - 5mm



Z lift speed - 40 mm/min

## **POST-PRINTING CLEANUP**

Clean the prints by pouring 91%/99% denatured alcohol (IPA) or ethyl alcohol 90%/99% (approximately 1 minute).

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

## **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.

We recommend printing large rings horizontally.

DO NOT store the resin for more than 48 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.