

# Multijet Plastic Printers

High part quality, speed and simplicity made accessible with the ProJet® MJP 2500 Series



**Projet MJP 2500**



**Projet MJP 2500 Plus**

<b>Printing Mode</b>	HD - High Definition	HD - High Definition
<b>Net Build Volume (xyz)*</b>	11.6 x 8.3 x 5.6 in (294 x 211 x 144 mm)	11.6 x 8.3 x 5.6 in (294 x 211 x 144 mm)
<b>Resolution (xyz)</b>	800 x 900 x 790 DPI, 32 μ layers	800 x 900 x 790 DPI, 32 μ layers
<b>Accuracy (typical)</b>	±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.	
<b>Build Materials</b>	Visijet ProFlex M2G-DUR – Tough, clear polypropylene-like Visijet M2R-WT** – Rigid white Visijet M2R-BK** – Rigid black	Visijet Armor M2G-CL – Tough, clear ABS-like Visijet ProFlex M2G-DUR – Tough, clear polypropylene-like Visijet M2R-GRY – Rigid gray Visijet M2R-WT** – Rigid white Visijet M2R-BK** – Rigid black Visijet M2R-CL** – Rigid clear Visijet M2 EBK – Elastomeric black Visijet M2 ENT – Elastomeric natural
<b>Support Material</b>	Visijet M2 SUP	Visijet M2 SUP
<b>Material Packaging</b> Build Materials Support Material	In clean 3.30 lbs (1.5 kg) bottles (printer holds up to 2 build materials bottles with auto-switching) In clean 3.08 lbs (1.4 kg) bottles (printer holds up to 2 support material bottles 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)	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)	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	Yes
<b>Internal Hard Drive Capacity</b>	500 Gb minimum	500 Gb minimum
<b>Connectivity</b>	Network ready with 10/100/1000 BaseT Ethernet interface USB port	
<b>Client Hardware Recommendation</b>	<ul style="list-style-type: none"> <li>• 3 GHz multiple core processor (2 GHz Intel® or AMD® processor mini) with 8 GB RAM or more (4 GB mini)</li> <li>• OpenGL 3.2 and GLSL 1.50 support (OpenGL 2.1 and GLSL 1.20 mini), 1 GB video RAM or more, 1280 x 1024 (1280 x 960 mini) screen resolution or higher</li> <li>• SSD or 10,000 RPM hard disk drive (30 GB of available hard-disk space for cache mini)</li> <li>• Google Chrome or Internet Explorer 11 (Internet Explorer 9 mini)</li> <li>• Other: 3 button mouse with scroll, keyboard, Microsoft .NET Framework 4.5 installed with application</li> </ul>	
<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>Post Processing</b>	MJP EasyClean System for easy removal of eco-friendly wax supports	
<b>Operating Temperature Range</b>	64-82 °F (18-28 °C), reduced print speed at > 77 °F (25 °C)	
<b>Operating Humidity</b>	30-70 % Relative Humidity	30-70 % Relative Humidity
<b>Noise</b>	< 65 dBa estimated (at medium fan setting)	
<b>5-Year Printhead Warranty</b>	Optional	Optional
<b>Certifications</b>	CE	CE

\* Maximum part size is dependent on geometry, among other factors.

\*\* Respectively replaces former Visijet® M2 RWT, RBK and RCL materials

# Visijet® M2 Materials

Functional precision plastic and elastomeric parts with the Projet® MJP 2500 Series



Visijet Armor M2G-CL



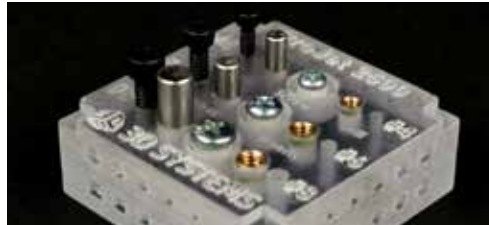
Visijet M2R-WT



Visijet M2 ENT



Visijet M2 EBK



Visijet M2R-CL



Visijet M2R-GRY

Properties	ASTM	Visijet Armor M2G-CL	Visijet ProFlex M2G-DUR	Visijet M2R-GRY	Visijet M2R-WT*	Visijet M2R-BK*	Visijet M2R-CL*	Visijet M2 ENT	Visijet M2 EBK	Visijet M2 SUP
Composition				UV curable plastic				UV curable elastomeric		Wax support
Color		Clear	Clear	Opaque gray	Opaque white	Opaque black	Translucent clear	Translucent natural	Opaque black	White
USP Class VI Certified**		No	No	Yes	Yes	No	Yes	No	No	No
Bottle Quantity (kg)		1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.5	1.4
Density @ 20 °C (solid) (g/cm³)	D792			1.16	1.16	1.16	1.16	1.12	1.12	N/A
Tensile Strength (MPa)	D638	30-35	15-20	35-45	35-45	45-55	35-45	0.2-0.4	0.2-0.4	N/A
Tensile Modulus (MPa)	D638	1500-2000	250-350	1500-2000	1500-2000	2000-2500	1500-2000	0.27-0.43	0.27-0.43	N/A
Elongation at Break	D638	55-65	65-75	20-30 %	20-30 %	6-12 %	20-30 %	160-230 %	160-230 %	N/A
Flexural Strength (MPa)	D790	40-45	N/A	50-60	50-60 MPa	80-90	50-60	N/A	N/A	N/A
Flexural Modulus (MPa)	D790	1000-1200	N/A	1700-2200	1700-2200	2400-3000	2000-2500	N/A	N/A	N/A
Impact Strength (Notched Izod) (J/m)	D256	40-50	70-80	20-25	20-25	15-18	20-25	N/A	N/A	N/A
Shore A Hardness	2240	N/A	N/A	N/A	N/A	N/A	N/A	28-32	28-32	N/A
Shore D Hardness	2240	70	60	77	77	81	77	N/A	N/A	N/A
Water Absorption (24 hr)	D570			0.50 %	0.50 %	0.50 %	0.50 %	0.90 %	0.60 %	N/A
Heat Distortion Temp @ 0.45 MPa	D648	47 °C	N/A	51 °C	51 °C	61 °C	51 °C	N/A	N/A	N/A
Heat Distortion Temp @ 1.82 MPa	D648	43 °C	N/A	45 °C	45 °C	53 °C	45 °C	N/A	N/A	N/A
Melting Point		NA	NA	N/A	N/A	N/A	N/A	N/A	N/A	60 °C
Softening Point		NA	NA	N/A	N/A	N/A	N/A	N/A	N/A	40 °C
Printer Compatibility		Projet MJP 2500 Plus	Projet MJP 2500/2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500/2500 Plus	Projet MJP 2500/2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500/2500 Plus
Description		Transparent clear	Transparent clear	Rigid gray, high contrast	High modulus, rigid white plastic	High modulus, rigid black plastic	Transparent clear	Flexible, rubber-like	Flexible, rubber-like	Non-toxic wax for hands-free melt-away supports

