

# Customer Information Bulletin



3D Professional Printer

CIB 00205

Date: 9/3/2020

**Subject: Material Update**

**ProX SLS 500/6100**

## Introduction:

This September 2020 material update includes the following:

1. DuraForm ProX HST material configuration file update
2. Advanced configuration file updates for all materials

This CIB lists installation steps to successfully deploy this material update over V6.3.527 Sinter software for ProX SLS 6100 and ProX SLS 500 printers.

## Why are we updating DuraForm ProX HST and Advanced configuration files?

DuraForm ProX HST Update (for ProX SLS 6100 only):

ProX 6100 printers running the DuraForm ProX HST material may have trouble reaching the required build temperature by the end of the warm up stage and may have parts that curl when they start printing, indicating a cold part bed.

## Solution:

The updated configuration file for the DuraForm ProX HST material on the ProX 6100 printer has new heater ratios for the default settings in both SP and Advanced mode. The changes to the default are detailed below.

Parameter	Old Setting	New Setting
RIGHT BACK (QUADRANT 1) HTR RATIO	31	33
LEFT BACK (QUADRANT 2) HTR RATIO	36	36
LEFT FRONT (QUADRANT 3) HTR RATIO	32	42
RIGHT FRONT (QUADRANT 4) HTR RATIO	22	30
LEFT INNER HTR RATIO	40	48
RIGHT INNER HTR RATIO	43	48

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## **Advanced configuration file updates for all materials:**

3D Systems offer SLS materials in Standard Production (SP) Mode, High Production (HP) Mode, and Advanced Mode.

The process settings in the SP configuration files controls the limits of the ProX SLS system to ensure customer get the performance they desire and removes variability that could occur during the standard print process. The HP mode offers faster processing times for users, a good starting point to operate while using this mode. Process settings for the 'Advanced' configuration files offer more processing latitude for **expert** users. The default mode, or the recommended mode, by 3D Systems is the SP Mode.

This material update fixes the 'Advanced' configuration files to use the same defaults as SP mode, thus providing a good starting point to operate.

Please note that 'Advanced' mode is for **expert** users only, who desire to customize the performance of the system. These Advanced configuration files addresses that need by increasing the allowed ranges for many parameter values.

**CAUTION:** It is the customers/users responsibility to validate results (such as part quality or mechanical properties) at the parameter values they use in 'Advanced' mode. Note: The 3D System's Field Service Engineer may require use of SP Mode material configuration files for troubleshooting.

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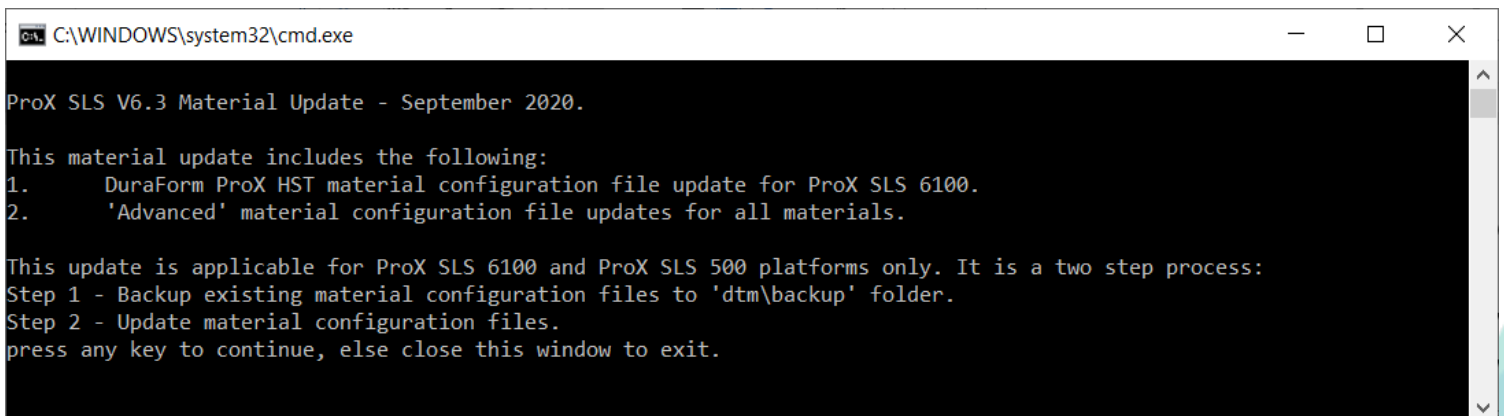
## Installation Steps:

