



BLUE CAST KERA MASTER DENTAL

DLP LCD

Compatible with all DLP / LCD 3d printer (405 nm) with FEP bottom tank

PRODUCT FEATURES

High dimensional accuracy

Very smooth surface after printing and excellent hardness

Proper color to highlight details

Shrinkage near to 0 for the dentals models

High printing speed

High stability of the resin pigment

Very low tank deterioration

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.



LCD

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

0,05 mm z Resolution

5 bottom layers - exp time 40 seconds

Other layers - from 6 to 8 seconds (depend on geometry)

Z lift - 5mm

Z lift speed -40 mm/min

Antialiasing – Off

Waiting time before print – 1 sec

HIGH POWER LCD

On the LCD printers like Slash + start from this settings:

0,05 mm z Resolution

Led Power 250 Watt

5 bottom layers - exp time 15 seconds

Other layers - from 2.5 to 4 seconds (depend on geometry)

Z lift - 5mm

Z lift speed -40 mm/min

Antialiasing – Off

DLP HD (405 nm)

0,05 mm z Resolution

5 bottom layers - exp time 15 seconds



Other layers - from 2 to 3 seconds (depend on geometry)

Z lift - 5mm

Z lift speed - 60 mm/min

Dimmer time: 1.5 seconds (Extending time can improve print quality)

Antialiasing – Off

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, 30 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

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