3D SYSTEMS- Procedures

PROJET® 3500 PRINTERS

“Procedure: VisiJet® M3 Black Material Hygiene”

P/N: 24122-P01-00, Rev. A
Revision date: 21-Sept-2013
Objectives

After completing this procedure you will be able to:

- Perform VisiJet® M3 Black/printhead hygiene maintenance procedure.
VisiJet® M3 Black Printhead Hygiene

The VisiJet® M3 Black material requires some additional hygiene steps to ensure continuous high quality printing.

• The level of hygiene required will be based on the operator’s printing patterns.

• Generally, if the printer is running continuously and printing multiple builds one after the other, the printer needs little to no additional hygiene.

• If the printer sits idle for some period of time, printer hygiene will be required and is described in the following procedure.
VisiJet® M3 Black Printhead Hygiene

Criteria for Printhead Hygiene

Perform this procedure if printer has been idle/not printing for longer than 12 hours.

PROCEDURE:

STEP 1:
From the ProJet® Operator Panel:
Select the Tools icon.
STEP 2:
In the next screen select **Print Diagnostics**.

STEP 3:
In the next screen select **Test Print**.
VisiJet® M3 Black Printhead Hygiene

The printer will start a print that will be approximately 10 minutes in duration. The build will lay down 1 layer of part and support material.

STEP 4:
Inspect the test build for consistency
- A good test build should be solid across the entire line for both part and support materials.
- Pay particular attention to the part material line to determine if additional hygiene should be performed.

Example of a Good Test Print
- Test print should be free of spaces or gaps.
STEP 5:
If the test print does not look good as described (See photo):
• Repeat Steps 1-3 to perform another Test Print.

STEP 6:
If after three (3) Test Print attempts, the build does not pass:
• Contact your 3D Systems Service Personnel who will provide you with advanced troubleshooting procedures.

Example of a Bad Test Print
• Notice the blank areas. This represents jets that are partially or fully clogged or missing.

The Test Print will quickly clear out any potentially clogged jets with minimal material usage. Please use this procedure when printing with VisiJet® M3 Black and a machine that has been idle for 12 hours or longer.