\* Respectively replaces former Visijet® M2 RWT, RBK and RCL materials

\*\* Suitable for use in certain medical applications when post-processed following 3D Systems guidelines

DISCLAIMER: 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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# Visijet® M2 Materials

Functional precision plastic and elastomeric parts with the Projet® MJP 2500 Series

Properties	Condition	Visijet M2R-WT**	Visijet M2 RWT	Visijet M2R-BK**	Visijet M2 RBK	Visijet M2R-CL**	Visijet M2 RCL	Visijet M2R-TN	Visijet M2 ENT	Visijet M2 EBK	Visijet M2 SUP
Composition		UV curable plastic						UV curable elastomeric		Wax support	
Color		Opaque White	Opaque White	Opaque Black	Opaque Black	Translucent Clear	Translucent Clear	Opaque Tan	Translucent Natural	Opaque Black	White
Bottle Quantity (kg)		1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.4 kg
Density @ 20 °C (solid)	ASTM D792	1.16 g/cm³	1.19 g/cm³	1.16 g/cm³	1.19 g/cm³	1.16 g/cm³	1.18 g/cm³	1.16 g/cm³	1.12 g/cm³	1.12 g/cm³	N/A
Tensile Strength	ASTM D638	35-45 MPa	37-47 MPa	45-55 MPa	29-37 MPa	35-45 MPa	40-50 MPa	60-70 MPa	0.2-0.4 MPa	0.2-0.4 MPa	N/A
Tensile Modulus	ASTM D638	1500-2000 MPa	1000-1600 MPa	2000-2500 MPa	600-1100 MPa	1500-2000 MPa	1000-1600 MPa	2500-3000 MPa	0.27-0.43 MPa	0.27-0.43 MPa	N/A
Elongation at Break	ASTM D638	20-30 %	7-16 %	6-12 %	11-21 %	20-30 %	9-18 %	6-12 %	160-230 %	160-230 %	N/A
Flexural Strength	ASTM D790	50-60 MPa	59-69 MPa	80-90 MPa	44-60 MPa	50-60 MPa	73-83 MPa	90-100 MPa	N/A	N/A	N/A
Flexural Modulus	ASTM D790	1700-2200 MPa	1400-2000 MPa	2400-3000 MPa	900-1500 MPa	2000-2500 MPa	1700-2300 MPa	2400-3000 MPa	N/A	N/A	N/A
Impact Strength (Notched Izod)	ASTM D256	20-25 J/m	14-17 J/m	15-18 J/m	14-17 J/m	20-25 J/m	14-17 J/m	14-17 J/m	N/A	N/A	N/A
Shore A Hardness	ASTM 2240	N/A	N/A	N/A	N/A	N/A	N/A	N/A	28-32	28-32	N/A
Shore D Hardness	ASTM 2240	77	77-80	81	77-80	77	77-80	72	N/A	N/A	N/A
Water Absorption	ASTM D570 24 hr	0.50 %	0.50 %	0.50 %	0.50 %	0.50 %	0.50 %	0.50 %	0.90 %	0.60 %	N/A
Heat Distortion Temp @ 0.45 MPa	ASTM D648	51 °C	52 °C	61 °C	48 °C	51 °C	54 °C	71 °C	N/A	N/A	N/A
Heat Distortion Temp @ 1.82 MPa	ASTM D648	45 °C	46 °C	53 °C	43 °C	45 °C	47 °C	61 °C	N/A	N/A	N/A
Melting Point		N/A	N/A	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	N/A	N/A	40 °C
Printer Compatibility		Projet MJP 2500 and 2500 Plus	Projet MJP 2500 and 2500 Plus	Projet MJP 2500 and 2500 Plus	Projet MJP 2500 and 2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500 Plus	Projet MJP 2500 and 2500 Plus
Description		High modulus, rigid plastic (white)	Rigid white	High modulus, rigid plastic (black)	Rigid black	High modulus, rigid plastic (clear)	Rigid translucent Clear	High modulus, rigid plastic (tan) for dental models	Flexible rubber-like	Flexible rubber-like	Non-toxic wax for hands-free melt-away supports

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