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ProJet™ 5000 Printer Facility Requirements Guide

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01.0 About this Manual

This document includes all of the overall facility requirements that will be needed to have a successful installation when our 3D Systems Customer Support Engineers (CSEs) or authorized 3D Systems representatives arrive to install your 3-D printer.

02.0 What is a Facility Requirements Guide







This guide provides important information on selecting a facility location and planning for the installation of 3D Systems' ProJet™ Production Printing System. It also presents planning guidelines to facilitate fast, convenient installation and operation of your printer.

What's Inside:

- A description of hardware, software, part material, networking components, and documentation that comprise the ProJet™ Production Printing System.
- An overview of the site requirements in typical engineering and design work spaces. These involve basic access, electrical, and environmental conditions for configuring a safe and efficient work area.
- A checklist is included to ensure that the facility is adequately prepared for installation of your printer.
- Information on how to obtain assistance from [3D Systems Customer Support Team](#).

03.0 Symbols Used in this Guide

!NOTE.jpg|width=30,height=30! **NOTE: The ProJet™ Production Printing System is part of 3D Systems' Multi-Jet-Modeling (MJM) product line.**

	<p>This symbol designates the accompanying texts or figures as either a CAUTION or a WARNING.</p> <ul style="list-style-type: none">• Caution: Indicates something may happen that could cause loss of data, damage to equipment, or personal injury.• WARNING: Indicates a hazard to both equipment and personnel that may be in the immediate area.
	<p>This symbol is used to warn of the presence of potentially HAZARDOUS VOLTAGE. High voltage electricity is accessible in the vicinity of this sign or behind the access panel. High voltage can cause severe burns or death. Access panels are for service only and should be opened only by certified service personnel or trained maintenance personnel.</p>
	<p>Invisible UV radiation is accessible in the vicinity of this sign or behind the panel. Radiation can cause eye injury. Access panels are for service only and should be opened only by certified service personnel. Use UV radiation eye and skin protection when servicing with "bypass engaged."</p>
	<p>A hot surface is accessible in the vicinity of this sign or behind the access panel. Avoid contact. Hot surfaces can cause severe burns. Access panels are for service only and should be opened only by certified service personnel or trained maintenance personnel.</p>
	<p>Harmful Irritant Warning: Indicates that skin or eye irritation could result while exposed to a chemical composition.</p>
	<p>When accompanied by the word "NOTE", the text and symbol are meant to call attention to a practice whose implementation can save time or prevent subsequent inconvenience to the user.</p>

04.0 The ProJet™ Production Printing System

The ProJet™ Production Printing System consist of the following components, providing these functions:

- Automatically outputs 3-dimensional prints from digital data supplied to the printer in the required .stl file format, using a two-material process.
- ProJet™ client software is provided with each printer. This software provides users with the ability to set up and submit jobs to the printer, and may be installed on additional user's workstations (within your facility) at no additional cost per user. Each workstation should meet the minimum "[Client Workstation Requirements](#)."
- VisiJet® support and build materials - VisiJet® build material is for production of the actual prints, and the VisiJet® support material produces the required support structures necessary to build 3-dimensional prints. These materials are formulated exclusively for use with the ProJet™ Production Printing System.

04.1 What is Included with a ProJet™ Production Printing System

A ProJet™ 5000 System ships with the following:

- One crated ProJet™ Production Printing System containing an accessory kit which consist of:
- Two Build Platform
- "Starter Pack" consisting of one (1) S300 Support Material Bottle and one (1) MX Build Material Bottle

- One licensed copy of 3D Systems ProJet® Client Software with integrated online Help and Quick Reference Guide
- Region-specific ProJet™ Production Printing System "country kit" consisting of:
 - One power cable kit for of a country-appropriate power, and a voltage warning document
 - One pack of nitrile gloves
 - One box of drip pans

05.0 Facility Guidelines

This section provides detail relating to site selection, site preparation and readiness of the facility to accept and install the ProJet™ Production Printing System.

