



For other resin user guides, please visit <https://siraya.tech> support section

Blu is developed to be a strong resin that has high resolution, precision, and is easy to print. It is tough and hard enough for making functional parts yet easy to print and clean for general use.

And it should not stink up user's work environment

Due to higher polymer content for its outstanding mechanical properties, the ideal printing condition for Blu is over 25°C.

If user can maintain a resin temperature of 30C, the printing time could be further reduced

**Please download profiles base for Elegoo, Anycubic, Phrozen, Peopoly, EPAX, Creality**

[https://drive.google.com/drive/folders/1eCz4\\_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing](https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing)

**Check out recommended support settings if you have print failures**

### Exposure For Blu and Blu Clear V2 (Not Blu Obsidian Black, Not V3)

	Recommended	Resin Temperature 25-35C			Room temperature 20-28C							
Printer	Layer Height	Exposure (s)	# of Initial Layers	Exposure for Init L	Exposure (s)	# of Initial Layers	Exposure for Init Layers	Note				
Photon	50um	11-12 (s)	4	60 s	12-13 (s)	6	90 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
Photon-S	50um	10 (s)	4	60 s	11 (s)	6	75 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
LD-002R	50um	10 (s)	4	40 s	11 (s)	4	50 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
EPA X1	50um	10 (s)	4	55 s	10 (s)	6	75 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
EPA X1	100um	12 (s)	4	75 s	12 (s)	6	90 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
Elegoo Mars	50um	11 (s)	4	50 s	11 (s)	6	60 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
Shuffle	50um				9(s)	5	75 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
Shuffle XL	50um				12(s)	5	75 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
D7	50um				9(s)	5	75 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
Inkspire	50um	11s	4	50 s	12-13 (s)	6	90 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
Moonray	50um	use settigs for nextdent Ortho rigid			use settigs for nextdent Ortho rigid							
Sonic Mini	50um	4s	5	35s	4s	5	35s	10mm lift distance help, lift speed 40mm/min, with support facing side surface				
Photon Mono	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Photon Mono X	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Mars 2 Pro	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Mars 3	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Saturn	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Sonic Mini 4K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Might 4K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Mega 8K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Slash	<p>Siraya on the Slash is better than anything I've tried...and I've tried 5-6 other resins on the Slash. Example from left to right are 100um, 75um, and 50um. The one I'm holding is 50um.</p> <p>100um 5 sec 75um 4 sec 50um 3.5 sec 25um 2.8 sec 10um 2.5 sec</p> <ul style="list-style-type: none"> <li>- LED power 250 (default)</li> <li>- First layer for all 12sec/ first 3 layers (default amount).</li> <li>- Slow setting for Lift speed</li> <li>- 8mm lift height is safest and allow time resin to flow back (they only allow you to pick from 3,8, and 15mm height...which sucks...I'd like 6mm if I could.</li> <li>- Cooldown between layers on auto (smaller prints i do 2sec to speed things up)</li> <li>- Supports point(head) size no less than 1mm, but 1.5 is recommended with 2mm shaft.</li> </ul>											

## Exposure For Blu Obsidian Black and for Blu V3

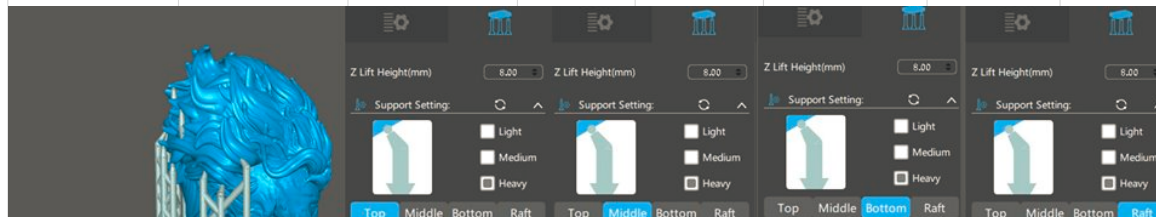
	Recommended	Resin Temperature 25-35C		Room temperature 20-28C				
Printer	Layer Height	Exposure (s)	# of Initial Layers	Exposure for Init L	Exposure (s)	# of Initial Layers	Exposure for Init Layers	Note
Photon	50um	9.5 (s)		4 60 s	9.5 (s)		4 60 s	6mm lift distance help, lift speed 40mm/min, with support facing side surface
Photon-S	50um	7.5 (s)		4 50 s	7.5 (s)		4 50 s	6mm lift distance help, lift speed 40mm/min, with support facing side surface
LD-002R	50um	9 (s)		4 40 s	9 (s)		4 50 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
EPA X1	50um	9 (s)		4 55 s	9 (s)		4 55 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
Elegoo Mars	50um	9.5 (s)		5 45 s	9.5 (s)		5 45 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
Shuffle	50um				9(s)		5 75 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
Shuffle XL	50um				12(s)		5 75 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
D7	50um				8(s)		5 65 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
Inkspire	50um	10s		4 50 s	10s		4 50 s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
Moonray	50um	use settigs for nextdent Ortho rigid			use settigs for nextdent Ortho rigid			
Sonic Mini	50um	3s		5 30s	3s		5 30s	10mm lift distance help, lift speed 40mm/min, with support facing side surface
Photon Mono	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>							
Photon Mono X	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>							
Mars 2 Pro	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>							
Mars 3	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>							
Saturn	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>							
Sonic Mini 4K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>							
Might 4K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>							
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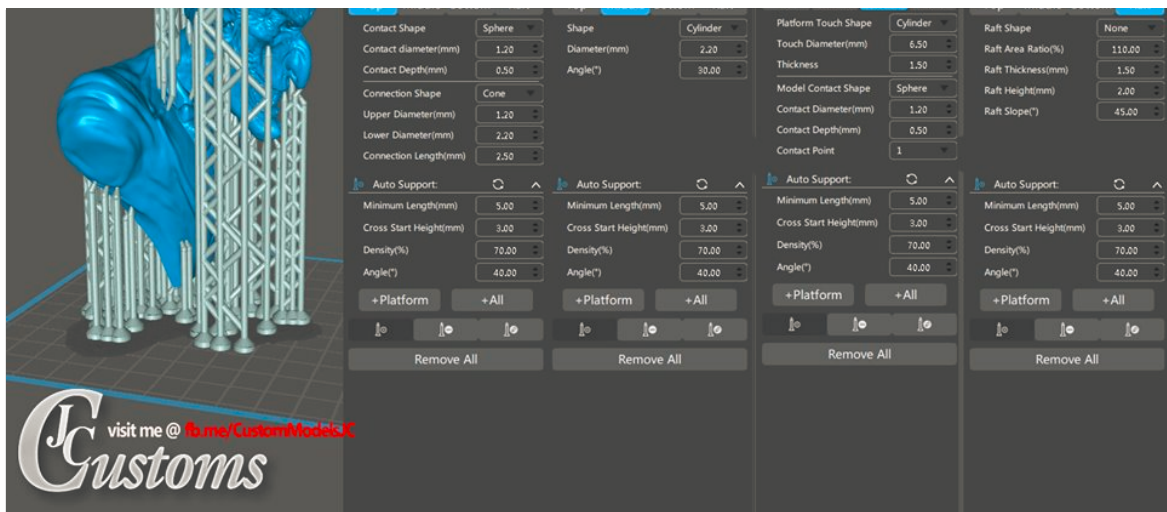
## Exposure For Blu Nylon Black Only

