MultiJet Plastic Printers

Functional precision plastic parts with ProJet® MJP 3D printers

	ProJet MJP 3600	ProJet MJP 3600 Max
Printing Modes	HD - High Definition UHD - Ultra High Definition XHD - Xtreme High Definition	HD - High Definition UHD - Ultra High Definition XHD - Xtreme High Definition
Net Build Volume (xyz)*		
HD Mode	11.75 x 7.3 x 8 in (298 x 185 x 203 mm)	11.75 x 7.3 x 8 in (298 x 185 x 203 mm)
UHD Mode	8 x 7.3 x 8 in (203 x 185 x 203 mm)	11.2 x 7.3 x 8 in (284 x 185 x 203 mm)
XHD Mode	8 x 7.3 x 8 in (203 x 185 x 203 mm)	11.2 x 7.3 x 8 in (284 x 185 x 203 mm)
Resolution (xyz)		
HD Mode	375 x 450 x 790 DPI; 32 µ layers	375 x 450 x 790 DPI; 32 µ layers
UHD Mode	750 x 750 x 890 DPI; 29 µ layers	750 x 750 x 890 DPI; 29 µ layers
XHD Mode	750 x 750 x 1600 DPI; 16 µ layers	750 x 750 x 1600 DPI; 16 µ layers
Accuracy (typical)	±0.001-0.002 inch per inch (0.025-0.05 mm per 25.4 mm) of part dimension. Accuracy may vary depending on build parameters, part geometry and size, part orientation, and post-processing.	
Build Materials	VisiJet M3-X – Rigid White VisiJet M3 Crystal – Rigid Clear VisiJet M3 Black – Rigid Black VisiJet M3 Proplast – Rigid Natural VisiJet M3 Navy – Rigid Blue VisiJet M3 Techplast – Rigid Gray VisiJet M3 Procast – Castable	VisiJet M3-X – Rigid White VisiJet M3 Crystal – Rigid Clear VisiJet M3 Black – Rigid Black VisiJet M3 Proplast – Rigid Natural VisiJet M3 Navy – Rigid Blue VisiJet M3 Techplast – Rigid Gray VisiJet M3 Procast – Castable
Support Material	VisiJet S300	VisiJet S300
Material Packaging	Build and support materials in clean 4.41 lbs (2 kg) bottles (printer holds up to 2 of each with auto-switching)	
Electrical	100-127 VAC, 50/60 Hz, single-phase, 15A 200-240** VAC, 50 Hz, single-phase, 10A	
Dimensions (WxDxH)		
3D Printer Crated	32.5 x 56.3 x 68.5 in (826 x 1430 x 1740 mm)	32.5 x 56.3 x 68.5 in (826 x 1430 x 1740 mm)
3D Printer Uncrated	29.5 x 47 x 59.5 in (749 x 1194 x 1511 mm)	29.5 x 47 x 59.5 in (749 x 1194 x 1511 mm)
Weight		
3D Printer Crated	955 lbs (433 kg)	955 lbs (433 kg)
3D Printer Uncrated	659 lb (299 kg)	659 lb (299 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	Yes
Internal Hard Drive Capacity	500 Gb minimum	500 Gb minimum
Connectivity	Network ready with 10/100 Ethernet interface Front panel USB Port	
Client Hardware Recommendation	CPU: Multiple core processor. Hyper-threading and clock speeds above 3GHz can be beneficial but should be paired with a good balance of cores. RAM: 8 GB of more. HARD DISK: SSD. Multiple core processor. OTHER: Google Chrome or Internet Explorer	
Client Operating System	Windows® 7, 8 and 8.1 (service pack)	
Input Data File Formats Supported	STL, CTL, OBJ, PLY, ZPR, ZBD, AMF, WRL, 3DS, FBX, IGES, IGS, STEP, STP, MJPDDD	
Post-Processing	ProJet Finisher for easy removal of eco-friendly wax supports (optional)	
Operating Temperature Range	64-82 °F (18-28 °C)	64-82 °F (18-28 °C)
Operating Humidity	30-70 % relative humidity	30-70 % relative humidity
Noise	< 65 dBa estimated (at medium fan setting)	
5-Year Printhead Warranty	Standard	Standard
Certifications	CE	CE

* Maximum part size is dependent on geometry, among other factors.
** Requires small external transformer supplied by 3D Systems in the provided country kit.

VisiJet® M3 Advanced Plastics

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Properties	Condition	VisiJet M3-X	VisiJet M3 Black	VisiJet M3 Crystal	VisiJet M3 Proplast	VisiJet M3 Navy	VisiJet M3 Techplast	VisiJet M3 Procast	VisiJet S300
Composition		UV Curable Plastic							Wax Support Material
Color		White	Black	Natural	Natural	Blue	Gray	Dark Blue	White
Bottle Quantity		2 kg	2 kg	2 kg	2 kg	2 kg	2 kg	2 kg	2 kg
Density @ 80 °C (liquid)		1.04 g/cm³	1.02 g/cm³	1.02 g/cm³	1.02 g/cm³	1.02 g/cm³	1.02 g/cm³	1.02 g/cm³	N/A
Tensile Strength	ASTM D638	49 MPa	35.2 MPa	42.4 MPa	26.2 MPa	20.5 MPa	22.1 MPa	32 MPa	N/A
Tensile Modulus	ASTM D638	2168 MPa	1594 MPa	1463 MPa	1108 MPa	735 MPa	866 MPa	1724 MPa	N/A
Elongation at Break	ASTM D638	8.3 %	19.7 %	6.83 %	8.97 %	8 %	6.1 %	12.3 %	N/A
Flexural Strength	ASTM D790	65 MPa	44.5 MPa	49 MPa	26.6 MPa	28.1 MPa	28.1 MPa	45 MPa	N/A
Heat Distortion Temperature	ASTM D648 @ 0.45 MPa	88 °C	57 °C	56 °C	46 °C	46 °C	46 °C	N/A	N/A
Ash Content		N/A	N/A	N/A	0.01 %	0.01 %	0.01 %	0.01 %	N/A
Melting Point		N/A	N/A	N/A	N/A	N/A	N/A	N/A	60 °C
Softening Point		N/A	N/A	N/A	N/A	N/A	N/A	N/A	40 °C
USP Class VI Certified*		No	No	Yes	No	No	No	No	N/A
Description		ABS-like Plastic	High strength and flexibility plastic	Tough Plastic, Translucent	Plastic, Natural	Plastic, Blue	Plastic, Gray	Castable Plastic	Non-toxic wax material for hands-free melt-away supports

* DISCLAIMER: Material is capable of meeting the requirements of USP Class VI testing. 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.

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