

User Guide
English

Eden260V 3-D Printer System



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Using This Guide

This user guide provides instructions for installing, operating and maintaining Eden 3-D printing systems. It explains how to use features, and provides practical examples to guide you as you use the system.

The text and figures in this guide are based on the Eden260V 3-D printer, printer software version 27.3 and Objet Studio software version 9.0.10.

This guide assumes that:

- all the hardware, software, and network components of your Eden system are installed, configured, and operating correctly.
- the operator has a working knowledge of the Windows® PC platform.

For More Information

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For other documents that relate to Eden260V 3-D printing systems, and for this document in other languages, contact your regional Stratasys Customer Support office.

If you have any questions about the information presented in this document, or if you have any comments or suggestions for future editions, please send a message to c-support@stratasys.com.

Terms Used in This Guide

build tray	<p><i>In Objet Studio:</i> The surface displayed on the screen that represents the actual build tray in the printer.</p> <p><i>In the printer:</i> The surface upon which models are produced.</p>
cleaning fluid	<p>Cleanser for flushing model feed tubes and the printing block, used to completely remove model material from the system before loading another type of material in the printer. The cleaning fluid is supplied in model-material cartridges.</p>
client/user workstation	<p>The workstation on which Objet software is installed, used for preparing build trays for production on Objet printers. (There is no limit to the number of client workstations in the local network.)</p>
Eden™ printer	<p>The Objet 3-D printer referred to in this guide.</p>
Printer computer	<p>The computer inside the Eden printer that operates it. (This is sometimes referred to as the “embedded” computer.)</p>
Printer interface	<p>The GUI (graphical user interface) used for controlling the Eden printer.</p>
Printer software	<p>Software running on the computer inside the Eden printer, that controls all printer operations.</p>
host/server workstation	<p>The workstation that interfaces directly with the Eden printer and is typically positioned next to it.</p>
Job Manager™	<p>The part of Objet Studio software that manages production jobs before they are sent to the Eden printer.</p>
Model material	<p>Material used for building models.</p>
Objet Studio™	<p>The software with which users prepare jobs for producing models.</p>
OBJTF (Objet Tray Format)	<p>The extension of a file that contains all of the information needed for a model-printing job on Objet 3-D printers. An <i>objtf</i> file is used to send a print job to an Objet 3-D printer.</p>
OBJZF (Objet Z Format)	<p>The extension of a compressed “wrapper” file containing all of the files used in an Objet Studio build tray. Using <i>objzf</i> files, a printing job can be saved as a single file, for convenient storage and transfer.</p>
resin	<p>The base substance from which photopolymer printing materials are made for use in Eden printers. In Objet Studio and printer-application screens, “resin” refers to cartridges of model and support materials.</p>

SLC	A file type used with Objet software. (These files are bitmaps of individual slices of the object. For more information, see page 3-4.)
STL	A file type used with Objet software. (For more information, see page 3-4.)
Support material	Material used for supporting the structure of models during production.

Safety

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Safety Features

Eden 3-D printers are designed to comply with CE and FCC standards. They are equipped with the following safety features:

Cover interlock switch

The power supplied to the UV lamp, the tray heater and the motion motors is turned off when the cover is opened.



WARNING: Do not defeat (override) the interlock switch. Doing so could result in serious personal injury. If the interlock switch does not function correctly, do not use the printer, and contact your service provider.

Cover lock

The cover is locked while the printer is working. It is released when the printer reverts to *pause* or *stop* mode.



WARNING: Do not defeat (override) the safety lock. Doing so could result in serious personal injury. If the safety lock does not function correctly, do not use the printer, and contact your service provider.

UV screen

The transparent section of the cover blocks harmful UV radiation, allowing the operator to view the model as it is being made.

Circuit breaker

The power to the printer is turned off in case of electrical overcurrent.

Note: The circuit breaker is only accessible to service personnel.

Grounded chassis

The chassis of the printer is grounded, to prevent electrical shock.





Note: The power outlet must be properly grounded, in accordance with the local electric code, to provide this protection.



If the Eden 3-D printing system is not used as specified in this guide, the safety features may not provide adequate protection.

Symbols and Warning Labels

The following table lists the warning labels located on or in Eden printers.

Warning Symbol	Meaning	Location	Comments
	Hazard (general)	On the name plate on the back of the printer.	Read the instructions in this document before operating the printer.
	Hot surface	On the print-head block.	Risk of burns. Do not touch this surface after printing.
	High voltage	Near the UV lamp connectors. Near the power-supply enclosures.	Risk of electric shock.
	Ultraviolet radiation	Near the UV lamps.	Risk of injury from ultraviolet radiation.

Safety Guidelines

The following general guidelines, together with the instructions provided throughout this user guide, ensure user safety while operating and maintaining the Eden system. **If the system is not operated as specified, the user's safety may be compromised!**

Printer Installation

- Installation and removal of the printer should only be done by qualified service personnel.
- Connect the printer to the electric outlet using a power cord that is safety-certified.
- The electric outlet should be easily accessible, near the printer.
- Never connect the power plug to an outlet that does not have a ground (earth) wire, and never disconnect the ground. Doing so might expose the operator to serious danger from electric shock.
- Leave a minimum of 15 centimeters between ventilation openings and walls or other objects.

Printer Operation

- The printer should only be operated by persons trained by a Stratasys customer-support representative.
- All personnel operating or maintaining the printer should know the location of first aid and emergency equipment and how to use it. **Never block access to this equipment!**
- Keep fingers and other body parts clear of the printer cover when closing it.
- Never attempt to open the main cover of the printer while it is working!
- Never override the interlock safety switch!
- If the interlock safety switch ever fails, **do not use the printer.**
- Several parts of the printer remain extremely hot even after it has stopped operating. Avoid touching the UV lamps and the print block.

UV Radiation

The UV lamps used in the printer emit dangerous radiation.

- If the UV lamps remain on when the printer cover is open, do not stare directly at the UV light. Shut down the printer and call your Stratasys service provider.

Printer Maintenance

- Service operations should be performed only by qualified personnel who have been instructed in relevant safety precautions.
- Notify co-workers and those who have access to the Eden system before beginning non-routine and hazardous work.



Report any potential dangers and safety-related accidents to your safety officer or to other appropriate authorities.

Model and Support Materials

Model and support materials are made of **chemical substances**. Although precautions must be taken when handling these materials directly, all model and support materials used by the Eden system are handled in sealed cartridges. Normally, operators of the printer should never be directly exposed to hazardous materials. In the unlikely event of a leak or spill, follow the instructions that are included with the printing-material cartridge used.

- Store cartridges of model and support materials indoors, in a dry area with adequate ventilation, between 16-27 degrees Celsius (60-81 degrees Fahrenheit). Never expose them to flames, heat, sparks, or direct sunlight.
- Keep model and support materials away from areas where food and drink are stored, prepared and consumed.
- Uncured printing material is considered a hazardous substance, requiring certain precautions when directly handling it. To prevent skin irritation, wear **neoprene** or **nitrile gloves**. If there is any chance that model and support materials might splash into the eyes, wear safety goggles. Prolonged direct contact with printing materials can cause an allergic reaction.
- When handling UV-cured models that may not be completely cured on the surface, common latex gloves are adequate.
- To prevent respiratory irritation, ventilate areas where model and support materials are used. The ventilation system should totally replace the air at least 20 times per hour.
- Clean up model-material and support-material spills with disposable towels or other absorbent, non-reusable material, such as sawdust or activated charcoal. Rinse the spill area with denatured or isopropyl alcohol (IPA), followed by soap and water. Dispose of the absorbent material in accordance with local regulations.
- Do not wash contaminated clothing at home; clothing should be professionally laundered.
- Dispose of contaminated shoes, belts and other leather items in accordance with any applicable regulations. Absorbed printing material may re-expose the user when these items are worn.

First Aid for Working with Printing Materials

In general, try to avoid direct contact with uncured printing material. If skin or eyes come into contact with it, wash the area immediately and thoroughly with water, and follow these first-aid instructions.

Contact with Skin

If uncured printing material comes in contact with skin, wash the affected area immediately and thoroughly with soap and cool water, then remove contaminated clothing. Pay particular attention to flushing the hair, ears, nose and other parts of the body that are not easily cleaned.

- Use cool water to prevent skin pores from opening, so that the liquid material does not easily penetrate the skin.
- Do not use solvents to clean skin.
- If large areas of skin have been exposed, or if prolonged contact results in blisters, seek medical attention. In any case, if irritation persists, seek medical attention.
- Avoid the accidental transfer of printing material from the hands to other areas of the body, especially to the eyes.
- If protective cream was used, do not reapply it until the skin has been completely cleansed.

Contact with Eyes

If uncured printing material comes in contact with the eyes, flush immediately with large amounts of water for 15 minutes and seek medical attention.

- Avoid sunlight, fluorescent light, and other sources of ultraviolet radiation.

The wearing of contact lenses when handling liquid printing materials is not recommended. If the liquid splashes into the eyes when contact lenses are worn, immediately remove the lenses and flush the eyes with water.

- Clean and disinfect the contaminated lenses.
- Do not wear contact lenses until eye irritation disappears.

Ingestion

If printing material is swallowed, refer to the instructions included with the cartridge. *Seek medical attention immediately.*

Inhalation

Vapors from printing materials can be irritating to the respiratory system. If respiratory irritation occurs, expose the victim to fresh air immediately.

- If the victim has stopped breathing, perform artificial respiration or cardiopulmonary resuscitation.
- Seek medical attention immediately.
- Keep the patient warm but not hot.
- Never feed anything by mouth to an unconscious person.
- Oxygen should be administered by authorized personnel only.

Waste Disposal

Fully cured printed models can be disposed of as ordinary office trash. However, special care is required when handling printer waste.

- When removing the waste container from the Eden printer, wear neoprene or nitrile gloves.
- To prevent liquid waste from splashing into the eyes, wear safety goggles.
- Liquid waste from the Eden printer is classified as hazardous industrial waste. Therefore, printing-material waste must be packaged and disposed of in a manner that prevents human contact with it and contamination of water sources.
- Empty model-material and support-material cartridges contain residue of their contents. Some leakage of this residue may occur through the broken cartridge seal. Therefore, handle and store empty cartridges with care.
- Do not attempt to reuse empty cartridges, and do not puncture them.
- Dispose of used cartridges and waste containers in accordance with local regulations.
- Discard contaminated clothing, shoes, empty containers, etc., in accordance with any applicable regulations.

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Figure 3-1: The Eden260V 3-D Printer

Work Configurations

The Eden 3-D printing system can be set up as a single-station system or as a multi-station system. When connected to a local computer network, the system can serve multiple users. In such configurations, each user workstation (client) prepares files with Objet Studio software for production. A server (host), typically next to the 3-D printer, acts as a job manager that sends production jobs to the printer for production.

Figure 3-2 shows the Eden260V printer set up in a multi-client configuration.

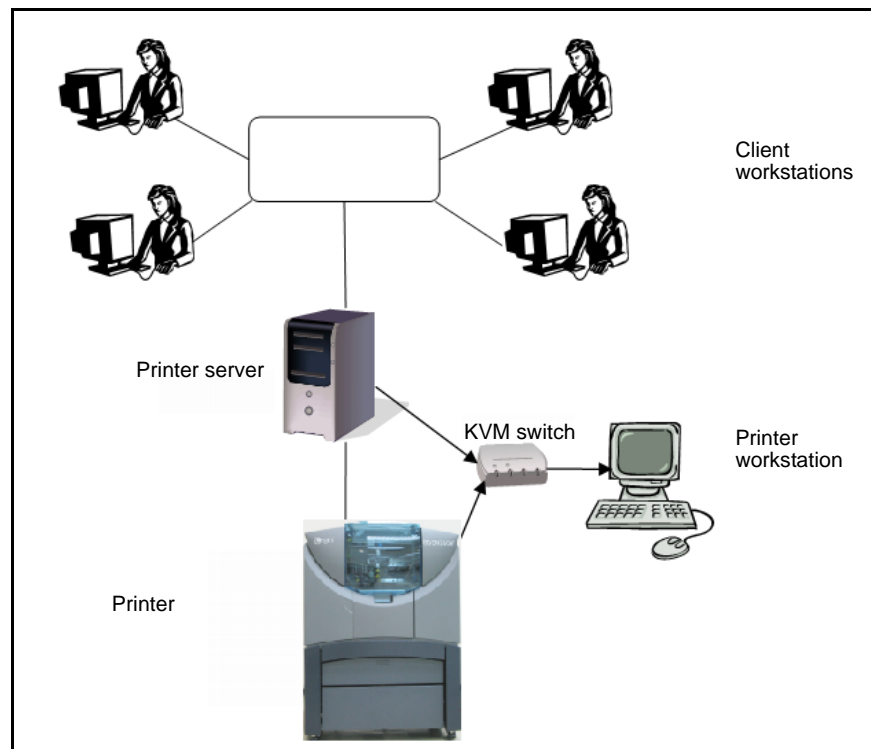


Figure 3-2: Multi-client network configuration

When installing the Objet software, you choose whether to install it as a client station or as a master station (server or standalone station).

The Objet software arranges the jobs it receives according to their priorities, model-material type, and other factors. In multi-workstation configurations, the operator of the server—typically the production administrator—has total control over the jobs sent to the 3-D printer, and can prioritize and delete jobs, review job history and reprint a job, and so on.

Source Files

Objet 3-D printing systems produce three-dimensional models designed with most 3-D CAD tools and with other job-specific 3-D applications.

Eden systems accept:

- STL Files
- SLC Files

Eden systems feature the capability of producing both types of model files simultaneously.

STL Files

STL is short for *Standard Triangulation Language*. This language views any object as a collection of surfaces, and describes each surface of the object as a collection of triangles.

For example, a square can be described as two triangles; a cube (six squares) as 12 triangles. Curved surfaces need more triangles to describe them. The higher the tolerance (for smooth surfaces), the more triangles are needed. The result is that high-quality object descriptions mean very heavy files.

Most CAD software can export STL files. The Eden system utilizes these files for building models (rapid prototyping), and also for directly making molds for mass-producing items.

STL files are ASCII (text) files. The content of each file begins with “solid” and ends with “end-solid” (both lower case). Between these keywords is a list of the triangles that describes the faces of the solid model. Each triangle defines a single normal vector directed away from the solid’s surface, followed by its X-Y-Z coordinates. These are expressed as Cartesian coordinates and are floating-point values. The coordinates of all triangles should be positive and should fall within the volume of the model.

SLC Files


SLC is short for *Stereo-Lithography Contour*. SLC files describe two-dimensional contours of the three-dimensional models. These contour lines are polylines.

SLC files are ASCII (text) files that save models as a series of slices. This means that models based on SLC files cannot be orientated; only their scale (size) and position on the build tray can be controlled. For this reason, the model’s orientation must be suitable for production before it is saved as an SLC file. Because of the nature of SLC files, the appearance of models in Objet Studio may be different than the solid-object images displayed from STL files.

Printing Materials

Eden printers produce models by jetting thin layers of printing materials on the build tray, until the complete model is formed. Two types of material are used in this process:

- *Model* material—which makes up the finished model
- *Support* material—which fills gaps and spaces in the model during printing, and is removed after printing

Storage	<p>Materials used for printing models with Eden printers are made of resins, which are composed of reactive monomers and oligomers. Although printing materials are supplied in sealed, UV-proof cartridges, care must be taken when storing and handling them. Follow these guidelines to protect operators and the environment, and to ensure optimum results.</p> <ul style="list-style-type: none">• To ensure product stability, do not allow these materials to come into contact with metal. Plastics made from monomer-soluble substances (such as polystyrene or polyvinyl chloride) are not suitable for storing printing materials.• When not in use, keep material cartridges tightly sealed to prevent contamination, the effects of exposure to UV radiation, and accidental spillage.• Store material cartridges indoors, in a dry area with adequate ventilation, between 16–27 degrees Celsius (60–81 degrees Fahrenheit). If exposed to heat or flames, cartridges may burst or ignite.• Signs of premature polymerization in material cartridges may include bulging, leaking, the emission of heat, and unusual odor. Exposure to heat can cause resin to gel in the cartridge.• Make sure that material cartridges are stored in accordance with all local regulations and other applicable requirements.
Shelf Life	<p>Materials used for producing models have a limited shelf life. The expiry date on the label is valid when properly stored in an undamaged, unopened cartridge. Always rotate your stock, so that the cartridge with the earliest date is used first.</p>
Exposure to Light	<p>If printing materials are not in their sealed cartridges, make sure to shield them from sunlight and other sources of UV radiation, such as fluorescent and mercury-vapor lights. Exposure to UV radiation causes an increase in viscosity and, eventually, solidification.</p>
Safety Considerations	<p>Before being cured, resins are hazardous materials. To prevent possible health hazards, follow these precautions regarding printing materials:</p> <ul style="list-style-type: none">• Do not expose to flames, heat or sparks.• Prevent contact with skin and eyes.• Ventilate areas where they are handled.• Keep them separate from food and drink. <p>Cured plastic parts, however, are safe. They can be handled and stored without precautions.</p>
	<p>You can find more safety information about resins in “Safety Guidelines” on page 2-4, and “First Aid for Working with Printing Materials” on page 2-6.</p>
Disposal	<p>Dispose of cartridges of Objet model and support material in accordance with all applicable laws and regulations. If necessary, the cartridges can be disassembled for recycling.</p>

Work Environment

Extreme heat and humidity conditions can adversely affect the operation of the Eden 3-D printer. Therefore, it is recommended that you use ventilation or air-conditioning systems, if necessary, to keep the work area within the following ranges:

- 18°–25° C (64°–77° F)
- 30%–70% relative humidity

Workstation Requirements

The minimum requirements for computer components used with Objet 3-D printer software are listed in the following table.

	Server/ Stand-alone Station	Client Workstation
Processor	Pentium 4, 3.0 GHz, 512 KB cache memory (min.)	
Operating System*	Windows XP <i>Professional</i> SP2	
Graphics Card	Supporting open GL, with 512 MB of memory	
	<i>For dental printers, use:</i> <ul style="list-style-type: none"> • ATI Radeon HD 5970, with 2 GB of memory <i>or</i> • NVIDIA GeForce GTX 285, with 2 GB of memory 	
RAM	4 GB (min.)	
CD Drive	IDE CD ROM	
Hard-Disk Drive	40 GB (min.)	
Network Adaptor Cards	LAN TCP/IP (2)	LAN TCP/IP (1)
Ethernet Cables	<ul style="list-style-type: none"> • Straight-through cable (1) • Crossover cable (1, supplied) 	Straight-through cable (1)

* Also supported:

- Windows 7 (32-bit/64-bit), *Professional, Ultimate, Enterprise* editions
- Windows Vista (32-bit/64-bit) *Ultimate, Business, Enterprise* editions

Note: On 64-bit operating systems, Objet Studio runs as a 32-bit application.

Recommendations:

- Monitor resolution: 1280 x 1024 pixels
- Color quality: 32 bit
- Two Ethernet ports

Preparing Files for Use with Objet 3-D Printing Systems

Before using files with Eden 3-D printing systems, you must convert them in your CAD program to either STL files or SLC files. (For an explanation of these file formats, see “Source Files” on page 3-4.)

After converting the model files, it is recommended that you check them for defects in an STL-repair application (such as Magics, by Materialise) before opening them in Objet Studio and producing the model.

Converting CAD Files to STL Format

This procedure may vary slightly, depending on the CAD software used, but the following instructions generally apply.

To convert a file to STL format (in a CAD program):

1. From the File menu, select Save As.
2. In the *Save As* dialog box, open the *Save As Type* pull-down menu and select *.STL.
3. Click Options and set the following parameters:
 - Total Quality—approximately 0.1 mm (deviation tolerance / linear-dimension tolerance)
 - Detail Quality—approximately 4° (angle tolerance)

Note: Lowering these values produces more accurate models, but results in larger files and longer loading and processing times. For this reason, it is generally not recommended that you use lower values.
4. In the file format option, choose *binary* or *ASCII*. (Both binary and ASCII formats can be used in Objet Studio. However, binary files are smaller, so this option is recommended.)
5. Click OK or Save.

Converting Files to SLC Format

When converting files to SLC format, it is recommended that you set a layer thickness of 15 microns (0.015 mm). Since SLC files cannot be orientated in Objet Studio, it is important that models are properly orientated before being saved as SLC files. Considerations for suitable model orientation are explained in “Model Orientation” on page 5-19.

Objet Studio Software

Objet Studio software for the Eden 3-D printing system consists of two main screens:

- Tray Settings / Model Settings
- Job Manager

Tray Settings / Model Settings

In the *Tray Settings* and *Model Settings* screens, you prepare source files for production in Eden 3-D printers. Objet Studio offers you a wide variety of file-preparation options, but always consists of the following basic procedure:

1. Inserting one or more objects on the *build tray*
2. Positioning the object(s) on the tray
3. Configuring object and tray parameters
4. Saving the tray configuration as an *objtf* (Objet Tray Format) file
5. Sending the *objtf* file to the Eden 3-D printer for production

Using Objet Studio to perform these tasks is described in detail in chapter 5, “Using Objet Studio.”

Job Manager

The *Job Manager* screen is different for client workstations and for the computer connected directly to the Eden 3-D printer.

- In Objet Studio installed on the directly-connected computer (server), the *Job Manager* screen displays the queue and status for all jobs sent to the 3-D printer by the client computers on the network, and allows editing and manipulation of all jobs.
- In Objet Studio installed on client computers, the *Job Manager* screen displays the queue and status only for jobs sent to the 3-D printer server from that computer, and allows the user to edit only these jobs.



Client computers can be connected, via the local network, to different Objet 3-D printers, but only to one at a time. The *Job Manager* screen displays the status of the 3-D printer to which the client is currently connected.

4

Installing Objet Software

How to Install Software for the Eden 3-D Printing System 2

How to Install Software for the Eden 3-D Printing System

The Objet Studio setup wizard guides you when installing the Objet software. During installation, you must choose to install either the server (“host”) application or the client application.

To install Objet software:

1. Insert the Objet Studio CD into the disk drive.
2. Right-click the Start button and select Explore (or use any other method for displaying files on the computer).
3. Open the CD-drive folder and select Setup.

To run the installation wizard, you must accept the Objet Studio license agreement. After reading its terms, click Yes to continue, or No to close the wizard.

If you click Yes, the following screen should appear.

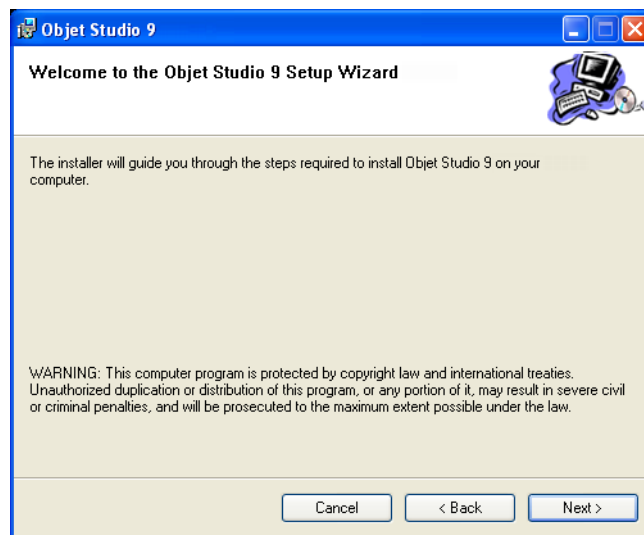


Figure 4-1:Objet Studio installation wizard—Welcome screen

4. Click Next to begin installation.
5. In the *Select Features* screen, select the required installation option.
Select *Objet Studio for a server computer...*
 - if you are installing Objet Studio on a server (“host”) computer—the computer directly connected to an Eden printer.
 - if you are installing Objet Studio on a standalone (off-line) computer.

Select **Objet Studio** for client workstations if you are installing **Objet Studio** on a “client” workstation—a remote computer that prepares print jobs and then sends them to a server computer.

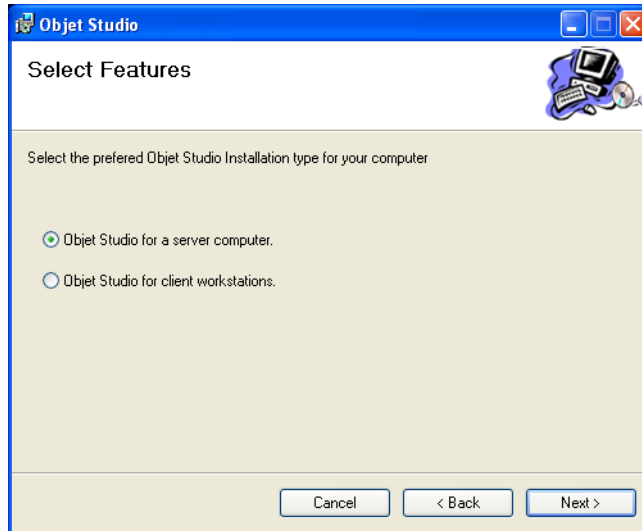


Figure 4-2: **Objet Studio** configuration selection

6. In the *Select Installation Folder* screen, verify the destination folder and click **Next**.



It is recommended that you do not change the default destination folder.

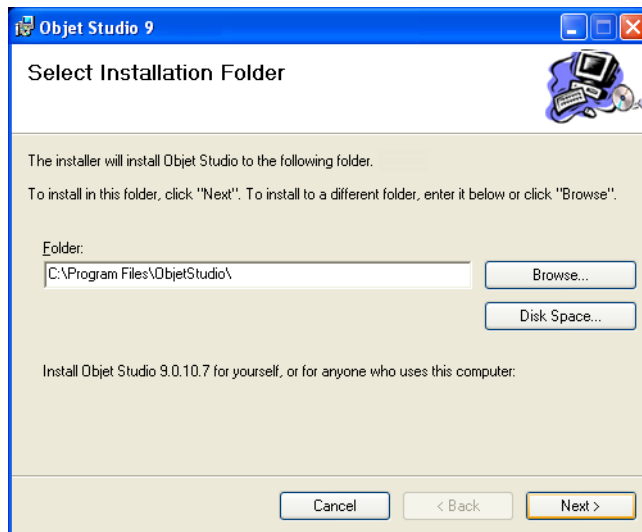


Figure 4-3: **Objet Studio** installation-folder selection

7. In the *Confirm Installation* screen, click **Next** to begin installation.

- In the *Select Printer Type* screen, select the Objet 3-D printer used for producing models.
To continue, click Next.

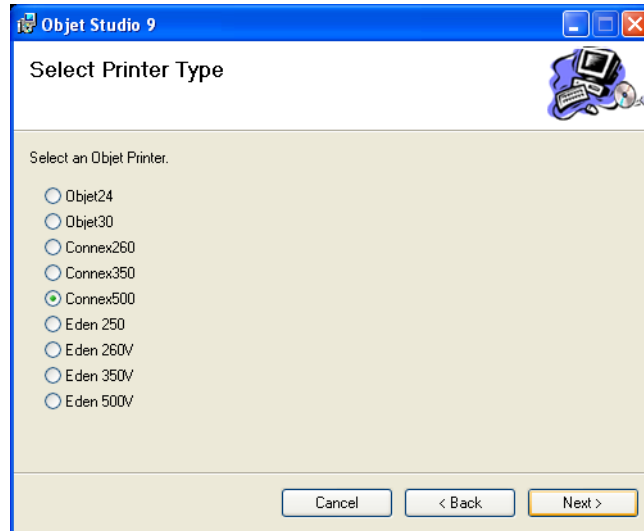


Figure 4-4: Printer selection

Installation begins and a progress bar appears, showing the progress of the installation process.

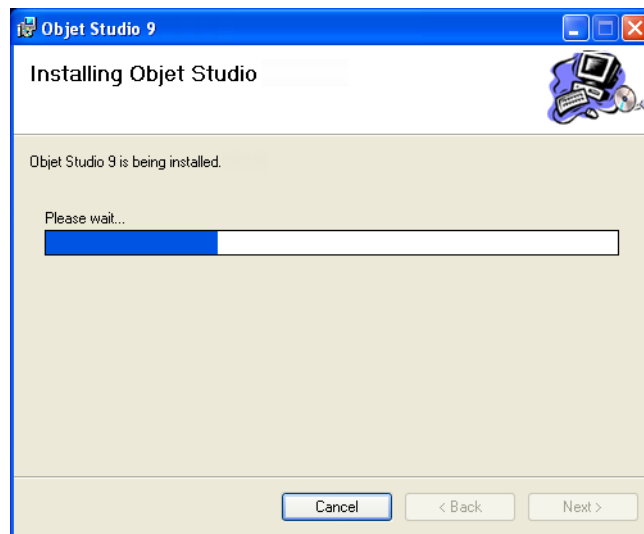


Figure 4-5: Installation progress bar

When the Objet program installation is complete, the final InstallShield Wizard screen appears.

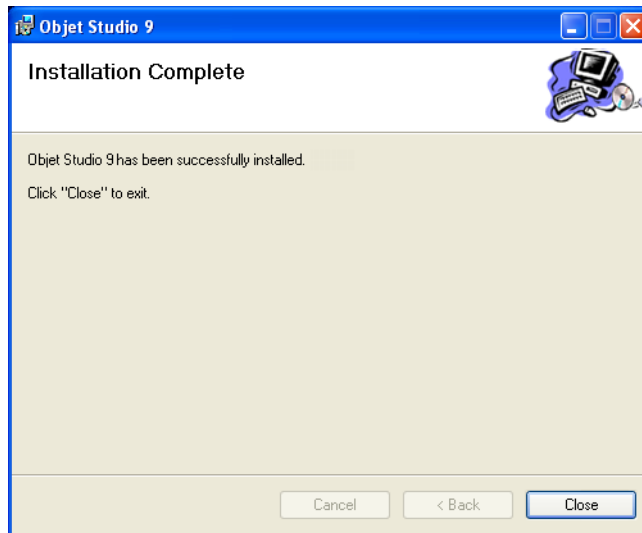


Figure 4-6: Final installation screen

Sometimes, you must restart the computer to complete the software installation. You can do so now or at another time.