Discuss the appropriate equipment locations with a 3D Systems' representative, so that the equipment is located in a convenient, appropriate location based on your organization's needs. When planning an installation, consider:

05.1 Space Planning

05.2 Access Area Surrounding Printers

05.3 Unit Portability

05.4 Electrical

05.5 Client Workstation Requirements

05.6 Network Interface

05.7 Material Storage

05.8 Material Bottle Disposal

05.9 Weights and Measures

05.1 Space Planning

Below is a suggested floor plan for a ProJet™ Production Printing System installation. Each printer requires use of a dedicated circuit. Multiple printers CAN NOT be located on a single circuit. An additional 110 or 220 VAC outlet is recommended for service needs. A phone near the printer is recommended to facilitate machine support. Each location of the machine requires a standard wall power outlet or power drop to power printer. **The outlet location must be near the printer and remain accessible to the end user at all times.**



*NOTE: The ProJet Finisher XL has to be hard-wired in the facility. Ensure a certified electrician is required for installation.

A freezer is required for cooling parts after builds. The size of the freezer must be able to accommodate the build platform's size of 22 (L) x 16.25(W).

Dimensions	(WxDxH)
Crated:	1828 x 1155 x 1981mm (72 x 45.5 x 78 inches)
Uncrated:	1531 x 908 x 1450mm (60.3 x 35.7 x 57.1 inches)

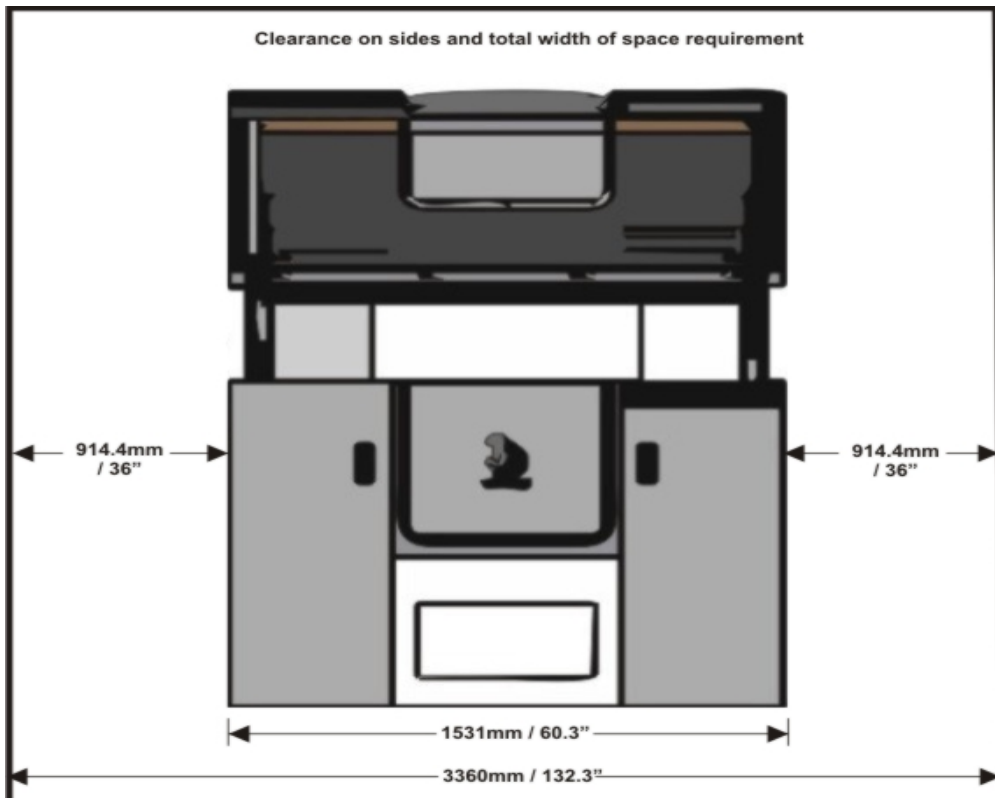


NOTE: The printer MUST be placed on a vibration free concrete floor. Do not install on any other floor covering such as vinyl, tile, carpeting, etc.. Doing so WILL affect machine performance.

