

# HOW TO USE IT

## BLUECAST X-FILIGREE V2

### BEFORE PRINT

- For maximum detail, it is strongly suggested to use HD FEP or No-FEP - PFA. Poor-quality FEP can compromise resin printability.
- Perform z-axis calibration following the manufacturer's instructions.
- Before use, it is recommended to heat the resin using microwave ovens (never exceeding 30 seconds), ultrasonic cleaners, hot air, baby bottle warmer, etc.
- Before pouring the resin into the resin tank, shake the bottle for one minute.
- For proper debubbling, allow the resin to rest in the resin tank for 5 minutes before starting the print. To expedite the process, the resin can also be filtered to remove air bubbles or vacuumed from the opened bottle.
- Failure to filter the resin after each print or neglecting to heat the resin before each print may result in printing failures. Do not store the resin in the tank. Please remove the resin from the printer tank, filter it, and store it in the original bottle.

### POST-PRINTING CLEANUP

- The patterns printed with this resin are harder and stiffer compared to other BlueCast resins.
- Clean the prints using 91% to 99% ethyl alcohol or IPA.
- When using an ultrasonic cleaner, run a 2-minute cycle (recommended procedure).
- With a resin washer machine, run a cycle of approximately 3 minutes.
- For simple immersion in an alcohol bath, wait approximately 5 minutes.
- After washing, dry the patterns with compressed air.
- If compressed air is unavailable, a hairdryer can be used to dry the patterns.
- A minimum post-curing time of 10 minutes is required.
- After UV post-curing, a quick washing with brand new alcohol ensures excellent casting results (dry it again).

### ULTRA FAST BURNOUT ALLOWED

- The ultra-fast burnout (2 hours at 700°C) has been validated for X-One and X-Filgree V2 only.
- Allow the flask to rest for 3 hours, then proceed to 700°C (1290°F) and maintain that temperature for 60 to 90 minutes.
- Reduce the temperature to your casting temperature and hold for 60 minutes before casting as usual.