### Download Steps:

- Download [ProXSLS V6.3 MaterialConfigUpdate-Sep2020.zip](#) from Infocenter.
- Copy the downloaded zip file to the drive where you have Sinter already installed (C drive).
- Extract the zip.
- Extracted path will be : *"C:\ProXSLS\_V6.3\_MaterialConfigUpdate-Sep2020"*
- After extraction is complete, verify **ProXSLS\_V6.3\_MaterialConfigUpdate-Sep2020** directory contains the following:
  - **dtm** directory
  - **UpdatedMaterials** directory
  - **ProXSLSMaterialConfigUpdateSep2020.bat** file.

### Steps to install the update on the printer PC:

- Close the Build Prep software if it is running.
  - On ProX 500: if Build Setup is running, save current build packet (if needed) and close it.
  - On ProX 6100: if 3D Sprint is running, save current file (if needed) and close it.
- If build is not in-progress, then run KillSinter.exe to close Sinter and related applications.
- Run **ProXSLSMaterialConfigUpdateSep2020.bat**. You may see a security warning, accept and continue to run the batch file. On successful launch, follow the steps.



```
C:\WINDOWS\system32\cmd.exe
ProX SLS V6.3 Material Update - September 2020.
This material update includes the following:
1. DuraForm ProX HST material configuration file update for ProX SLS 6100.
2. 'Advanced' material configuration file updates for all materials.
This update is applicable for ProX SLS 6100 and ProX SLS 500 platforms only. It is a two step process:
Step 1 - Backup existing material configuration files to 'dtm\backup' folder.
Step 2 - Update material configuration files.
press any key to continue, else close this window to exit.
```

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## Installation Steps:

Enter installation drive letter ('C' or 'c') and choose the platform (6100? Yes or no):

```
C:\WINDOWS\system32\cmd.exe
Please enter the drive letter where you installed ProX SLS SINTER software V6.3 ?

*** Enter letter ONLY (no colon) e.g. C or D ***

C

Choose platform : Is this update for ProX SLS 6100 ? Enter Yes or No.
No
```

OR

```
C:\WINDOWS\system32\cmd.exe
Please enter the drive letter where you installed ProX SLS SINTER software V6.3 ?

*** Enter letter ONLY (no colon) e.g. C or D ***

C

Choose platform : Is this update for ProX SLS 6100 ? Enter Yes or No.
Yes
```

Step 1: Back up files from "dtm\config\material" to "dtm\backup"

```
C:\WINDOWS\system32\cmd.exe
Step 1 - Copying existing material configuration files to 'dtm\backup' folder...
15 File(s) copied

Step 1 complete. Please check "c:\dtm\backup\config\material" directory for backup before proceeding to Step 2.

Press any key to continue, else close this window to exit.
```

OR

If backup folder is not empty, you will see below screen.

Type 'n' for NO, 'y' for Yes or 'a' for all:

```
C:\WINDOWS\system32\cmd.exe
Step 1 - Copying existing material configuration files to 'dtm\backup' folder...
Overwrite C:\dtm\backup\config\material\ProX_SLS_6100_DuraFormProX-AFplus_Advanced.cfg (Yes/No/All)? n
Overwrite C:\dtm\backup\config\material\ProX_SLS_6100_DuraFormProX-AFplus_SP.cfg (Yes/No/All)? n
Overwrite C:\dtm\backup\config\material\ProX_SLS_6100_DuraFormProX-EX_Black_Advanced.cfg (Yes/No/All)? y
Overwrite C:\dtm\backup\config\material\ProX_SLS_6100_DuraFormProX-EX_Black_SP.cfg (Yes/No/All)?
```

Step 2: Deploy updated material files.

```
C:\WINDOWS\system32\cmd.exe
Step 2 - Updating material configuration files...
9 File(s) copied
9 File(s) copied

Step 2 - Update material configuration files complete. Please check updated files.
Thank you
```

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**Subject: Material Update****ProX SLS 500/6100****Verify if the update installed successfully:**