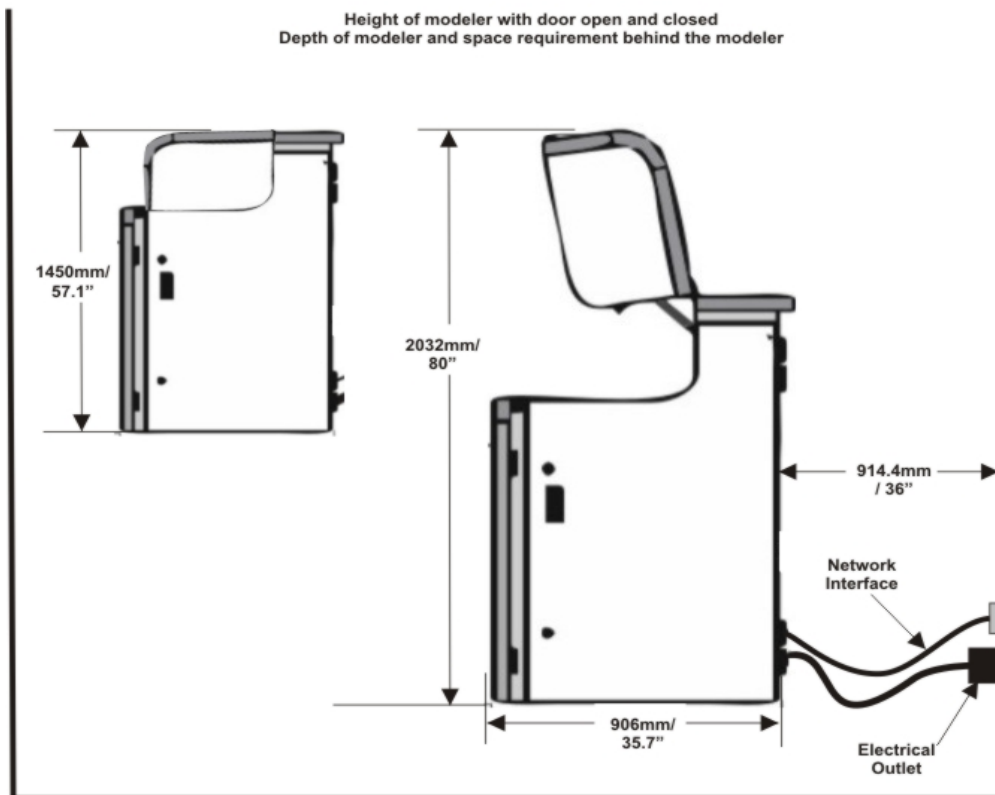


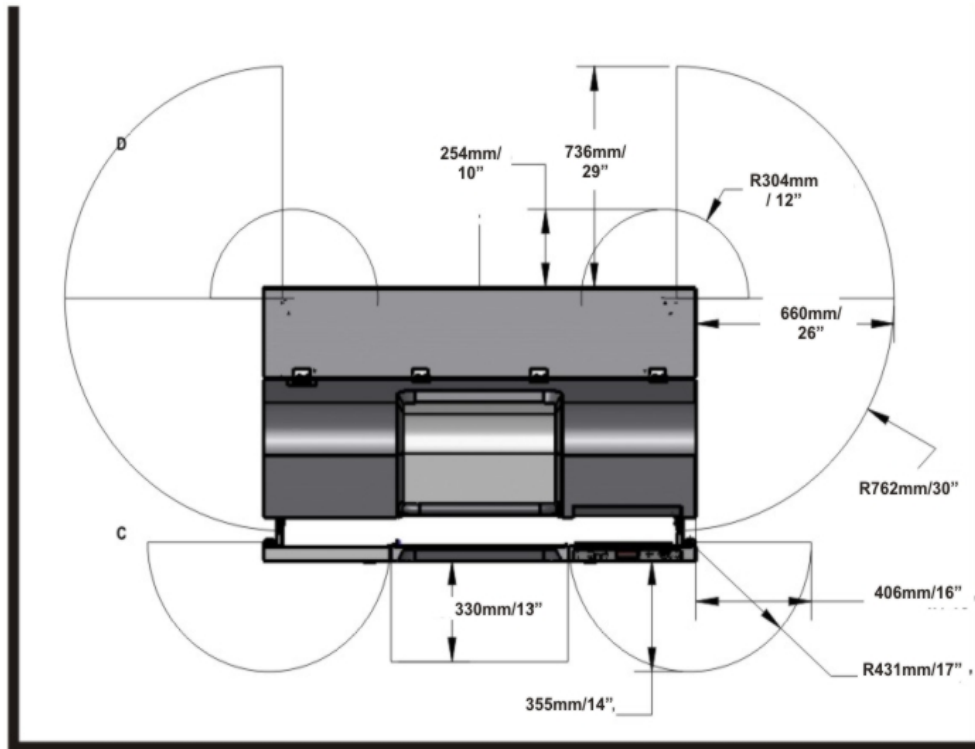
NOTE: The ProJet™ Production Printing System is not designed to connect to an IT system.

