iPro® and ProX® 800

3D Production Printers

Filled Material Usage for New Resin Bottles

P/N 40-D040
Rev. A

Purpose of Document

The purpose of this document is to inform about a change in how all filled materials from 3D Systems are supplied to customers. Materials affected are:

Accura® Bluestone™
Accura® HPC™
Accura® CeraMax™
Accura® Greystone™

The changes in how the materials are packaged are as follows:

- **We have designed a new bottle with a wide opening that allows for easy mixing and pouring of material.**
- **We are packaging a programmed RFID cap in with each new bottle.**

The following pages describe how to fill the MDM/RDM with resin on the iPro printer (pg. 3), as well as how to fill the MDM with resin on the ProX 800 printer (pg. 5).

WARNING: WHETHER THE PRINTER IS POWERED ON, POWERED OFF, OR IN BYPASS MODE, PERFORMING THIS PROCEDURE MAY EXPOSE YOU TO UV LIGHT, MOVING MECHANISMS, HEATED PARTS, HAZARDOUS VOLTAGES AND SENSITIZING MATERIALS.

YOU MUST FOLLOW ALL SAFETY PRECAUTIONS AS PROVIDED IN THE USER TRAINING PROGRAM AND WEAR ALL PERSONAL PROTECTIVE EQUIPMENT AS SPECIFIED IN THE USER TRAINING PROGRAM.

iPro SLA Systems Procedure:
Fill MDM/RDM with Print Material

1. Wearing nitrile gloves, insert the programmed cap into one of the two material-refill readers inside the bottle chute.
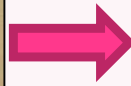
NOTE: Always stir the resin in the MDM/RDM prior to the addition of new material. Recommended methods of stirring are: performing platform stirring, using a shaft-driven, high-shear mixing blade, or using a squirrel-cage mixer.

NOTE: Always stir the material in the bottle prior to pouring it in the MDM to ensure it is completely mixed. Recommended methods of stirring are: using a shaft-driven, high-shear mixing blade or a squirrel-cage mixer.

2. Pour the material from the new, wide-mouth bottle into the MDM/RDM (Fig. 1, below).

⚠️ WARNING: AVOID POURING MATERIAL ANYWHERE AROUND THE OMRON FINE-LEVEL SENSOR, CIRCLED IN FIG. 2 BELOW. RESIN SPLASHES COULD DAMAGE THE SENSOR.

Fig. 1 – ProX 800 pictured, demonstrating an ideal place to pour resin into the MDM/RDM

Fig. 2 – iPro OMRON fine-level sensor location

📝 **NOTE: ALLOWING FOR EASE OF USE, YOU NO LONGER HAVE TO WEIGH THE BOTTLE.**

3. When bottle is empty, or when prompted by the printer UI, remove the programmed cap from the bottle chute.

ProX 800 Procedure:
Fill MDM with Print Material

1. Insert the programmed cap into the receptacle of the MDM, located on the front of the unit.

NOTE: Always stir the resin in the MDM/RDM prior to the addition of new material. Recommended methods of stirring are: performing platform stirring, using a shaft-driven, high-shear mixing blade, or using a squirrel-cage mixer.

NOTE: Always stir the material in the bottle prior to pouring it in the MDM to ensure it is completely mixed. Recommended methods of stirring are: using a shaft-driven, high-shear mixing blade or a squirrel-cage mixer.

2. Pour the material from the new, wide-mouth bottle into the MDM (Fig. 1, below).

⚠️ WARNING: AVOID POURING MATERIAL ANYWHERE AROUND THE OMRON FINE-LEVEL SENSOR, CIRCLED IN FIG. 1 BELOW. RESIN SPLASHES COULD DAMAGE THE SENSOR.

Fig. 1 – Pour resin into MDM, avoiding area around OMRON fine-level sensor.

3. When bottle is empty, or when prompted by the printer UI, remove the programmed cap from the receptacle by pushing the button on the side of it.

📝 **NOTE: Please see the next page for ordering information.**

Ordering Information

The part numbers to use for ordering filled materials for iPro and ProX 800 printers remain the same (all 10kg bottles):

Accura® Bluestone™ – P/N 24025-920
Accura® HPC™ – P/N 24091-920
Accura® CeraMax™ – P/N 24085-920
Accura® Greystone™ – P/N not needed when ordering

Please use the following contact information for your material order:

USA and Canada
+1 888-598-1438
order@3dsystems.com

Global
+1 803.326.3930
customerservice.de@3dsystems.com

Pn: 40-D040