

Subject: Customer Release Notes for ProX SLS 500

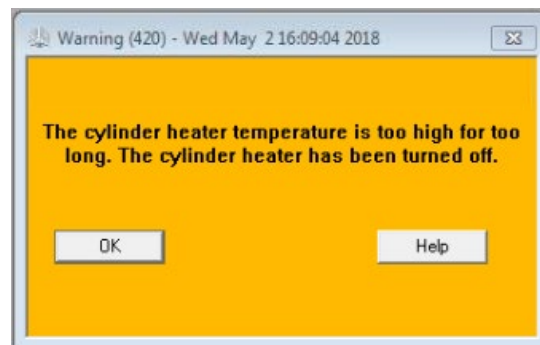
Software Release versions:

- Sinter V6.3.527.10808
- 3DConnect Client V1.1.2.2 (Optional)

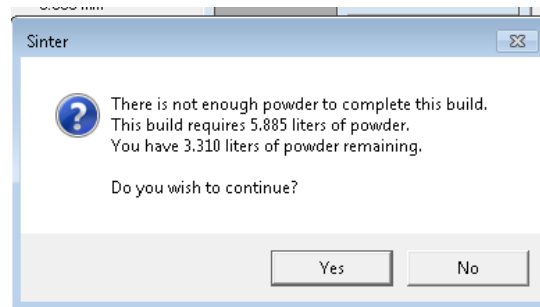
Updates and Fixes:

Sinter Improvements and fixes:

- In installer, the End User License Agreement has been updated
- Add Powder Layer (APL) Dialog
 - Purge HFM** - Added support for quickly emptying the Hopper Feed into the part cylinder. This new feature is designed to automatically and efficiently empty the Hopper Feed
 - Added a layer count remaining display when using HFM Purge or Add Layer
 - Removed manual overflow transport sequence
- Improved hardware failure detection for failures of the Part Bed, Cylinder, HFM, Piston and Laser Window Heaters. Failures during warmup and build stages will cause alarms, failures during cool-down stage and Manual Ops will cause warnings. e.g.

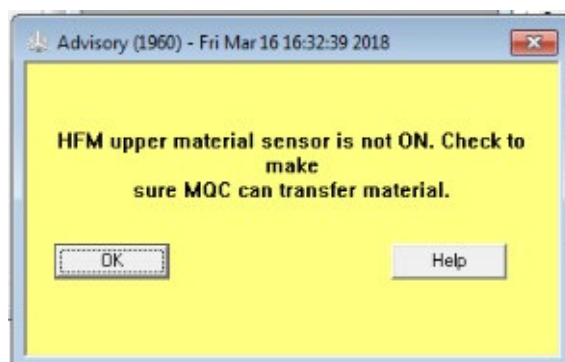


- Added Warning when starting a build if the MQC blended bin has less than 15 litres of powder
Note: This is independent of the powder needed for the build to complete.
- Corrected warning when starting a build if the MQC blended bin does not have enough powder to complete the build.



Subject: Customer Release Notes for ProX SLS 500

- Added an Advisory message when starting a build if the upper HFM sensor not ON



- Added Warning for excessive traverse roller proximity searches. Excessive traverse roller searches *may* indicate a need for field service intervention.
- Build Parameter - Wait For Temperature during Warmup and Cool-down
 - **Warmup Stage** - Sinter will now only wait if the part bed temperature is less than the Part Bed set point associated with the 'Wait for Temp'. Previously, if Part Bed Temp was above the set point, Sinter would wait until Part Bed temp decreased to set point.
 - **Cool-down Stage** - Sinter will now only wait if the part bed temperature is greater than Part Bed set point associated with the 'Wait for Temp'. Previously, if Part Bed Temp was below the set point, Sinter would wait until Part Bed temp increased to set point
- Sinter no longer has a limitation for number of parts in a build.