Clearance on sides and total width of space requirement



Height of modulator with door open and closed
Depth of modulator and space requirement behind the modulator





05.2 Access Area Surrounding Printers

At least 36" (908mm) of unobstructed floor space is recommended around each accommodate, to allow unobstructed service access to the drawers, hood and doors.

Store crate where it will be easy access to wheel locks or have a jack lift available for the 3D Systems Field Engineers when installation occurs.

05.3 Unit Portability

	NEVER unpack, assemble, or connect any component of the shipment without the aid of a qualified, 3D Systems Field Service Engineer or authorized reseller. 3D Systems accepts no responsibility for damaged, defective, or incomplete systems uncrated by anyone other than 3D Systems Field Service Engineer or authorized reseller.
	The casters provided have a small diameter and are not intended for use on rough or uneven surfaces including deep carpet.
	To avoid the risk of tipping the printer when moving between locations, only push from the side of the printer.

The printer is intended to be lifted from its crate base using a fork lift device and place on casters to roll to its final destination. Leveled fork lift pads have been placed beneath the machine to accommodate this need. The front and rear guard panels must be removed prior to lifting.

The ProJet™ Printing System is equipped with four caster-type rollers, as well as four integral threaded feet. Leveling can be adjusted using the threaded leveling feet, and tighten in place to secure the printer.

	Once the printer is installed, it cannot be moved without the aid of a qualified, 3D Systems Field Service Engineer or authorized reseller. 3D Systems accepts no responsibility for damage to the printer by anyone other than 3D Systems Field Service Engineer or authorized reseller.
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When moving, **DO NOT** push from the front of the printer. It can tip over if casters are on uneven flooring. Always push printer from the side.



05.4 Electrical

The AC voltage and current requirements for the ProJet™ Production Printing System are:

- 115 VAC, 50/60 Hz (dedicated 20 amp breaker)
- 230 VAC, 50/60 Hz (dedicated 15 amp breaker)

Note: The installation of The ProJet™ Production Printing System shall comply with the National Standards and/or Electrical Codes of the country in which it is placed.

ProJet™ Production Printing System Power Considerations:

During normal operation, the power usage of the printer will not exceed the continuous current rating indicated in the electrical section (above). A dedicated, surge-and-spike protected electrical power circuit for each printer should be provided that meets or exceeds the corresponding continuous current rating.



The ProJet™ Production Printing System is not designed to connect to an IT power system.

Protected Power/Uninterruptible Power: A dedicated, surge and spike protected electrical power circuit is required for each printer installed. No other equipment is to be installed on this circuit.

Uninterruptible power/active battery backup is **required**, especially in areas where circuits may be affected by an outside source, i.e. lightning strikes, power interruption, etc.

They should have a **minimum rating of 3KVA**. Some examples of suppliers are Toshiba or APC. Power loss during a build will fail the build and can cause damage to your printer. Uninterruptible power is critical to the successful operation of the machinery.

05.5 Client Workstation Requirements

Before a build can be built on the printer, the build data file must be saved or exported to the industry-standard .stl file format, and submitted over the network (or fashdrive or cable). The compact disk (CD) shipped with the ProJet™ Printer contains ProJet™ Client Software, which is installed on each intended users' workstation to allow users to select, preview, and submit jobs; as well as manage the build queue (for designated administrators).

Prior to installing the software, ensure that the initially selected workstation meets the following minimum specifications. The specifications described represent 3D Systems tested minimum "baseline" configuration for using the client software. It is **recommended** that this workstation be further enhanced for **maximum** performance, particularly with more powerful processors and added memory.



Although the ProJet™ client software will run on less powerful computers, meeting the minimum recommended configuration will ensure acceptable performance.

