

What's new in Sinter V5.4

Customer Information Bulletin



Advisory

Upgrade / Repair / Retrofit

Safety Alert

Purpose: Overview of new features in Sinter V5.4

ProX 500

New material configuration file

DuraFormProX-PA

New Build Parameter

ReFeed Delay:

- The number of seconds the ProX 500 will wait before the refeed stroke of the traverse roller. This delay allows the part bed temperature to stabilize before the refeed motion.

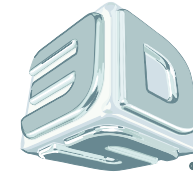
Improved MQC logging and communications

- Warning if MQC loses connection during a build
- Warning if MQC blended hopper does not have enough powder to respond to powder request (15 minute timeout)
- MQC log for each build will now be included in the 3dl file for each build.
- MQC extended log size (MQC.tlog) will now be limited to xxx. When this size is exceeded, the file will be auto-truncated.



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Manual Operations

- Offline IR calibration waits for the IR sensor block temperature to stabilize before beginning the calibration. This adds 5-10 minutes to the calibration time.
- The part bed heaters will not allowed to be turned ON if the system is not inert. Open the inert dialog and enable inert before turning on part bed heaters.
- Add Powder dialog now includes the ability to launch an overflow transfer sequence.

Build mode

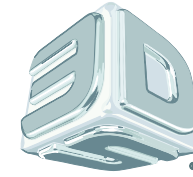
- Sinter will not allow a build to start if the IR sensor block is not at temperature setpoint. Sinter will issue a message asking the user to wait until the setpoint is reached, this normally takes 2-3 minutes.
- Sinter will issue a warning when ProX500 is low on powder. If powder is not received in the next 25 layers, Sinter will issue an alarm and terminate the build.
- Overflow sequence has priority over inert process. Inert will be temporarily disabled during overflow sequence.

Minor ProX 500 GUI changes

- Updated status screens
- Minor changes to Manual Operation windows
- MQC status screen now available from Main Tool Bar as well as Manual Operations Tool Bar

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MQC User interface changes

- The display entries are now as follows:
 - “U” symbol is now used to represent the used bin.
 - “F” symbol is now used to represent the fresh bin.
 - “B” symbol is now used to represent the blender bin.
 - “PA” symbol is now used to represent Printer A.
 - “PB” symbol is now used to represent Printer B.
 - “X->Y” symbol is now used to represent a transport from X to Y. For example, “U->B” means transport used powder to the blender. “B->B” is blender recirculation.
- Main display now displays blending requirements (rightmost column).
 - For the used and fresh bin, this column shows the minimum amount of powder (liters) needed to start a blend cycle.
 - For the blender, this column shows the maximum volume allowed before starting the blend.
- When multiple transport events are displayed on the top line of the display, the currently active transport will now be displayed first on the left. Everything to the right is waiting on queue. Note: The queued items are not in order.
- The “N₂” flag is no longer displayed on the top line of the main screen. The status of the cooling cycle is always displayed at the bottom of the screen, and is independent of the transport activities.

MQC operational changes

- Bin level is now controlled by volume only. The proximity sensors on the bins are still checked, but they only generate log warnings.
- Used and Blended bin recirculation will only take place if its volume is at least 10 liters
- The Fresh powder bin loading sequence is inhibited if the bin is within ½ a bottle of being full.
- When the used bin fills up while sifting, the MQC stops the sifting cycle from restarting, and clears the active flag.