Note: This is independent of Build Setup or 3D Sprint capability to handle large number of parts. That number depends on several factors such as number of facets/part and processing capabilities of the CPU where the Build Prep (Build Setup or 3D Sprint) software is running.

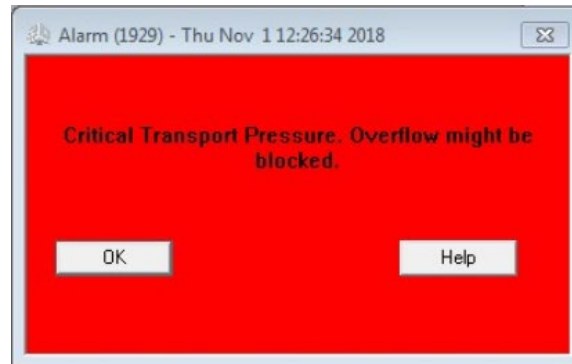
- "Setup" icon in Sinter is now changed to "Prep".



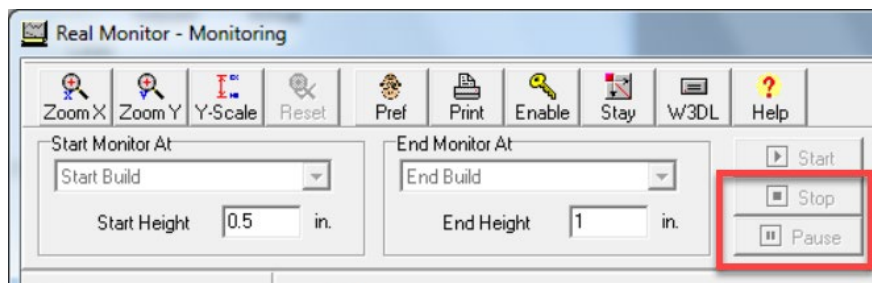
Customer Information Bulletin

Subject: Customer Release Notes for ProX SLS 500

- Changed Air Pressure Alarm to “Critical Transport Pressure. Overflow might be blocked.”

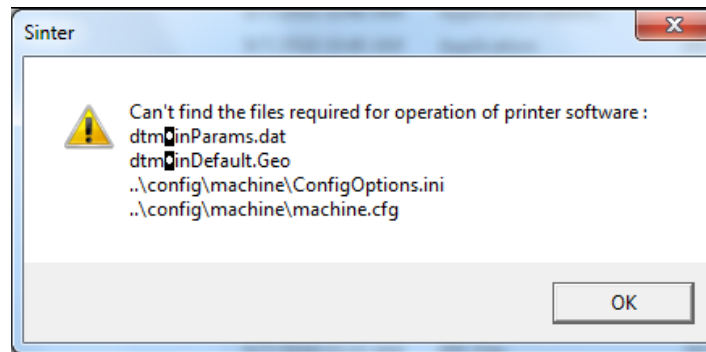


- Disabled non-English languages in Sinter
- Monitors the temperature of scanner mirrors and report warning if it exceeds 50 degree Celsius
- Supports communication with Single MQC
- To prevent accidental termination of critical processes, RealMonitor and DSPIF windows now cannot be exited only minimized. Real Monitor process will exit when Sinter is exited. Kill Sinter must be used to terminate DSPIF process.
- Cannot Pause or Stop Real Monitor logging when the build is in process.