Minimum System Requirements	
Operating System	Windows XP/Windows Vista/ Windows 7
Processor	Intel® Pentium® 4 Processor
Memory	1 GB RAM
Hard Drive	4 GB free space
Video	Graphics adaptor with OpenGL 3D acceleration, true color at 1024x768 resolution
Network	Ethernet network infrastructure with TCP/IP protocol
Pointing Device	Two-button mouse

05.6 Network Interface

The ProJet™ Production Printing System requires an Ethernet network connection to transfer print jobs from workstation(s) to the printer.

Network Specifications, Physical: The machine's internal controller provides an integrated, 10/100-megabit-per-second (Mbps) Ethernet network connection. This connection supports both the 10base-T and 100base-TX Ethernet standards. The controller's connector (an RJ45 socket located on the back panel) is designed for attaching a shielded twisted pair (UTP) Ethernet cable.

When a facility's internal network is not 10base-T or 100base-TX, a media converter, such as a Coax to 10base-T will be required. Consult with your organization's network engineering or MIS staff to provide assistance with these requirements.

The printer works on networks running TCP/IP ONLY each printer MUST have a STATIC IP address on the network. Additionally, each printer's subnet mask and default gateway must be known and available to 3D Systems' 3D Systems Field Service Engineer or authorized reseller at the time of its installation, and should also be known by personnel installing the client software. They will need access either to the appropriate subnet mask or the individual IP address of each printer to complete the workstation software installation, and to enable access to any printer on the network.



Not all networks have the TCP/IP installed. Make sure to have a network administrator check that TCP/IP are both installed and are running as required PRIOR TO THE ARRIVAL of the printer.

05.7 Material Storage

VisiJet® part and support materials should be stored in a conveniently located storage cabinet in proximity to the printer itself. A cabinet is recommended to protect against long term exposure to external UV light sources, including sunlight, overhead lighting, or other UV light sources. **Storage temperature of the material should not exceed the specified maximum of 35°C (95°F).** VisiJet® part material should be stored away from strong oxidizing agents, such as hydrogen peroxide, bromine, or chromic acid.

NOTE: When storing material bottles that have been used but still have materials in the bottles, do not lay the bottles on their side in storage. Store box with side spacers installed. *DO NOT rest on nose of bottle. Also, in the case where used bottles with materials are removed from the MDM and are still warm, it must be stored with the cap vented. If the warm bottle is not vented, the wax will contract during cooling and the bottle's bottom may become flat which will prevent reengagement in the MDM.*



More detailed information on the VisiJet® build material and VisiJet® support material, relevant applicable safety precautions and remediation, and specific storage and disposal requirements, can be found in the [Material Safety Data Sheet \(MSDS\)](#). Your organizations' Facilities Manager (or equivalent) should maintain a copy of the two MSDS documents, and provide ready, convenient access to these documents. To obtain the [VisiJet material MSDS from 3D Systems](#), [click here](#) for additional copies. If further information is needed, please contact 3D Systems' Customer Hotline within the U.S. at (800) 793-3669 (or from outside the U.S.A. at +49 (0) 6151 357357, or by visiting [3D Systems website](#).

05.8 Material Bottle Disposal

Used part material bottles must be disposed of in a manner consistent with local and other applicable laws and regulations governing such materials. Refer to the VisiJet® materials' MSDS sheets prior to shipment of the ProJet™ Production Modeling System. Discuss your organization's methods for disposing or recycling of such material with your facilities manager, or for more information, contact 3D Systems' Customer Support Hotline .

05.9 Weights and Measures

Printer's Weight and Dimensions

Measurements (W x D x H)

CRATED	UNCRATED
183cm x 116cm x 198cm (72" x 45.5" x 78")	152cm x 91cm x 149cm (60" x 36" x 57"- Lid up) 152cm x 95.25 cm x 149cm (60" x 37.5" x 57"- Lid down)

Weight

Material Delivery Module (MDM): 14kg (30 lbs.)

CRATED	UNCRATED
With two (2) MDM: 651kg (1435 lbs.)	With two (2) MDM: 481kg (1060 lbs.)
Without two (2) MDM: 624kg (1375 lbs.)	Without two (2) MDM: 454kg (1000 lbs.)