Note: Make sure to remove the CD from the disk drive before restarting the computer.

The installation process ends when the appropriate icon(s) appear on the computer desktop:


- Objet Studio
- Stop Job Manager (for servers and standalone stations)

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Objet Studio Interface

After you install Objet Studio, a launch icon  appears on the Windows desktop. Open the application by double-clicking this icon, or by selecting Objet Studio from the Start menu.

Objet Studio opens, displaying an empty build tray.

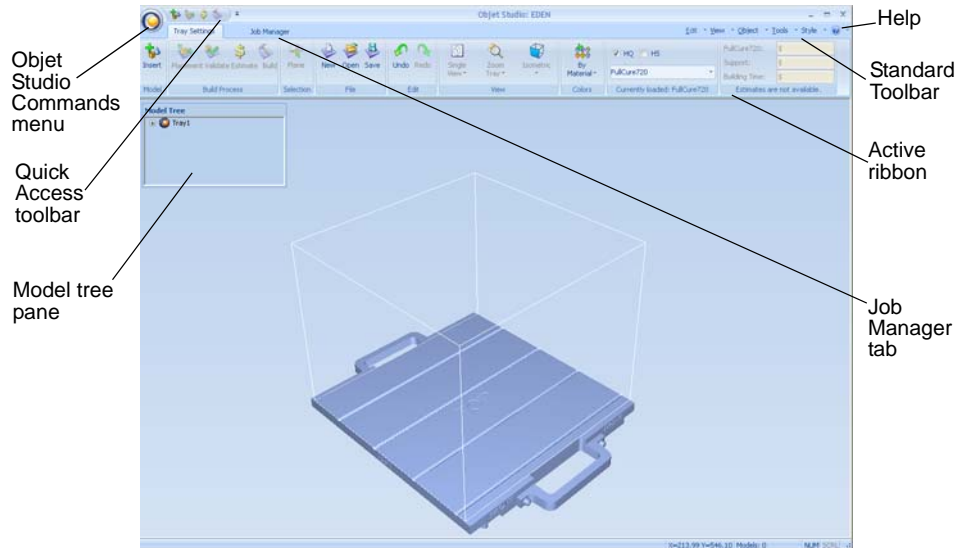


Figure 5-1: Objet Studio opening screen

The Objet Studio interface consists of two main screens:

- **Tray Settings**—for arranging models and preparing them for printing. This screen is described below.
- **Job Manager**—for monitoring and managing print jobs. This screen is described in “Monitoring and Managing Print Jobs” on page 57.

Each is controlled by menus and icons on its own ribbon. An additional ribbon, *Model Settings*, displays controls for configuring and manipulating selected models.

Objet Studio anticipates your work flow by displaying and enabling the options relevant to your current task. For example, when you first open Objet Studio, the *Model Settings* ribbon is disabled until you place a model on the build tray. Similarly, menu options available from the Standard Toolbar menus are enabled or disabled to match the current workflow.

The ribbon, colors used, and several other interface features can be customized. How to change the appearance of the interface is explained in “Customizing Objet Studio” on page 45.



Instructions for using the commands for preparing models for production and sending jobs to the printer, appear later in this chapter.

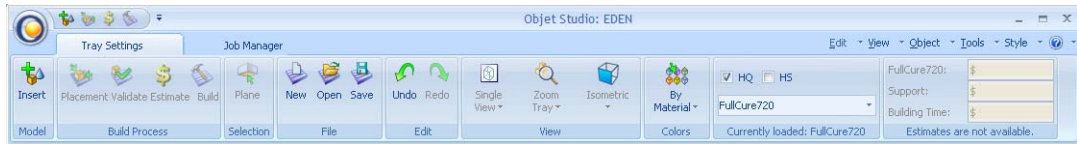


Figure 5-2: Tray Settings ribbon

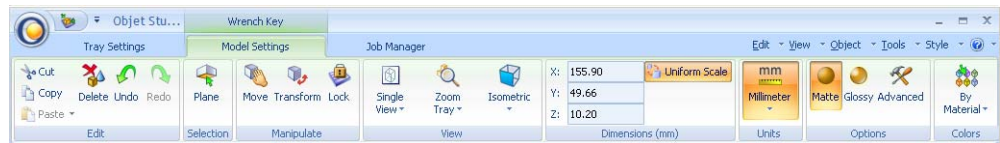




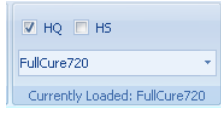

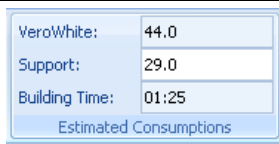



Figure 5-3: Model Settings ribbon

Ribbon Commands

The following table lists the *Tray Settings* and *Model Settings* ribbon command groups, and shows when they are enabled, and where they appear.


Group	Purpose	When enabled	Tray Settings Ribbon	Model Settings Ribbon
	Setting display colors.	Always.	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	Selecting perspective and zoom level.	Models are on the build tray.	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	Choose to select a plane.	Models are on the build tray.	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	Change the perspective of the active pane.	Models are on the build tray.	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>
	Assigning model material.	<ul style="list-style-type: none"> Build tray is empty. Models are not selected. 	<input checked="" type="checkbox"/>	
	Undoing or redoing actions.	After an action or object selection.	<input checked="" type="checkbox"/>	
	Estimating the amount of printing materials required.	Build tray is empty. Models are not selected.	<input checked="" type="checkbox"/>	
	Opening and saving files.	Models are not selected.	<input checked="" type="checkbox"/>	

Group	Purpose	When enabled	Tray Settings Ribbon	Model Settings Ribbon
	Placing model files on the build tray.	Always.	<input checked="" type="checkbox"/>	
	Pre-build/build commands.	Models are on the build tray.	<input checked="" type="checkbox"/>	
	Setting model dimensions.	A model is selected.		<input checked="" type="checkbox"/>
	Cutting, copying, pasting and deleting models.	A model is selected.		<input checked="" type="checkbox"/>
	Moving, rotating and resizing models.	A model is selected.		<input checked="" type="checkbox"/>
	Assigning model finish and setting support strength/“hollow.”	A model is selected.		<input checked="" type="checkbox"/>
	Setting a model's unit of measure (millimeters or inches).	A model is selected.		<input checked="" type="checkbox"/>



To quickly identify an icon, move the cursor over the icon to display its tooltip. The “Undo” and “Redo” tooltips change to reflect your last Objet Studio action.

Objet Studio Commands Menu

Clicking the Objet icon  (in the upper-left corner) opens the Objet Studio Commands menu. This menu displays basic application commands and options.

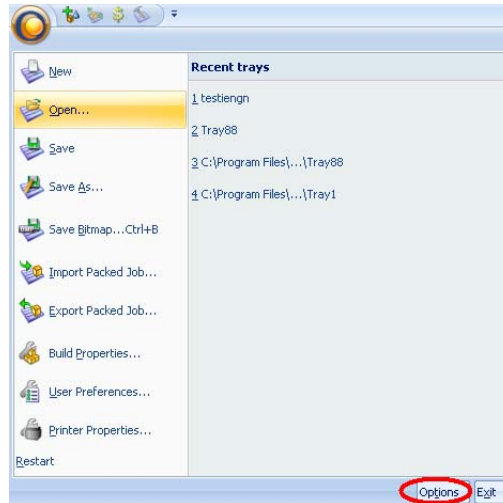


Figure 5-4: *Objet Studio Commands* menu

The *Options* button opens a dialog box for customizing Objet Studio.

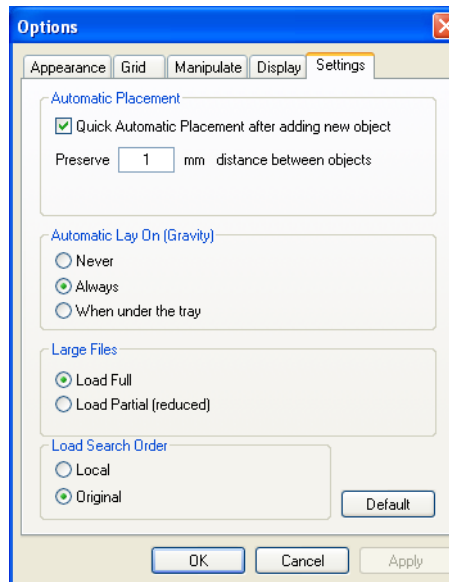


Figure 5-5: *Options* dialog box

Model Tree Pane

The Model Tree pane lists the objects placed on the build tray. By default, the pane “floats” — that is, you can move it to another position on the screen and resize it. Alternatively, you can fix its position at the left of the application window, and even hide it.

Preparing Models for Production

Model preparation involves the following basic steps:

1. Place objects on the build tray.
2. If necessary, manipulate the object's orientation and position.
3. Select the material and model finish.

OBJDF Files: Overview

An *objdf* file describes both the geometry of a single object and the material, and finish required to print it. You can use the *objdf* format to save a group of separate objects on the build tray as one unit, together with their relative positions and material.

Further explanations of *objdf* files, and instructions for utilizing their features, appear throughout this chapter.

Model Files

To produce models, you must open one or more model files in Objet Studio and position objects on the build tray. You can place objects on the build tray in two ways:

- by inserting individual *stl* or *slc* files.
- by pasting objects that you copied to the Windows clipboard.

If you know what type of model material will be used to produce the models, make sure it is selected from the material drop-down menu.

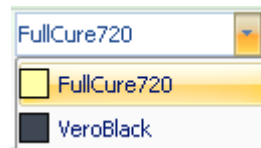



Figure 5-6: Model material selection toolbar

Note: It is not necessary to select the model material now, but it is recommended—each type of material has unique characteristics that may affect the valid positioning of objects on the build tray.

Placing Objects on the Build Tray

To place an object on the build tray using *stl*, *slc* or *objdf* files:

1. Open the *Insert* dialog box—
 - From the *Object* menu, select *Insert*.
 or—
 - On the *Tray Settings* ribbon, click  *Insert*.
 or—
 - Right-click on the build tray, and select *Insert* from the context menu.

The *Insert* dialog box appears.

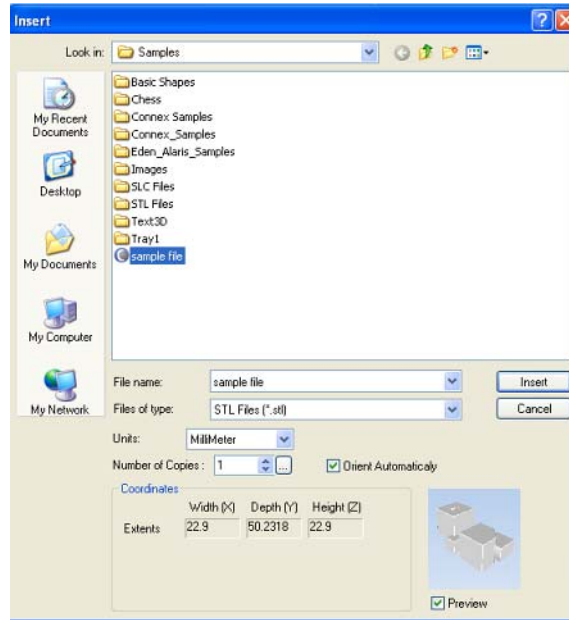


Figure 5-7: *Insert* dialog box

2. In the *Look in* field, display the appropriate folder.
3. In the *Files of type* field, select the file types to display (*stl*, *slc*, *objdf*).
4. Select the desired file, and make sure that it appears in the *File name* field.

If the *Preview* check box is selected, the object is displayed in the dialog box, as shown in figure 5-7.

The *Model Settings* ribbon is displayed when objects are placed on the build tray.

5. Select any of the following options, as required:
 - **Units**—*Millimeters* or *inches* for the object's units of measure.
The 3-D file contains the object's proportions, but not its units of measure. Therefore, make sure to correctly select either millimeters or inches when inserting an object. Otherwise, the size of the object on the build tray will be either much too large or much too small. To change the measurement units of objects already placed on the tray, see "Measurement Units" on page 23.
 - **Number of copies**—How many copies of this object to place on the build tray.
 - **Orient Automatically**—Automatically orient objects on the build tray for efficient model building.

Note: The Extents values displayed in the *Insert* dialog box's *Coordinates* field, represent the maximum dimensions of the object on each axis. These dimensions correspond to the virtual "bounding box" surrounding the object see figure 5-49 on page 36).

6. Click Insert.

Objet Studio places the object on the build tray, and in the model tree.

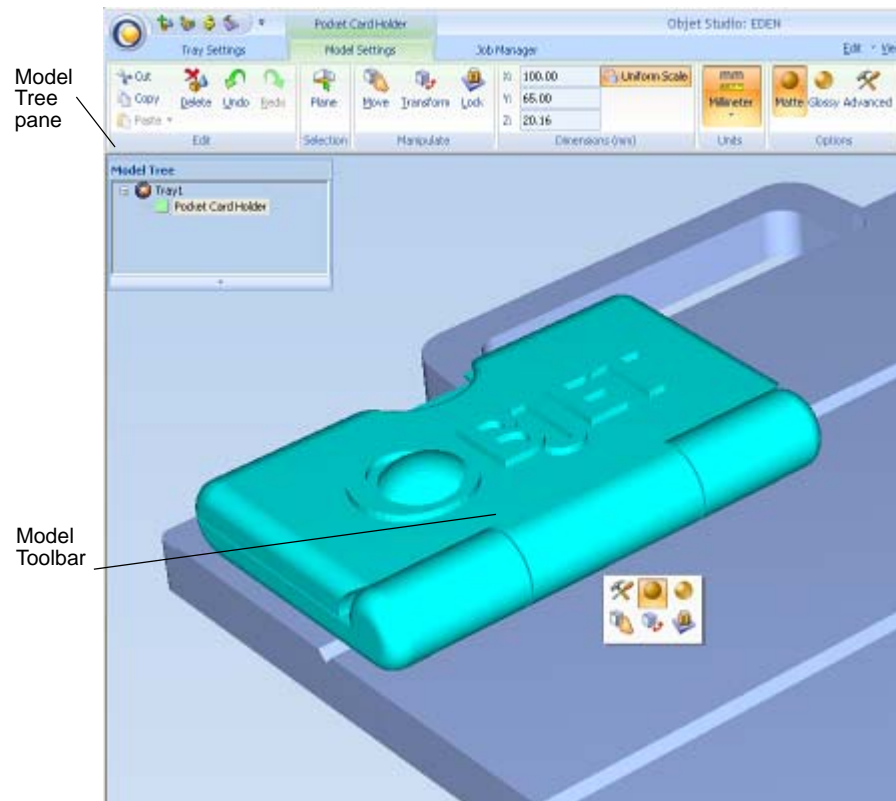


Figure 5-8: Default screen layout

The *Model Settings* ribbon is displayed when objects are placed on the build tray.

If the object is over a certain size, the *Loading Placed Elements* dialog box may appear.

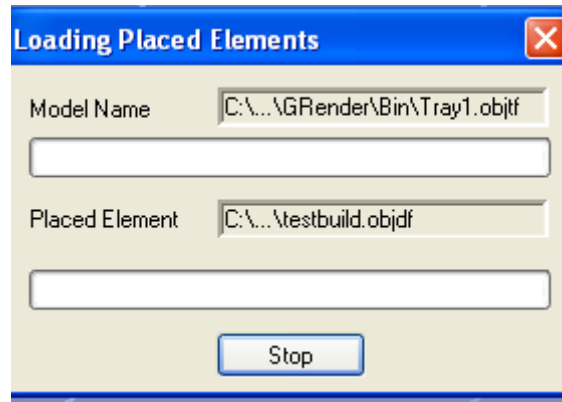


Figure 5-9: *Loading Placed Elements* dialog box



You can speed up the opening of large files by changing the *Large Files* settings—see “Loading Large Files” on page 33).

Opening *objdf* files Before placing *objdf* files on the build tray, Objet Studio must extract the component *stl* files together with information about their orientation and materials. To do this, Objet Studio creates a folder with the same name as the *objdf* file, in the same location.

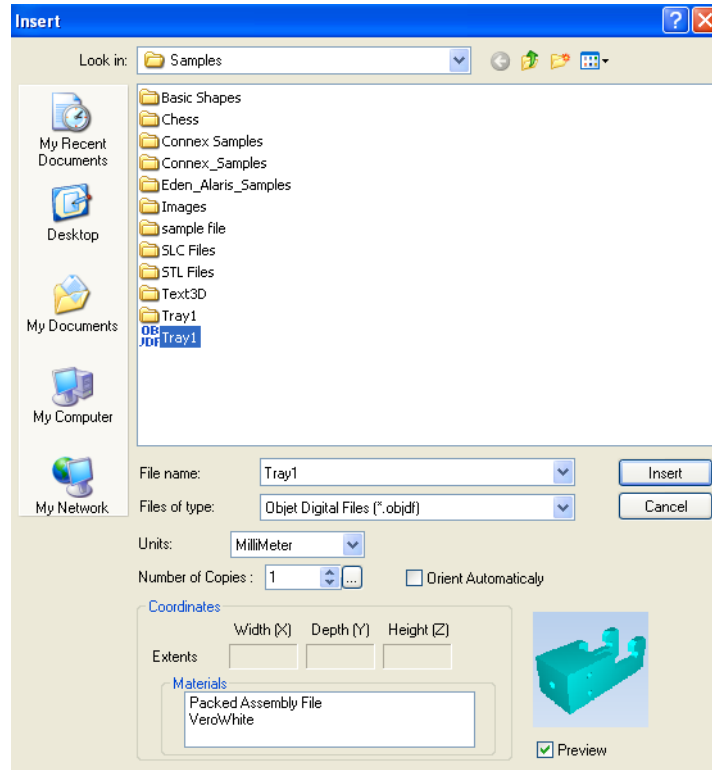



Figure 5-10: *Insert* dialog box (*objdf* file)

Opening Objet Tray Files

You can open trays that were saved as *objtf* files, for example, a tray you saved while preparing it for printing, and now you want to continue preparing it.

To place an object saved as an Objet Tray File (*objtf*) file on the build tray:

1. From the *File* group, click  **Open**.

OR —

From the *Objet Studio Commands*, select **Open**.

The *Open* dialog box is displayed.

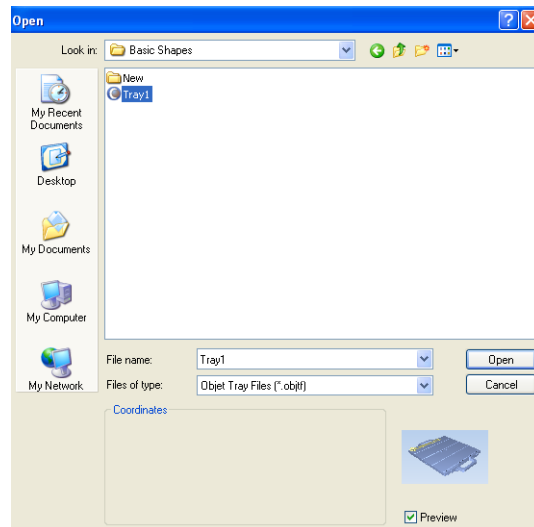


Figure 5-11: Objet Tray File *Open* dialog box

2. Select the desired file, and make sure that it appears in the *File name* field.

If the *Preview* check box is selected, the object is displayed.

3. Click **Open**.

Objet Studio opens the tray file.

Stl file loading preference If there are identically named *stl* files in more than one location, you need to ensure that the correct component *stl* files are linked to the *objtf* file. For example, if there are identically named *stl* files on one drive and on a flash drive (this can occur if you copy the original files to a working folder), you can set the default location from which files are loaded.

To set the Load Order:

1. From the *Tools* menu, select *Options*.
or—
In the *Objet Studio Commands Menu*, click *Options*.
2. In the *Options* dialog box, display the *Settings* tab.

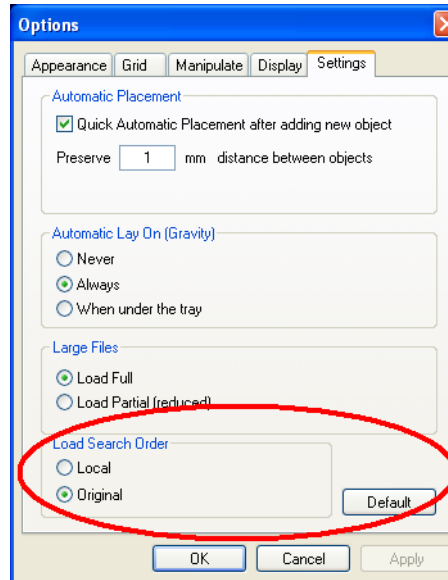


Figure 5-12: *Options* dialog box, *Settings* tab

3. Under *Load Search Order*, select an option:
 - *Local*—to load files from the location where they were last saved.
 - *Original*—to load files in their original location.
4. Click *OK*.

Quick-Access Model Commands







You can access common commands for working with objects on the build tray with the convenient Model Toolbar and context menus.

Model Toolbar Select an object in the tray to display the Model Toolbar that contains icons to perform common tasks.



Figure 5-13: Model Toolbar

The table below describes the Model Toolbar icons.

Icon	Description
	Applies a matte finish to the model.
	Applies a glossy finish to the model.
	Opens the <i>Advanced Properties</i> dialog box for setting the Grid Style and the Hollow option.
	Enables dragging an object (see page 24).
	Opens the <i>Transform</i> dialog box for changing the object's position and scale.
	Toggles the Lock Model Orientation setting.

Right-click model menu If you right-click on an object, a pop-up context menu is displayed from which you can also select the model finish, change its position and scale, and set the *Grid Style* and *Hollow* options.



You can also create a Quick Access toolbar with your most commonly used icons grouped together. See “Building a Quick Access Toolbar” on page 89.

Copying and Pasting Objects

If you need to duplicate objects on the build tray, you can, of course, insert the same object from its file more than once. An easier way, however, is to copy and paste the object. You can copy objects from the build tray or the model tree. The objects copied remain in the Windows clipboard until you paste them onto the build tray.

You can also copy objects from one tray and paste them onto another, in the same way as you copy text from one document and paste it into another one. However, Objet Studio allows only one tray to be open at a time. For each build tray you need to work with (at the same time), you must open a separate Objet Studio window, by running the application again (from the Windows *Start* menu).



Having multiple Objet Studio windows open can be convenient when you need to manipulate or configure objects before inserting them in your production build tray. Copying and pasting also allows you to utilize objects already configured on previously-used build trays for newer projects.

You perform the *Copy* and *Paste* commands as in other Windows applications:

- from the right-click context menu.
- by using keyboard shortcuts (Ctrl+C and Ctrl+V, respectively).

The *Paste Special* command (from the object's right-click context menu) enables you to place duplicate objects even more efficiently:

- You can specify the number of duplicates to place on the build tray at once.
- You can set the distance, on each axis, between the duplicate objects.
- You can manipulate mirror images of the original object, and flip them on selected axes.

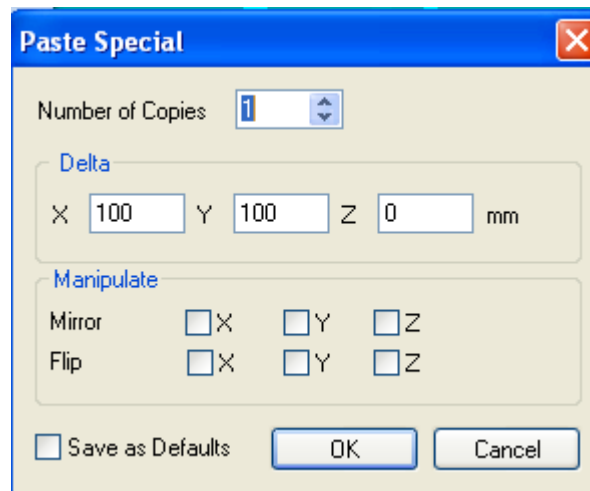


Figure 5-14: *Paste Special* dialog box

Selecting Objects

To manipulate an object on the build tray or assign characteristics to it (building style, for example), you must first select the object. You select an object by clicking it, either on the tray or in the model tree. Its image on the build tray changes color (to light blue, by default) and its name is highlighted in the model tree. You can select multiple objects by drawing a box around them with the mouse cursor, or by pressing the **Ctrl** or **Shift** keys while clicking additional objects.

Alternatively, select or de-select objects using the following *Edit* menu commands:

- Select All
- Invert Selection
- Undo Select object

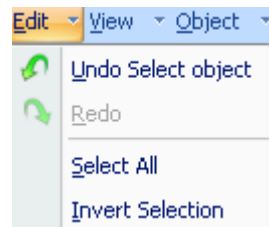




Figure 5-15: *Edit* menu

Surface Finish

Models can be printed with a matte or glossy surface finish. To create a matte finish, the printer surrounds models with a thin layer of support material.

To set the model finish:

1. Select the model.
2. Select Matte  or Glossy  in one of the following places:
 - *Model Settings* ribbon, *Options* group
 - Model Toolbar
 - right-click context menu (when selecting the model)

You can configure Objet Studio to distinguish between objects' surface finish on the build tray by color. To configure how Objet Studio displays objects, see "Setting Object Colors" on page 32.

Positioning Objects on the Build Tray

To produce models efficiently and with the required finish, it is important to carefully position objects on the build tray. Objet Studio supports the automatic positioning of objects. However, you should check to make sure that the objects are orientated logically for your needs, according to the considerations explained in “Model Orientation” on page 19.

Two things that affect the positioning of objects on the build tray are *orientation* and *placement*. You can let Objet Studio determine the optimum orientation and position, or you can control them.

Automatic Orientation

By default, Objet Studio automatically orients objects, when placed on the build tray, for the shortest printing time. (You can later change the orientation manually.) However, you can cancel automatic orientation when placing an object on the build tray.

To place an object on the build tray without automatic orientation:

- In the *Insert* dialog box, make sure *Orient Automatically* is **not** selected.

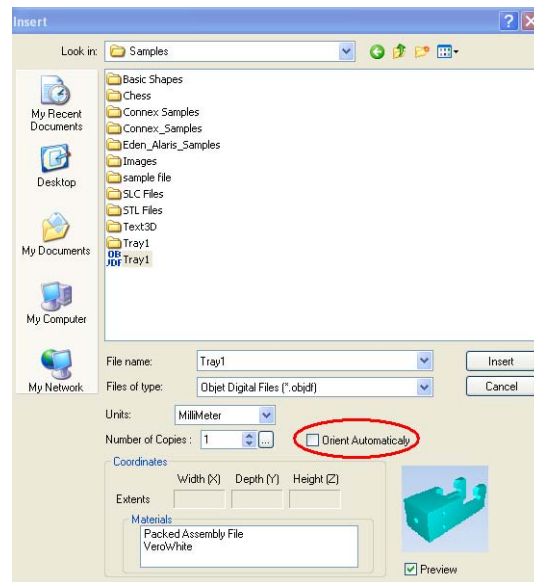


Figure 5-16: *Orient Automatically* option disabled




You can change the default setting, so that automatic orientation is *not* applied unless you select the *Orient Automatically* check box each time you place an object on the build tray. To do this, see “Default Settings” on page 51.

Automatic Placement

After placing several objects on the build tray, you can let Objet Studio arrange them on the tray for printing. This ensures that the objects are positioned properly, and that they will be printed in the shortest time and with a minimum of material.

To automatically arrange objects on the build tray:

- On the *Tray Settings* ribbon, click  Placement .
- or—
- From the *Tools* menu, select Automatic Placement.

The effects of automatic positioning are shown in the figures below.

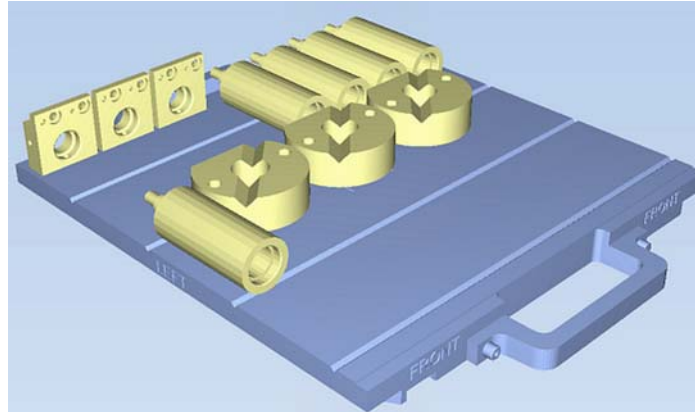


Figure 5-17: Tray before objects are properly arranged

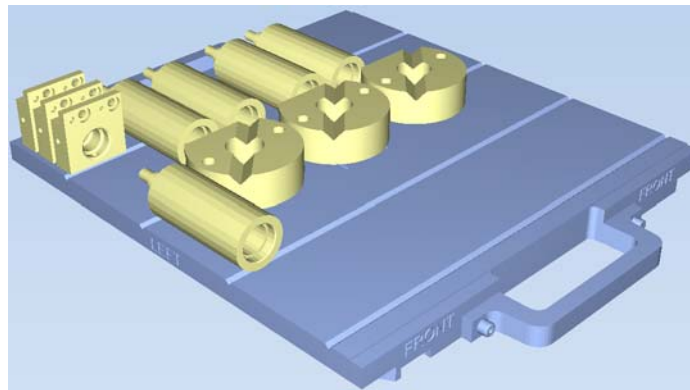


Figure 5-18: Tray arrangement when applying automatic placement



- For best results arrange the tray with *Automatic Placement*, on the *Tray Settings* ribbon, even if you inserted the objects with the *Orient Automatically* option.
- The physical characteristics of each type of model material you use can affect the positioning of objects on the build tray. Therefore, select the material **before** running *Automatic Placement*.