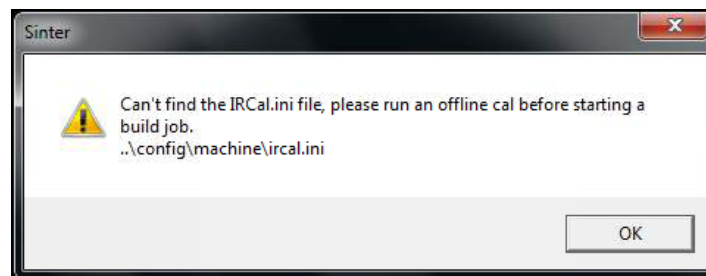


Subject: Customer Release Notes for ProX SLS 500

- Now only one .3dl file is created when build alarms or is user-terminated.
- Removed low and high dead bands from Sinter Status dialog and added too high and too low temperatures
- Added check for calibration files on Sinter startup.
 - a. Checks for presence of Params.dat, Default.geo, ConfigOptions.ini and Machine.cfg. If these files are not present, Sinter will not start and will give the follow error message:



- Checks for the presence of IR sensor calibration file, IRcal.in when Sinter starts
 - a. If IRcal.ini is not present, Sinter will start but will give the follow warning, prompting user to perform an offline calibration after Sinter has started.



3D Connect

This release will contain the ability to enable 3D Connect Service, a secure cloud-based connection to 3D System's service teams for proactive and preventative support

For more information please see the following link:

<https://www.3dsystems.com/software/3d-connect>

Subject: Customer Release Notes for ProX SLS 500

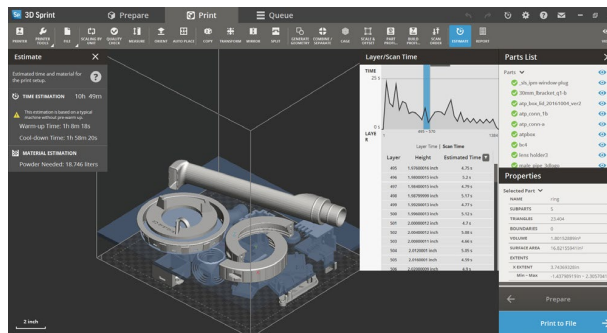
3D Sprint V2.10.0

Note:

- 3D Sprint V2.10.0 can only be installed on a stand-alone pc for off-line build prep.

Estimation Scan times – For estimations on SLS printers, Layer time display shows the total layer time which include scan time, roller motion and other wait times for the layer. We have now added an option to show Scan Time, a layer time that excludes the roller motion and other wait times.

BPZ Import Update - When importing an SLS Build File (.bpz), if the current printer setting do not match those in the .bpz file you will be given an option to import the parts only (if an SLS printer is currently selected) or import the part and change the printer settings to match those in the build packet, where able.



Fixes

- A number of UI and Localization issues have been fixed for the German version
- When reopening and resubmitting a job from Queue, the name now stays on the rename location.
- Measurements applied to a cage now delete when the cage is moved to Prepare.
- The 'FAST ADD POWDER LAYER' parameter is no longer being incorrectly displayed for the High-Speed Build style on the sPro 60 / DuraForm PA combination.
- Cage is no longer incorrectly generated after a change of Font for the Label text.
- Scale offset values are no longer being applied even when the part is deselected.
- 3D Sprint now shows Failed/Aborted/Success for builds on the ProX SLS 6100 Printer.
- Preset combo box for parameters now works correctly.
- ProX SLS material guides have been updated to most recent versions.
- Fixed an issue where parts were colliding when printing to file from a converted 3dprint file

Know Issues

- Favorites do not update correctly when the print mode is changed from SP to HP
- Cage is incorrectly being moved to Prepare Tab after doing Undo and Redo operations.
- SLS profile editors inputs are currently behaving differently for mouse and manual input
- When importing a BPZ file, the printer set up changes on click of [X] on the Progress bar
- Build Style are incorrectly being reset to default when File -> Close is run
- Build/Part profile & Scale offset values are incorrectly updated on opening 3dprint file with warning message.
- For SLS printers sPro 60,140 & 230 the 'Platform Type' is not switched correctly on click of File->Close
- An incorrect error message is displayed on opening 3dprint file generated on a printer with hidden visibility. Enable printer visibility to correctly view the file.

Customer Information Bulletin



3D Printer

CIB# 00113

Date: 3/4/2019

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