

**3D SYSTEMS****Goaltech**  
Engineering Solutions

# Multijet Plastic Printers

High part quality, speed and simplicity made accessible with the ProJet® MJP 2500 Series

**ProJet MJP 2500****ProJet MJP 2500 Plus**

<b>Printing Mode</b>	HD - High Definition	HD - High Definition
<b>Net Build Volume (xyz)*</b>	11.6 x 8.3 x 5.6 in (295 x 211 x 142 mm)	11.6 x 8.3 x 5.6 in (295 x 211 x 142 mm)
<b>Resolution (xyz)</b>	800 x 900 x 790 DPI, 32 µ layers	800 x 900 x 790 DPI, 32 µ layers
<b>Accuracy (typical)</b>	±0.004 in per in (±0.1016 mm per 25.4 mm) of part dimension. Accuracy may vary depending on build parameters, part geometry and size, part orientation, and post-processing.	
<b>Build Materials</b>	Visijet M2R-WT** – Rigid White Visijet M2R-BK** – Rigid Black	Visijet M2R-WT** – Rigid White Visijet M2R-BK** – Rigid Black Visijet M2R-CL** – Rigid Clear Visijet M2 EBK – Elastomeric Black Visijet M2 ENT – Elastomeric Natural
<b>Support Material</b>	Visijet M2 SUP	Visijet M2 SUP
<b>Material Packaging</b> Build Materials Support Material	In clean 3.30 lbs (1.5 kg) bottles (printer holds up to 2 build materials bottles with auto-switching) In clean 3.08 lbs (1.4 kg) bottles (printer holds up to 2 support material bottles with auto-switching)	
<b>Electrical</b>	100-127 VAC, 50/60 Hz, single-phase, 15A 200-240 VAC, 50 Hz, single-phase, 10A Single C14 receptacle	
<b>Dimensions (WxDxH)</b> 3D Printer Crated 3D Printer Uncrated	55 x 36.5 x 51.7 in (1397 x 927 x 1314 mm) 44.1 x 29.1 x 42.1 in (1120 x 740 x 1070 mm)	55 x 36.5 x 51.7 in (1397 x 927 x 1314 mm) 44.1 x 29.1 x 42.1 in (1120 x 740 x 1070 mm)
<b>Weight</b> 3D Printer Crated 3D Printer Uncrated	716 lb (325 kg) 465 lb (211 kg)	716 lb (325 kg) 465 lb (211 kg)
<b>3D Sprint™ Software</b>	Easy build job set-up, submission and job queue management; Automatic part placement and build optimization tools; Part stacking and nesting capability; Extensive part editing tools; Automatic support generation; Job statistics reporting tools	
<b>E-mail Notice Capability</b>	Yes	Yes
<b>Internal Hard Drive Capacity</b>	500 Gb minimum	500 Gb minimum
<b>Connectivity</b>	Network ready with 10/100/1000 BaseT Ethernet interface USB port	
<b>Client Hardware Recommendation</b>	<ul style="list-style-type: none"> <li>• 3 GHz multiple core processor (2 GHz Intel® or AMD® processor mini) with 8 GB RAM or more (4 GB mini)</li> <li>• OpenGL 3.2 and GLSL 1.50 support (OpenGL 2.1 and GLSL 1.20 mini), 1 GB video RAM or more, 1280 x 1024 (1280 x 960 mini) screen resolution or higher</li> <li>• SSD or 10,000 RPM hard disk drive (30 GB of available hard-disk space for cache mini)</li> <li>• Google Chrome or Internet Explorer 11 (Internet Explorer 9 mini)</li> <li>• Other: 3 button mouse with scroll, keyboard, Microsoft .NET Framework 4.5 installed with application</li> </ul>	
<b>Client Operating System</b>	Windows® 7, Windows 8 or Windows 8.1 (Service Pack)	
<b>Input Data File Formats Supported</b>	STL, CTL, OBJ, PLY, ZPR, ZBD, AMF, WRL, 3DS, FBX, IGES, IGS, STEP, STP, MJPDDD	
<b>Post Processing</b>	MJP EasyClean System for easy removal of eco-friendly wax supports	
<b>Operating Temperature Range</b>	64-82 °F (18-28 °C), reduced print speed at > 77 °F (25 °C)	
<b>Operating Humidity</b>	30-70 % Relative Humidity	30-70 % Relative Humidity
<b>Noise</b>	< 65 dBa estimated (at medium fan setting)	
<b>5-Year Printhead Warranty</b>	Optional	Optional
<b>Certifications</b>	CE	CE

\* Maximum part size is dependent on geometry, among other factors.

