

# ProJet® MJP 2500 IC

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



## ProJet MJP 2500 IC

<b>Printing Mode</b>	HD - High Definition
<b>Net Build Volume (xyz)*</b>	11.6 x 8.3 x 5.6 in (294 x 211 x 144 mm)
<b>Resolution (xyz)</b>	600 x 600 x 600 DPI; 42 µm layers
<b>Accuracy (typical)**</b>	±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
<b>Volumetric Print Speed</b>	1 Lane 12.5 in <sup>3</sup> /hour (205 cm <sup>3</sup> /hour) 2 Lanes 12.1 in <sup>3</sup> /hour (199 cm <sup>3</sup> /hour) 3 Lanes 11.6 in <sup>3</sup> /hour (189 cm <sup>3</sup> /hour)
<b>Build Material</b>	Visijet® M2 ICast
<b>Support Material</b>	Visijet® M2 IC SUW
<b>Material Packaging</b> Build Material	In clean 2.87 lbs (1.3 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)
<b>Electrical</b>	100-127 VAC, 50/60 Hz, single-phase, 15A 200-240 VAC, 50 Hz, single-phase, 10A Single C14 receptacle
<b>Dimensions (WxDxH)</b> 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)
<b>Weight</b> 3D Printer Crated 3D Printer Uncrated	716 lb (325 kg) 465 lb (211 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
<b>Internal Hard Drive Capacity</b>	500 Gb minimum
<b>Connectivity</b>	Network ready with 10/100/1000 base ethernet interface USB port
<b>Client Operating System</b>	Windows® 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>	Optimal 64-75 °F (18-24 °C), not to exceed 82 °F (28 °C)
<b>Operating Humidity</b>	30-70 % relative humidity
<b>Noise</b>	< 65 dBa estimated (at medium fan setting)
<b>Certifications</b>	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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