- Verify if the files are copied in the right locations.
  - Old files back-up under 'dtm\backup\config\material '
  - Updated material configuration files deployed under 'dtm\config\material'.
- Check if following files under 'dtm\config\material' show updated content.
  - **ProX\_SLS\_6100\_DuraFormProX-HST\_Advanced.cfg**

```
# 3DSystems SLS Software Version 6.3.527, ProX SLS 6100
PACKET ProX_SLS_6100_DuraFormProX-HST_Advanced.cfg
style 503
last_modified 1435330140 # Thu Aug 20 2020 21:58:00
```

```
STRUCTURE BLACKBODY_HEAT_MAT
```

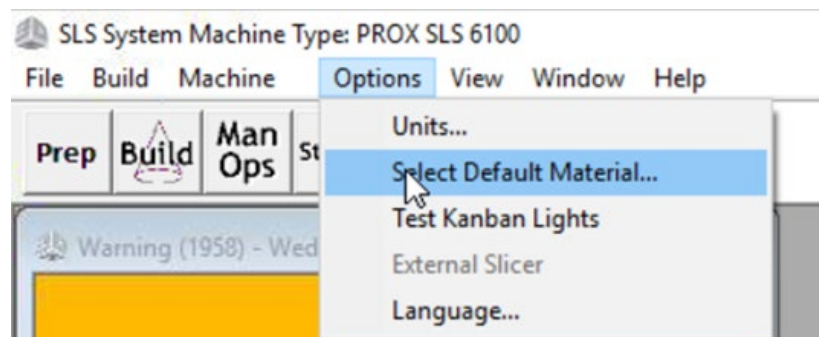
...

- **ProX\_SLS\_500\_DuraFormProX-HST\_Advanced.cfg**

```
# 3DSystems SLS Software Version 6.3.527, ProX SLS 500
PACKET ProX_SLS_500_DuraFormProX-HST_Advanced.cfg
style 503
last_modified 1435330140 # Fri Mar 06 2020 01:05:00
```

```
STRUCTURE BLACKBODY_HEAT_MAT
```

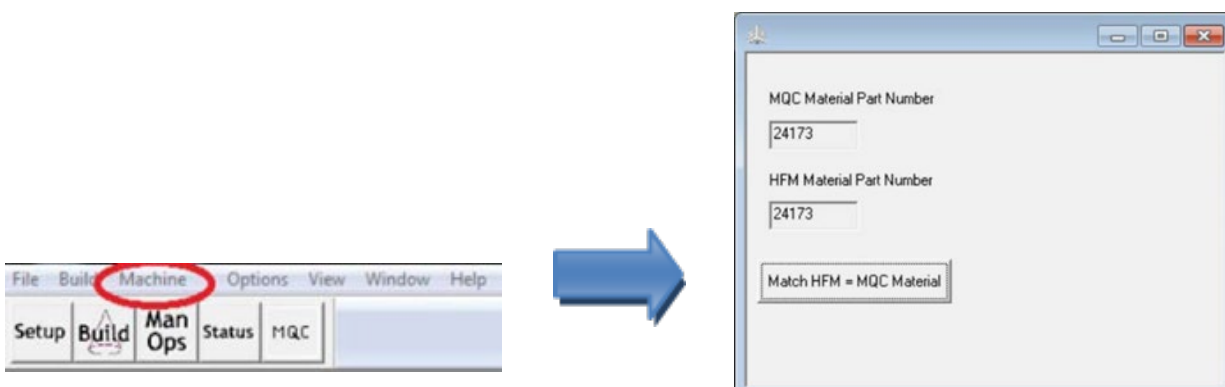
- **For ProX SLS 500 only:** Launch Build Setup to check if you can select new V6.3.527 material configurations files (File >> Change Material). Before launching Sinter application, you need to set correct material in Build Setup (File >> Change Material...)
- On Sinter, check if you see the updated material configurations. Select the required material as default.



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**Subject: Material Update****ProX SLS 500/6100****Verify if the update installed successfully:**

- If you see issues setting the correct material in Sinter, then follow below steps to “sync” material:
  - After Sinter is running, go to “Machine” menu and select “Material Tracking”



- Click on “Match HFM = MQC Material” button.  
**This should display a success message.**
- In case an unsuccessful message is displayed, please follow below steps:
  - i. Exit Sinter by running “Kill Sinter”
  - ii. Go to “C:\dtm\config\machine” directory
  - iii. Rename “machine.ovrl” file to “machine.old-ovrl”
  - iv. Restart Sinter and go through material “sync” sequence again.

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