BLUECAST X-Filigree V2®

Please read and understand these Guidelines before opening and using X-Filigree resin.

PRODUCT FEATURES

- Improved castable resin specifically developed for print and casting extreme filigree designs.

- Perfect casting results with any kind of investments and burnout cycles. Standard wax burnout (12 hrs), Fast burnout (6 hrs), Ultra fast burnout (2 hrs).

- Improved accuracy and weight repeatability.

- Improved rigidity and hand workability.

- Perfect printing properties with sharp details: suitable for jewelry with micro-pave and filigree

- Create lighter jewelry with perfect accuracy.

- No bleeding issue also on LCD machines.

- Excellent dimensional stability in time. No shrinkage.

- Low viscosity even at low temperature (easier to clean, easier to get back from patterns).

- Strong adhesion to platform, no need to primer.

- Toxic and carcinogenic component free, Low fumes emission during burnout. Very low VOC and negligible smell.

- Low fumes emission during burnout

QUICK START GUIDE FOR LCD PRINTERS

Before use X-Filigree V2 please read these instructions with attention.

Following informations are suitable only for X-Filigree V2 resin and will not apply to other BlueCast resins.

BlueCast X-Filigree V2 resin is fully compatible with the new monochromatic LCD Generation and DLP printers.

On old RGB LCD machines the exposure times are much more longer than standard resins. With some COB LED machines the resin may not work.

In order to get the maximum details use of HD FEP or No-FEP are strongly suggested. A bad quality FEP compromise the resin printability.

Before run the Z-Axis calibration, please check if your build platform is planar. The colored platform coating like the one of the old Anycubic Photon or Elegoo Mars inhibits the sticking of the castable resins. To fix this machine issues you can sand the build platform with 150/200 grade sandpaper.

Perform z-axis calibration following the manufacturer's instructions.

Before use we suggest to heat the resin by microwave ovens (NEVER OVER 30 SECONDS), ultrasonic cleaner, hot air, etc.

Before pour the resin into the resin tank shake the bottle for one minute.

For a correct debubbling let the resin rest in to the resin tank for 5 minutes before start the print. To speed up the operations you can also filter the resin in order to remove the air bubbles or or vacuum the opened bottle.

Not filter the resin after each print and not heating the resin before each print may lead to printing failures. Do not store the resin in to the tank. Please remove the resin from printer tank, filter it and store in to the original bottle.

PLEASE NOTE THE EXPOSURE TIME CAN CHANGE BY 30% IN ACCORDING TO THE MANUFACTURER LED CALIBRATION, TO THE USED FEP AND TO THE PRINTER EFFICIENCY

PRINTING SETTINGS

We don’t provide official after sales service for the machines not listed below. The settings are specifically developed for Chitubox slicer.

Click the link to open the web printing profiles folder

CHITUBOX PRINTING PROFILES

POST-PRINTING CLEANUP AND TREE PREPARATION

Patterns are really hard and siff respect other BlueCast resins

Clean the prints into 91%/99% ethyl alcohol.

- With Ultrasonic cleaner run a cycle of 3 minutes (SUGGESTED PROCEDURE)
- With resin washer machine run a cycle of 5 minutes approx.
- With simple immersion in an alcohol bath wait 8 minutes approx.

After washing dry the patterns with compressed air.

If you don’t have compressed air you can dry the pattern with a hair dryer.

A patterns post curing (10 minutes minimum) is required.

After the UV post a curing quick washing with brand new alcohol ensure great casting results.

Same as wax, use sand paper to make welding zone rough, apply a drop of wax, stay on for some seconds, weld wax sprue.

X-Filigree V2 is suitable for fast /production wax burnout, if you want to use it mind you need to apply for extra wax sprues around pattern; wax will melt away quickly leaving routes for resin exit.