



3DSYSTEMS™

Steps to Update Printers for Reseller Pretest

7/30/13

3D CONFIDENTIAL



Table of Contents

- Manufacturing Items
- Content for Downloads and Pretest
- Method to Transfer to Reseller
- Steps for Printers with 1.06 and older FW
- Steps for Printers with 1.07 FW
- Repackage Printer

Content for Downloads and Pretest

Reseller Pretest Keyfile for USB

Calibration Files

■ Setup Gap – Only print the file for the printer designation

- GAP_Test_PLA_Single.cubex
- GAP_Test_PLA_Duo.cubex
- GAP_Test_PLA_Trio.cubex

■ Manufacturing Verification- Only print the file for the printer designation

- LEVEL_Lines.cubex
- CX_PLA_2cubes_V1.cubex (If off use calibration files for offsets)
- CX_PLA_3cubes_V1.cubex (If off use calibration files for offsets)

■ Calibration Files for Offsets

- CX_2_CAL.cubex
- CX_3_CAL.cubex

Content for Downloads and Pretest

☐ Test Prints

■ 25mm GeoTower

- One Color
- Two Color
- Three Color
- Test Sidewall Surface quality of each nozzle to insure each nozzle is good.
 - A good nozzle should not have sputtering look in the surface due to defects inside the nozzle assembly.
 - A good nozzle should not have shifting sidewall surfaces due to a loose nozzle.

■ Vase- Test for seam quality and graduated sidewall surface

■ Candle Holder- Test for sidewall surface for extreme graduating side wall

■ Napkin Holder- Test for nozzle ability to maintain multiple jumps within a part

■ Notre Dame Two Towers- Test for fine detail.

Steps for Printers with 1.06 and older FW

- ❑ Step 1: Reseller to record printer manufacturing settings
 - Reseller to send printer Serial #(s) to Service and Service to return data by serial #:
 - PJ2-XY Offset Calibration
 - PJ3-XY Offset Calibration
 - Wipe Offset

- ❑ Step 2: Service to return Pretest packet via zip file containing:
 - Documents for loading FW, setting Z-gap and Leveling Print Pad
 - All Pretest Files

Steps for Printers with 1.06 and older FW

- ❑ Step 3: Reseller unpacks printer and sets up on bench or desk.
 - All packaging removed and stored in box for future use. Note banding and/or zip ties can be used for foam and holding materials onto bed plate.
 - Ensure wipe box is seated in grooves on pegs.
 - Ensure wiper top is ~1mm below flange of nozzle.

- ❑ Step 4: Reseller powers on printer.
 - Power on will open to 3D Systems welcome screen. Press the screen to go to activation screen.

- ❑ Step 5: Reseller to follow steps in *How to Update Firmware* document and load 1.07 FW

Steps for Printers with 1.06 and older FW

- Step 6: Reseller places all Pretest files from 3D Service onto a blank USB stick.
- Step 7: Reseller places USB stick into the USB slot on the front of the printer.
- Step 8: Reseller powers on the printer and presses the 3D Systems icon. The printer should go to the icon menu and NOT the activation screen.

Steps for Printers with 1.06 and older FW

- ❑ Step 9: Select the Offset Icon and input all default settings obtained from 3D Service Dept. These include:
 - PJ2-XY Offset Calibration
 - PJ3-XY Offset Calibration
 - Wipe Offset
- ❑ Step 10: Select the Z-Gap Icon and set Z-Gap using the [*How to Set CUBE X Z-Gap*](#) document obtained from the 3D Systems Service Dept.

Steps for Printers with 1.06 and older FW

- ❑ Step 11: Run Level Test using the [*How to Level CUBEX Print Bed*](#) document obtained from the 3D Systems Service Dept.

- ❑ Step 12: Once printer has offsets, Gap, and level set, reseller can print the permitted test prints on the USB stick that were obtained from 3D Systems Service Dept
 - Recommended to run 25_GeoTower and NotreDame_Two Towers to test printer.
 - Other files can be used per Resellers discretion as time permits.

Steps for Printers with 1.07 FW

- Step 1: Reseller unpacks printer and sets up on bench or desk.
 - All packaging removed and stored in box for future use. Note banding and/or zip ties can be used for foam and holding materials onto bed plate.
 - Ensure wipe box is seated in grooves on pegs.
 - Ensure wiper top is ~1mm below flange of nozzle.

- Step 2: Reseller place all Pretest files from 3D Service onto a blank USB stick.

- Step 3: Reseller place USB stick into the USB slot on the front of the printer.

Steps for Printers with 1.07 FW

- ❑ Step 4: Power on the printer and press the 3D Systems icon. The printer should go to the icon menu and NOT the activation screen.
- ❑ Step 5: Go to GAP Icon and verify GAP using the *How to Set CUBEX Gap* document obtained from the 3D Systems Service Dept.
- ❑ Step 6: Run Level Test using the *How to Level CUBEX Print Bed* document obtained from the 3D Systems Service Dept.

Steps for Printers with 1.07 FW

- ❑ Step 7: Once printer has offsets, Gap, and level set, reseller can print the permitted test prints on the USB stick that were obtained from 3D Systems Service Dept
 - Recommended to run 25_GeoTower and NotreDame_Two Towers to test printer.
 - Other files can be used per Resellers discretion as time permits.

Repackage Printer

- Report all issues back to 3D Service Dept
- Follow *Printer Repackaging Document* to repackage Printer



3D Systems, Inc.
333 Three D Systems Circle | Rock Hill, SC | 29730
Cubify.com

©2013 3D Systems, Inc. All rights reserved.
The 3D Systems logo, CubeX and Cubify are
registered trademarks of 3D Systems, Inc.

pn: 401704, Rev. B