Manual Positioning

You can change the position of objects on the build tray—even if they were inserted with the *Orient Automatically* option. Considerations for positioning objects are presented in “Model Orientation,” below. Tools for changing the position of objects are presented in “Manipulating Objects on the Build Tray” on page 20.

Model Orientation

The orientation of models on the build tray affects how quickly and efficiently they will be produced by the 3-D printer, where and how much support material is used, and whether or not model parts will have a glossy finish. Therefore, you should consider a variety of factors when deciding how to place models on the tray, using the following positioning rules.

X-Y-Z Rule

This rule considers a model's outer dimensions.

- Since the print heads move back and forth along the X-axis, the printing time along this axis is relatively short, compared to printing time along the Y-axis and Z-axis. From this point of view, it is advisable to place the object's *largest* dimension along the X-axis.
- Any surfaces that come into contact with support materials become matte.
- Since high-resolution models are built up, on the Z-axis, in 16 or 30-micron layers (according to the selected printing setting), it is very time-consuming to print a tall object. From this point of view, it is advisable to place the object's *smallest* dimension along the Z-axis.
- Since the print heads measure about 2 inches (5 centimeters) on the Y-axis, models measuring less than this (on the Y-axis) are printed in one pass. From this point of view, it is advisable to place the object's *intermediate* dimension along the Y-axis.

Tall-Left Rule

This rule considers models where, after being orientated on the build tray according to other considerations, one side is taller than the other.

- Since the print heads move along the X-axis from left to right, taller sections on the right require the print heads to scan unnecessarily from the left until reaching them. If, on the other hand, the taller sections are positioned on the left of the tray, the print heads only have to scan the model until printing these sections—once the lower parts have been completed. Therefore, you should position the taller side of the model, when possible, *on the left*.



The following rules are based on the fact that support material is not required on the top of the printed model.

Recess-Up Rule

This rule considers models containing surface recesses.

- Recesses in the surface (like hollows, drill holes, etc.) should, when possible, be positioned *face-up*.

Fine-Surface Rule

This rule considers models that have one side on which there are fine details (like the keypad side of a telephone).

- The side of the model containing fine details should, when possible, be positioned *face-up*. This results in a smooth finish.

Avoid Support-Material Rule

This rule considers models that have large holes or hollows, open on at least one side (like a pipe or a container).

- It may be advantageous to print a model *standing up*, so support material does not fill the hollow, even though printing the model lying down would be much faster.

Manipulating Objects on the Build Tray

Positioning Objects on the Z-Axis

When you use the automatic positioning option to arrange objects on the build tray (see “Automatic Orientation” on page 17), the objects are positioned directly on the tray. If you do not insert objects with automatic positioning, they often appear either above or below the tray.



In practice, the Eden system prints all models on the build tray on a one-millimeter bed of support material. The importance of positioning objects directly on the build tray with Objet Studio is to correctly display the objects on the screen.

To position objects directly on the tray:

1. Select the object.
2. From the *Object* menu, select Lay On.

To ensure that objects are always positioned directly on the tray:

1. From the *Tools* menu, select Options, and display the *Settings* tab.

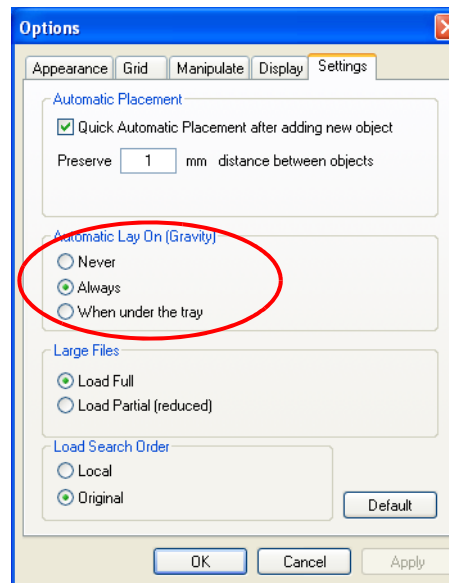


Figure 5-19: Options dialog box, Settings tab

2. In the *Automatic Lay On (Gravity)* section, select Always.

Other Z-axis options (in the *Automatic Lay On* section):

- When under the tray—The display of objects that are below the build tray is automatically changed so that the object is at tray level.
- Never—The display of objects that are above or below the build tray is not changed.

Valid Object Placement

You can ensure that models do not overlap when you position them on the build tray, and that they do not extend beyond the tray.

To ensure valid object placement:

1. From the *Tools* menu, select *Constraints Settings*.

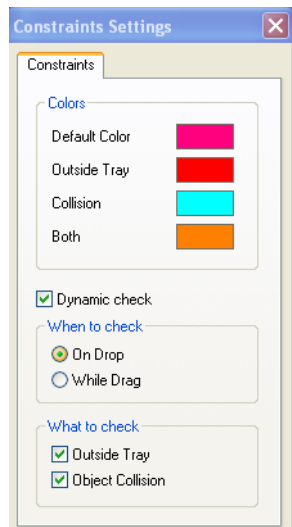


Figure 5-20: *Constraints Settings* dialog box

2. Select *Dynamic check* to identify:
 - invalid object placement while placing objects—*On Drop* selected.
 - invalid object placement after moving objects—*While Drag* selected.
 - objects placed beyond the tray's boundaries—*Outside Tray* selected.
 - objects that overlap—*Object Collision* selected.



Even if you do not use *Dynamic Check* when placing objects on the build tray, Objet Studio automatically checks if there is a problem with the positioning of objects on the tray before sending it to the printer. You can also manually check for problems after positioning objects (see “Tray Validation” on page 36).

Note: Remember that Objet Studio calculates the space occupied by an object including the “bounding box” surrounding it (see figure 5-33 on page 29).

Using a Grid to Position Objects

Displaying a grid on the image of the build tray can be useful when positioning objects. You can make use of this feature by selecting the following menu options.

Menu Option	Result
Tools > Grid	Displays a grid on the build tray.
Tools > Snap to grid	When moving the object, it aligns with the nearest grid line.
Tools > Options > Grid	Enables you to change the grid origin (X- and Y-axis meeting point) and appearance.

You can review and configure grid settings—and apply them—from the *Options* dialog box.

To view and change grid settings:

1. From the *Tools* menu, select *Options*, and display the *Grid* tab.

The current grid settings are displayed.

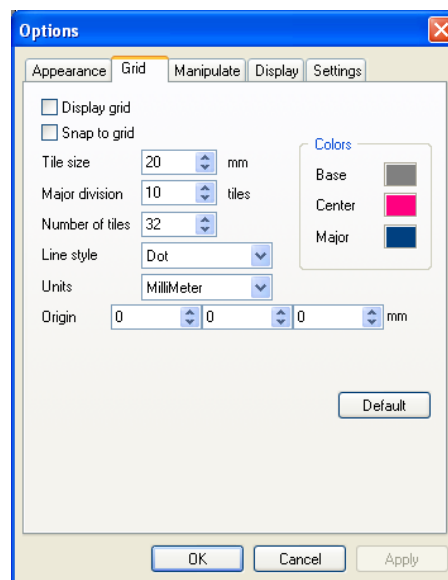


Figure 5-21: *Options* dialog box, *Grid* tab

2. As required, change the settings, and select or clear the check boxes.
3. Click *Apply* or *OK*.

Measurement Units

3-D files contain an object's proportions, but not its units of measure. Therefore, make sure to correctly select either millimeters or inches when inserting an object. Otherwise, the size of the object on the build tray will be either much too large or much too small.

To set the measurement units when inserting an object:

- In the *Insert* dialog box, *Units* field, select Millimeter or Inch:

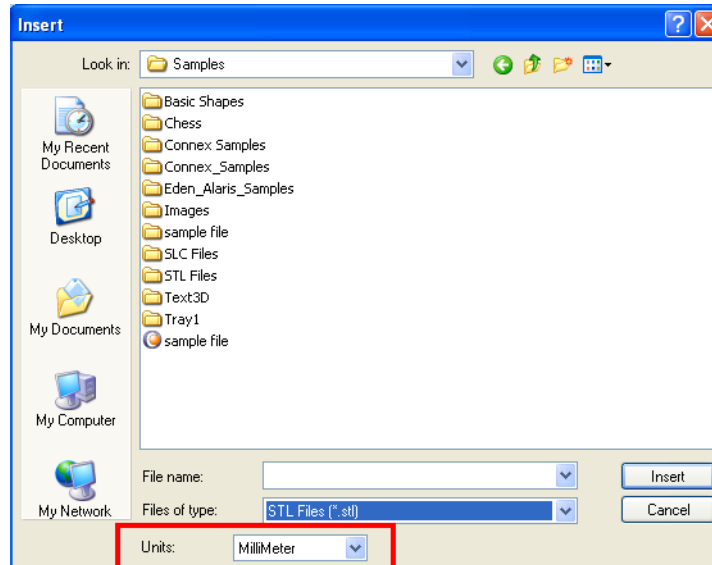


Figure 5-22: *Units* field in the *Insert* dialog box

To change units of measurement on the *Model Settings* ribbon:

1. Open the *Units* flyout toolbar.



Figure 5-23: *Units* flyout toolbar

2. Select the measurement units desired.

To change units of measurement with the Standard Toolbar:

1. From the *Object* menu, select Change Units.

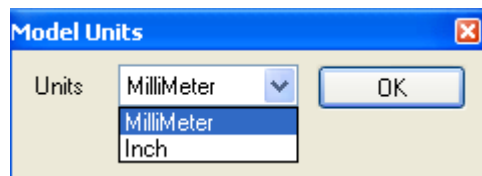


Figure 5-24: *Model Units* dialog box

2. In the *Model Units* dialog box, change the setting and click OK.

Setting Model Dimensions

You can change the object's dimensions by changing the coordinates in the *Dimensions* group on the *Model Settings* ribbon.



Figure 5-25: *Dimensions* on the *Model Settings* ribbon


Note: You can change the height of the objects on the build tray only if this is allowed by the Objet Studio settings(see “Positioning Objects on the Z-Axis” on page 20.)

Repositioning Objects

You can manually move and rotate an object on the build tray with the arrow keys, or by dragging it with the mouse.

To manually manipulate an object:

1. Select an object by clicking it on the build tray, or in the model tree pane.

2. Click  **Move** on the Model Toolbar, or on the *Model Settings* ribbon.

A frame appears around the object, and the cursor changes to indicate that the object can be moved.

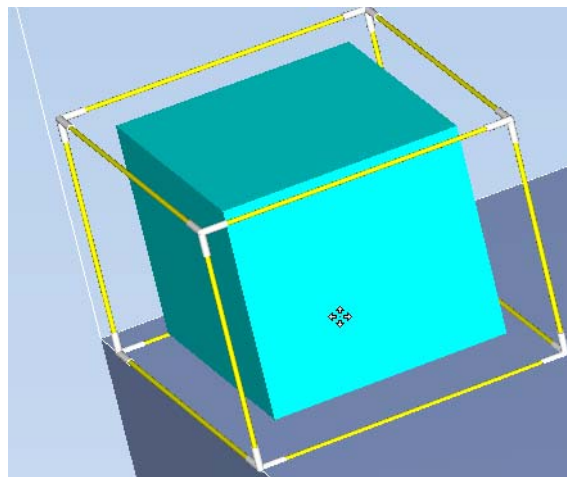


Figure 5-26: Manually moving an object

- If you click on a corner of the frame, the cursor changes to indicate that the object can be rotated.

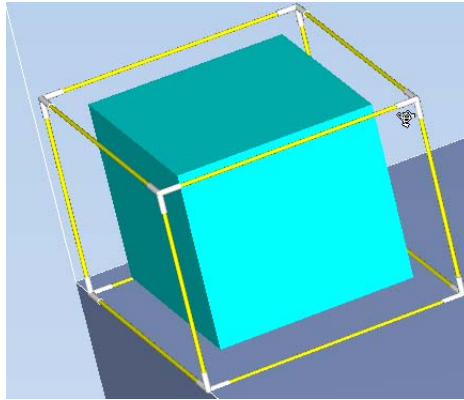


Figure 5-27: Manually rotating an object

- Manipulate the object with the arrow keys or with the mouse.

Using the *Transform* Dialog Box

You can make precise changes to an object by changing the properties in the *Transform* dialog box.

To access the *Transform* dialog box (when an object is selected):


- Click  on the Model Toolbar or on the *Model Settings* ribbon.
- From the right-click context menu, select *Transform*.
- From the *Object* menu, select *Transform*.



Figure 5-28: *Transform* dialog box

To change an object with the *Transform* dialog box:

- Change any of the values, then click *Apply* to see how the object changes on the build tray.

Note: The changed values remain in the dialog box after clicking *Apply*. Therefore, you can make small changes to values in the dialog box to see how the object changes on screen each time you click *Apply*.

To reset all of the values in the dialog box:

- Click *Reset*.

Note: The object does not change. Any changes previously applied remain.

To undo **all** changes made with the *Transform* dialog box:

- Click *Cancel Actions*.



After closing the *Transform* dialog box, clicking *Undo* (on the *Model Settings* ribbon or from the *Edit* menu) cancels **all** changes made with the dialog box.


Changing an Object's Orientation

There are several methods for changing the orientation of objects on the build tray.

To rotate an object:

- Select the object and use the *Object* menu options (see also "Repositioning Objects" on page 24).

To re-align an object's plane:

1. On the *Tray Settings* or *Model Settings* ribbon, click .
 - or—
 - From the *Tools* menu, select *Plane Alignment > Select Plane*.
2. Click on part of an object on the build tray.

The selected plane is displayed.

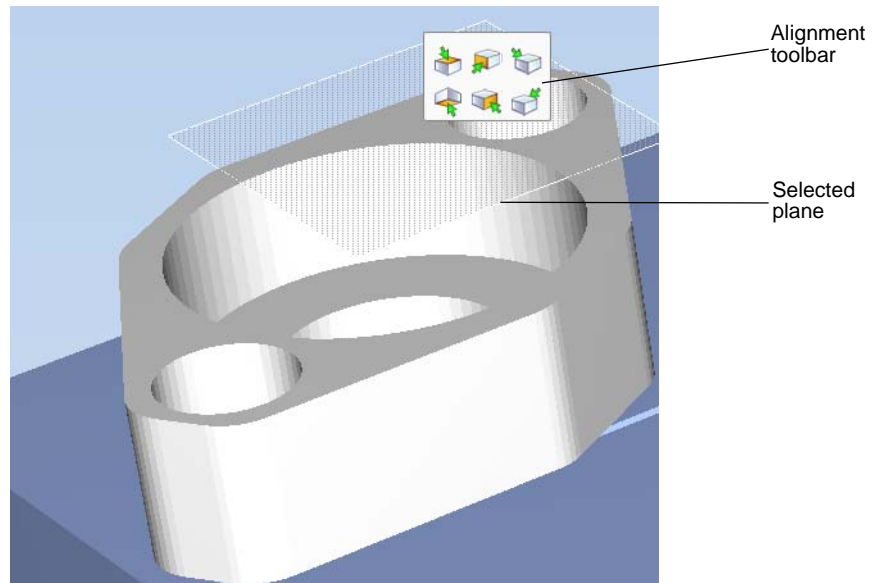


Figure 5-29: Aligning by plane

3. On the *Alignment toolbar*, click an appropriate icon to change the alignment.

or—

From the *Tools* menu, select *Plane Alignment*, and select an alignment option.

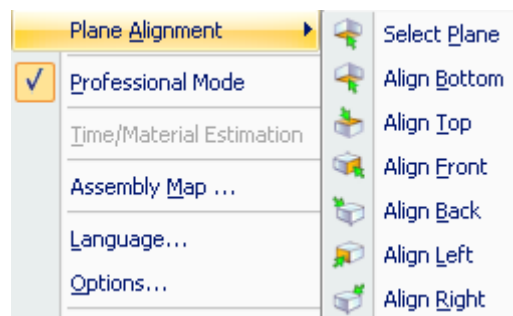



Figure 5-30: *Tools* menu, *Plane Alignment* options

To cancel plane selection after re-aligning objects on the build tray:

- On the *Tray Settings* or *Model Settings* ribbon, click  .

or—

From the *Tools* menu, select *Plane Alignment > Select Plane*.

To flip an object 180 degrees on any axis:

1. Select the object.
2. From the *Object* menu, select *Flip > Flip X / Flip Y / Flip Z*.


To make precise changes to the object's orientation on any axis:

1. Select the object.
2. Display the *Transform* dialog box (see figure 5-28 on page 25).
3. Change the *Rotate* parameters for each axis.


Freezing Model Orientation

If you manipulate an object on the build tray, you can freeze its orientation so that it does not change when you position it automatically (see “Automatic Placement” on page 18).

To freeze an object:

1. Select an object on the build tray.
2. On the *Model Settings* ribbon, in the *Manipulate* group, or on the Model Toolbar, click  .

To unfreeze an object:

- Select the object and click  (to de-select it).

Display Options

Viewing Objects

From the *View* menu, you can change the way objects are displayed. The default method for displaying models on the build tray is as solid (“shaded”) objects.

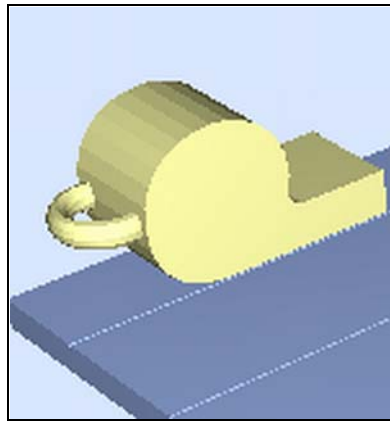


Figure 5-31: Tray and model displayed in *Shaded* view

The other display options are *WireFrame* and *Points*.

To display the build tray in *WireFrame* view:

- From the *View* menu, select *WireFrame*.

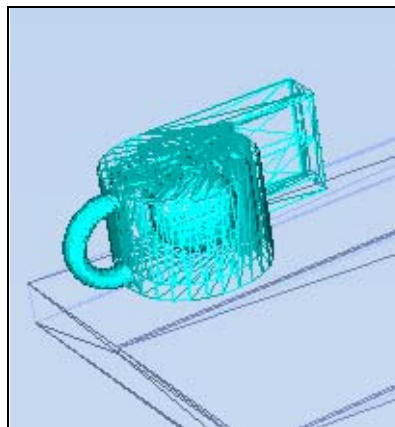


Figure 5-32: Tray and model displayed in *WireFrame* view

To revert to the *shaded* view:

- From the *View* menu, select *Shaded*.

To display objects as boxes, showing their maximum dimensions instead of their shape:

- From the *View* menu, select Display Bounding Box.

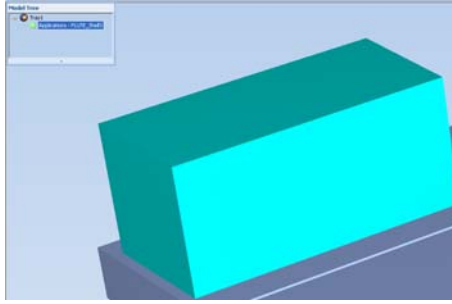


Figure 5-33: Model displayed with bounding box

To display the area around objects needed for support material (to produce a matte finish):

- From the *View* menu, select Display Thickening Box.

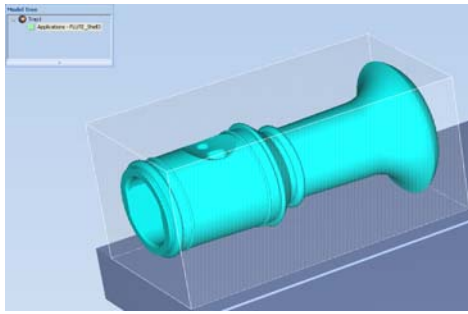


Figure 5-34: Model displayed with thickening box

To display the maximum build height:

- From the *View* menu, select Display Tray 3D Box.

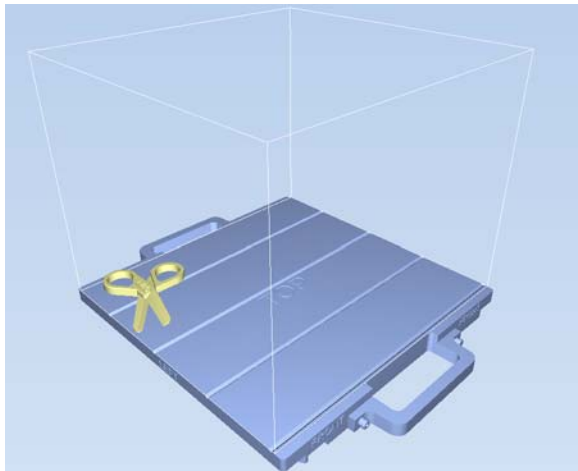


Figure 5-35: Tray 3-D Box

To display objects without the build tray:

- From the *View* menu, clear (de-select) the *Display Tray* option.

Screen Layout Objet Studio automatically adjusts the default screen layout to display the optimum views of the build tray and the model tree. You can view models from different perspectives by changing the screen layout.

To change the screen layout:

- On the *View* flyout toolbar, select *Single View*, or *4 Views*.

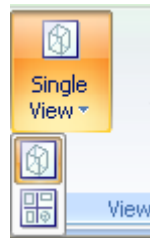




Figure 5-36: Screen layout icons

- Single View  is the default screen layout.
- 4 Views  displays *perspective*, *top*, *front* and *right* views.

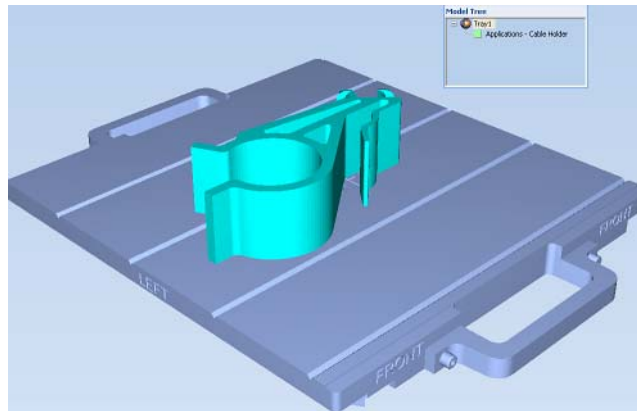


Figure 5-37: Single-view screen layout

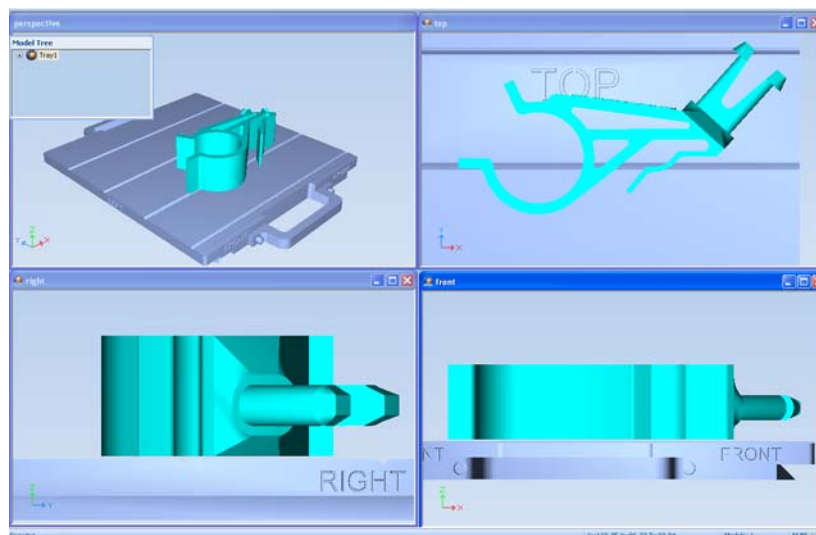


Figure 5-38: 4-view screen layout

Tray Perspective

The default perspective of the build tray is “isometric.” You can change the perspective of the active window with one of ten options.

To change the perspective of the build tray in the active window:

1. On the *Tray Settings* ribbon, open the *Perspective* flyout toolbar.



Figure 5-39: *Perspective* flyout toolbar

2. Click the icon that represents the desired perspective.

Tray Positioning

To view the tray and models from different directions, you can move the tray around the screen and change its display angle.

To move the tray in the Objet Studio screen:

- Press the mouse wheel while moving the mouse.

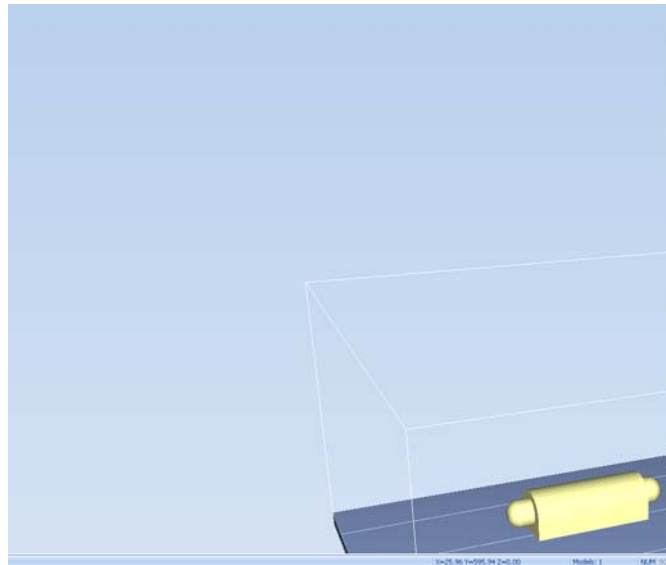


Figure 5-40: Tray after moving it in the Objet Studio display

To manually rotate the tray:

- Press Alt and press the mouse wheel while moving the mouse.

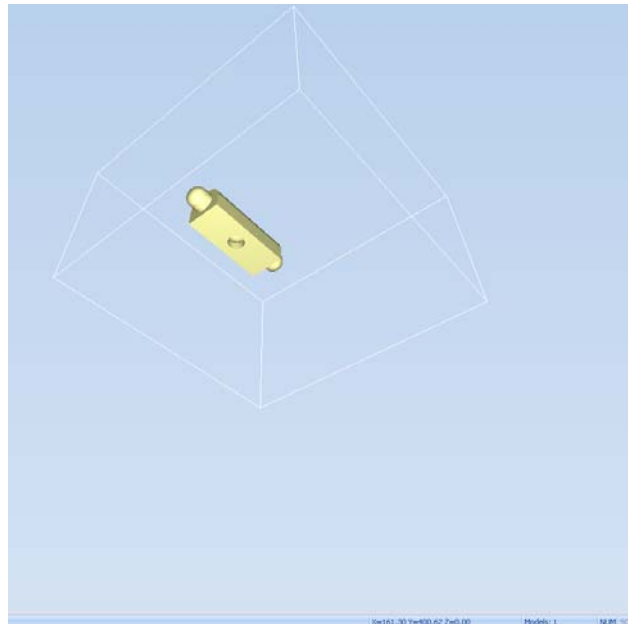


Figure 5-41: Tray after rotating it upside-down

Setting Object Colors

The color of objects on the build tray can indicate how they are printed. Objet Studio enables you to choose the color display so that you can easily see the material, and surface of objects.

To choose how colors are applied on the display:

- On the *Model Settings* ribbon, in the *Colors* group, select one of the options from the flyout toolbar.

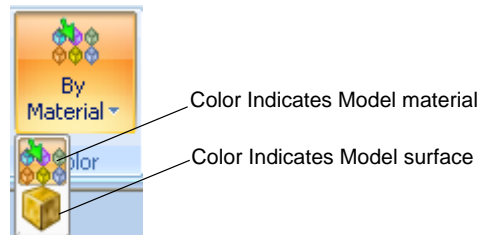


Figure 5-42: Colors display options



Before sending a build tray to the printer, or when you perform *tray validation*, Objet Studio checks if there is a problem with the *stl* files or the positioning of objects on the tray. If so, the affected objects are displayed with special colors (see “Tray Validation” on page 36).

Loading Large Files

Very large *stl* files can be slow to load and may be difficult to manipulate easily on the build tray. If this is the case, you can display just an image of the object on the build tray without loading the entire file. The *stl* file itself is not changed, and the complete file is sent to the printer.

To display an image of *stl* files when you place objects on the build tray:

1. From the *Tools* menu, select *Options*, and display the *Settings* tab.

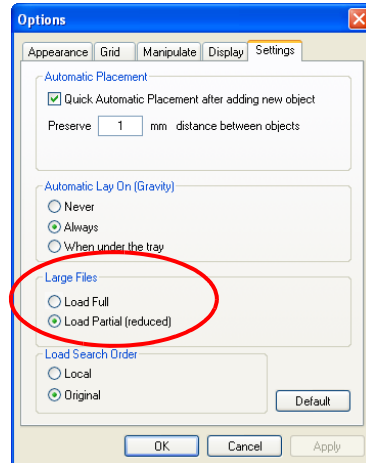


Figure 5-43: *Options* dialog box, *Settings* tab

2. In the *Large Files* section, select *Load Partial (reduced)*.

Large File Manipulation

If you need to work with a detailed model that is composed of a large number of polygons, you can speed up its display and manipulation in *Objet Studio* by reducing the number of polygons on the screen. Although this may reduce the resolution on the screen, it has no affect on the printed models.

