

# ProJet<sup>®</sup> MJP 2500W, 3600W & 3600W MAX

High-throughput Multijet Printing production of precision metal casting patterns



**ProJet MJP 2500W**



**ProJet MJP 3600W**



**ProJet MJP 3600W Max**

|   |   |   |   |
|---|---|---|---|
| <b>Printing Modes</b>   | XHD - Xtreme High Definition  | HD - High Definition<br>UHD - Ultra High Definition<br>XHD - Xtreme High Definition                                   | HD - High Definition<br>UHD - Ultra High Definition<br>XHD - Xtreme High Definition   |
| <b>Net Build Volume (xyz)*</b><br>HD Mode<br>UHD Mode<br>XHD Mode     | 11.6 x 8.3 x 5.6 in (295 x 211 x 142 mm)  | 11.75 x 7.3 x 8 in (298 x 185 x 203 mm)<br>6 x 7.3 x 8 in (152 x 185 x 203 mm)<br>6 x 7.3 x 8 in (152 x 185 x 203 mm) | 11.75 x 7.3 x 8 in (298 x 185 x 203 mm)<br>11.2 x 7.3 x 8 in (284 x 185 x 203 mm)<br>11.2 x 7.3 x 8 in (284 x 185 x 203 mm) |
| <b>Resolution (xyz)</b><br>HD Mode<br>UHD Mode<br>XHD Mode            | 1200 x 1200 x 1600 DPI; 16 µ layers   | 375 x 450 x 790 DPI; 32 µ layers<br>750 x 750 x 1300 DPI; 20 µ layers<br>750 x 750 x 1600 DPI; 16 µ layers            | 375 x 450 x 790 DPI; 32 µ layers<br>750 x 750 x 1300 DPI; 20 µ layers<br>750 x 750 x 1600 DPI; 16 µ layers                  |
| <b>Accuracy (typical)**</b>   | ±0.004 in per in (±0.1016 mm per 25.4 mm) of part dimension   | ±0.001-0.002 inch per inch (0.025-0.05 mm per 25.4 mm) of part dimension.   |   |
| <b>Build Materials</b>  | Visijet M2 CAST   | Visijet M3 CAST and M3 Hi-Cast  | Visijet M3 CAST and M3 Hi-Cast  |
| <b>Support Material</b>   | Visijet M2 SUW  | Visijet S400  | Visijet S400  |
| <b>Material Packaging</b><br>Build Material                           | In clean 2.58 lbs (1.17 kg) bottles (printer holds up to 2 with auto-switching)   | In clean 3.86 lbs (1.75 kg) bottles (printer holds up to 2 with auto-switching)                                       |   |
| Support Material  | In clean 2.87 lbs (1.3 kg) bottles (printer holds up to 2 with auto-switching)  | In clean 3.86 lbs (1.75 kg) bottles (printer holds up to 2 with auto-switching)                                       |   |
| <b>Electrical</b>   | 100-127 VAC, 50/60 Hz, single-phase, 15A<br>200-240 VAC, 50 Hz, single-phase, 10A<br>Single C14 receptacle  | 100-127 VAC, 50/60 Hz, single-phase, 15A<br>200-240*** VAC, 50 Hz, single-phase, 10A                                  |   |
| <b>Dimensions (WxDxH)</b><br>3D Printer Crated<br>3D Printer Uncrated | 55 x 36.5 x 51.7 in (1397 x 927 x 1314 mm)<br>44.1 x 29.1 x 42.1 in (1120 x 740 x 1070 mm)  | 32.5 x 56.3 x 68.5 in (826 x 1430 x 1740 mm)<br>29.5 x 47 x 59.5 in (749 x 1194 x 1511 mm)                            | 32.5 x 56.3 x 68.5 in (826 x 1430 x 1740 mm)<br>29.5 x 47 x 59.5 in (749 x 1194 x 1511 mm)                                  |
| <b>Weight</b><br>3D Printer Crated<br>3D Printer Uncrated             | 716 lb (325 kg)<br>465 lb (211 kg)  | 955 lb (433 kg)<br>659 lb (299 kg)  | 955 lb (433 kg)<br>659 lb (299 kg)  |
| <b>3D Sprint™ Software</b>  | Easy build job set-up, submission and job queue management; Automatic part placement and build optimization tools; Part stacking and nesting capability; Extensive part editing tools; Automatic support generation; Job statistics reporting tools |   |   |
| <b>E-mail Notice Capability</b>                                       | Yes   | Yes   | Yes   |
| <b>Internal Hard Drive Capacity</b>                                   | 500 Gb minimum  | 500 Gb minimum  | 500 Gb minimum  |
| <b>Connectivity</b>   | Network ready with 10/100/1000 base ethernet interface<br>USB port  | Network ready with 10/100 Ethernet interface<br>Front panel USB port  |   |
| <b>Client Operating System</b>  | Windows <sup>®</sup> 7, Windows 8 or Windows 8.1 (Service Pack)   |   |   |
| <b>Input Data File Formats Supported</b>                              | STL, CTL, OBJ, PLY, ZPR, ZBD, AMF, WRL, 3DS, FBX, IGES, IGS, STEP, STP, MJPDDD  |   |   |
| <b>Operating Temperature Range</b>                                    | 64-82 °F (18-28 °C), reduced print speed at > 77 °F (25 °C)   | 64-82 °F (18-28 °C)   | 64-82 °F (18-28 °C)   |
| <b>Operating Humidity</b>   | 30-70 % relative humidity   | 30-70 % relative humidity   | 30-70 % relative humidity   |
| <b>Noise</b>  | < 65 dBA estimated (at medium fan setting)  |   |   |
| <b>5-Year Printhead Warranty</b>                                      | Optional  | Standard  | Standard  |
| <b>Certifications</b>   | CE  | CE  | CE  |