Recommended		Resin Temperature 25-35C		Room temperature 20-28C						
Printer	Layer Height	Exposure (s)	# of Initial Layers	Exposure for Init L	Exposure (s)	# of Initial Layers	Exposure for Init Layers	Note		
Photon Mono	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									
Photon Mono X	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									
Mars 2 Pro	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									
Mars 3	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									
Saturn	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									
Sonic Mini 4K	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									
Might 4K	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									
Mega 8K	<a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing">Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing</a>									

Make sure the support tip diameter is 1.2mm for larger prints with a depth of 0.5mm. See more full settings recommended

<https://www.facebook.com/groups/sirayatech/permalink/290257771885611/>





It is best to use island style base like below left, not the raft style on the right. If you have problem keeping first layer on, make sure you level again to minimize gap between build plate and LCD screen

#### Cleaning:

Use a painter brush (or any brush made with hair) remove excess resins on the printed part with Use 95% concentrated Ethanol (preferred) or IPA to clean. Some form of methnol should work but make sure it does not contain acetone.

Do not submerge the parts in alcohol for more than 5 minutes After cleaning remove alcohol as soon as possible with a hair dryer or air blower. For complex part with lots cavities, it may be a good idea to clean/dry multiple times.

User can check by touching the dried surface of the part to see if it is still sticky. If the dried surface is still sticky, wash some more and dry again.

#### Post Curing:

Blu reached its optimal strength when the printed part is post-cured with UV after cleaned. Use 395-405nm UV light and cure for about 15 minutes.

Make sure resin is completely cleaned off and there is not alcohol left (it needs to be dry) on the print before curing.

Curing by submerging object in water will significantly increase curing efficiency

For Biocompatibility related application, please follow post-processing guideline here:

<https://siraya.tech/blogs/news/blu-biocompatibility-certification-iso-10993>

**Blu Tough TDS** <https://drive.google.com/file/d/1VaM-5Ya2xGjfPrQOqTTQsXb5YX92mfyG/view>  
**Blu Nylon Black TDS** [https://drive.google.com/file/d/1qYtX-JazIS\\_s1AbZKFu2WLiZm0z-zvzv/view](https://drive.google.com/file/d/1qYtX-JazIS_s1AbZKFu2WLiZm0z-zvzv/view)  
**Blu Nylon Mecha TDS** [https://drive.google.com/file/d/1D7hmqgoTotSgFr30GjvbvQTHNq7owV-gT/view?usp=drive\\_link](https://drive.google.com/file/d/1D7hmqgoTotSgFr30GjvbvQTHNq7owV-gT/view?usp=drive_link)

#### Blu Tough Properties (Emerald Blue, Clear V2,V3, Obsidian Black)

Shore Hardness 85D  
Tensile Stress at Break 50 MPa  
IZOD Impact 45 Notched, J/m  
HDT at 0.455 MPa 70°C  
Elongation at Break 32%  
Young's Modulus 1800 MPa

MSDS  
[https://drive.google.com/open?id=1QA9HKiQD-9b4onVCs1W\\_MjBiT940yGOK](https://drive.google.com/open?id=1QA9HKiQD-9b4onVCs1W_MjBiT940yGOK)

#### Blu Nylon Properties

[illegible]