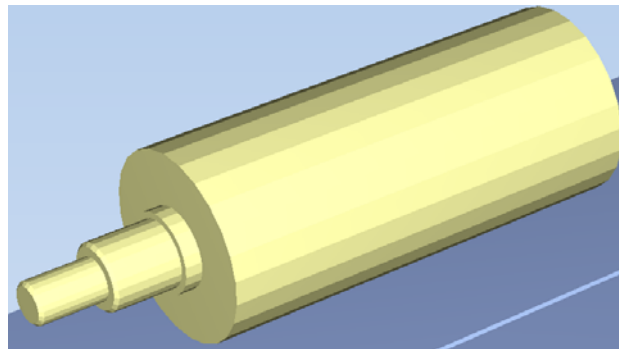


Figure 5-44: Object displayed without polygon reduction

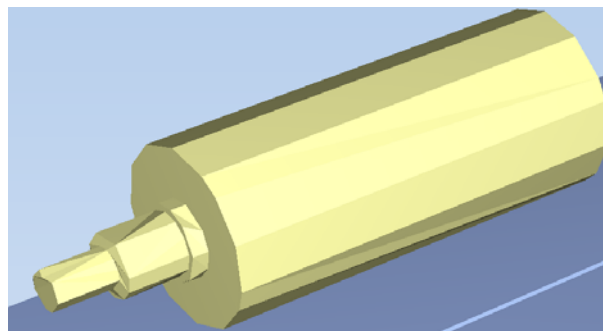


Figure 5-45: Object displayed with only five percent of its polygons showing

To use polygon reduction:

1. From the *Tools* menu, select *Options*.
or—
In the *Objet Studio Commands Menu*, click *Options*.
2. In the *Options* dialog box, display the *Display* tab.

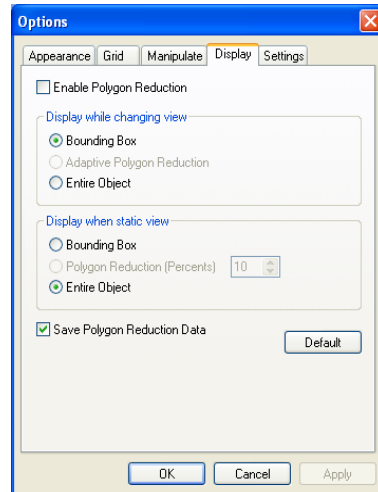


Figure 5-46: *Options* dialog box, *Display* tab

3. Select *Enable Polygon Reduction*.
4. Select *Polygon Reduction (Percent)*.
5. Enter the percentage of total polygons to display.
When you click *Apply*, the display changes.

Note: The setting affects the static display (when the object is not being moved).

6. Set display options when the object is being moved (*Display while changing view*):
 - *Bounding Box*—A box representing the object's maximum dimensions is displayed.
 - *Adaptive Polygon Reduction*—Varying degrees of polygon reduction are applied, as necessary.
 - *Entire Object*—No polygon reduction is applied.
7. To save these settings, so that they will be applied every time you place **this object** on the build tray, click *Save Polygon Reduction Data*.
8. Click *Apply* to see the results of the settings without closing the dialog box.



Selecting the *Entire Object* options cancels polygon reduction.

Object display options

The display format affects how quickly objects display. For example, if you select *Bounding Box*, objects display faster than they do when you select *Entire Object*. You can choose display formats for objects when they are stationary (*static view*) and for when you are dragging them (*changing view*).

To select the object display preference while changing view, and in static view:

1. Select to display objects:
 - With a *Bounding Box* (see figure 5-33 on page 29)
 - With *Adaptive Polygon Reduction* (*changing view only*)
 - With *Polygon Reduction* (*static view only*)
 - *Entire Object*
2. Click OK when done.

Zoom Options

While manipulating objects, you often need to view them at different zoom levels.

To change the zoom level:

- On the ribbon, open the *Zoom* flyout toolbar and select an option:

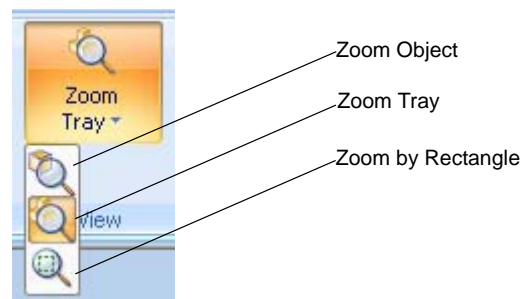


Figure 5-47: *Zoom* flyout toolbar

- Zoom Object* focuses on the selected object.
- Zoom Tray* displays the whole tray.
- Zoom by Rectangle* allows you to display a section of the tray by selecting it with the mouse.

You can also zoom in and zoom out with the mouse wheel.




You can configure *Objet Studio* to automatically zoom in on the objects placed on the build tray. See “*Automatic Zoom*” on page 51.

Handling Completed Trays

After you have properly placed all objects on the build tray, you save the tray as an *objtf* file, which is sent to the 3-D printer for production. But before saving the tray, you can check that there would be no problem producing it. You can also calculate how much material would be consumed during production and how much time this would take.

Tray Validation Before sending a job to the printer for production, you should check that the tray is “valid” and can be printed.

To validate that the tray can be printed:

- On the *Tray Settings* ribbon, in the *Build Process* group, click  **Validate**.
- or —

From the *Tools* menu, select **Placement Validation**.

If the tray is not valid, the color of the problematic models on the tray changes according to a pre-set code.

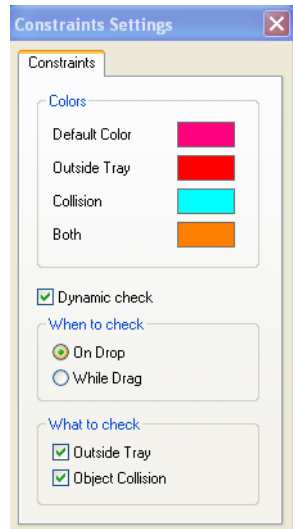


Figure 5-48: Color code

The validation status appears on the bar at the bottom of the screen.

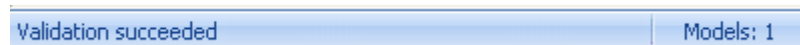


Figure 5-49: Validation details in status bar

High Quality/ Speed Setting

Objet Studio allows you to choose the quality/speed setting most suitable for your job.

HQ (High Quality)—

- Prints models in 16-micron layers, suitable for producing fine details and delicate items.
- Requires much more time to print most trays, compared to High Speed setting.

HS (High Speed)—

- Prints models in 30-micron layers, suitable for producing larger models.
- Requires much less time to print most trays, compared to High Quality setting.

Change the setting, if necessary, before sending the tray to the 3-D printer.

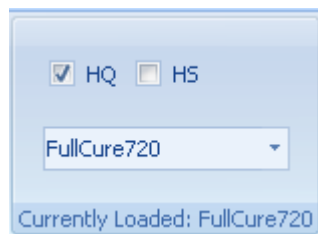



Figure 5-50: Quality/speed setting

Production Estimates

Objet Studio enables you to calculate the time and material resources needed for producing trays before sending them to the printer. The time it takes Objet Studio to make this calculation depends on the number of objects on the tray and their complexity. Calculating the production estimate for a full tray could take up to 15 minutes, depending on your computer's specifications.

To calculate the time and materials needed for producing the current tray:

- On the *Tray Settings* ribbon, in the *Build Process* group, click  **Estimate**.

While the estimate is being calculated, a progress bar is displayed—on the right side of the status bar (at the bottom of the screen).



Figure 5-51: Estimate progress bar

When Objet Studio finishes calculating the production resources, the results are displayed in the *Estimated Consumptions* group on the *Tray Settings* ribbon.

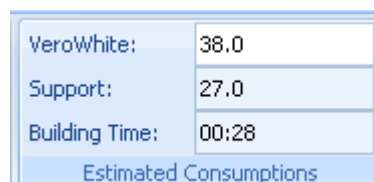


Figure 5-52: Production resource calculation

E-mailing Objet Digital Files

You can e-mail *objtf* files using Microsoft® Office Outlook®.

To e-mail a file:

1. From the *Tools* menu, select Email Objet Digital File.


Outlook opens with the file attached and Subject details added to the e-mail form.

2. Enter the e-mail address and send the file.

Printing the Tray File

When a tray is ready to be printed, it is placed in the Jobs Queue. When the job reaches the head of the queue, Objet Studio pre-processes the tray file to create slices, and feeds them to the 3-D printer.

To send the tray to the print queue:

1. On the *Tray Settings* ribbon, *Build Process* group, click  **Build**.

If the build tray file has not been saved, the *Save As* dialog box opens for you to save it now.

Objet Studio checks if there is a problem with the positioning of objects on the tray. If so, the affected objects are displayed with special colors (see “Tray Validation” on page 36), and the following warning message appears.

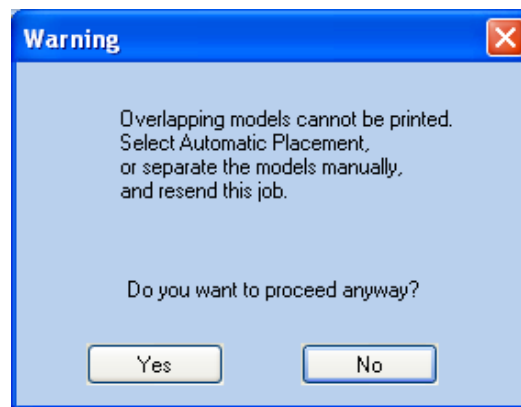


Figure 5-53: Tray validation warning message

- To cancel the *Build* command so you can correct the problem, click **No**.
- To print the models as they are positioned on the tray, click **Yes**.

The *Job Manager* screen opens, so you can monitor the progress of your trays—before, during, and after printing. See “Monitoring and Managing Print Jobs” on page 57.

Applying Additional Objet Studio Features

Dividing Objects

You can use the Split Object feature to produce objects larger than the tray area by dividing the model into separate parts. With this feature, you produce only a specific section of a model.

To split an object:

1. Select the object.
2. From the *Object* menu, select *Split*.
3. In the *Split Object* dialog box, enter the values to determine how Objet Studio will divide the object. You can divide an object along any of its axes, by entering either exact measurements or the number of parts.

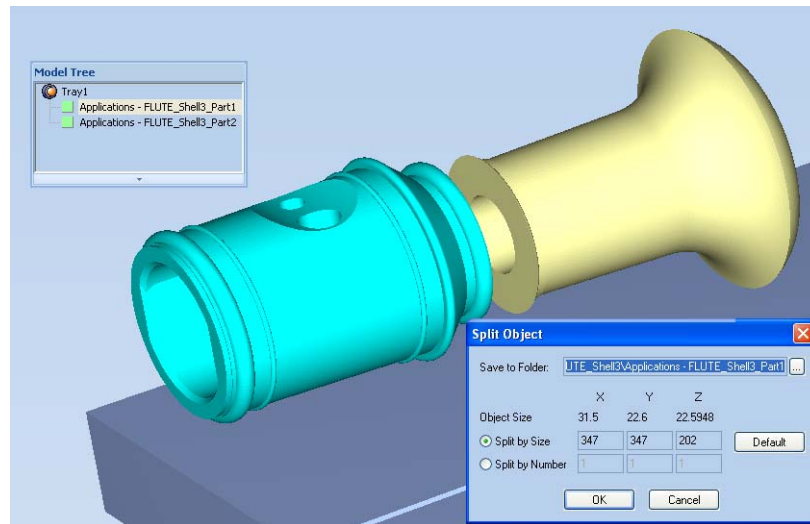


Figure 5-54: *Split Object* dialog box

4. In *Save to Folder*, enter the folder name.
5. Click *OK*.



The composite parts are saved as new *stl* files with “Part 1,” “Part 2,” etc., added to the original file name.

Note: Before printing the newly created *stl* files, it is recommended that you check them for defects in an STL-repair application, such as *Magics*, by Materialise.

Choosing the Support Strength

When producing models, support material fills some hollow and empty sections (see “Model Orientation” on page 19). Objet Studio allows you to adjust the strength of the structure formed with the support material. This adjustment is useful when producing either large/massive models or small/delicate models. For most purposes, the default setting provides adequate support strength.

To change the strength of the support structure used when printing a model:

1. Select a model on the tray.
2. On the *Model Settings* ribbon, in the *Options* group, click .
or—
 - On the Model Toolbar, click .
 - or—
 - From the right-click context menu, select Advanced Properties.

The *Advanced Properties* dialog box opens.

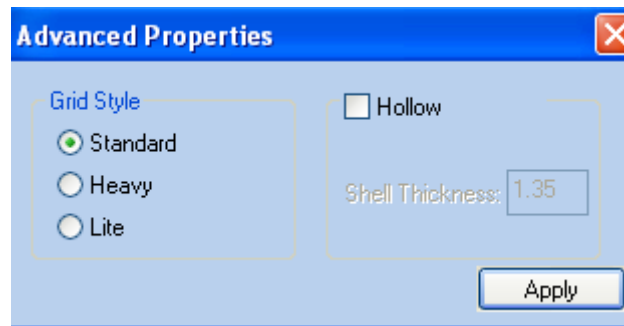


Figure 5-55: *Advanced Properties* dialog box


3. In the *Grid Style* section, choose the support strength suitable for the selected model. You can select a different support strength for each model on the tray.
 - **Standard**—for models needing average support (most models).
 - **Heavy**—for large models needing much support.
 - **Lite**—for delicate models needing little support.
4. Click Apply.

“Hollow”— Filling Models with Support Material

Many objects placed on the tray from *stl* files are “solid.” This means that, when printed, the model will be completely filled with model material. Often, especially with large objects, this is unnecessary. Instead, the model can be filled with support material, which is less costly. It is also advisable to fill models with support material when preparing them for investment casting, since this material burns off more quickly during the process of making the cast.

Objet Studio enables you to print objects on the tray with an outer shell of model material and a center filled with support material. This feature of Objet Studio is called “Hollow.” You can set the thickness of the shell—between 0.015 and 3.825 millimeters.

To use the Hollow feature:

1. Select a model on the tray.
 - or—
 - On the Model Toolbar, click .
 - or—
 - From the right-click context menu, select Advanced Properties. The *Advanced Properties* dialog box opens.

2. Select Hollow.

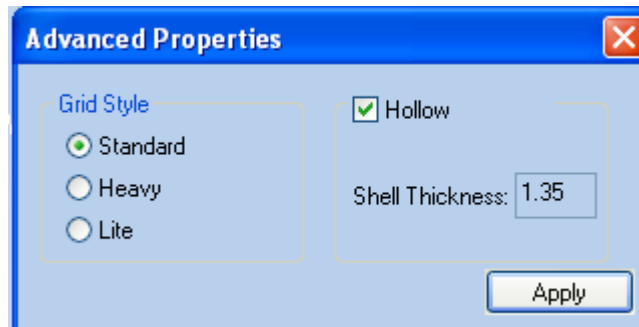


Figure 5-56: *Advanced Properties* dialog box

3. Set the shell thickness, in millimeters.
4. Click Apply.

Note: There is no change in the display of objects in Objet Studio when Hollow is selected.

To inspect, change or cancel the Hollow setting:

1. Select a model on the tray.
2. Access the *Advanced Properties* dialog box, as above.
3. If you change or cancel the Hollow setting, click Apply.

Displaying the Cross Section of Objects

The *Section* feature enables you to view the interior of an object by “slicing” it on any axis. You can then manipulate the object to inspect the interior from different angles. This may be important for deciding on the type of support necessary when producing the model (see “Choosing the Support Strength” on page 40). Displaying an object’s cross section only affects how the tray is displayed on the screen; it does not change the object itself.

To display a cross section of the tray:

1. From the *Tools* menu, select *Section*.

The *Section* dialog box opens.

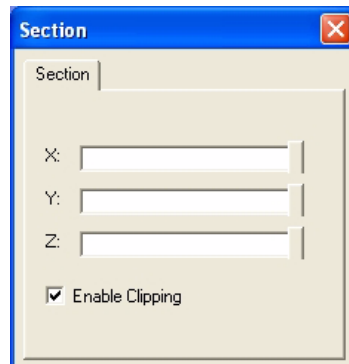


Figure 5-57: *Section* dialog box

2. Select *Enable Clipping*.
3. Use the slider controls for the X-, Y-, and Z-axes to cut the tray so that you see the cross section you want.

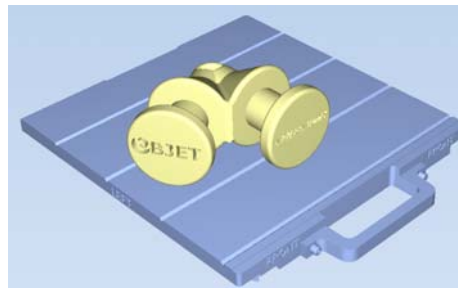


Figure 5-58: Whole view

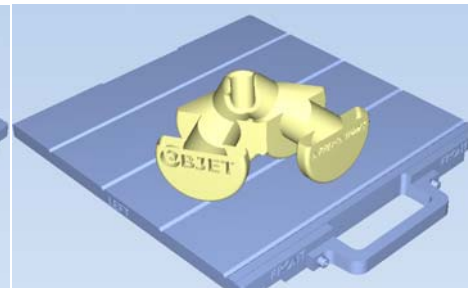


Figure 5-59: Cross-section view, after using the Z-slider

Saving the Screen Display as an Image File

You can save the image displayed in the active viewing screen as a graphic file.

To save the screen display as an image:

1. Press Ctrl+B.

or —

From the Objet Studio Commands Menu menu, select Save Bitmap.

The *Save Bitmap* dialog box opens.

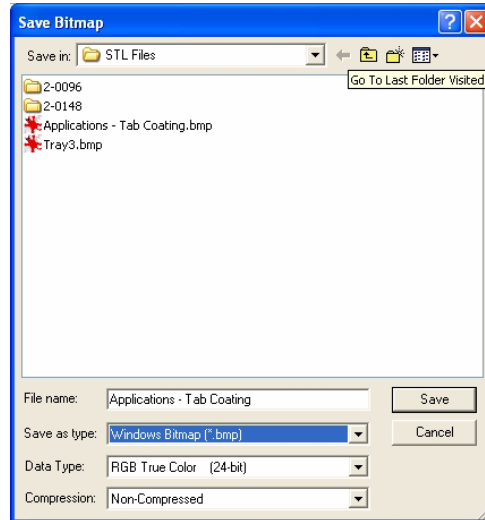


Figure 5-60: *Save Bitmap* dialog box

2. At the top of the dialog box, select the appropriate folder.
3. At the bottom of the dialog box, enter a file name.
4. Open the *Save as type* pull-down menu, and select the file format.
5. Click Save.

Exporting and Importing Objet Build Trays

When you save build trays in Objet Studio, they are saved as *objtf* files. These files contain instructions to Objet Studio and to Eden printers for displaying and producing the *stl* files used on the tray. To conveniently save all of the files that comprise the build tray, for storing the job, or for transferring it to another location, Objet Studio compresses them into one *objzf* file. To later use the *objzf* file, the file must first be expanded in Objet Studio and its component files saved.

Note: If you export an *objzf* file containing a *stl* file originally saved as read-only, you cannot open (import) this *objzf* file to the folder where the read-only *stl* file is saved.

To create an *objzf* file:

1. From the Objet Studio Commands Menu menu, select Export Packed Job.

The *Save As* dialog box opens.

2. Select the appropriate folder and change the file name (if necessary).
3. Click Save.

To open an *objzf* file:

1. From the Objet Studio Commands Menu menu, select Import Packed Job.
2. In the *Open* dialog box, display the appropriate folder and select the file.
3. In the *Browse for Folder* dialog box, display the folder in which you want Objet Studio to expand the compressed file, and click OK.

The *objtf* file and associated *stl* files are expanded and placed in the selected folder, and the tray is displayed in Objet Studio.

Customizing Objet Studio


You can customize Objet Studio to suit your particular working needs and preferences. Features that you can customize include:

- Creating a quick-access toolbar for frequently used commands.
- Changing the position of the Quick Access toolbar.
- Minimizing the ribbon.
- Changing the Objet Studio color theme.
- Configuring default settings for objects placed on the build tray.

Creating a Quick Access Toolbar

As you work with Objet Studio, you may use certain commands frequently. You can create a quick-access toolbar to make your work easier.

To create a quick-access toolbar:

1. Above the ribbon tabs, click .

The *Customize Quick Access Toolbar* menu opens.

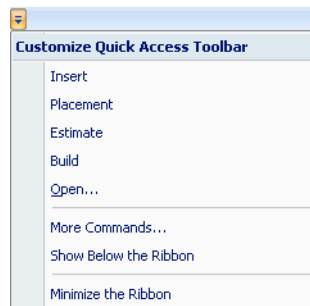


Figure 5-61: *Customize Quick Access Toolbar* menu

2. Select a command you want to add to the toolbar.

An icon for the selected command is added to the toolbar.

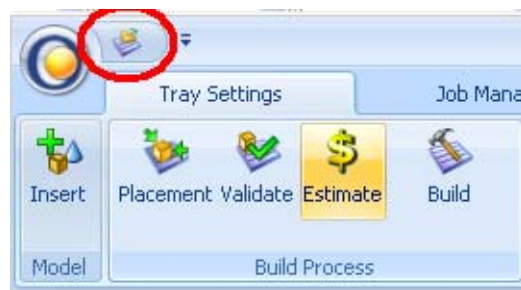


Figure 5-62: Quick Access toolbar

To add another command, repeat the above procedure.

3. To choose from a wider range of commands:
 - From the *Customize Quick Access Toolbar menu* (see figure 5-61 on page 45), select *More Commands*.
- or—
- Right-click on the *Objet Studio Commands* icon, or elsewhere on the ribbon, and select *Customize Quick Access Toolbar*.

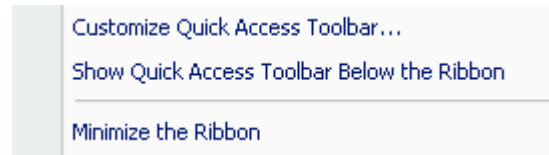


Figure 5-63: Right-click ribbon menu

The *Options* dialog box opens.

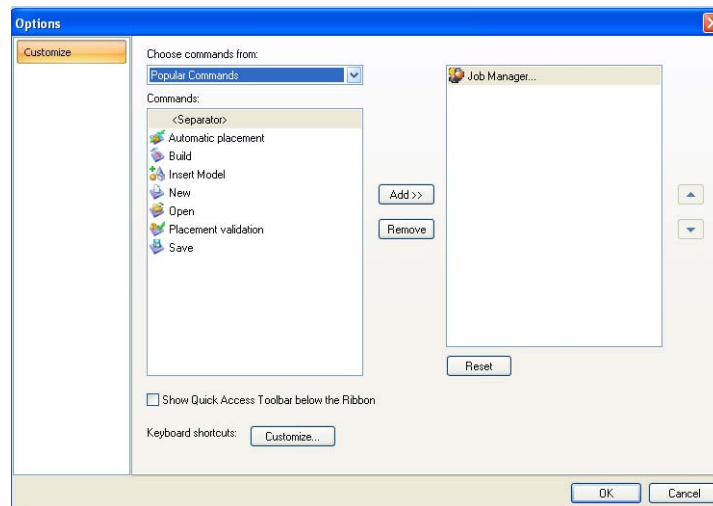



Figure 5-64: Quick Access Toolbar *Options* dialog box

4. Open the drop-down list and select either *Popular Commands* or *Commands not on the Ribbon*.
5. Select a command and click *Add*.
6. Click *OK*.

Hiding the Ribbon

To make more room for displaying the build tray, you can hide the *Objet Studio* ribbons.

To hide the ribbons:

1. Right-click anywhere on the ribbon or on the menu bar, or in the *Objet Studio Commands Menu* .
2. Select *Minimize the Ribbon*.

The ribbons disappear, but you can temporarily display the ribbon icons by clicking *Tray Settings* or *Job Manager* on the menu bar. When you next click outside of the ribbon, it disappears again.

To return the permanent ribbon display:

- Repeat the steps above to cancel *Minimize the Ribbon*.

Display Colors You can customize some of the colors used for displaying Objet Studio screens and for displaying objects on the build tray.

To change the colors used in Objet Studio screens:

1. From the *Tools* menu, select Define Colors.
The *Define Colors* dialog box appears.
2. In the *Define Colors* dialog box, click the color patch you want to change:
 - *Tray Color*.
 - *Background Colors*.
 - *Selection Color*.



Figure 5-65: *Define Colors* dialog box

3. In the *Color* dialog box, select one of the *Basic colors*.
or—

Click Define Custom Colors to expand the dialog box and allow you to define a customized color.

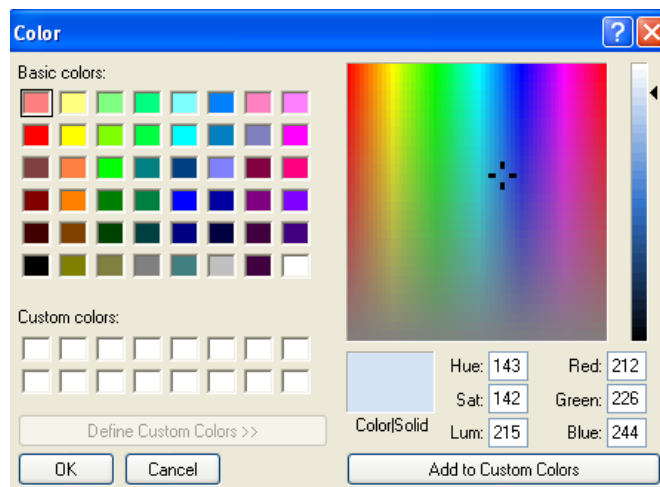


Figure 5-66: *Color* dialog box (expanded)

4. Click OK when done.
The patch color in the dialog box changes according to your selection.

Changing Color Themes Objet Studio offers a choice of four background color themes—blue, black, silver and aqua.

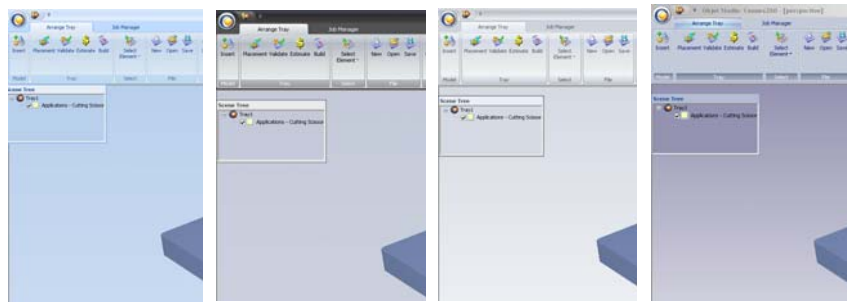


Figure 5-67: Background color themes


To change the color theme:

- From the *Style* menu, select one of the options.

Keyboard Shortcuts

You can define shortcut keys for frequently used commands.

To define shortcut keys:

1. Above the ribbon tabs, click .

The *Customize Quick Access Toolbar* menu opens.

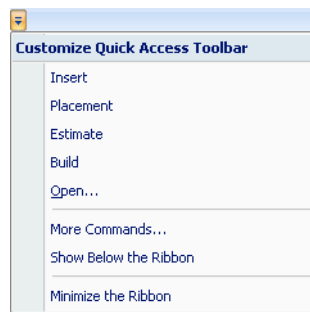


Figure 5-68: *Customize Quick Access Toolbar* menu

2. Select *More Commands*.

The *Options* dialog box opens (see figure 5-64 on page 46).

3. Click *Customize*.

The *Customize Keyboard* dialog box appears.

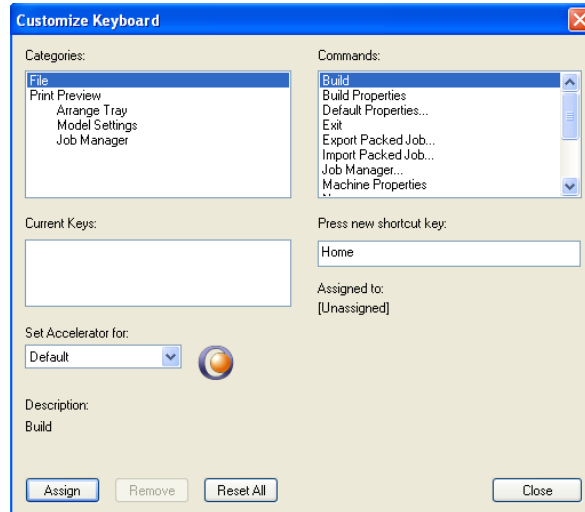


Figure 5-69: *Customize Keyboard* dialog box

4. Select command *Categories* to display all the commands in that category, for example, all the *Model Settings* commands. Current shortcut keys are displayed.
5. Enter the shortcut key in the *Press new shortcut key* field, and click *Assign*.
6. If you want to redefine all shortcut keys, click *Reset All*.

Setting User Preferences

You can change several Objet Studio settings that affect objects placed on the build tray.

To change default settings:

- From the Objet Studio Commands Menu, select *User Preferences*.

