3D SYSTEMS®

ProJet® MJP 2500 Plus and 3600 Dental

High throughput productivity MultiJet Printing of precision wax-ups, models and surgical guides

	ProJet MJP 2500 Plus	ProJet MJP 3600 Dental
Printing Modes		
HD Mode	High Definition	
UHD Mode		Ultra High Definition
HDX Mode		High Definition Smooth (drill guides, jaw models and orthodontic thermoforming models)
HDP Mode		High Definition Plaster (plaster-like appearance for crown and bridge, partial denture and orthodontic models)
Net Build Volume (xyz)*	11.6 x 8.3 x 5.6 in (295 x 211 x 142 mm)	11.2 x 7.3 x 8 in (284 x 185 x 203 mm)
Resolution (xyz)		
HD Mode	800 x 900 x 790 DPI; 32 µ layers	
UHD Mode		750 x 750 x 890 DPI; 29 µ layers
HDX Mode		375 x 450 x 790 DPI; 32 µ layers
HDP Mode		375 x 450 x 790 DPI; 32 µ layers
Accuracy (typical)	±0.001-0.002 inch per inch (0.025-0.05 mm per 25.4 mm) of part dimension (on platform) Accuracy may vary depending on build parameters, part geometry and size, part orientation, and post-processing.	
Build Materials		
HD Mode	VisiJet M2R-TN – Rigid Tan	
UHD Mode		VisiJet M3 Dentcast
HDX Mode		VisiJet M3 Dentcast, VisiJet M3 Stoneplast, VisiJet M3 PearlStone
HDP Mode		VisiJet M3 Dentcast, VisiJet M3 Stoneplast, VisiJet M3 PearlStone
Support Material	VisiJet M2 SUP	VisiJet S300
Material Packaging	Build materials: In clean 3.30 lbs (1.5 kg) bottles (printer holds up to 2 build materials bottles with auto-switching) Support materials: In clean 3.08 lbs (1.4 kg) bottles (printer holds up to 2 support material bottles with auto-switching)	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 Single C14 receptacle	100-127 VAC, 50/60 Hz, single-phase, 15A 200-240** VAC, 50 Hz, single-phase, 10A
Dimensions (WxDxH)		
3D Printer Crated	55 x 36.5 x 51.7 in (1397 x 927 x 1314 mm)	32.5 x 56.3 x 68.5 in (826 x 1430 x 1740 mm)
3D Printer Uncrated	44.1 x 29.1 x 42.1 in (1120 x 740 x 1070 mm)	29.5 x 47 x 59.5 in (749 x 1194 x 1511 mm)
Weight		
3D Printer Crated	716 lb (325 kg)	955 lbs (433 kg)
3D Printer Uncrated	465 lb (211 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 10/100/1000 BaseT Ethernet interface USB port	Network ready with 10/100 Ethernet interface Front panel USB Port
Client Hardware Recommendation	CPU: 3 GHz multiple core processor (2 GHz Intel® or AMD® processor mini) with 8 GB RAM or more (4 GB mini), OpenGL 3.2 and GLSL 1.50 support (OpenGL 2.1 and GLSL 1.20 mini) RAM: 1 GB video or more, 1280 x 1024 (1280 x 960 mini) screen resolution or higher HARD DRIVE: SSD or 10,000 RPM hard disk drive (30 GB of available hard-disk space for cache mini) OTHER: Google Chrome or Internet Explorer 11 (Internet Explorer 9 mini), Microsoft .NET Framework 4.5 installed with application	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, Windows 8 or Windows 8.1 (Service Pack)	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	MJP EasyClean System for removal of wax supports (optional)	ProJet Finisher for removal of wax supports (optional)
Operating Temperature Range	64-82 °F (18-28 °C), reduced print speed at > 77 °F (25 °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)	< 65 dBa estimated (at medium fan setting)
5-Year Printhead Warranty	Optional	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® Dental Materials

For castable and pressable wax-ups, precision dental models and surgical guides
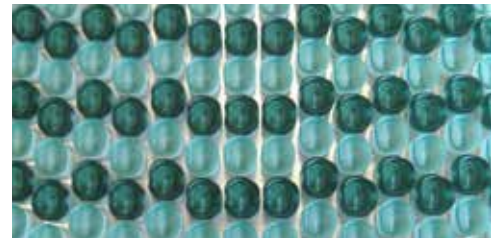
Properties	Condition	VisiJet M2R-TN	VisiJet M3 Dentcast	VisiJet M3 PearlStone	VisiJet M3 Stoneplast	VisiJet M2 SUP	VisiJet S300
Composition		UV Curable Plastic				Wax Support Material	
Color		Opaque Tan	Dark green	White	Natural	White	White
Bottle Quantity		1.5 kg	2 kg	2 kg	2 kg	1.4 kg	2 kg
Density @ 20 °C (solid)		1.16 g/cm³	1.16 g/cm³	1.16 g/cm³	1.19 g/cm³	N/A	N/A
Tensile Strength	ASTM D638	60-70 MPa	32 MPa	40 MPa	41 MPa	N/A	N/A
Tensile Modulus	ASTM D638	2500-3000 MPa	1724 MPa	1794 MPa	1850 MPa	N/A	N/A
Elongation at Break	ASTM D638	6-12 %	12.3%	7.7%	17%	N/A	N/A
Flexural Strength	ASTM D790	90-100 MPa	45 MPa	N/A	51 MPa	N/A	N/A
Heat Distortion Temperature	ASTM D648 @ 0.45 MPa	71 °C	N/A	88 °C	56 °C	N/A	N/A
Ash Content		N/A	0.01%	N/A	N/A	N/A	N/A
Melting Point		N/A	N/A	N/A	N/A	60 °C	60 °C
Softening Point		N/A	N/A	N/A	N/A	40 °C	40 °C
USP Class VI Certified*		No	No	No	Yes	N/A	N/A
Printer Compatibility		ProJet MJP 2500 Plus	ProJet MJP 3600 Dental	ProJet MJP 3600 Dental	ProJet MJP 3600 Dental	ProJet MJP 2500 Plus	ProJet MJP 3600 Dental
Description		High modulus, rigid plastic (tan) for dental models	Wax-up castable material	Solid stone appearance	Translucent or stone finish**	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 thier own testing to ensure suitability for their intended application.

** Choice of finish requires additional post processing.

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