

BlueDent _ Dental Cast

For all LCD and DLP 3d printers (385-405)

PRODUCT FEATURES

HIGH ACCURACY AND DIMENSIONAL STABILITY

FAST PRINTING SPEED

PERFECT CASTING PROPERTIES WITH SHARP DETAILS

NO BLEADING ISSUE ALSO ON LCD MACHINES.

MATTE FINISHING FOR BETTER DETAILS

NO INVESTMENT CRACKS OR EXPANSION – 100% ASH FREE BURNOUT

PERFECT FOR E-MAX PRESS LOST WAX CASTING

- BD Blue Dental Cast have been developed in collaboration with dental experts.

Without shrinkage, extreme accuracy and dimensional stability, it is suitable for any kind of applications like dental frames, crowns, bridges and Toronto bars.

- Perfect casting and success results with any dental investment materials and any kind of alloy. It makes possible to obtain high quality castings. Opposite to main casting resins, it melts instead of burning, making the casting process much easier.

- Blue Dental Cast it can be used on all open source SLA, MSLA / LCD and DLP 3D printers.



QUICK START GUIDE FOR LCD PRINTERS

BD Blue Dental Cast resin is fully compatible with all LCD printers (RGB and Monochromatic) and DLP machines.

For best results we suggest to use a resin tank provided with high quality FEP (FEP 100 OR 127 HD are suggested).

In case of particular climatic conditions (such as in case of room temperature inferior to 18°C) it is suggested to preheat the resin. If the resin has been sitting for a long time into the tank, use the putty knife to ensure it is thoroughly mixed.

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

The platform adhesion is perfect and permit to print multiples files in the same time.

PRINTING SETUP

With BlueDent Dental Cast you can easy arranging the models using few and small supports. Raft is not needed.

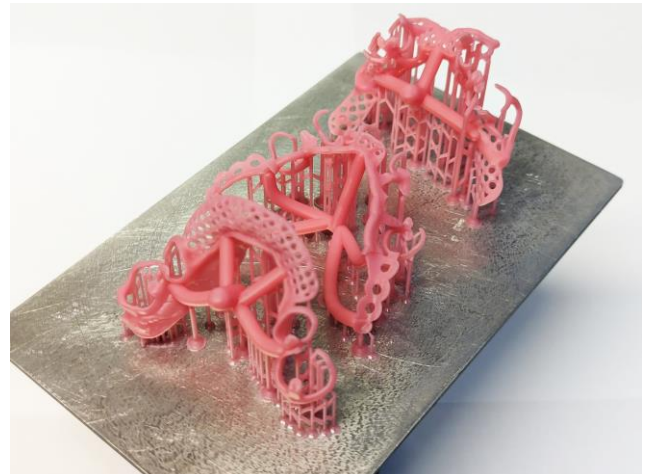
Perform z-axis calibration following the manufacturer's instructions.

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.



SUGGESTED 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

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.

BD Dental Cast 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.