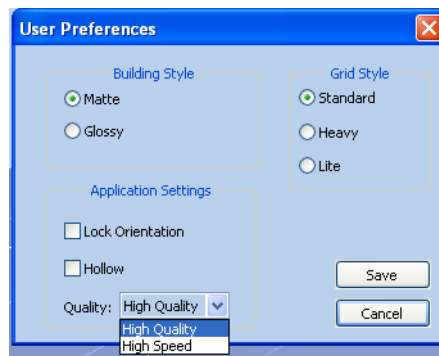


Figure 5-70: Setting work preferences

- Building Style—see “Surface Finish” on page 16.
- Grid Style—see “Using a Grid to Position Objects” on page 22.
- Application Settings—see “Choosing the Support Strength” on page 40, and “Freezing Model Orientation” on page 27.

Professional Mode Features

Some advanced features of Objet Studio are only accessible in *Professional Mode*.

To see the current Objet Studio setting:

- Open the *Tools* menu.

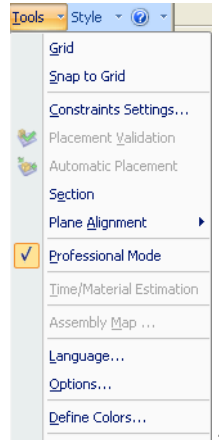


Figure 5-71: *Tools* menu, showing *Professional Mode* selected

If *Professional Mode* is checked, advanced features are displayed.

To change the *Professional Mode* setting:

1. From the *Tools* menu, select *Professional Mode*.

The following message is displayed, reminding you that the change will only take effect the *next time* you open Objet Studio—even though the check mark next to the *Professional Mode* option appears immediately.

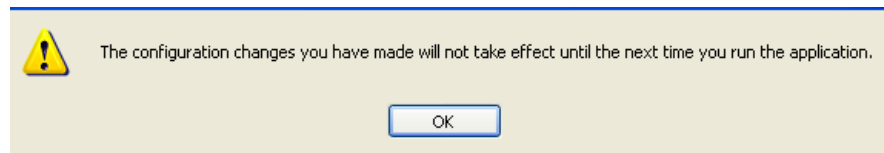


Figure 5-72: Configuration-change message

2. Close and re-open Objet Studio to use the *Professional Mode* features.

Default Settings

You can control the default settings of several Objet Studio features from the *Advanced* tab of the *Options* dialog box.

To display the *Options* dialog box

- From the *Tools* menu, select *Options*.

or—

In the *Objet Studio* Commands Menu, click *Options*.

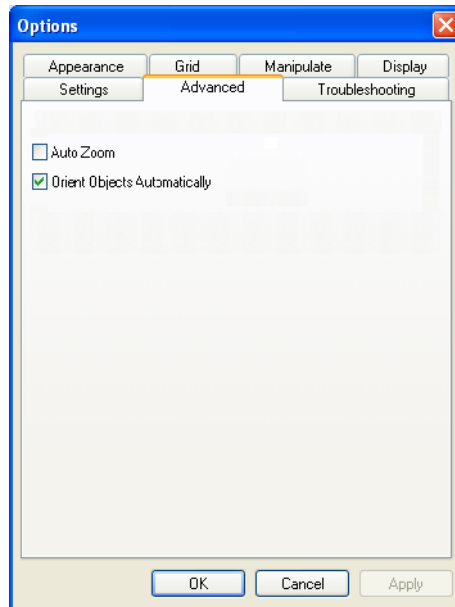


Figure 5-73: *Options* dialog box, *Advanced* tab

Automatic Orientation By default, when *Objet Studio* places objects on the build tray, it orients them optimally, for the shortest printing time. If necessary, you can choose to cancel automatic orientation each time you place an object on the build tray (see “Automatic Orientation” on page 17). In any case, when objects are on the build tray, you can change their orientation manually, if necessary—see “Model Orientation” on page 19.)

To change the default setting so that *Automatic Orientation* is disabled:

- In the *Advanced* section of the *Options* dialog box, clear the check box.

Automatic Zoom When *Auto Zoom* is selected in the *Advanced* section of the *Options* dialog box, the display zooms to display the objects placed on the build tray. This allows you to carefully inspect and manipulate the objects.

By default, this feature is **not** enabled. In any case, you can change the zoom level, as necessary (see “Zoom Options” on page 35).

Open GL Driver Configuration

The OpenGL driver displays 3-D graphics on your screen. There is normally no reason to adjust its settings. If you suspect a problem with the way Objet Studio displays objects, you can use the OpenGL Driver Configuration tool to check and configure the driver settings.

To access the *OpenGL Driver Configuration* dialog box:

1. From the *Tools* menu, select *Options*.
or—
In the *Objet Studio Commands Menu*, click *Options*.
2. In the *Options* dialog box, display the *Troubleshooting* tab.

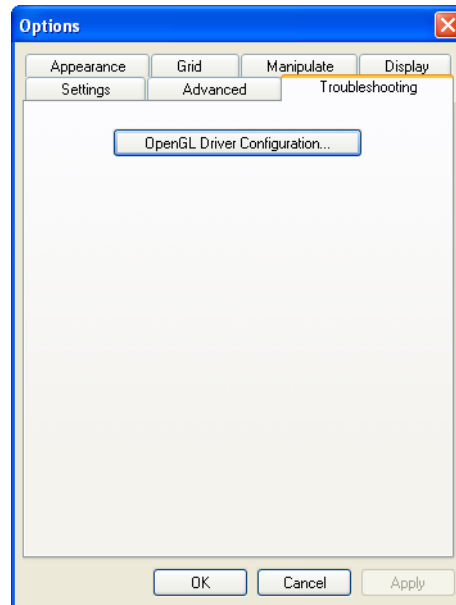


Figure 5-74: Access to GL-driver configuration



The Troubleshooting tab is only accessible when Professional Mode is active (see Professional Mode Features).

3. Click *OpenGL Driver Configuration*.
The dialog box that opens displays details of the pixel format ID (index) for the window and the memory.

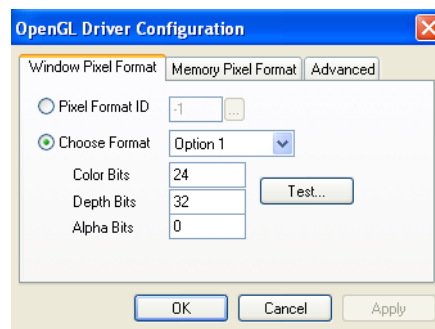



Figure 5-75: *OpenGL Driver Configuration* dialog box

If you want to display the values and change them, click .
Alternately, you can select Choose Format and change the values in this dialog box.

To perform a test of the driver configuration and enter the suggested pixel format ID:

1. Select Choose Format.
2. Click Test.

Objet Studio returns the recommended pixel format ID.

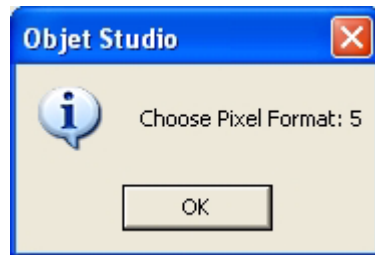


Figure 5-76: Recommended pixel format ID

3. Click OK.
4. In the OpenGL Driver Configuration dialog box (figure 5-75), select Pixel Format ID and enter this number.
5. Click Apply.
6. Display the other pixel format tab, and repeat this procedure.

Model Scaling Accuracy

Depending on your requirements, you may occasionally need to check that model scaling is accurate. If there is a deviation of 300 micrometers or more from the required measurements, you can adjust the scaling of models sent to the printer to reduce this deviation.

Note: Calibration is only enabled if you are running Objet Studio in its server configuration (see “Monitoring and Managing Print Jobs” on page 57).

Model tests and scaling calibrations should be done separately for materials with different characteristics. For example, if you calibrate Objet Studio for printing with VeroWhite (a “Rigid” material), the printer will print models accurately with all “rigid” materials. To ensure accurate printing with materials in another family, you need to calibrate with a material in that family.

To check model scaling:

1. Make sure that Professional Mode is selected in the *Tools* menu.
2. Make sure that the build tray is clear.
3. From the *Tools* menu, select Model Scaling > Load Tray for Calibration.

Objet Studio places the calibration model for your printer on the build tray.

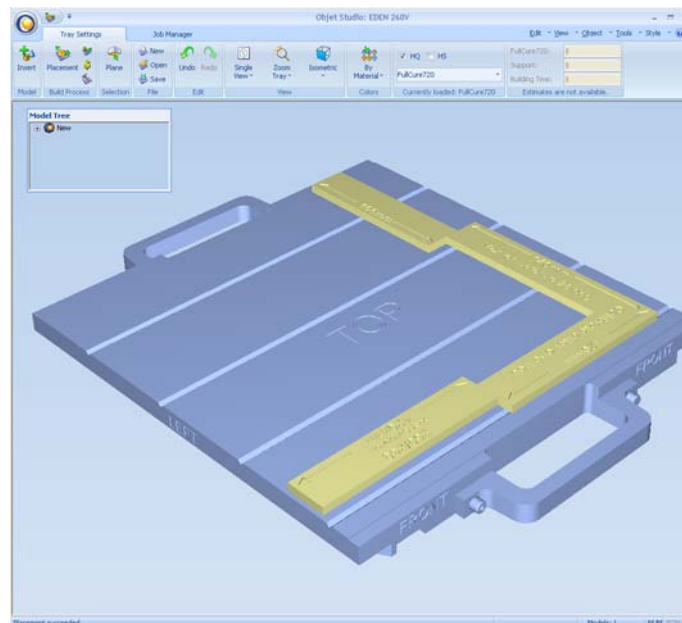



Figure 5-77: Calibration model on the build tray

4. Select the model and set its finish as Glossy (see “Surface Finish” on page 16).
5. Perform Automatic Placement (see page 18).

6. On the *Tray Settings* ribbon, in the *Build Process* group, click . The tray is sent for printing. (See “Monitoring and Managing Print Jobs” on page 57.)
7. After the printed model cools to room temperature, remove it and carefully measure the X- and Y- dimensions with a micrometer (caliper). If there is a deviation of more than 300 micrometers (0.3 mm) from the expected measurement, calibrate the model scaling.

To calibrate model scaling:

1. Make sure that Professional Mode is selected in the *Tools* menu.
2. From the *Tools* menu, select *Model Scaling > Model Scaling Calibration*.

The *Model Scaling Calibration* dialog box opens.

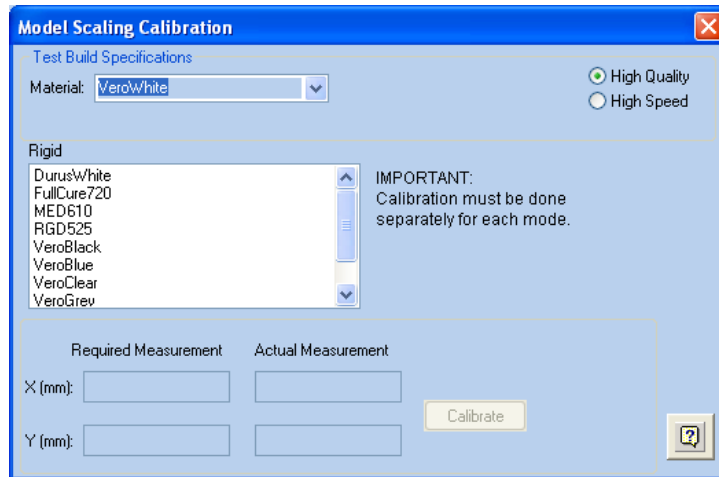


Figure 5-78: *Model Scaling Calibration* dialog box

3. Select the model material used for printing the calibrated model: For High Quality or High Speed mode, the dialog box displays all of the model materials included for this calibration.
4. Enter the model’s nominal measurement in the *Required Measurements* fields. (These measurements are on the face of the printed model)
5. Enter the *Actual Measurement*.



To calibrate only one axis: For the axis you do **not** want to calibrate, enter the same value in both the *Actual Measurement* field and in the *Required Measurement* field.

6. Click *Calibrate*.
Objet Studio adjusts the printer’s scaling parameters for the material and mode used in the calibration procedure.

Getting Additional Objet Studio Assistance

Objet Studio Help provides on-screen information, as you work.

To view Objet Studio Help:

- Press F1.

or—

On the standard toolbar, click  and then click Objet Studio Help.

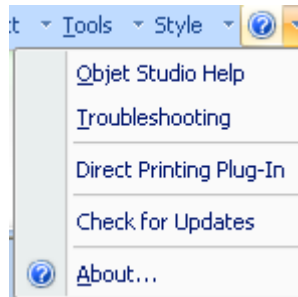


Figure 5-79: Help options

You can also view information on the following subjects:

- *Troubleshooting* opens a list of error messages and their explanations.
- *Direct Printing Plug-in* opens information on additional software programs that extend the capabilities of Objet Studio.
- *Check for Updates* checks if you are using the latest Objet Studio version.

Monitoring and Managing Print Jobs

In the *Job Manager* screen of Objet Studio, you monitor and manage jobs sent to the printer. There are a few differences between Objet Studio on client workstations and on the computer connected directly to the 3-D printer—the server workstation.

- Objet Studio installed on a client computer only displays the queue and status for jobs sent to the 3-D printer server from that computer, and it allows the user to edit only these jobs.

Note: If there are several Objet printers on the local network, client computers can connect to any of them, but only one at a time.

- Objet Studio installed on the computer directly connected to a specific 3-D printer (server), displays the queue and status for all jobs sent to that 3-D printer by the server and by all client computers on the network. It also allows editing and manipulation of all jobs, and enables re-sending previously-printed jobs to the printer.



If Objet Studio is not connected to a printer (or printer server), you can prepare tray files for any Objet printer. Later, these files can be used by Objet Studio on the appropriate printer server.

Job Manager Screen

The *Job Manager* screen on the client and server workstations looks identical. The only difference is that options only relevant to the server workstation are disabled for client installations.

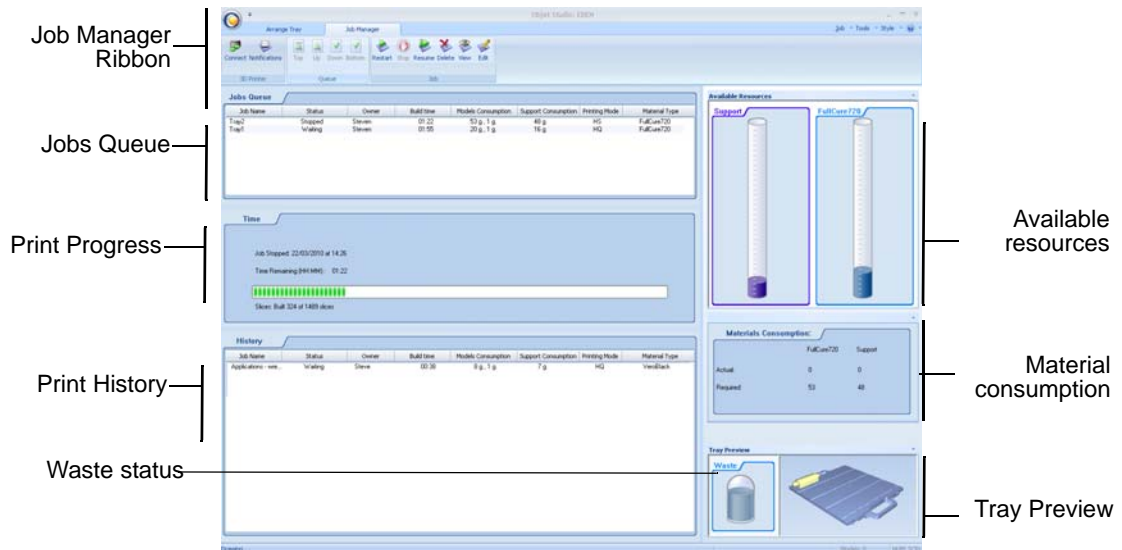


Figure 5-80: *Job Manager* screen

The *Job Manager* screen is divided into panels:

- Jobs Queue
- Print Time
- History
- Available Resources
- Material Consumption
- Tray Preview
- Waste

Jobs Queue On the server, the *Jobs Queue* lists the last 15 jobs sent from client computers. On client workstations, the *Jobs Queue* lists jobs sent from that computer to the printer server.

Information for each of the queued jobs is displayed, including the job status.

Status	Meaning
Waiting	Printing of this job has not started.
Building	Printing of this job is in progress.
Stopped	Printing of this job was interrupted. Printing can later be continued (<i>Resume</i>) or begun again (<i>Restart</i>).
Error	Errors occurred during the printing of this job, and it was placed in the Jobs Queue again.
Editing	This job is now being edited in Objet Studio.
Spooling	The job file is being spooled in the printer.
Preprocessing	The 3-D printer is readying itself for printing: the cover locks, print heads warm up and are put in starting position, UV lamps are turned on, and the build tray level is adjusted.
On Schedule	The job is scheduled to be printed at a specified time.

In addition, the following information is displayed:

- *Owner*—the computer that sent the job.
- *Build Time*—the estimated building time for the job.
- *Model Consumption*—the amount of model material required to complete the job, and the amount actually used till now.
- *Support Consumption*—the amount of support material required to complete the job, and the amount actually used till now.

Print Time The *Time* panel shows printing times and the number of slices sent to the printer.

History The *History* panel shows information for the last 50 jobs and their final status. You can drag a job from *History* to *Jobs Queue* to print the tray again.

Available Resources The *Available Resources* panel contains graphic indicators that show the amount of available printing material remaining. If you move the mouse over an indicator, the exact amount is displayed.

Material Consumption

- *Actual*—the amount of material used till now
- *Required*—the amount of material still needed to finish the job

Tray Preview The *Tray Preview* panel displays the build tray view of the job selected in the *Job Queue* or the *History* list.

On a server, you can open an enlarged preview window by clicking on the *Tray Preview* display (see “Extended Tray Preview” on page 67).

Waste If you move the mouse over the *Waste* display, the amount of waste in the container is displayed.

Setting the Printer Connection

When an Objet 3-D printer is installed, the server computer is connected to that printer. Normally, there should be no reason to change this connection. Occasionally, however, you may need to reset the connection, to connect the server to another printer, or to use Objet Studio in off-line mode (without a printer connection).

To set (or change) the printer connection:


1. On the *Job Manager* ribbon, in the *3D Printer* group, click .
2. In the *Set Printer* dialog box, click **Connect**.



Figure 5-81: Connecting to a printer (A)

3. Enter the computer name or its IP address, or click **Browse** to find and select it.

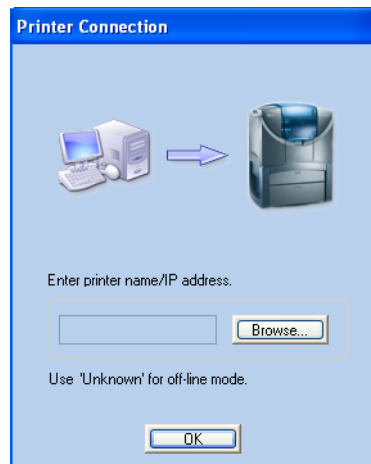


Figure 5-82: Connecting to a printer (B)

4. Click **OK**.

When the connection is established, Objet Studio is configured to prepare print jobs for that printer.




Objet Studio is connected to the printer if you can see the material levels in the *Job Manager* screen (see Figure 5-80 on page 57).

Off-line Mode

You can use Objet Studio to prepare trays for printing in off-line mode, on a remote computer or when the printer connection is not available. You also use off-line mode to prepare trays for printing with other printers. In this case, if Objet Studio is currently connected to a printer, you must change to off-line mode by removing this connection.

To disconnect Objet Studio from the printer:

1. On the *Job Manager* ribbon, in the *3D Printer* group, click  **Connect**.
2. In the *Set Printer* dialog box, click **Connect** (see figure 5-81).

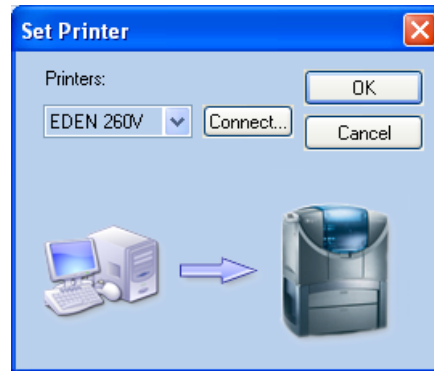


Figure 5-83: Disconnecting Objet Studio from a printer (A)

3. In the *Printer Connection* dialog box, delete the computer name/IP address.

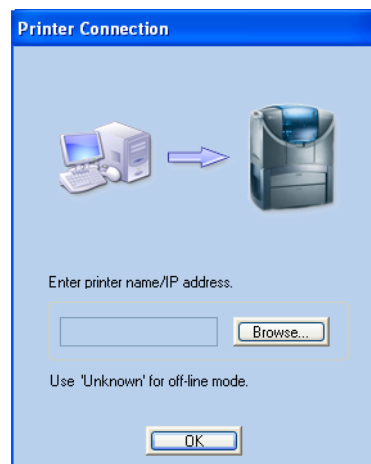


Figure 5-84: Disconnecting Objet Studio from a printer (B)

4. Click **OK**.
“Unknown” appears in the printer-name field.
5. Click **OK**.

6. In the pop-up message, confirm that you want to work in off-line mode by clicking No.

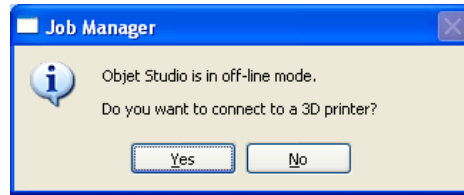


Figure 5-85: Off-line message

When Objet Studio is in off-line mode, you can configure it for preparing print jobs for different printers.

To change the Objet Studio off-line configuration:

1. In the *Set Printer* dialog box, select a printer type.

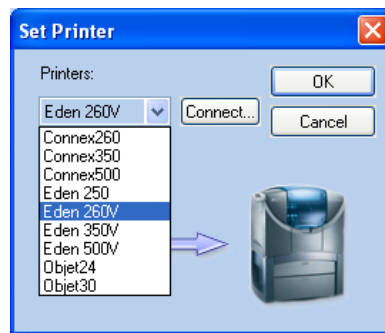



Figure 5-86: Off-line printer selection

2. Click OK.

Setting the Remote Printer Connection (Client Mode)

When you open Objet Studio for the first time in a client installation, you are prompted to connect to an Objet server computer that sends jobs to a 3D printer. To do this, the server computer must be operating and connected to the local network.

To set (or change) the connection to the server-computer:

1. On the *Job Manager* ribbon, in the *3D Printer* group, click .
2. Enter the name of the server computer or its IP address, or click **Browse** to find and select it.
3. Click **OK**.

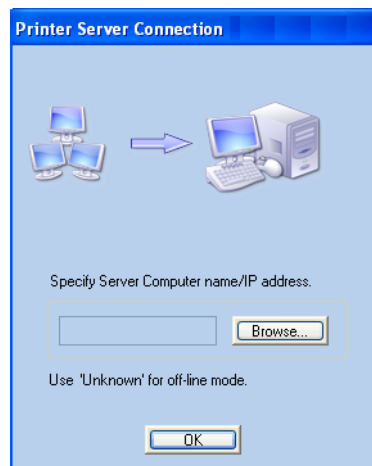


Figure 5-87: *Printer Server Connection* dialog box

Job Manager Commands

The Job Manager ribbon has three icon groups:













- 3D Printer
- Queue
- Job



Figure 5-88: *Job Manager* ribbon commands

Icons are enabled or disabled according to their relevancy. For example, you cannot stop printing a job that is not being printed, so the *Stop* command is disabled.

The following operations are available on the *Job Manager* ribbon:

Group	Icon	Purpose
3D Printer		Client: Sets the server connection. See “Setting the Remote Printer Connection (Client Mode)” on page 62. Server: Sets the printer connection. See “Setting the Printer Connection” on page 59.
		Configures options for printer alerts. See “Configuring User Alerts” on page 65.
Queue		Server: Moves a job to the head of the Jobs Queue. Client: Disabled. See “Jobs Queue” on page 58.
		Server: Moves a job to a higher position in the <i>Jobs Queue</i> . Client: Disabled. See “Jobs Queue” on page 58.
		Server: Moves a job to the bottom of the <i>Jobs Queue</i> . Client: Disabled. See “Jobs Queue” on page 58.
		Server: Moves a job to a lower position in the <i>Jobs Queue</i> . Client: Disabled. See “Jobs Queue” on page 58.
		Server: <ul style="list-style-type: none"> For a job in the <i>Jobs Queue</i>—Prints it again (from the beginning). For a job in the <i>History</i> list—Moves it to the <i>Jobs Queue</i> for printing. Client: Disabled. See “Restarting Jobs” on page 68.
	Server: Stops a job in progress. Client: Disabled.	
	Server: Continues printing the current job from the point where printing stopped. Client: Disabled. See “Resuming Jobs” on page 68.	
	Removes the selected job from the queue.	
	Refreshes the image of the selected job in the <i>Tray Preview</i> display.	
	Opens the <i>Tray Settings</i> screen and displays the tray. For deleted jobs, this enables you to make changes before printing.	

In addition to using ribbon command icons, you can use commands on context (pop-up) toolbars and from the *Job* menu on the standard toolbar.

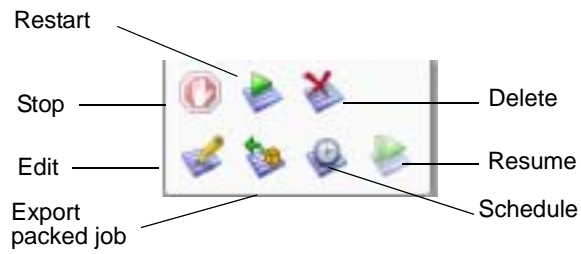


Figure 5-89: Icons on pop-up toolbar (server)



Figure 5-90: Icons on pop-up toolbar (client workstation)



When you position the cursor over an item, a tooltip displays the name of the command.



Figure 5-91: *Job* menu options (server)


Configuring User Alerts

Objet Studio can alert you (and others) to the status of jobs sent to the server for printing. This is especially useful during long printing jobs, when the operator is away from the printer. The following events can be reported:

- The level of model or support material is low.
- The job was interrupted.
- The job was completed successfully.

To send e-mail and SMS alerts, make sure that e-mail software supporting MAPI is installed on the server computer. To send SMS alerts, the cellular phone service must support the transmission of e-mail messages by SMS. Only the subject line of the e-mail message is transmitted by SMS.

To configure Objet Studio to send notifications and alerts:

1. On the *Job Manager* ribbon, in the *3D Printer* group, click  .

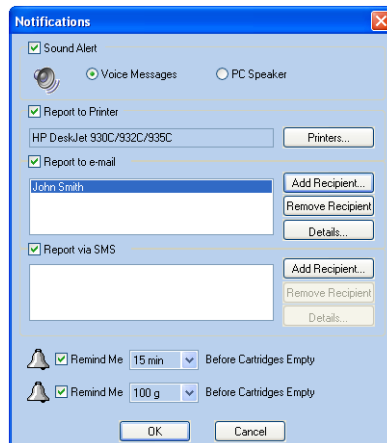


Figure 5-92: *Notifications* dialog box (server)

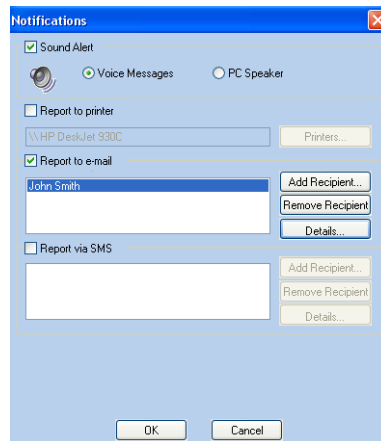


Figure 5-93: *Notifications* dialog box (client workstation)

2. Set the desired reporting options.

3. Click **Details**.

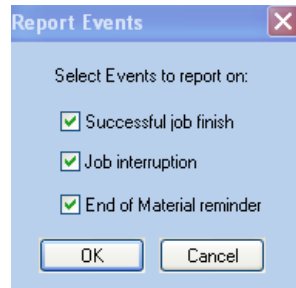


Figure 5-94: Event selection for alerts

4. In the *Reports Events* dialog box, select the alert events and click **OK**.
5. In the *Notifications* dialog box, click **OK**.

Printing the Tray

If there is a job in the Jobs Queue, it is sent automatically to the Eden printer—as long as it is on, there is a connection to the printer, and the printer is on line. Chapter 6 describes starting and operating the printer.

Additional Server Features

Object Studio on the printer servers includes the following additional features:

- Extended Tray Preview
- Editing Jobs
- Restarting Jobs
- Resuming Jobs
- Scheduling Jobs
- Exporting Jobs (objzf)
- Modifying the Job Manager Screen

These features are described on the following pages.

Extended Tray Preview

In this window, you can view the tray from different angles and magnifications without leaving the *Job Manager* screen. In addition to displaying the selected job in the *Tray Preview* pane, you can open an enlarged build tray window.

To display the build tray window:

1. Select a job in the *Jobs Queue* or the *History* list.
2. Click the *Tray Preview* pane.

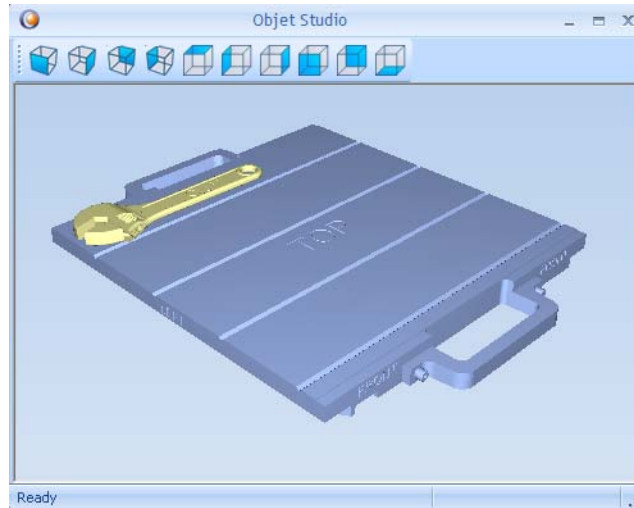


Figure 5-95: Job Preview

- To change the tray magnification, turn the mouse wheel.
- To view the tray from a different perspective, click the relevant icon.
- To resize the window, drag its edge or corners.

