

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 (294 x 211 x 144 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 in ³ /hour (205 cm ³ /hour) 2 Lanes 12.1 in ³ /hour (199 cm ³ /hour) 3 Lanes 11.6 in ³ /hour (189 cm ³ /hour) |
| Build Material | Visijet [®] M2 ICast |
| Support Material | Visijet [®] M2 IC SUW |
| Material Packaging 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) |
| 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/cm ³ | 0.87 g/cm ³ |
| 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 |

www.3dsystems.com

Warranty/Disclaimer: The performance characteristics of these products may vary according to product application, operating conditions, material combined with, or with end use. 3D Systems makes no warranties of any type, express or implied, including, but not limited to, the warranties of merchantability or fitness for a particular use. 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.



© 2018 by 3D Systems, Inc. All rights reserved. Specifications subject to change without notice. 3D Systems, the 3D Systems logo, Visijet and 3D Sprint are registered trademarks and RealWax is a trademark of 3D Systems, Inc.