06.0 Operating Environment

Locate the ProJet™ Printing System in a convenient location meeting the requirements specified in this document. To ensure optimum performance, it is important that the printer should be installed in a clean, dry, air-conditioned room. Avoid placing the printer in any environment with airborne contaminant, including cigarette smoke, fumes, and mechanical particulates that can adversely affect the long term functioning of this equipment.



Each ProJet™ Production Printing System undergoes an operational test at the factory, and is shipped with a limited, residual amount of build and support material already in its internal reservoir. When ordering, order enough build and support materials for each MDMs supplied and for reserves when running production builds. This will ensure adequate supplies of material are available to avoid build delays.

06.1 Air Conditioning

06.2 Humidity

06.3 Lighting

06.4 Vibration and Shock

06.1 Air Conditioning

A number of the ProJet™ 5000 System's internal electronic components as well as the part material, are sensitive both to ambient temperature and, to some extent, humidity. In addition, the build process itself can be temperature-sensitive within certain limits. The operating temperature range should be between 18-28°C (64-82°F); optimally approximately 21-24°C (70-75°F). The facility air conditioning system where the printer is operating should be capable of dissipating 1.0 kW (3412 Btu or 0.28 ton U.S. refrigeration) of heat or equivalent to deep temperature requirements. Ensure that any air conditioning ducting does not vent directly onto the machine.



CAUTION: Do not install a ProJet™ Production Printing System in the same area as equipment with heavy vibration, or airborne contaminants that may adversely affect the printer's performance.

06.2 Humidity

Humidity should be maintained at less than 50% non-condensing.

06.3 Lighting

The ProJet™ Production Printing System is equipped with its own internal light build chamber, and back lit operating panel control with display. Normal area lighting is necessary for operation and service of this system. Florescent light is the best lighting for the system.

06.4 Vibration and Shock

The ProJet™ Production Printing System consists of many precision mechanical and sensing systems that are sensitive to vibration during the build process. To maximize the quality and accuracy of the build, it is required that the unit not be near heavy machinery or any source causing high vibration or shock (i.e. exterior walls near train tracks or airports).

NOTE: The printer **MUST** be placed on a vibration free concrete floor. Do not install on any other floor covering such as vinyl, tile, carpeting, etc.. Doing so **WILL** affect machine performance.

07.0 Preparation for Shipment Arrival



NOTE: Never unload, unpack, assemble, connect, or install 3D Systems' ProJet™ Production Printing System without the aid of a qualified 3D Systems Field Service Engineer or an authorized reseller.

The following topics should be arranged PRIOR TO THE ARRIVAL OF THE SYSTEM, to simplify installation of the ProJet™ Production Printing System.

Refer to later sections of this guide for details of this procedure.

Make sure the following resources are available (✓):

___ A forklift or similar, heavy-duty equipment required for unloading the printer crate from the truck to the location where it will be uncrated and installed.

___ Network connection(s) - 1

___ If ProJet Finisher XL is to be installed, a certified electrician will be need at the site to hard wire the finisher in the facility.

___ Power outlet(s) - a dedicated circuit to power the printer

___ Storage cabinetry for extra printer material containers and other consumables

___ At least one (1), networked graphics workstation or CAD/CAM/CAE terminal meeting the requirements described in [Client Workstation Requirements](#).