If there are several objects on the build tray, you can exclude one or more from being printed, without actually deleting the object from the tray file.

To prevent the printing of an object on the build tray:

1. Double-click on the object you don't want to print.
2. Display the *Build* tab.
3. Select *Exclude from Build*.

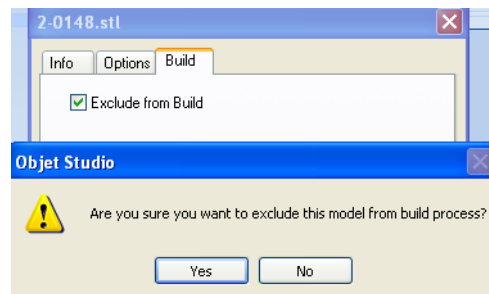


Figure 5-96: Excluding a model from the build

4. Click *Yes* to confirm.

On server computers, you can use Tray Preview to dynamically display objects as they are printed, layer by layer. This enables you to visually monitor printing progress on the computer screen.

To display printing progress in the Tray Preview pane:

- From the *Job* menu, select Show 3dProgress.




This option uses additional system resources.


Editing Jobs

You can open jobs in the *Jobs Queue* for editing.

To edit a job:

1. Select the job.
2. Click the *Edit* icon .

The *Tray Settings* screen opens, displaying the build tray. The status of the job in the *Job Manager* screen changes to “Editing.”


3. Edit the job.
4. On the *Tray Settings* ribbon, click .

The status of the job in the *Job Manager* screen changes back to “Waiting.”

Restarting Jobs

You can restart jobs from the *Jobs Queue* and the *History* list.

To restart a job:


1. Select the job.
2. Click the *Restart* icon .

The job status changes to “Waiting” (in the *Jobs Queue*).

Resuming Jobs

If the printing process is stopped or interrupted, you may be able to continue printing the job from the point where printing stopped.


To resume a job:

1. Select the job.
2. Click the *Resume* icon .

Scheduling Jobs

You can schedule jobs to be printed at a future time. For example, you can configure Objet Studio to start long printing jobs in the late evening and early morning hours.

To schedule a job:

1. Select a job in the *Jobs Queue*, and click  on the pop-up toolbar.
2. In the *Scheduler* dialog box, set the Start Date and Start Time for the job. Click on the *Start Date* arrow to open a calendar.

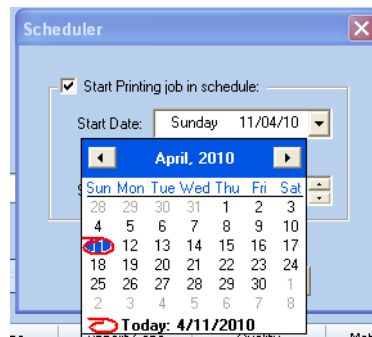


Figure 5-97: Scheduler with calendar displayed

3. Click OK.


Exporting Jobs (*objzf*)

You can save print jobs as compressed files.



For an explanation of *objzf* files, see “Exporting and Importing Objet Build Trays” on page 44.

To export a print job:

1. Select a job.
2. On the pop-up toolbar, click .
3. In the *Save As* dialog box, select a folder.
4. Click *Save*.

Modifying the Job Manager Screen

You can change the size of the sections of the *Job Manager* screen, by dragging the panel edges. This applies to:

- the *Jobs Queue* panel
- the *Time* panel
- the *History* panel

Similarly, you can change the way the screen area is divided between the main section (*Jobs Queue/Time/History*) and the panels on the right side of the screen.

You can collapse (hide) the right panels (*Available Resources/Material Consumption/Tray View*) by clicking the top of the panel.

- Click again to display the panel.

6

Operating & Maintaining the Eden260V 3-D Printer

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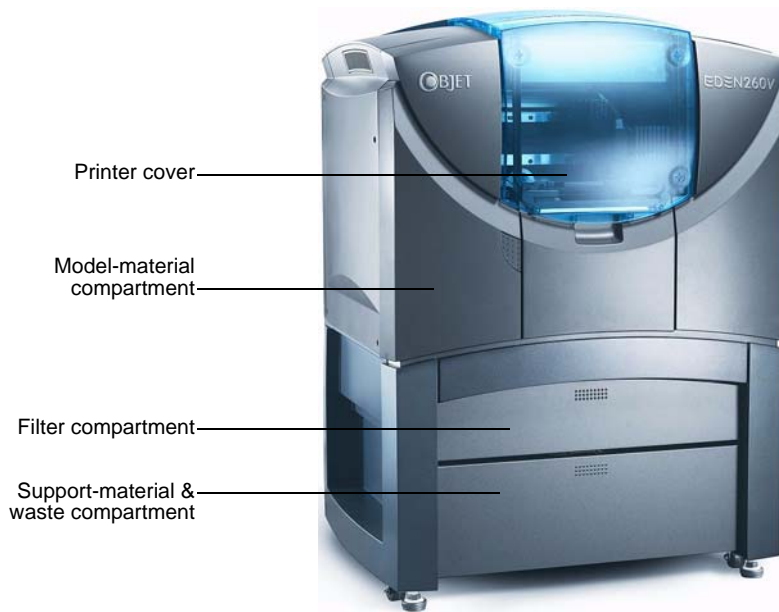


Figure 6-1: The Eden260V 3-D Printer

Starting the Eden260V Printer



CAUTION!

- Do not attempt to operate the Eden printer before being trained by a customer-support representative.
- Observe all safety warnings and follow the safety guidelines described in chapter 2.

1. Turn on the main power switch, located at the back of the printer.



Figure 6-2: Main power cable and switch

When the printer turns on, so does the built-in computer.

2. After the computer boots, log in to Windows and launch the printer-control application:
 - On the computer desktop, double-click the *Eden260V* icon.
 - or—
 - From the *Start* menu, select *Objet > Eden260V*.



A HASP plug containing a valid product activation key is required on the printer computer. This is installed at the factory or during printer upgrade. If the application does not open and a HASP message appears, contact your dealer or Customer Support.

The Eden printer interface screen opens (see figure 6-3). All monitoring and controlling of the printer is done from this interface.



Figure 6-3: Edens260V interface



Eden installations utilize one monitor for displaying both the computer running Objet Studio and the computer installed inside the printer. Make sure that the KVM (keyboard-video-mouse) switch is in the correct position so that the printer interface is displayed.

Loading Model and Support Cartridges

Eden260V printers use two cartridges of model material and two cartridges of support material, each weighing 3.6 kilograms when full. A graphical representation of the cartridges and their current weight appears in the printer interface (see figure 6-3).



The printer uses RFID technology to automatically identify the material cartridges. For this purpose, an RFID module is part of the printer hardware. Tampering with this module will render the printer inoperable and may void Stratasys warranties and service contracts.

Important: If you need to replace the model material currently installed with another type, see “Changing the Model Material” on page 6-10. Otherwise, make sure to replace the model cartridge with one containing the same type of material.

To load model and support cartridges:

1. On the front of the printer (see figure 6-1), push the door of the relevant storage compartment to release and open it.
2. If you are replacing a cartridge, grasp its handle and pull the cartridge out, taking care not to twist or turn it.
3. Load model and support cartridges into their respective compartments. (Note that the cartridges only fit into their correct compartments.)
You should feel some resistance, as a needle pierces the cartridge.
4. Check the printer interface to make sure that the new cartridge is detected and that its weight is displayed (see figure 6-3).
5. Close the storage-compartment door.

Tips about replacing cartridges:

- You can replace material cartridges either before or during printing.
- If printing stops for an extended time before you replace a material cartridge, the printer may go into *Standby* or *Idle* mode. If this happens, see “Resuming Production After Printing has Stopped” on page 9.
- You can replace partially used cartridges to avoid the need for replacing them during printing.
- You can load partially used cartridges, as long as they contain more than 100 grams of material.

Producing Models

The Eden260V printer produces models by printing tray files prepared in the Objet Studio application and sent to the printer from there. For information about preparing model files for printing, see “Using Objet Studio” or Objet Studio Help.



Before beginning to produce models, it is recommended that you check the current printing quality of the print heads by performing a pattern test (see “Pattern Test” on page 21).

To prepare the printer for producing models:

1. Make sure that the build tray in the printer is empty and clean. If not, remove old material with the scraper, and clean the tray thoroughly with cleaning fluid.



CAUTION: Use protective gloves when cleaning the build tray, and be careful of the sharp edges of the scraper blade.

2. Make sure that there is sufficient model and support material loaded in the printer, as indicated in the printer interface (see figure 6-3). You may want to replace the cartridges of model and support material currently loaded in the printer to avoid the need for replacing them during printing.

For installing material cartridges and replacing empty ones, see “Loading Model and Support Cartridges” on page 6-4.

For changing the type of model material currently loaded, see “Changing the Model Material” on page 10.

3. At the bottom of the printer interface, click the red button to switch the printer to *online* mode.

The color of the button changes from red to green (see figure 6-4). If there is a job in the Job Manager queue, it is sent to the printer.

In the printer interface, the printer mode changes from *Idle* to *Pre-print*, as the printer’s components prepare themselves for production:

- The print block is heated.
- The UV lamps are powered and they warm up.

When printing begins, Objet Studio sends seven slices to the printer. This is the standard buffer between Objet Studio and the printer. As each slice is printed, another slice is sent to the printer.

Depending on the size of the model(s) to be produced, printing can take between several hours to several days. As long as there is enough model and support material in the supply cartridges, printing proceeds automatically until the job is finished.



During printing, the server computer must remain on and it must communicate with the Eden printer. Do not log-off Windows until printing is finished.

The Eden260V printer uses one model-material cartridge and one support-material cartridge to produce models. When four cartridges are loaded in the printer, two of them are reserve, or standby, cartridges. By default, the printer first uses the cartridges with the least material in them.

➤ The active cartridges are *blue* in the printer interface.

You can monitor printer status indicators by switching the printer interface display. To do this, click the display toggle button in the printer interface screen.

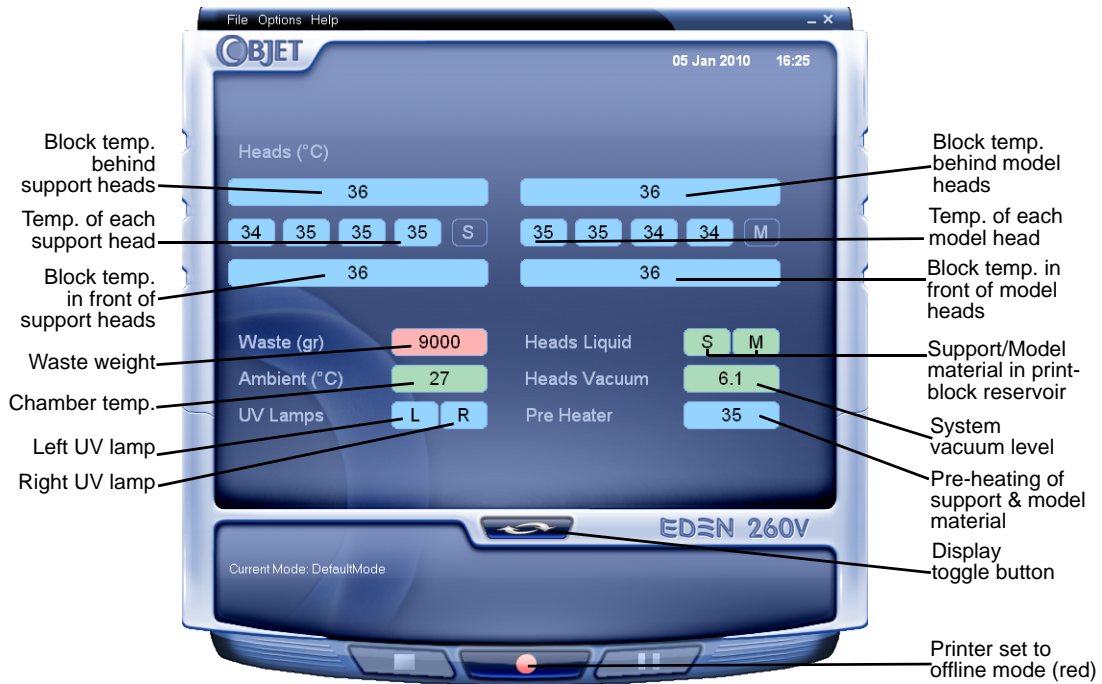


Figure 6-4: Printer indicators

Printer Interface Color Key

The background colors in the printer indicator fields tell you at a glance whether or not the value or item is suitable or ready for printing.

- *Green*—suitable/ready for printing

For example, in figure 6-4:

- Ambient*—The ambient temperature of the printing chamber is within the acceptable range.
- Heads Liquid*—The level of model and support material in the print-block reservoir is OK.
- Heads Vacuum*—The vacuum level in the system is within the acceptable range.
- Pre-Heater*—The model and support resins need to be heated before being supplied to the print block. The temperature has reached the acceptable range.

- *Red*—not suitable for printing (or indicates a warning)

For example, in figure 6-4:

- Waste*—The weight of the waste container is 7300 grams, more than allowed when beginning a print job. (See “Replacing the Waste Container” on page 6-61.)

- *Blue*—not ready

For example, in figure 6-4:

- UV lamps*—The UV lamps are not on.
- Heads (°C)*—The heads have not reached the temperature required for printing models (in printing mode).

The color of the material cartridges displayed in the printer interface indicates which cartridges are active for the current (or next) print job.

- *Blue*—active cartridges
- *Gray*—reserve cartridges

Printing Indicators

The printer interface screen changes when you send a print job from Objet Studio to the printer, and the printer is *on line* (see figure 6-5):

- The mode changes from *Pre-print* to *Printing*.
- The specific activity being performed is shown in the “current activity” field.
- Current job-printing information is displayed.
- The printing progress bar is displayed.
- The *Stop* and *Pause* buttons are enabled.

When the weight of a cartridge drops below 100 grams, the display of the material level in the printer interface is *red*.



Figure 6-5: Printer interface during printing


Resuming Production After Printing has Stopped

If the printing process is interrupted, Objet Studio stops sending slices to the printer. This can happen, for example, if the printing material runs out in the middle of a print job, and you don't replace the empty cartridge immediately. After the printer changes to *Standby* or *Idle* mode, you need to resume printing from the *Job Manager* screen of Objet Studio.



After printing stops, the printer goes into *Standby* mode, when heating of print heads is reduced. About 10 hours later, the printer goes into *Idle* mode, when heating of print heads is stopped.

To continue printing the model:

1. If the printer is in offline mode, switch it to online mode by clicking the red button at the bottom of the printer interface (see figure 6-3 on page 3).
The button changes from red to green (see figure 6-4 on page 6).
2. If you don't know why printing has stopped, make sure that the connection between the printer and the server computer is active.
3. In the *Job Manager* screen of Objet Studio, click the *Resume* icon .
4. In the *Continue from Slice* dialog box that appears, confirm the slice number, after checking the printer interface.

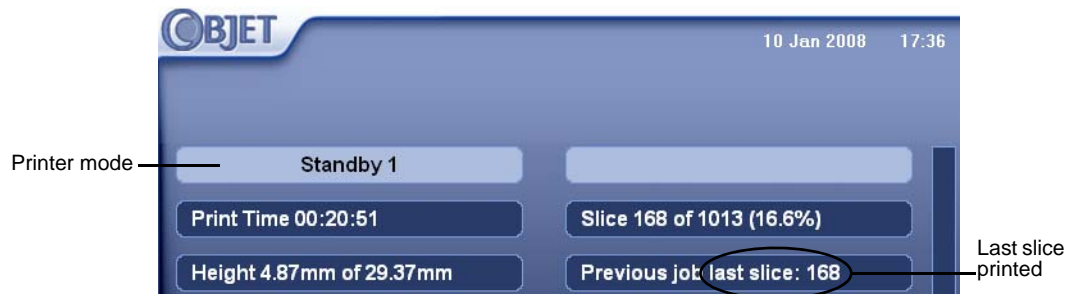


Figure 6-6: Printer interface after interrupted printing

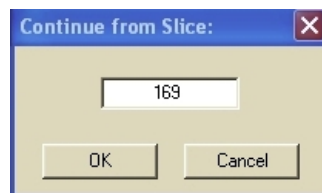


Figure 6-7: *Continue from Slice* confirmation in Objet Studio (*Job Manager* screen)

5. If, for any reason, the correct number does not appear in the dialog box, enter the number and click OK.

You cannot continue printing the model if:

- The number of the last slice printed does not appear in the printer interface, even if the server computer displays the *Continue from Slice* confirmation dialog box.
- There was a relatively long interruption in printing, even if the “last slice” and “continue from slice” indicators are correct. The part of the model already printed may deform or shrink, and there might be a visible difference between it and the newly printed part. The effects of a

printing stoppage on a model depend on the model size and structure, model material used, ambient temperature and the length of the stoppage.

If you cannot continue printing:

1. Cancel the print job in the *Job Manager* screen.
2. Remove the partially printed model from the build tray.
3. Send the job to the printer again.



You can stop and later resume printing from either the printer interface or from the *Job Manager* screen of *Objet Studio*, since both applications are updated when you use these commands. However, after clicking the *Pause* button in the printer interface, you can only resume printing from the printer interface.

Changing the Model Material

Before producing models using a different type of model material (resin) than is currently installed, run the Material Replacement Wizard to flush the print block and feed tubes.



You should carefully plan printing models with different model materials to avoid unnecessary waste of the material loaded in the printer. The amount of material flushed depends on the flushing cycle chosen and if you are replacing one or both cartridges.

To replace the model material:

1. Start the Material Replacement Wizard from the *Options* menu.



Figure 6-8: Starting the Material Replacement Wizard from the *Options* menu

2. In the opening screen, click *Next*.
3. If the printer cover is not closed, a screen appears instructing you to close the cover. Confirm that it is closed and click *Next*.

- In the *Compartment Selection* screen, select an option for changing either cartridge or both cartridges, and click Next.

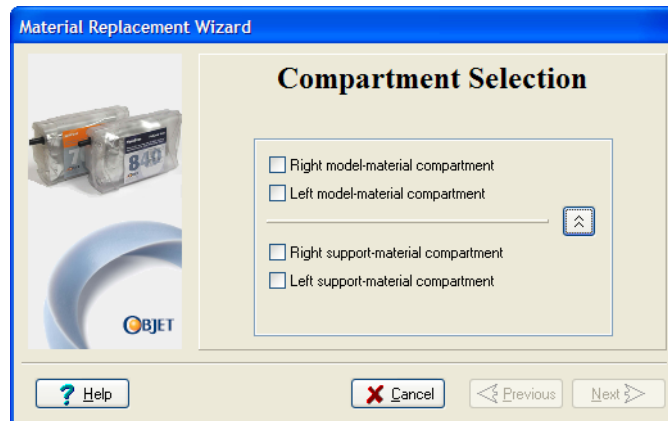


Figure 6-9: *Compartment Selection* screen

- From the drop-down menu, choose the model material you want to install, and click Next.

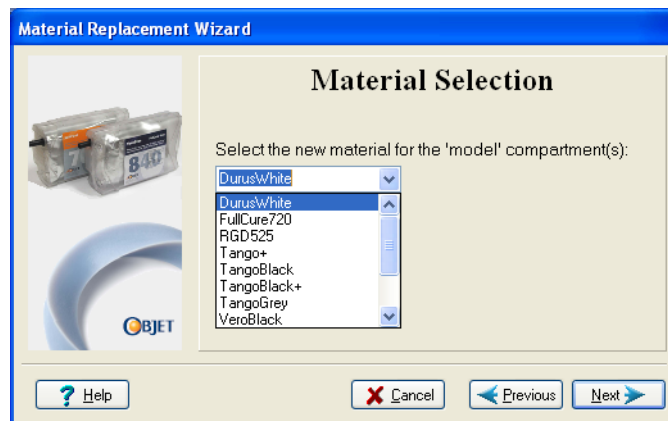


Figure 6-10: *Material Selection* screen

Note: This selection automatically affects the default material setting in Objet Studio.

6. In the *Flushing Options* screen, choose the appropriate cycle for the model material you want to install.



Figure 6-11: *Flushing Options* screen

- *Economy*. During this cycle, which takes about 20 minutes, the pump purges the model material from the print block, then flushes the system with the new material.

Since traces of the previous material may be present in the first models printed with the new material, this cycle is usually acceptable when replacing a light-colored model material with a darker material (such as TangoBlack™ or VeroBlack™), or if the exact color of the printed models is unimportant. However, this cycle ensures that models will have the *mechanical properties* of the new material.

- *High-performance*. During this cycle, which takes about 55 minutes, the wizard cleans the feed tubes and print block more thoroughly by flushing the system with more material.

This cycle ensures that models will have the *color* (and the mechanical properties) of the new material, when replacing a dark-colored material (such as TangoBlack or VeroBlack) with a lighter-colored material.

- Click **Next**, and take note of the warning screen.

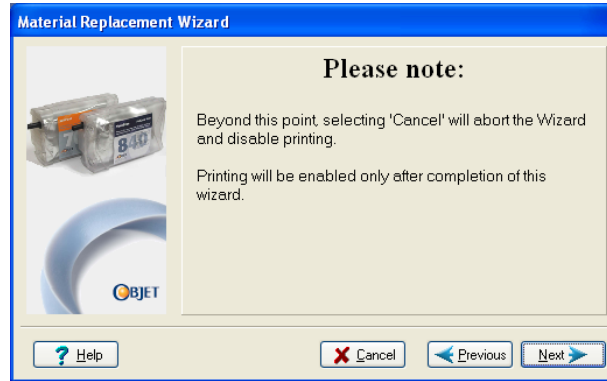


Figure 6-12: Material Replacement warning screen



Once you start this procedure, you must complete it before you can produce models with the Eden printer. To perform the procedure at another time, click **Cancel**. If you continue (by clicking **Next**) and you do not complete the procedure, you must start the Material Replacement Wizard again before producing models.

- To continue, click **Next**.
- When prompted by the wizard screen, remove the material cartridge and load the replacement cartridge for the required compartment(s). Confirm and click **Next**.



Figure 6-13: *Remove Cartridge* confirmation screen

If the printer does not identify the replacement cartridge(s), the following wizard screen appears.



Figure 6-14: Prompt to load new model cartridges

After identifying the cartridge(s), the printer begins filling the print heads with the new model material.

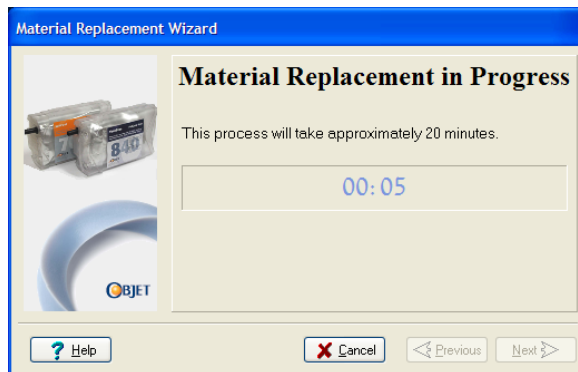


Figure 6-15: Material replacement: filling heads with new material

10. When the final wizard screen appears, make sure that the screen displays the newly-loaded material(s). Click Done to close the wizard.



CAUTION: Dispose of all material cartridges in accordance with all applicable laws and regulations. If necessary, the cartridges can be disassembled for recycling. If this is done, protect the person handling the cartridges from direct exposure to uncured resins.

The printer-control interface is automatically updated, and should display the new material(s). The Objet Studio interface (on the printer-server workstation) is also updated.

Keeping the Printer in Idle Mode

Between printing jobs, the Eden260V printer can be kept on for up to one week. If the printer will not be used for more than a week, use the Shutdown Wizard to automatically perform the procedures that must be done before turning off the printer (see “Shutting Down the Printer,” below).

When the printer stops producing models, the printer software automatically reduces the temperature of the print heads as follows:

Time after printing	Mode	Change in heating of print heads
first 15 minutes	<i>Standby 1</i>	none
next 10 hours	<i>Standby 2</i>	heating reduced (to room temp.)
after 10 hours	<i>Idle</i>	heating stopped

Note: The printer mode is indicated in the green field on the left of the interface (see figures 6-3, 6-4 and 6-5 on pages 3, 6 and 8).

If, after printing a job, you know that the printer will not be used for 10 hours or more, you can immediately turn off the heating of the print heads by putting the printer into *Idle* mode.

To put the printer into *Idle* mode:

- From the *File* menu (in the printer interface) click Exit.

Note: The printer remains in *Idle* mode until you open the Eden printer application and begin printing again.



When the printer is in *Idle* mode, do **not** turn it off. It can remain in this mode—with the cover closed—for up to a week. For longer periods, shut down the printer by running the Shutdown Wizard (see below).

Shutting Down the Printer

You only need to shut down the Eden printer if it will not be used for a week or more. Otherwise, the printer can remain on, in *Idle* mode. To properly shut down, the printer needs to perform several processes. These are controlled by the Shutdown Wizard. **Do not attempt to shut down the printer by simply closing the computer interface (the printer-control application), and never disconnect power to the printer before completing this wizard.**

Depending on the length of time the printer will not be used, you can choose between a short shutdown procedure, and a more thorough procedure.

- **Up to 10 days:** The wizard empties the print block of model and support material, to prevent leaks. This takes about 10 minutes.
- **More than 10 days:** The wizard empties the print block, then flushes the system with cleaning fluid. This takes up to 35 minutes, and you must be present to load cleaning-fluid cartridges when instructed.

To run the Shutdown Wizard:

1. Select Shutdown from the *Options* menu, or press F8.



Figure 6-16: Shutdown Wizard, opening dialog box

2. In the opening wizard screen, click **Next**.
3. Choose the appropriate option for the length of time that the printer will not be used—less or more than ten days.
Note: Before selecting *More than 10 days*, make sure that cleaning-fluid cartridges are available.
4. In the next screen, verify that the tray is empty and click **Next**.

The shutdown procedure begins.



Figure 6-17: Shutdown progress screen

5. When the final wizard screen appears, close the printer-control application and shut down the built-in computer.



Figure 6-18: Final Shutdown Wizard screen

6. After the printer computer shuts down, turn off the main power switch (at the back of the printer).

Maintaining the Printer

The performance of routine maintenance tasks is essential for getting satisfactory results from Eden 3-D printers. Perform the tasks at specified intervals for optimum performance.

Routine Maintenance Schedule

Frequency	Task	For More Information
Daily, before printing	Clean the print heads.	See "Cleaning the Print Heads" on page 6-19.
Weekly	Clean the build tray and the surrounding area.	
Weekly	Perform the Pattern test.	See "Pattern Test" on page 6-21.
Weekly	Clean and inspect the wiper.	See "Cleaning and Replacing the Wiper" on page 6-23.
Weekly	Restart the printer computer and the server computer.	
Weekly	Clean the roller waste collector.	See "Cleaning the Roller Waste Collector and Inspecting the Roller Scraper" on page 6-25.
Monthly, and after replacing print heads	Check the alignment of the print heads.	See "Aligning the Print Heads" on page 6-30.
Monthly	Calibrate the load cells.	See "Calibrating the Load Cells" on page 6-49.
Monthly	Inspect the exhaust system (duct, fan, connections).	
Every 2000 hours of printing, or once a year	Preventive maintenance visit by authorized service engineer.	Contact your support center.

Cleaning the Print Heads

Periodic inspection and cleaning of the orifice plates on the bottom of the print block ensures that the print nozzles are not clogged. A wizard guides you through the procedure, and adjusts components of the printer to enable you to perform it. This procedure takes about 20 minutes, and should be done at the beginning of the work day or before a big printing job.

To clean the print heads:

1. Prepare—
 - isopropanol (IPA— isopropyl alcohol) or ethanol (ethyl alcohol)
 - disposable cleaning gloves
 - a Stratasys-supplied cleaning cloth or equivalent
 - a mirror
2. Start the Heads Cleaning Wizard from the *Options* menu (see figure 6-25 on page 23).
3. Follow the instructions on the wizard screens, and select the check boxes to confirm that:
 - you have checked that the tray is empty.
 - you have closed the cover.



Figure 6-19: Head cleaning procedure—wizard screen

4. Click Next.
The printer prepares for you to clean the print heads.

- When the following screen appears, open the cover.



Figure 6-20: Head cleaning wizard—steps 5–10



WARNING: The print head orifice plates (bottom surface) may be hot. Do not touch them with your bare hands, and proceed with caution.

- Place the mirror on the build tray.
- Put on the gloves.
- Soak the cleaning cloth with the cleaning fluid.
- Clean the orifice plates, with a back-and-forth motion (see figure 6-21). Use the mirror to make sure that you have removed all of the residue material.

