

## BLUE CAST \_ BC CR3A - For all LCD 3d printers

### PRODUCT FEATURES

- Consistent casting quality as BlueCast standard
- Ash residual 0.00%
  - \_ proprietary TGA at 750°C / 4 hrs without contact to air, in closed vessel
- Low cost
- Negligible shrinkage
- No primer needed
- Monomer based resin (\*)
- High resolution
- Good strength
- Fast printing speed
- Very low odor
- Very low viscosity, no need to heat
- Chromacure® will tell you when postcure is done and pattern is ready to cast



### CONS

- Has to be managed with individual protections because of presence of monomer
- Postcuring treatment require
  - Differently from other monomer based resin that requires complex and tricky treatments our BC Crea just requires to be washed after print and cured in to BC CURING LIQUID we supply. No hot water wash required, no boiling, no overnight curing.

## PRINTING SETTINGS

### Phrozen Shuffle

BURN IN LAYER  
NUMBERS OF LAYERS: 5  
LAYER THICKNESS: 50u  
CURE TIME: 45 SEC  
WAIT BEFORE PRINT: 4 SEC  
WAIT AFTER PRINT: 0.5 SEC  
LIFT AFTER PRINT: 5 mm  
WAIT AFRER LIFT: 0.1 SEC

NORMAL LAYER  
LAYER THICKNESS: 50u  
CURE TIME: 11 SEC  
WAIT BEFORE PRINT: 1 SEC  
WAIT AFTER PRINT: 0.1 SEC  
LIFT AFTER PRINT: 4 mm  
WAIT AFRER LIFT: 0.1 SEC

MOTOR SPEED 200 u/SEC

### Phrozen Shuffle 4K

BURN IN LAYER  
NUMBERS OF LAYERS: 5  
LAYER THICKNESS: 30u  
CURE TIME: 25 SEC  
WAIT BEFORE PRINT: 5 SEC  
WAIT AFTER PRINT: 0.5 SEC  
LIFT AFTER PRINT: 7 mm  
WAIT AFRER LIFT: 0.1 SEC

NORMAL LAYER  
LAYER THICKNESS: 30u  
CURE TIME: 9.5 SEC  
WAIT BEFORE PRINT: 0.5 SEC  
WAIT AFTER PRINT: 0.1 SEC  
LIFT AFTER PRINT: 5 mm  
WAIT AFRER LIFT: 0.1 SEC

MOTOR SPEED 200 u/SEC

### Phrozen XL

BURN IN LAYER  
NUMBERS OF LAYERS: 5  
LAYER THICKNESS: 45u  
CURE TIME: 50 SEC  
WAIT BEFORE PRINT: 5 SEC  
WAIT AFTER PRINT: 0.5 SEC

LIFT AFTER PRINT: 5 mm  
WAIT AFRER LIFT: 0.1 SEC

NORMAL LAYER  
LAYER THICKNESS: 50u  
CURE TIME: 9 SEC  
WAIT BEFORE PRINT: 1.5 SEC  
WAIT AFTER PRINT: 0.1 SEC  
LIFT AFTER PRINT: 4 mm  
WAIT AFRER LIFT: 0.1 SEC

MOTOR SPEED 180 u/SEC

## **ANYCUBIC PHOTON**

LAYER THICKNESS: 0.05 mm  
NORMAL EXPOSURE TIME: 14 SEC  
OFF TIME: 0.5 SEC  
BOTTOM EXPOSURE TIME: 50 SEC  
BOTTOM LAYERS OFF TIME: 1 SEC  
BOTTOM LAYERS: 5  
SUPPORTS: preset medium

## **ELEGOO MARS**

LAYER THICKNESS: 0.05 mm  
NORMAL EXPOSURE TIME: 11 SEC  
OFF TIME: 0.5 SEC  
BOTTOM EXPOSURE TIME: 65 SEC  
BOTTOM LAYERS OFF TIME: 1 SEC  
BOTTOM LAYERS: 5  
SUPPORTS: preset medium

## **ANYCUBIC PHOTON S**

LAYER THICKNESS: 0.05 mm  
NORMAL EXPOSURE TIME: 11.5 SEC  
OFF TIME: 3 SEC (don t affect the printing – it is a fake parameters on photon S)  
BOTTOM EXPOSURE TIME: 40 SEC  
BOTTOM LAYERS: 5  
Z LIFT DISTANCE: 5 mm  
Z LIFT SPEED: 1.9 mm/S  
Z RETRACT SPEED: 1.9 mm/S  
SUPPORTS: preset medium

## SparkMaker FHD

BURN IN LAYER  
NUMBERS OF LAYERS: 8  
LAYER THICKNESS: 50u  
CURE TIME: 40 SEC  
WAIT BEFORE PRINT: 4 SEC  
WAIT AFTER PRINT: 0.5 SEC  
LIFT AFTER PRINT: 5 mm  
WAIT AFRER LIFT: 0.1 SEC

NORMAL LAYER  
LAYER THICKNESS: 50u  
CURE TIME: 14 SEC  
WAIT BEFORE PRINT: 1 SEC  
WAIT AFTER PRINT: 0.1 SEC  
LIFT AFTER PRINT: 5 mm  
WAIT AFRER LIFT: 0.1 SEC

MOTOR SPEED 200 u/SEC

## Zortrax Inkspire

LAYER THICKNESS 50  
LAYER EXPOSURE: 8 SEC  
BOTTOM LAYER EXPOSURE: 25 SEC  
EXPOSURE OFF TIME: 1.5 SEC  
BOTTOM LAYERS: 5  
ADDITIONAL SUPPORTS EXPOSURE: 1 SEC  
Z LIFT DISTANCE 5  
PLATFORM SPEED 90

MOTOR SPEED 90mm/M

## Solus 1

LAYER THICKNESS 30  
LAYER EXPOSURE TIME1  
INITIAL LAYER EXPOSURE 12  
NUMBER OF INITIAL LAYER 4  
EXPOSURE BUFFER TIME 1  
ANTI ALIASING – NONE  
SUPPORT MESH QUALITY – MEDIUM

## POST-PRINTING PROCESS

Remove the prints from the build plate

Wash the prints in ethyl alcohol 90% to 99%

Dry the patterns with compressed air for best results.

Place the prints in a vessel / plastic cup - Fill the vessel with CREA CURING LIQUID in order to fully submerge patterns

Place the vessel with the patterns inside at UV oven for 30 / 40 min according lamp power and patterns size

The UV cure is done when the pattern color will be BLU (ring on the right)

Wash with tapered water and dry with air AND GO TO CAST