\*\* Respectively replaces former Visijet® M2 RWT, RBK and RCL materials.

# Visijet® M2 Materials

Functional precision plastic and elastomeric parts with the ProJet® MJP 2500 Series



Properties	Condition	Visijet M2R-WT*	Visijet M2R-BK*	Visijet M2R-CL*	Visijet M2 ENT	Visijet M2 EBK	Visijet M2 SUP
Composition			UV curable plastic		UV curable elastomeric		Wax support
Color		Opaque White	Opaque Black	Translucent Clear	Translucent Natural	Opaque Black	White
Bottle Quantity (kg)		1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.5 kg	1.4 kg
Density @ 20 °C (solid)	ASTM D792	1.16 g/cm <sup>3</sup>	1.16 g/cm <sup>3</sup>	1.16 g/cm <sup>3</sup>	1.12 g/cm <sup>3</sup>	1.12 g/cm <sup>3</sup>	N/A
Tensile Strength	ASTM D638	35-45 MPa	45-55 MPa	35-45 MPa	0.2-0.4 MPa	0.2-0.4 MPa	N/A
Tensile Modulus	ASTM D638	1500-2000 MPa	2000-2500 MPa	1500-2000 MPa	0.27-0.43 MPa	0.27-0.43 MPa	N/A
Elongation at Break	ASTM D638	20-30 %	6-12 %	20-30 %	160-230 %	160-230 %	N/A
Flexural Strength	ASTM D790	50-60 MPa	80-90 MPa	50-60 MPa	N/A	N/A	N/A
Flexural Modulus	ASTM D790	1700-2200 MPa	2400-3000 MPa	2000-2500 MPa	N/A	N/A	N/A
Impact Strength (Notched Izod)	ASTM D256	20-25 J/m	15-18 J/m	20-25 J/m	N/A	N/A	N/A
Shore A Hardness	ASTM 2240	N/A	N/A	N/A	28-32	28-32	N/A
Shore D Hardness	ASTM 2240	77	81	77	N/A	N/A	N/A
Water Absorption	ASTM D570 24 hr	0.50 %	0.50 %	0.50 %	0.90 %	0.60 %	N/A
Heat Distortion Temp @ 0.45 MPa	ASTM D648	51 °C	61 °C	51 °C	N/A	N/A	N/A
Heat Distortion Temp @ 1.82 MPa	ASTM D648	45 °C	53 °C	45 °C	N/A	N/A	N/A
Melting Point		N/A	N/A	N/A	N/A	N/A	60 °C
Softening Point		N/A	N/A	N/A	N/A	N/A	40 °C
Printer Compatibility		ProJet MJP 2500 and 2500 Plus	ProJet MJP 2500 and 2500 Plus	ProJet MJP 2500 Plus	ProJet MJP 2500 Plus	ProJet MJP 2500 Plus	ProJet MJP 2500 and 2500 Plus
Description		High modulus, rigid plastic (white)	High modulus, rigid plastic (black)	High modulus, rigid plastic (clear)	Flexible rubber-like	Flexible rubber-like	Non-toxic wax for hands-free melt-away supports

\* Respectively replaces former Visijet® M2 RWT, RBK and RCL materials

DISCLAIMER: It is the responsibility of each customer to determine that its use of any Visijet® material is safe, lawful and technically suitable to the customer's intended applications. The values presented here are for reference only and may vary. Customers should conduct their own testing to ensure suitability for their intended application.



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