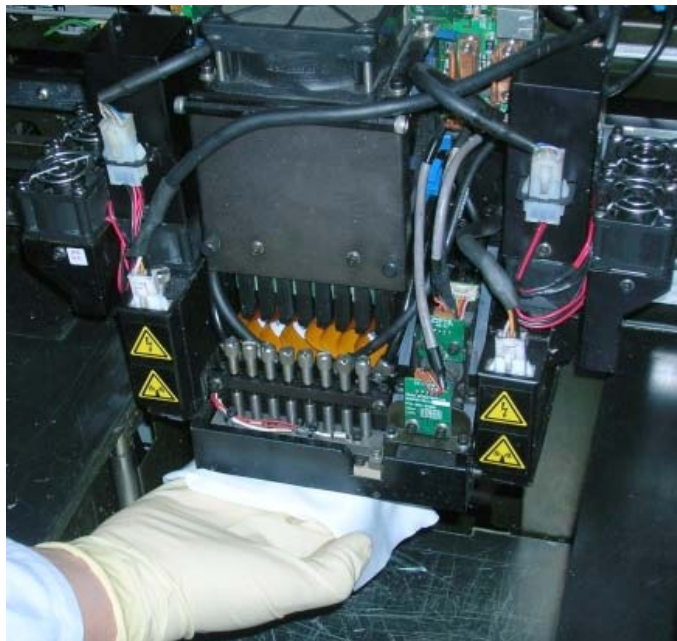


Figure 6-21: Cleaning the heads



It is recommended that you use this opportunity to also clean the roller and the UV lamps.

10. When you have finished cleaning, select the confirmation check box in the wizard screen (see figure 6-20) and click **Next**.
11. Remove the cleaning materials from the printer and close the cover.
12. Select the confirmation check boxes in the wizard screen and click **Next**.

The head-purge cycle begins. When this is complete, the final wizard screen appears.



Figure 6-22: Head-cleaning wizard—final screen

13. Click **Done** to close the wizard.

Pattern Test

The pattern test is the basic verification of the printer's ability to produce quality models, since it demonstrates the condition of the nozzles in the print heads. Make sure, therefore, that you perform this test weekly, and whenever you suspect a printing problem.

To perform the pattern test:

1. Make sure that the build tray is empty.
2. Prepare a sheet of pink paper—A-4 or Letter size.
3. In the printer, tape the pink paper to the center of the build tray.
4. Press F3, or open the *Options* menu and select **Pattern Test**.

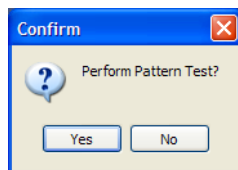


Figure 6-23: Pattern Test confirmation

The printer prints a series of lines on the test paper (see next figure).

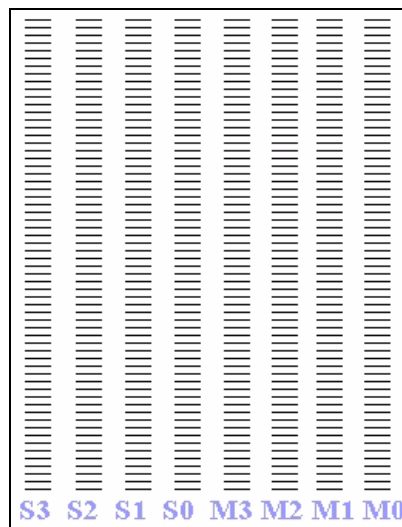


Figure 6-24: Sample Pattern Test

5. Carefully inspect the test paper to see if there are missing lines. Too many missing lines, especially if they are in the same area, indicates that the quality of printing when producing models will be poor. If this is the case, see “Improving Print Quality,” below.

Note: Acceptable model quality is subjective, and depends on the type and scale (size) of the models produced. As a rule, however, more than 10 missing lines in one area of a column is considered unacceptable.

Improving Print Quality

If you suspect that print quality is poor, perform the pattern test (see “Pattern Test” on page 6-21). If the results are poor, use the following procedure to improve print quality.

If the results of the last pattern test are poor:

1. From the *Options* menu, select *Execute Purge Sequence*, or press F4.
2. In the confirmation dialog box, click *Yes*.
The print heads are purged of model and support material, and the wiper removes excess material from them.
3. Repeat the purge sequence.
4. Perform the pattern test.

If the results of the pattern test are still poor:

1. Manually clean the print heads (see “Cleaning the Print Heads” on page 6-19).
2. Perform the purge sequence.
3. Perform the pattern test.

If the results of the pattern test are still poor:

1. Carefully clean the print heads again, making sure there is no residue left on them.
2. Perform the purge sequence.
3. Perform the pattern test.

Cleaning and Replacing the Wiper

If the results of the pattern test are still poor:

- Optimize the print heads and replace faulty print heads, if necessary (see “Calibrating Print Heads” on page 6-34).

A rubber wiper removes excess material from the print heads after the purge sequence. This is done automatically before each print job, and performed manually during maintenance tasks. You should clean the wiper and surrounding area at least once a week. If the wiper is damaged or worn, replace it.

To inspect and clean the wiper:

1. Prepare—
 - isopropanol (IPA— isopropyl alcohol) or ethanol (ethyl alcohol)
 - disposable cleaning gloves
 - a Stratasys-supplied cleaning cloth or equivalent
 - a spare wiper
2. Start the Wiper Cleaning Wizard from the *Options* menu.



Figure 6-25: Starting the Wiper Cleaning Wizard

3. Close the printer cover, and click Next in the wizard screen.
4. Make sure that the build tray is empty, and close the printer cover.

Confirm this in the wizard screen.

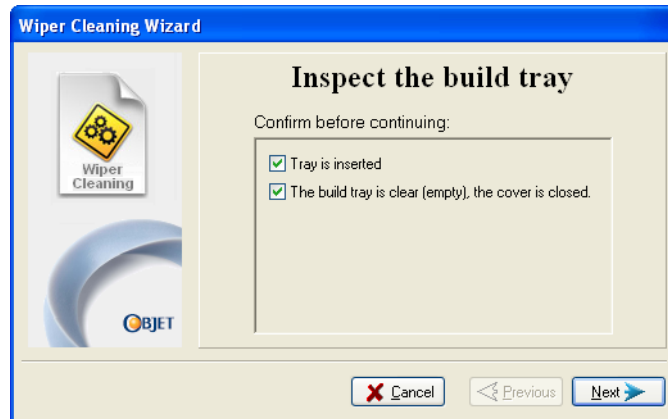


Figure 6-26: Wiper Cleaning procedure—step 4

5. Click Next.
6. When the following screen appears, open the cover.



Figure 6-27: Wiper Cleaning Wizard during steps 7–10

7. Put on the cleaning gloves.
8. Using a generous amount of cleaning fluid and the cleaning cloth, remove any material remaining on the wiper and the surrounding area.
9. Inspect the wiper.
 - If the wiper is scratched, torn or worn, or if you cannot clean it completely, replace it.
 - a. Grasp it and pull it up and out of its bracket.
 - b. Insert the new wiper blade, *making sure that it is straight and secured well on both sides.*
10. In the wizard screen (see figure 6-27), confirm that the wiper blade is clean, and click Next.
11. Make sure that you have removed all tools and cleaning materials from the printer, and close the cover.

12. Select the confirmation check boxes in the wizard screen and click Next.



Figure 6-28: Wiper Cleaning procedure—final screen

13. Click Done to close the wizard.

Cleaning the Roller Waste Collector and Inspecting the Roller Scraper

The roller waste collector removes waste material scraped from the roller. Suction removes this waste to the printer's waste container.

This assembly should be cleaned weekly to prevent a blockage in the tubes leading to the waste container, so that waste material does not overflow into the printer.

To clean the roller waste collector:

1. Prepare—
 - M2.5 and M2 Allen keys
 - disposable cleaning gloves
 - isopropanol (IPA— isopropyl alcohol) or ethanol (ethyl alcohol)
 - cleaning cloth
 - cotton swabs (Q-tips[®] or similar)
2. Put on the gloves.

3. Remove the right UV-lamp assembly:
 - a. Disconnect the UV power cable and the fan power cable.

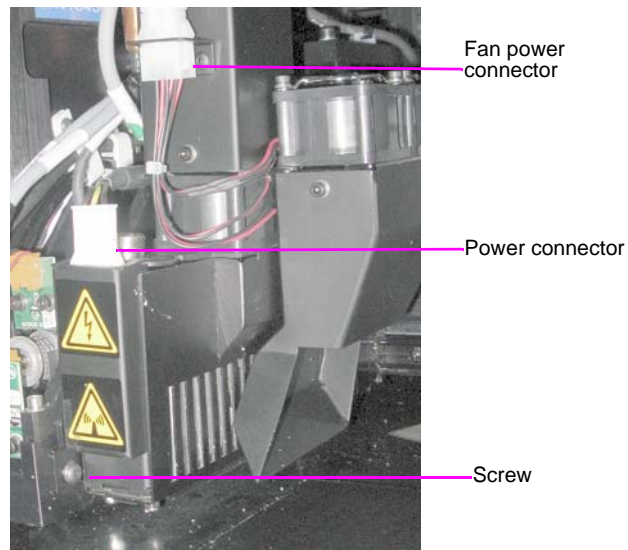


Figure 6-29: Disconnecting the right UV assembly

- b. Remove the screw attaching the right UV lamp to the print block, and then pull and lift up the UV lamp.
4. Loosen the two screws securing the suction tube on the print block.

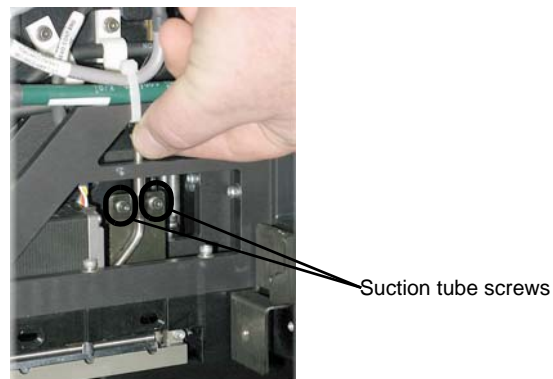


Figure 6-30: Lifting the suction tube

5. Lift the suction tube to secure it in a raised position.

- Remove the two screws securing the covering of the roller waste collector and remove it.



Be very careful to save the covering screws. These are special screws; if they are lost you need to order replacements.

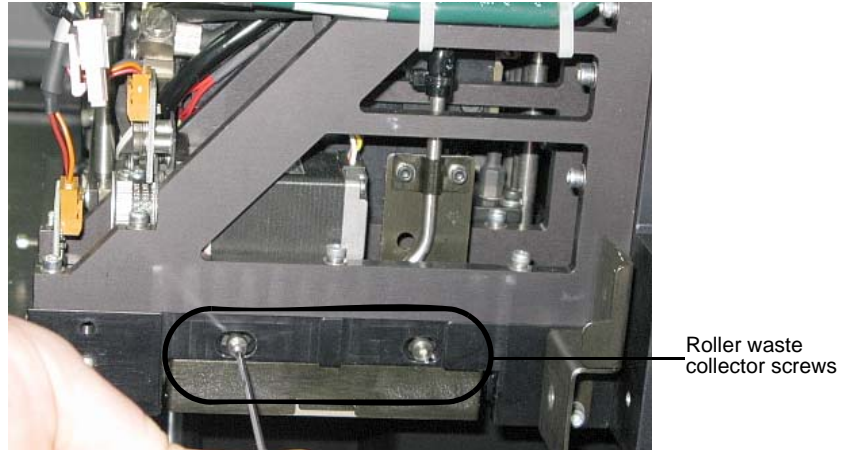


Figure 6-31: Removing the roller waste collector covering

- Remove the covering by pulling it out, and then lower it.
- Clean the roller waste collector and the scraper blade surface using cotton swabs. Make sure to remove any remaining printing materials.

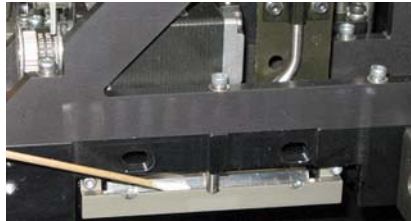


Figure 6-32: Cleaning the roller waste collector



Before replacing the covering you can check the effectiveness of the roller scraper—see below.

To check the effectiveness of the roller scraper:

- Put on the cleaning gloves.
- Wet a cloth with isopropanol.
- Use the cloth to wet the bottom of the roller.
- Turn the roller slowly with your hand. As the blade scrapes the roller, make sure the isopropanol is spread evenly over the entire length of the blade.
- Inspect the roller. If it is not dry, replace the blade. (See “Replacing the Roller Scraper” on page 6-28.)

6. Before returning the roller waste collector to the print block, make sure that the pins are clean.

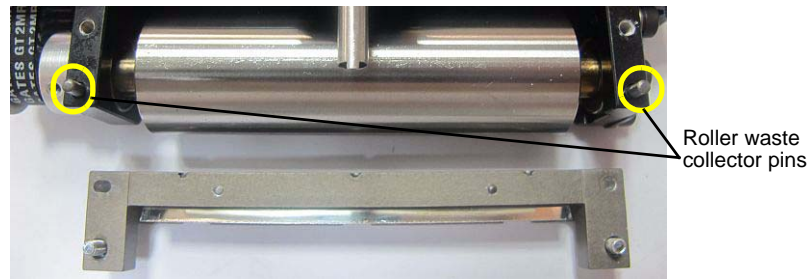


Figure 6-33: Roller waste collector pins

7. Return the roller waste collector to the print block and screw on the covering (see figure 6-31 on page 6-27).
8. Loosen the screws securing the suction tube.

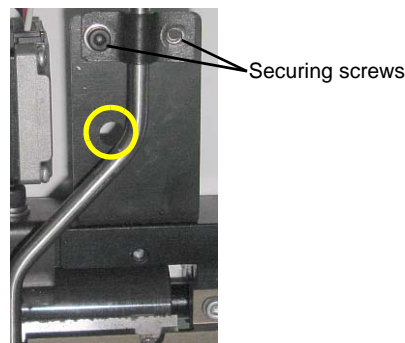


Figure 6-34: Suction tube correctly positioned

9. Lower it so that the hole in the panel behind the suction tube is visible, and tighten the screws to secure the tube.
10. Attach the right-UV-lamp assembly to the print block and reconnect the UV power and fan cables.

Replacing the Roller Scraper

You should replace the roller scraper blade:

- after 1,000 hours of printing.
- if it does not effectively keep the roller clean.



You should periodically test the effectiveness of the roller scraper when you clean the roller waste collector. See “Cleaning the Roller Waste Collector and Inspecting the Roller Scraper” on page 25.

To replace the roller scraper:

1. Prepare—
 - a new roller scraper (knife) (KIT-01026-S)
 - a Phillips 1x75 mm screwdriver
 - M2.5 and M2 Allen keys
2. Remove the right UV lamp and the roller waste collector covering (see steps 3 to 6 on page 6-26.)

- Loosen the two screws securing the roller waste collector and pull it out.

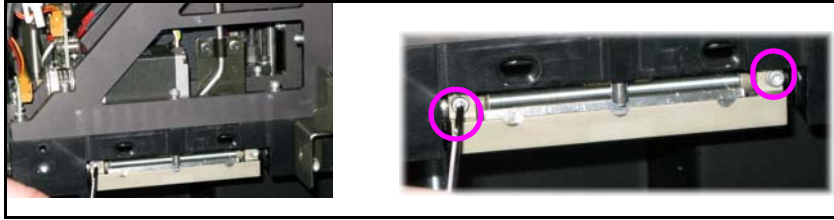


Figure 6-35: Removing the roller waste collector

- Remove the screws that secure the roller scraper assembly.

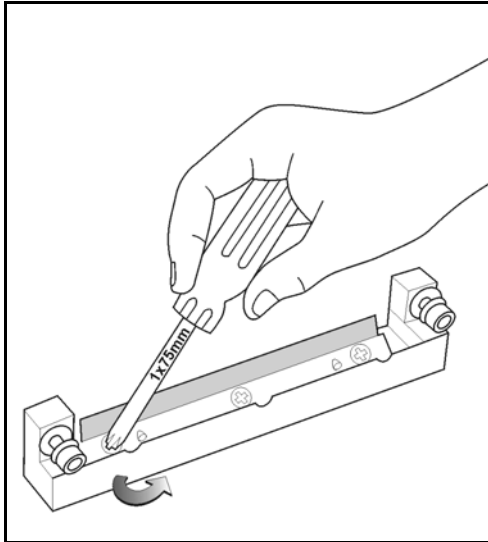


Figure 6-36: Removing the roller scraper screws

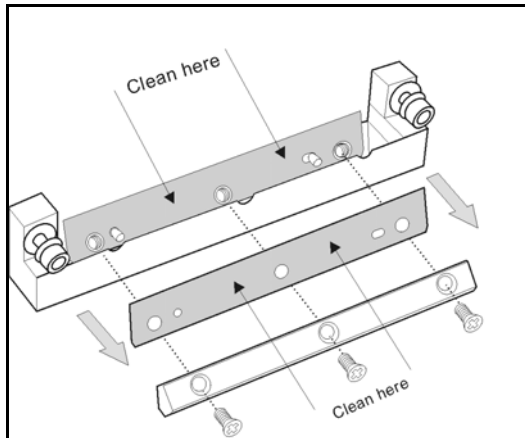


Figure 6-37: Removing the old roller scraper blade

- Remove the scraper blade and discard it.

- Place the new scraper blade onto the pins in the holder, as shown.

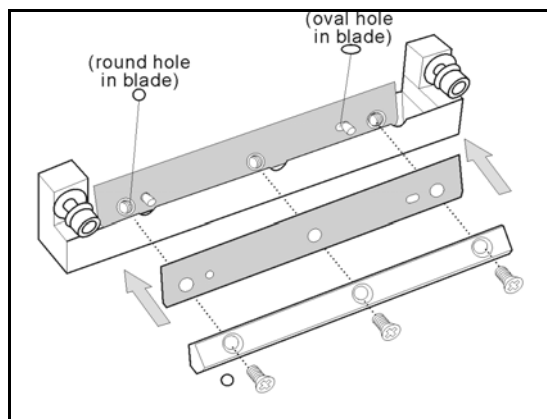


Figure 6-38: Inserting the new roller scraper blade

- Insert and tighten the roller scraper blade screws.

Important:

- Tighten the screws in the order shown in figure 6-39.
- Use the new screws supplied in the replacement kit.

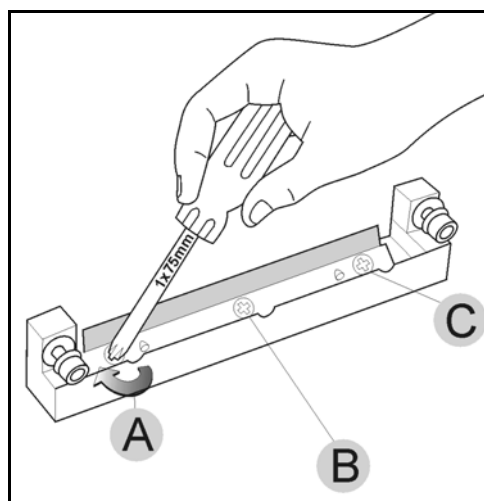


Figure 6-39: Tightening the roller scraper screws

- After tightening the screws, inspect the blade and make sure that it is straight. If necessary, loosen the screws and tighten them again, evenly.
- Return the roller waste collector assembly and the right UV lamp to the print block. See steps 6 to 10, from page 6-28.

Aligning the Print Heads

You should check the alignment of the print heads—

- once a month
- after replacing one or more heads
- if model quality is not acceptable even after cleaning the orifice plate on the bottom of the print block (see “Cleaning the Print Heads” on page 6-19)

The head-alignment procedure takes about 20 minutes.

To check the alignment of the print heads:

1. Prepare—
 - a transparency sheet—A-4 or Letter size
 - any type of sticky tape, to fasten the transparency sheet to the build tray
2. Start the Head Alignment Wizard from the *Options* menu (see figure 6-25 on page 23).
3. Click **Next** to begin, and close the cover.
4. In the wizard screen, select the check box to confirm that the cover is closed, and click **Next**.
5. When instructed to do so, place the transparency on the build tray—next to the left and rear edges of the tray, as shown in the following figure.

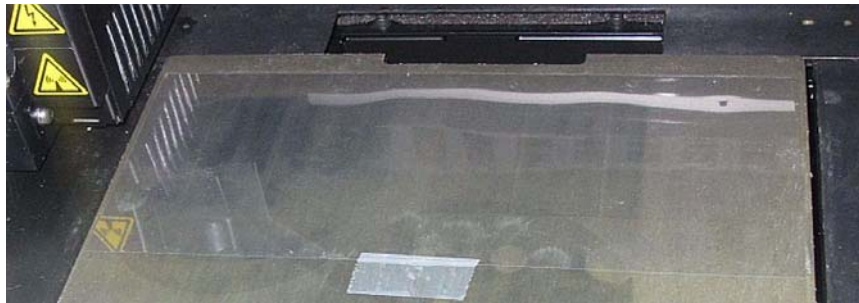


Figure 6-40: Positioning the transparency on the build tray

6. Make sure that the transparency sheet is lying flat, and tape it to the tray.
7. In the wizard screen, select the check box to confirm that the transparency sheet is on the build tray, and click **Next**.
The printer prints the head alignment test on the transparency.
8. When the following screen appears, remove the transparency.

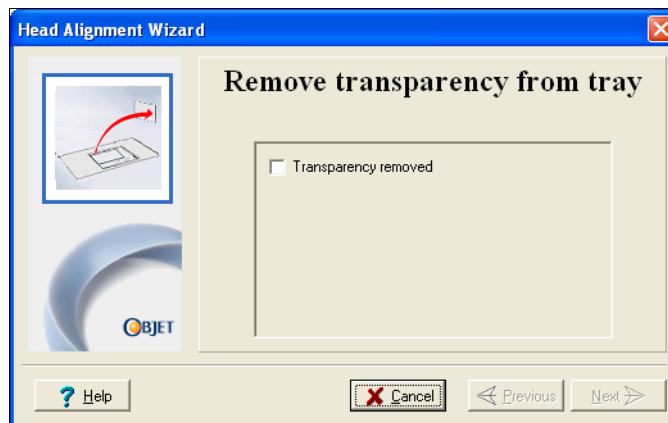


Figure 6-41: Head Alignment Wizard—steps 8–10

The transparency sheet is printed with sets of vertical lines in seven columns, each showing the results from a different print head.

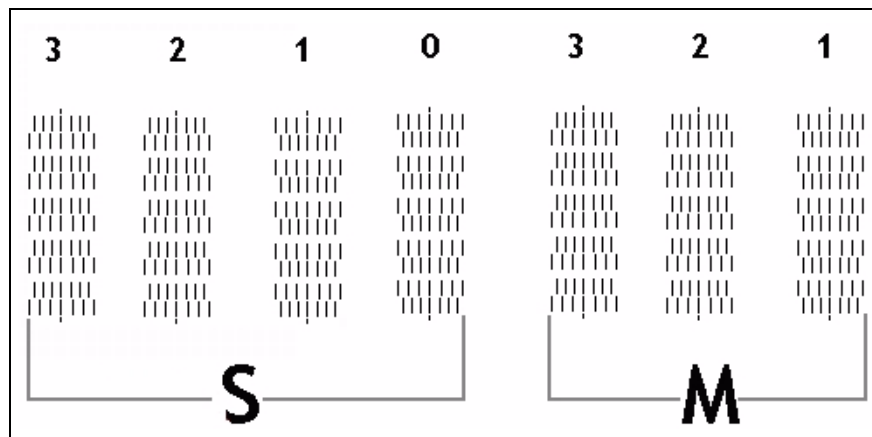


Figure 6-42: Sample head-alignment test

- The three columns on the right were printed by the heads used for applying model material when producing models. From right to left, the columns represent heads M1, M2, M3, respectively. (There is no column for head M0 because its alignment is used as a reference for aligning all other heads.)
 - The four columns of lines on the left were printed by the heads used for applying support material. The columns represent heads S3, S2, S1 and S0, respectively.
9. For each column of lines, use a magnifying glass or loupe to inspect pairs of consecutive rows printed on the transparency to see where the vertical lines align.

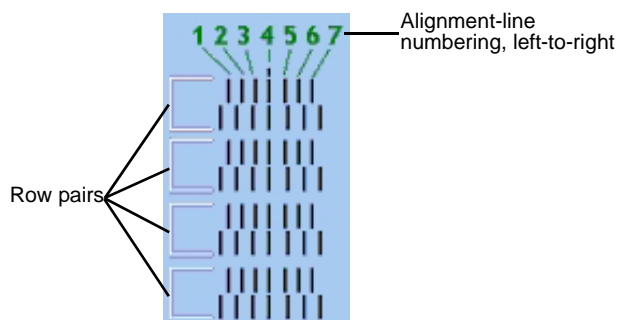


Figure 6-43: Comparing rows of alignment lines

Note: It does not matter which pair of lines you inspect, since they were all printed by the same head. Choose a pair of clearly printed lines for the inspection. (Since some nozzles may not print clearly, you may have to inspect several pairs of lines to properly view the alignment.)

Optimum head alignment is shown when the *fourth* lines in the upper and lower rows are aligned, as in figure 6-43. In the example shown, no change to the head alignment is necessary. If other lines in the set are aligned, you need to change the alignment of that head—in the next wizard screens.

10. In the wizard screen shown in figure 6-41, select the *Transparency removed* check box, and click Next.

The first in a series of alignment screens appears.



Figure 6-44: Head alignment screen

11. In the head-alignment screen, select the number that indicates which lines align in the upper and lower rows of a pair on the transparency (counting from the left) for this print head.
Note: Because the alignment of the fourth lines is optimum, the number “4” is selected, by default, in the wizard screen. This does not change the head alignment. If you select other numbers, the wizard adjusts the head alignment, accordingly.
12. Click Next to display the next head alignment screen, and again select the number representing the most closely aligned vertical lines on the transparency for that print head.

When you have finished aligning all of the heads, the following screen is displayed.

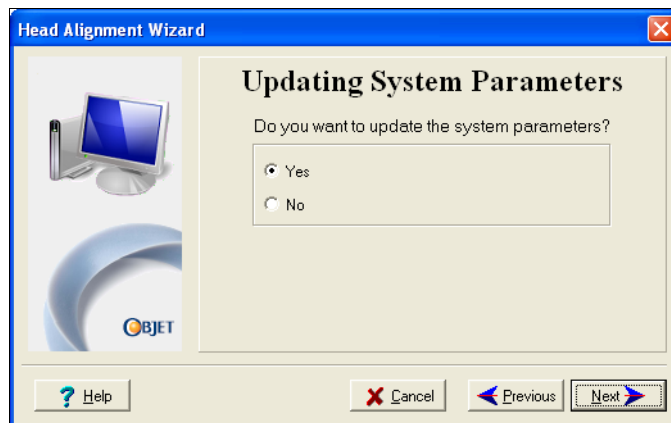


Figure 6-45: Update confirmation screen

13. Continue as follows:
 - To make the alignment changes in the printer, make sure that *Yes* is selected, and click Next.
 - To recheck the alignment test results before making the alignment changes in the printer, click Previous.
 - If you do not want to make alignment changes in the printer at this time, select *No* and click Next.

14. In the final wizard screen, choose to either repeat the head alignment procedure or close the wizard.

- If the most closely aligned vertical lines for a print head were at either extreme—the first or seventh lines—choose *Yes* to run the Head Alignment Wizard again, then click *Next*.

The transparency test will show if the heads are now properly aligned, and—if not—the wizard will allow you to “fine tune” the alignment.

- If the vertical lines for the print heads were not aligned at either extreme, choose *No* to close the wizard, then click *Next*.



Figure 6-46: Final Head Alignment Wizard screen

Calibrating Print Heads

The condition of the print heads directly affects the quality of printed models. To maintain optimum printing, you should routinely test the print heads, and calibrate them to the best working configuration possible. You do this by running the Head Optimization Wizard.

During the optimization process, 32 samples are printed on the build tray. After carefully weighing each of them, you enter the weight in the wizard's data-entry screen. The wizard uses this data to optimize the heads.

If, during the optimization process, the wizard determines that a print head is faulty—or that it is negatively affecting layer uniformity with the current head configuration—the wizard instructs you to replace it. If this happens, you can continue the wizard (to replace the print head) or abort the wizard (to replace the head at another time).



Run the Head Optimization Wizard whenever the condition of print heads is negatively affecting the quality of printed models, or if you suspect that there is a problem with one or more of the print heads.

To test and calibrate the print heads:

1. Prepare—
 - isopropanol (IPA— isopropyl alcohol) or ethanol (ethyl alcohol)
 - disposable cleaning gloves
 - a Stratasys-supplied cleaing cloth or equivalent
 - a mirror
 - the scale supplied by Stratsys for use in the Weight Test

2. Start the Head Optimization Wizard from the *Options* menu of the printer interface.



Figure 6-47: Starting the Head Optimization Wizard

3. In the opening wizard screen, click Next to begin.
The *Wizard Conditions* screen appears.
4. Read the conditions, select *I Agree* and click Next.
5. Close the printer cover, and confirm this in the wizard screen.
6. In the following screen, make sure *Optimize all print heads* is selected, and click Next.

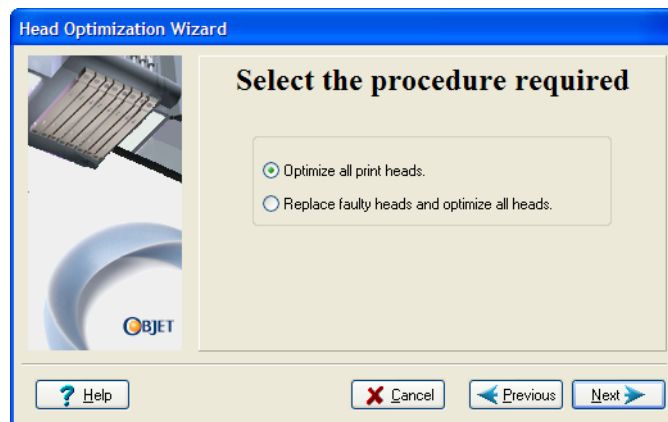


Figure 6-48: Procedure selection screen

The print block moves into position for cleaning and inspecting the print heads.