08.0 MDM Bottle & Build Platform Installations



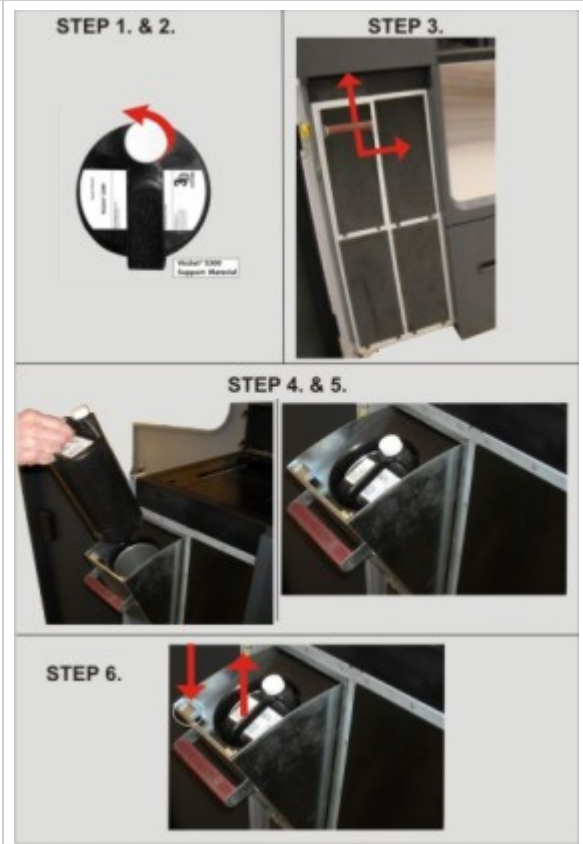
CAUTION: IF AT ANY TIME THE "UNCRATED" ProJet™ Production Printing System is to be moved a forklift must be used, ALWAYS contact a 3D Systems' CSE PRIOR TO THE MOVE. Exercise care in moving the machine, physical shock should be avoided. 3D Systems accepts no responsibility for any damage to the machine, repairs that may result from accidental damage to the printer.



WARNING: Avoid accidental contact with potentially hazardous voltage, or circumstances that may cause a short or ground fault.

Material Bottles: The printer has up to four material delivery modules for build materials and up to four material delivery modules for support materials. The support delivery modules are located on the left side and the build is located on the right side of the printer. Each delivery module holds one (1) bottle of material.
NOTE: Before handling the build material bottle, read the Material Safety Data Sheet (MSDS).

1. Install Material Bottles: Unpack bottles and the MSDS/SDS Sheet from cartons.
2. Open left and/or right material delivery doors. Pull material delivery module (MDM) handle down and out to open.
3. Install bottle into the MDM; press bottle down until a click sounds.
4. To ensure that bottle is locked in place, gently pull on bottle. If bottle is loose, press bottle down to ensure it is secured in MDM.
5. Loosen bottle cap 1/2 to 3/4 turn counterclockwise to allow the bottle to vent.
6. Before removing bottle from the MDM, re-tighten bottle cap to prevent spillage. To remove bottle, open material delivery module and press release latch down and lift bottle out of module.



Build Platform:

1. Ensure that the corner guides on the backside of platform are clean and free of debris. If debris exists when installing, the platform guides will not lock into the platform elevator.
NOTE: Clean platform elevator and platform using a lint free cloth and Isopropyl alcohol. When cleaning platform, clean the front and back sides.
2. Lift build chamber door; place platform with corner guides and pads facing down onto the platform elevator. Seat onto elevator. The corner guides will affix the platform to the elevator and if properly installed, platform will not move. It should sit squarely on the elevator and be firmly located by the corner guides. Use caution not to drop the platform or hit the printhead.
3. Close build chamber door and press ONLINE.
4. To remove platform, lift from the sides; pull up and out from the platform elevator.



The ProJet™ Production Printing System can now be used to produce prints.

Note: Retain the shipping crate, brackets and hardware incase the ProJet™ Production Printing System needs to be shipped back to the manufacturer for repair. These crates are designed to allow fast, easy removal and packaging of the product. If printer needs to be return to the manufacturer, contact 3D Systems Customer Support for shipping instructions.

09.0 Limitation of Liability

3D Systems is not, in any event, liable for any damages, including lost profits, cost of cover, or other special, incidental, consequential, or indirect damages arising from the use of this document, however caused and on any theory of liability. This limitation will apply even if 3D Systems or an authorized dealer or representative has been otherwise advised of the possibility of such damage. This document, in whole or in part, may be changed or modified at any time at the sole discretion of 3D Systems, without notice.

10.0 Thank You

3D Systems is confident that you will be very satisfied with the purchase of your ProJet™ Production Printing System. Enjoy the ability to produce high quality parts from your 3-D digital data. We are dedicated to developing a relationship that extends beyond the terms of the sale. Please take the time to contact 3D Systems with questions, comments or suggestions about your ProJet™ Production Printing System, or other products or services. 3D Systems strives for higher quality, better products, and comprehensive services to benefit our customers.

