3D SYSTEMS®

ProJet® MJP 2500 IC

Tool-less 100% wax investment casting pattern production with industrial MultiJet Printing

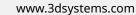|	ProJet MJP 2500 IC
Printing Mode	HD - High Definition
Net Build Volume (xyz)*	11.6 x 8.3 x 5.6 in (295 x 211 x 142 mm)
Resolution (xyz)	600 x 600 x 600 DPI; 42 μm layers
Accuracy (typical)**	±0.004 in/in (±0.1016 mm/25.4 mm) of part dimension across printer population ±0.002 in/in (±0.0508 mm/25.4 mm) of part dimension typical for any single printer
Volumetric Print Speed	1 Lane 12.5 in³/hour (205 cm³/hour) 2 Lanes 12.1 in³/hour (199 cm³/hour) 3 Lanes 11.6 in³/hour (189 cm³/hour)
Build Material	VisiJet® M2 ICast
Support Material	VisiJet® IC SUW
Material Packaging Build Material Support Material	In clean 2.87 lbs (1.3 kg) bottles (printer holds up to 2 with auto-switching) In clean 2.87 lbs (1.3 kg) bottles (printer holds up to 2 with auto-switching)
Electrical	100-127 VAC, 50/60 Hz, single-phase, 15A 200-240 VAC, 50 Hz, single-phase, 10A Single C14 receptacle
Dimensions (WxDxH) 3D Printer Crated 3D Printer Uncrated	55 x 36.5 x 51.7 in (1397 x 927 x 1314 mm) 44.1 x 29.1 x 42.1 in (1120 x 740 x 1070 mm)
Weight 3D Printer Crated 3D Printer Uncrated	716 lb (325 kg) 465 lb (211 kg)
3D Sprint™ Software	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
E-mail Notice Capability	Yes
Internal Hard Drive Capacity	500 Gb minimum
Connectivity	Network ready with 10/100/1000 base ethernet interface USB port
Client Operating System	Windows® 7, Windows 8 or Windows 8.1 (Service Pack)
Input Data File Formats Supported	STL, CTL, OBJ, PLY, ZPR, ZBD, AMF, WRL, 3DS, FBX, IGES, IGS, STEP, STP, MJPDDD
Operating Temperature Range	Optimal 64-75 °F (18-24 °C), not to exceed 82 °F (28 °C)
Operating Humidity	30-70 % relative humidity
Noise	< 65 dBa estimated (at medium fan setting)
Certifications	CE, UL, EAC, KCC and FCC

* Maximum part size is dependent on geometry, among other factors.
** Across printer variation can be reduced to equal single printer variation via user calibration.
   Accuracy may vary depending on build parameters, part geometry and size, part orientation, and post-processing.

VisiJet® M2 ICast

High performance RealWax™ material for direct metal casting

Properties	Condition	VisiJet M2 ICast	VisiJet M2 IC SUW
Composition		100% Wax	Wax Support Material
Color		Green	White
Bottle Quantity		1.3 kg	1.3 kg
Density @ 80 °C (liquid)	ASTM D3505	0.80 g/cm³	0.87 g/cm³
Melting Point		61-66 °C	55-65 °C
Softening Point		40-48 °C	N/A
Volumetric Shrinkage, from 40 °C to RT		2 %	N/A
Linear Shrinkage, from 40 °C to RT		0.70 %	N/A
Needle Penetration Hardness	ASTM D1321	12	N/A
Ash Content	ASTM 2584	< 0.05 %	N/A
Printer Compatibility		ProJet MJP 2500 IC	ProJet MJP 2500 IC
Description		High resolution, durable casting wax An unfilled paraffin based wax with added resins	Non-toxic wax support material with easy break-away structure and dissolvable hands-free removal

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