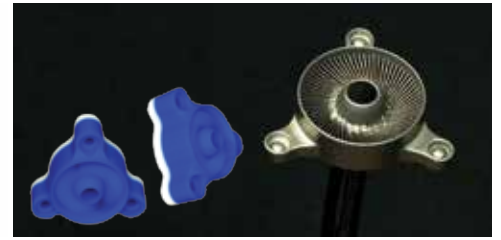
\* Maximum part size is dependent on geometry, among other factors.

\*\* Accuracy may vary depending on build parameters, part geometry and size, part orientation, and post-processing.

\*\*\* Requires small external transformer supplied by 3D Systems in the provided country kit.

# VisiJet® M2 CAST, M3 CAST and Hi-Cast

High performance RealWax™ materials for direct metal casting



| Properties                             | Condition  | VisiJet M2 CAST                      | VisiJet M3 CAST                      | VisiJet M3 Hi-Cast          | VisiJet M2 SUP                           | VisiJet S400            |
|--|------------|--------------------------------------|--------------------------------------|-----------------------------|--|-------------------------|
| Composition                            |            | 100% Wax                             | 100% Wax                             | 100% Wax                    | Wax Support Material                     | Wax Support Material    |
| Color                                  |            | Deep Purple                          | Deep Purple                          | Navy Blue                   | White                                    | White                   |
| Bottle Quantity                        |            | 1.17 kg                              | 1.75 kg                              | 1.75 kg                     | 1.3 kg                                   | 1.75 kg                 |
| Density @ 80 °C (liquid)               | ASTM D3505 | 0.80 g/cm <sup>3</sup>               | 0.80 g/cm <sup>3</sup>               | 0.81 g/cm <sup>3</sup>      | 0.87 g/cm <sup>3</sup>                   | 0.87 g/cm <sup>3</sup>  |
| Melting Point                          |            | 61-66 °C                             | 61-66 °C                             | 70 °C                       | 55-65 °C                                 | 55-65 °C                |
| Softening Point                        |            | 40-48 °C                             | 40-48 °C                             | 52-62 °C                    | N/A                                      | N/A                     |
| Volumetric Shrinkage, from 40 °C to RT |            | 2 %                                  | 2 %                                  | 2.24 %                      | N/A                                      | N/A                     |
| Linear Shrinkage, from 40 °C to RT     |            | 0.70 %                               | 0.70 %                               | 0.75 %                      | N/A                                      | N/A                     |
| Needle Penetration Hardness            | ASTM D1321 | 12                                   | 12                                   | 9                           | N/A                                      | N/A                     |
| Ash Content                            | ASTM 2584  | < 0.05 %                             | < 0.05 %                             | < 0.05 %                    | N/A                                      | N/A                     |
| Printer Compatibility                  |            | Projet MJP 2500W                     | Projet MJP 3600W Series              | Projet MJP 3600W Series     | Projet MJP 2500W                         | Projet MJP 3600W Series |
| Description                            |            | High resolution, durable casting wax | High resolution, durable casting wax | High resolution casting wax | Eco friendly, hands-free dissolvable wax |                         |

\* DISCLAIMER: It is the responsibility of each customer to determine that its use of any VisiJet® material is safe, lawful and technically suitable to the customer's intended applications. The values presented here are for reference only and may vary. Customers should conduct their own testing to ensure suitability for their intended application.