11.0 Contacting 3D Systems

For information or assistance, contact 3D Systems' corporate headquarters at:

3D Systems Corporation
333 Three D Systems Circle
Rock Hill, SC 29730
Toll-Free Number: (800) 889-2964
Phone Number: (803) 326-4080
Web: www.3dsystems.com
Email: more info@3d systems.com

For Customer Support:

Region	Telephone	Email
North America	(800) 793-3669	3DWW-MJM Customer Support@3dsystems.com
Europe	+49 (0) 6151 357357	

For localized service or support, contact the appropriate 3D Systems regional facilities listed below:

Region	Telepone	Fax Number	Email
France	+33 1 69351717	+33 1 69351718	hotline.fr@3d systems.com
Germany	+49 6151 357 357	+49 6151 357355	hotline.de@3d systems.com
Hong Kong	+852 2923 5077	+852 2574 4200	asian info@3d systems.com
Italy	+39 039 68 904 00	+39 039 68 81156	Marketing.IT@3d systems.com
Japan	+03 5451 1690	+03 5451 6630	japan info@3d systems.com
Portugal	+33 1 69 35 17 17		
Spain	+33 1 69 35 17 17		
UK	+44 1442 282600	+44 1442 282661	marketing.uk@3dsystems.com

Contact the following Account Representative:

Name: _____
Address: _____

Tel: _____
Fax: _____

Returning the Advance Preparation Checklist?

Return the completed checklist via the method chosen below:
 Fax to the Account Representative's fax number (above):
 Fax to the _____
 office fax number (see above)
 Fax or mail to: _____

ACCOUNT REPRESENTATIVES Place Business Card here and staple to document.

STAPLE CARD HERE

12.0 Printer Advance Preparation Checklist



NOTE: Unless governed by prior arrangement, 3D Systems is not responsible for loading the ProJet™ client software on the user's workstation(s). Thus, BEFORE THE PRINTER ARRIVES, ensure that your workstation is capable of supporting the requirements of both the client software and communication with the machine via your network.

Review this list with a network administrator, IT department, facilities manager or other responsible person within your organization. Complete and place a check mark next to each item. Once everything is complete, photocopy this page, and fax it to the number checked or provided on the bottom of the inside back cover of this document. If no number is provided or relevant, then fax to +1 970-257-4601 (U.S.A).

Please complete the following (if making a copy to fill in, please print):

Company Name: _____
 Contact (Print full name): _____
 Date faxed: _____
 Telephone (with area code): _____
 Email: _____

Please place a check in each box once that item is complete.	Check Box
Final installation site selected. The intended physical location for each ProJet™ Production Printing System(s) should be selected in advance, and checked for adherence to the guidelines set out in this guide.	
If required by the shipper, a method of removing the crate from the shipper's truck has been arranged (forklift is required) and is available to transfer the crate(s) to the decrating location.	
NETWORK CONNECTION IS INSTALLED. An RJ45 (UTP, female connection jack) Ethernet network connection for EACH printer that is to be installed at the delivery site must be installed, tested and functioning.	
Operating system and workstation configurations are compatible and meet the minimum requirements as stated in the "Client Workstation Requirements" section.	
TCP/IP is installed and enabled.	
Static IP address(es) has/have been allocated for each printer ordered. A permanent IP address on the network is assigned (presumably by a Network Administrator) to each printer that is to be connected to the network. Write IP address here: _____	
Test each IP address by pinging it, or by temporarily connecting a network resource (such as a workstation or a Printer) and "pinging" from another workstation on the network.	
Dedicated line, with a surge-and-spike-protected electrical power circuit for each printer, meeting one of the following specifications (Place check mark beside the appropriate specification: <input type="checkbox"/> 115 VAC, 50/60 Hz (dedicated 20 amp breaker) <input type="checkbox"/> 230 VAC 50/60 Hz (dedicated 15 amp breaker)	
Provide uninterruptible power (active battery back-up)	

Before the printer is installed into this facility, we acknowledge that the installation site complies with the specifications stated in the ProJet™ Facility Requirements Guide. Once the printer is installed, we agree not to alter any requirements without consulting with 3D Systems' Customer Service Representative. If alteration are made without consulting 3D Systems, it may void the system's warranty.

Customer Signature: _____ **Date:** _____

Please return a copy of the check list by FAXING it to the appropriate fax number provided in **Contacts**.