7. When the following screen appears, clean the print heads.



WARNING: The print head orifice plates (bottom surface) may be hot. Do not touch them with your bare hands, and proceed with caution.

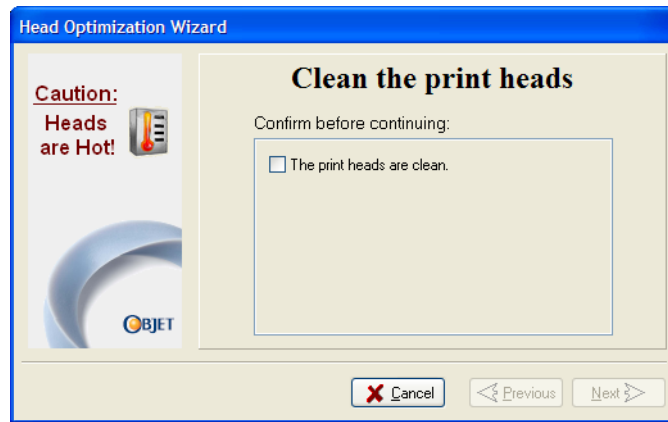


Figure 6-49: Clean print heads screen

8. Place the mirror on the build tray.
9. Put on the cleaning gloves.
10. Soak the cleaning cloth with the cleaning fluid (alcohol).
11. Clean the orifice plates, with a back-and-forth motion.

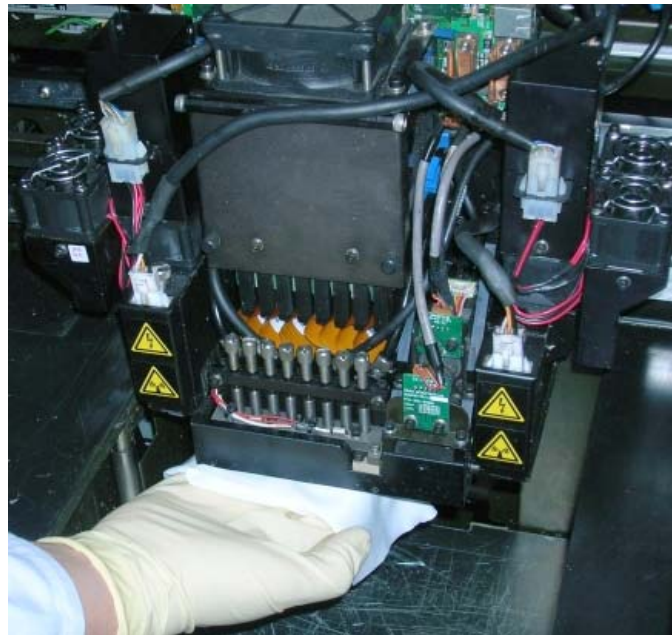


Figure 6-50: Cleaning the print heads

Use the mirror to make sure that you have removed all of the residue material.

12. When the print heads are clean, select the confirmation check box in the wizard screen and click Next.

13. Remove the cleaning materials from the printer, and close the cover.

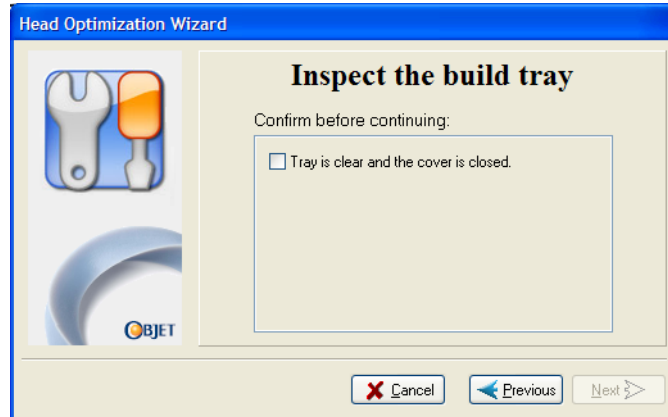


Figure 6-51: Confirmation screen

14. Select the confirmation check box in the wizard screen and click Next. The head-purge cycle runs, after which the Weight Test is printed.

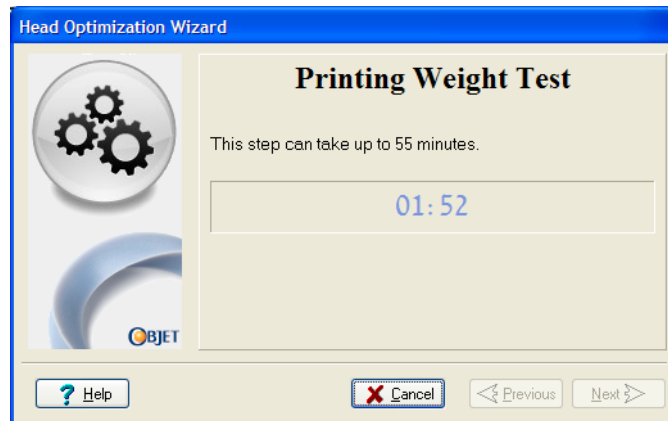


Figure 6-52: Printing Weight Test

32 samples are printed on the build tray, four for each of the print heads. This can take up to 55 minutes.

15. When the following screen appears, open the printer cover. Enter the data that describes the condition of each print head, after inspecting each of the printed samples.

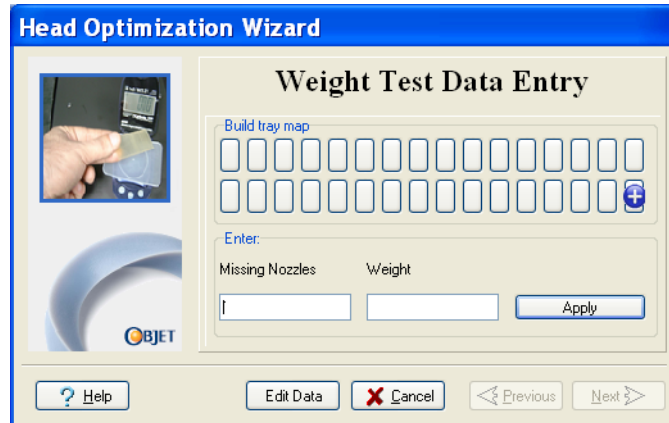



Figure 6-53: Weight Test Data Entry screen



The layout of the data entry screen matches the printed samples on the build tray. Enter the data for the sample indicated by  in the screen.

- a. Enter the number of faulty (“missing”) nozzles.

Faulty nozzles are seen in Weight Test samples as a missing row of printed material. Compare the height of the missing row with the lines printed on the “missing nozzles” ruler. Enter the number next to the line that most closely matches the height of the missing row.

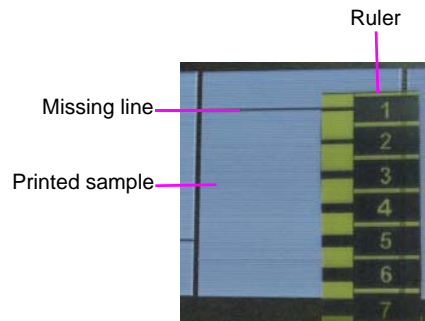



Figure 6-54: Measuring the missing line in a printed sample

In the example above, you would enter “1” in the wizard screen.

- b. Carefully remove the sample, weigh it, and enter the weight in the wizard screen.
Be sure to remove and weigh the entire sample, even if it breaks into several pieces.
 - c. Click Apply or press Enter.
The data-entry-indicator  moves to the next position.
 - d. Repeat these steps for all 32 samples.
To change an entry, click Edit Data, enter the correct data, and click Save.
16. When you have entered the all of the data in the wizard screen, click Next.

The wizard uses the data you entered to analyze the condition of the print heads, and optimizes them so they print models with a uniform layer of material. If the heads are in satisfactory condition, the final wizard screen appears.

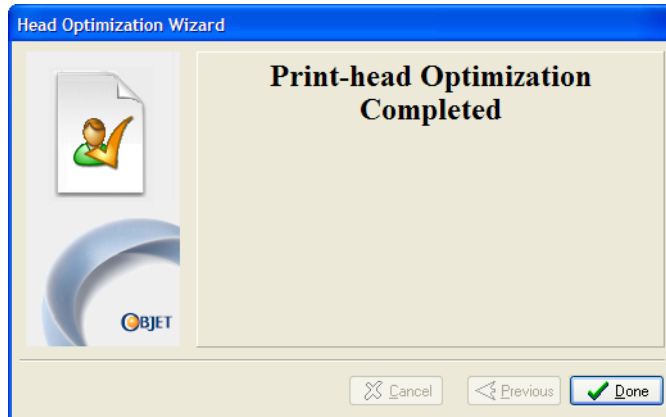


Figure 6-55: Final wizard screen, after optimizing print heads

However, if the wizard determines that a print head is faulty—or that it is negatively affecting model quality with the current head configuration—the wizard instructs you to replace it. In this case, the following screen appears.



Figure 6-56: Defective print heads found

17. Choose *Replace defective head(s)* if you are prepared to replace the print heads now.

or—

Choose *Abort wizard* if you want to replace the print heads at another time.



Replacing print heads is expensive. Replace them only after consulting with an authorized customer-support engineer.

If you are replacing the print heads now, the wizard guides you through the procedure when you click Next. Continue with “Preparing the Print Block” on page 6-41.

Replacing Print Heads

The condition of the print heads directly affects the quality of printed models. You need to replace a print head if one or more of the following symptoms occurs:

- The Head Optimization Wizard determines that one or more print heads are defective. (See “Calibrating Print Heads” on page 34.)
- There are noticeable grooves in the surface of printed models.
- Visual inspection of the head reveals that its surface is damaged—peeling or bubbles in the nozzle area.
- The printer interface displays a warning or malfunction message relating to a print head—
 - Head Heater temperature timeout
 - Head Heater thermistor open
 - Head Heater thermistor short

The Head Optimization Wizard guides you through the procedure of replacing a print head, and adjusts components of the printer to enable you to perform it. Only replace a print head with the aid of the wizard. The procedure takes 75–90 minutes, and consists of the following phases:

- A. Identifying the head(s) needing replacement.

This is normally done by the Head Optimization Wizard. Otherwise, evidence of physical damage to the head surface or a malfunction message indicates which head needs replacing.
- B. Preparing the print block for head replacement.

This is done automatically when you run the Wizard.
- C. Removing the defective print head.
- D. Installing a new print head.
- E. Optimizing the print heads (done automatically by the wizard).
- F. Performing head alignment.

To replace a print head:

1. Prepare—
 - replacement print head(s)
 - isopropanol (IPA— isopropyl alcohol) or ethanol (ethyl alcohol)
 - disposable cleaning gloves (included in the head replacement kit)
 - a Stratasys-supplied cleaning cloth or equivalent
 - a flat-head screwdriver (5 mm)
 - the scale supplied by Stratasys for use in the Weight Test

Note: Make sure that you have these items before running the wizard.

2. Start the Head Optimization Wizard from the *Options* menu of the printer interface (see figure 6-47 on page 35).
3. In the opening wizard screen, click Next to begin.

The *Wizard Conditions* screen appears.

4. Read the conditions, select *I Agree* and click Next.

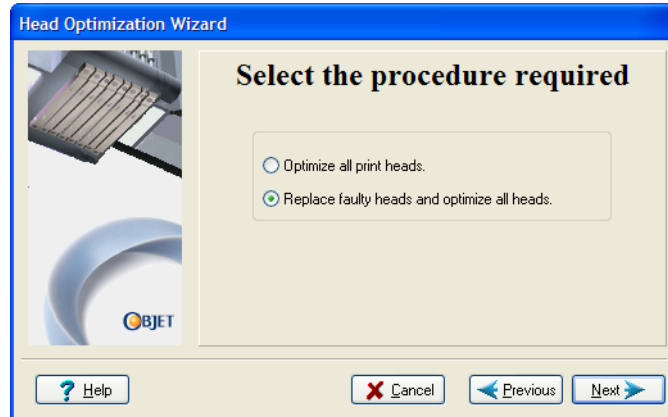


Figure 6-57: Procedure selection screen

5. Choose *Replace faulty heads*, and click Next.
 6. Select the print head(s) needing replacement, and click Next.
- Preparing the Print Block

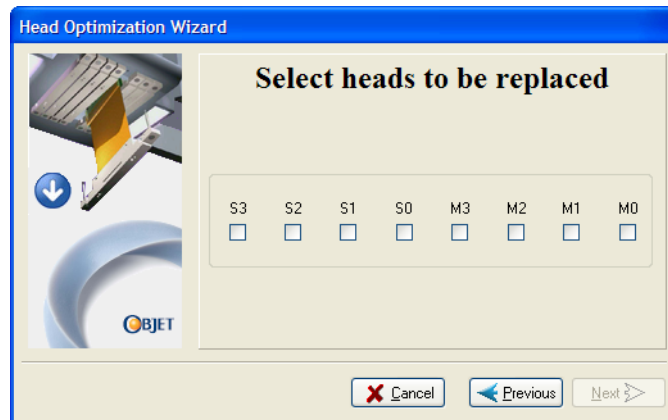


Figure 6-58: Head selection screen

The printer heats and empties the print block, and prepares the printer. (This should take up to 30 minutes.)

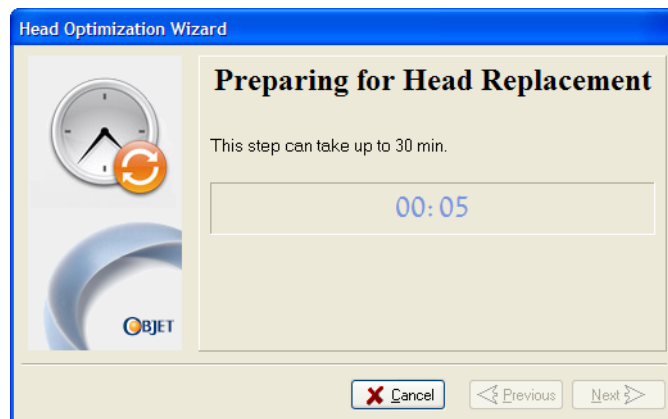


Figure 6-59: Printer preparation progress screen

7. Put on the safety gloves.

8. When the following screen is displayed, open the printer cover.

Note: The printer disconnects power to the heads for your safety.

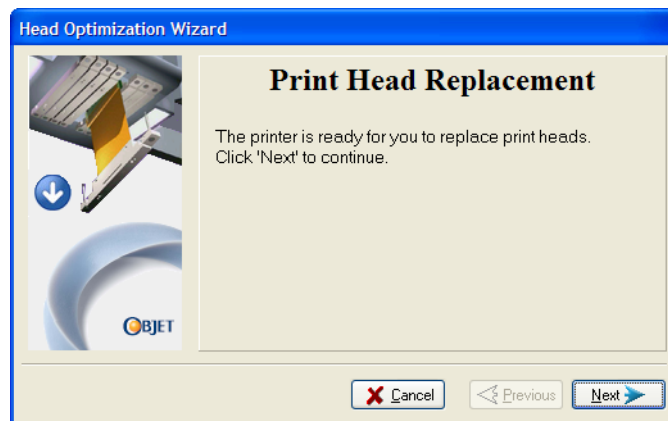


Figure 6-60: Replace the defective head when this screen appears

- Removing the Defective Head
- On the print block, release the upper and lower screws that secure the print head in the block. (If necessary, you may use a screwdriver to loosen the screws.)

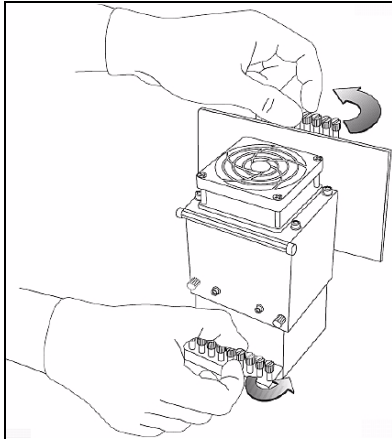


Figure 6-61: Releasing the locking screws

- Press down on the upper and lower locking screws to release the print head.

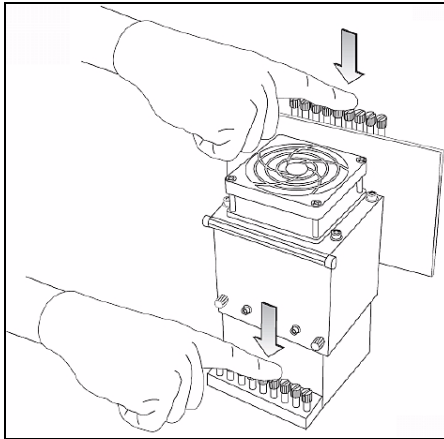


Figure 6-62: Releasing the print head

- Loosen the screws on the door of the compartment protecting the print-head driver cards (A), then pull and lift the door (B).

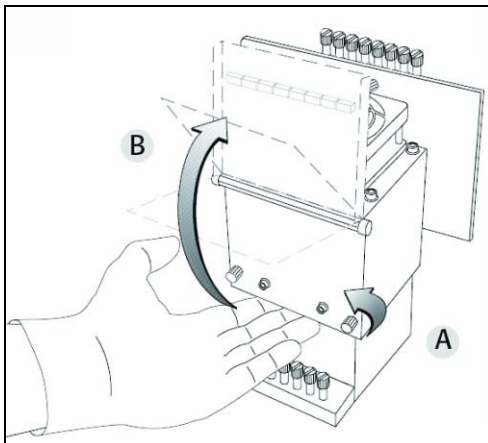


Figure 6-63: Opening the print-head compartment

12. Pull the print-head driver card out of its socket so that the head is free (A), and remove it from the bottom of the print block (B).

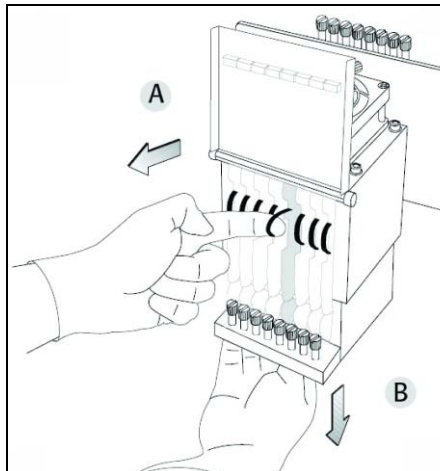


Figure 6-64: Releasing the print-head driver card to remove the head

13. Make sure that along with the head, you remove the two rubber O-ring seals.

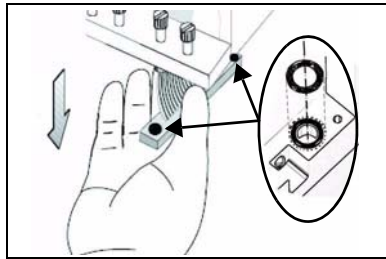


Figure 6-65: O-ring seals on the print head



Important: If the seals are not removed with the head, they are probably stuck to the print block housing. If so, remove them.

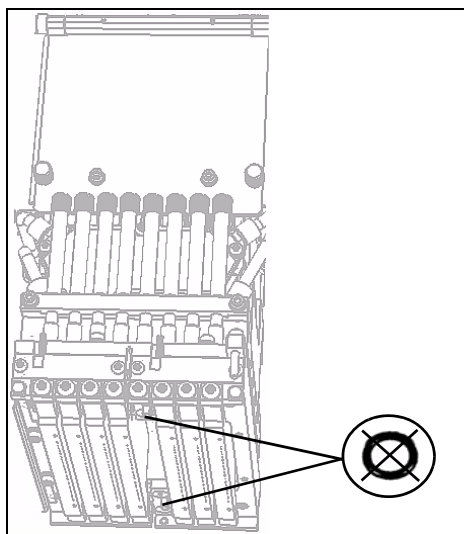


Figure 6-66: Making sure the O-rings are not stuck to the print block

Installing the New Head

Important: Remove the protective tape from the surface of the new print head.

14. Inspect the replacement head, and make sure that the O-ring seals are in place (see figure 6-65).
15. Gently insert the replacement head into the vacant slot in the print block, and push the print-head driver card into its socket.

Note: Make sure to insert the head with the driver card facing its socket, in the rear of the print block.

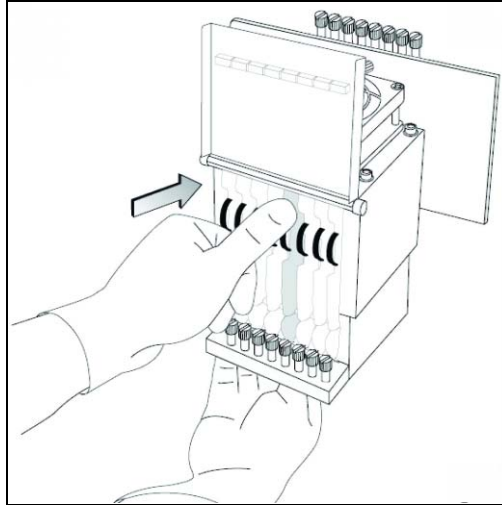


Figure 6-67: Inserting the print-head driver card into its socket

16. Push the head up until you hear it click into place, in both front and rear holders.

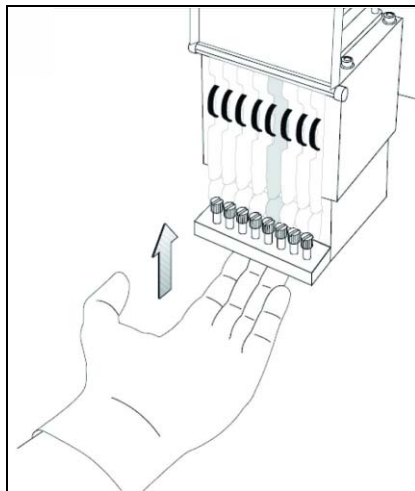


Figure 6-68: Clicking the head into place in the print block

17. Lower the door of the print head compartment, and tighten the screws to lock it in place.
18. Tighten the upper and lower screws that secure the print head in the print block (see figure 6-61 on page 43).

Note: Hand-tighten these screws. Do *not* use a screwdriver.

19. In the *Replace print heads* screen, select the check box to confirm that you have replaced the head(s), and click Next.

20. With your fingers, make sure that the new head is level and even with the other heads.

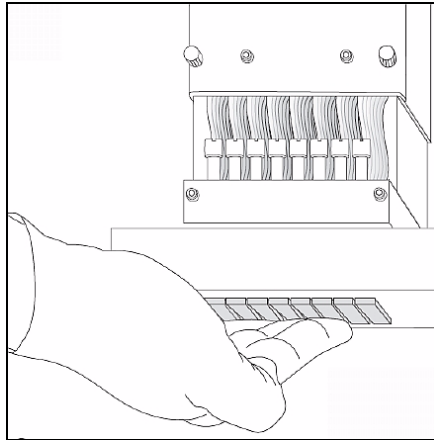


Figure 6-69: Checking the level of the new head

21. Confirm that the heads are level and even by selecting the check box in the following wizard screen, and click Next.

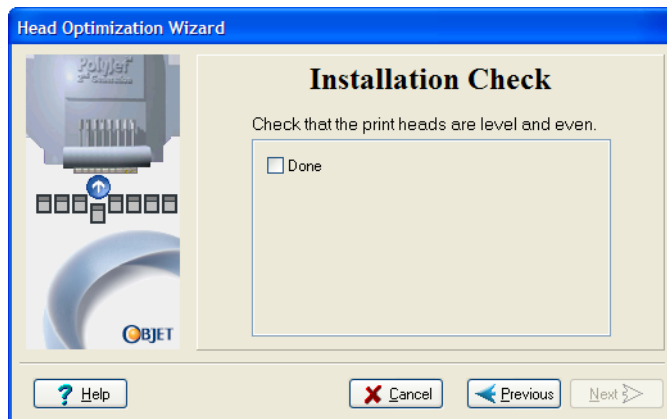


Figure 6-70: Installation-check screen

22. In the next wizard screen, select the check box to confirm that you have removed all tools and objects from the printer.

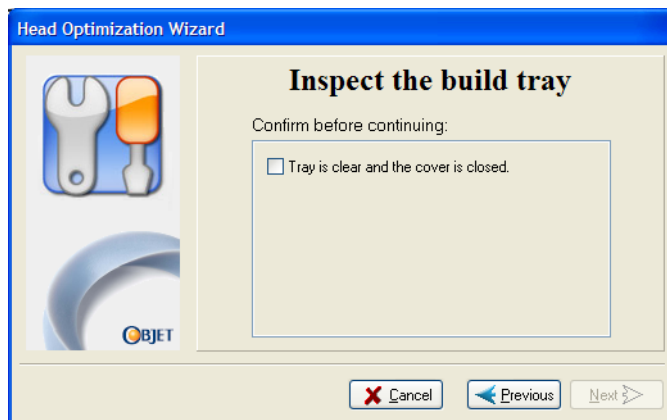


Figure 6-71: Cleared-tray confirmation screen

23. Close the printer cover.

The wizard continues by filling the heads, then heating and purging them. If there are no installation problems, the Head Optimization procedure begins (see “Calibrating Print Heads” on page 6-34).

If a vacuum leakage is detected, or if there are other problems, the wizard alerts you and instructs you how to continue (see “Installation Problems,” next).

After replacing print heads, you should check the head alignment before using the printer to produce models. In the final wizard screen...

- select Yes and click Done to open the Head Alignment Wizard (see “Aligning the Print Heads” on page 30).
- select No and click Done to align the heads at another time.



Figure 6-72: Final Head Optimization Wizard Screen

Installation Problems If the printer detects that there is a problem after you install print heads, relevant warning screens appear.

- If the printer software does not sense the replaced head, the following warning screen appears.



Figure 6-73: Incorrect-installation screen

If this happens:

- Open the print head compartment (see figure 6-63 on page 43).
 - Re-insert the print-head driver card into its socket (see figure 6-67 on page 45).
 - In the wizard screen, select the check box to confirm that you have re-inserted the card, and click **Next**.
- If the replacement head was not factory-calibrated, the following warning screen appears.



Figure 6-74: Invalid-data warning screen

If this happens:

- Remove the head and replace it with another one (starting with step 9 on page 6-43).
- In the wizard screen, select the check box to confirm that you have installed another print head, and click **Next**.
- Contact your authorized Customer Support center about the unformatted head.

- If the vacuum test is not successful, the replacement head was not sealed properly during installation, and the following warning screen appears.



Figure 6-75: Vacuum-leakage warning screen

If this happens:

- Click Next.
- Follow the instructions on the wizard screens to re-install the head.

Calibrating the Load Cells

Load cells are sensors that measure the weight of the printing cartridges and the waste container in the printer. It is important that you periodically check that the weight measurements are accurate, both for convenience and to prevent unnecessary waste of printing materials. It is recommended that you calibrate the load cells once a month, with the Load Cell Calibration Wizard.

To calibrate load cells:

1. Start the Load Cell Calibration Wizard from the *Options* menu (see figure 6-25 on page 23).
2. Select one or more load cells that you want to calibrate, and click Next.

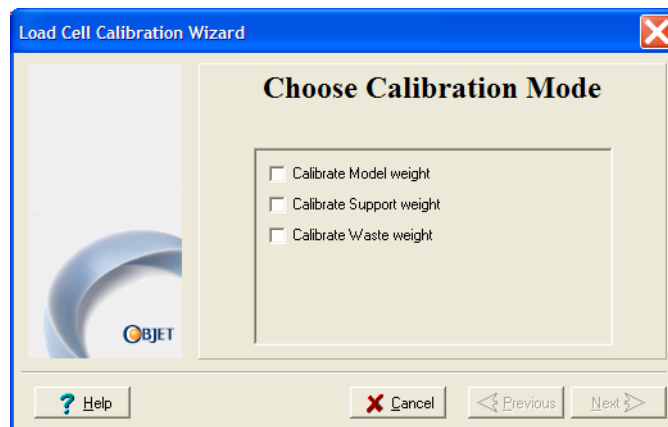


Figure 6-76: Load cell selection

Note: It is recommended that you routinely calibrate all of the load cells.

3. Remove the cartridge or container, as instructed by the wizard, confirm this in the wizard screen, and click Next.

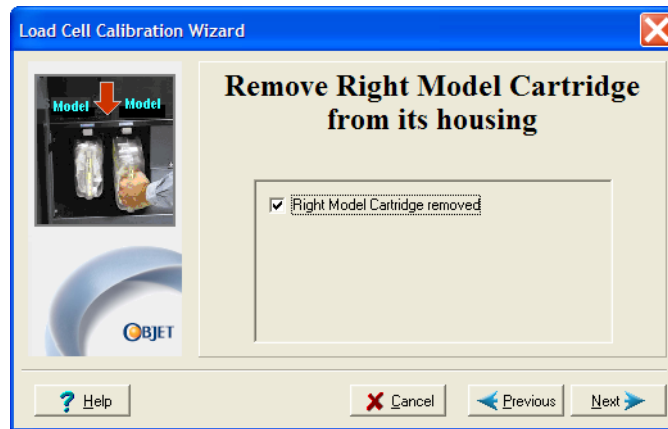


Figure 6-77: Confirmation of cartridge removal

4. In the next wizard screen, observe the numbers and wait until the level is relatively stable—two units above or below the average level shown.

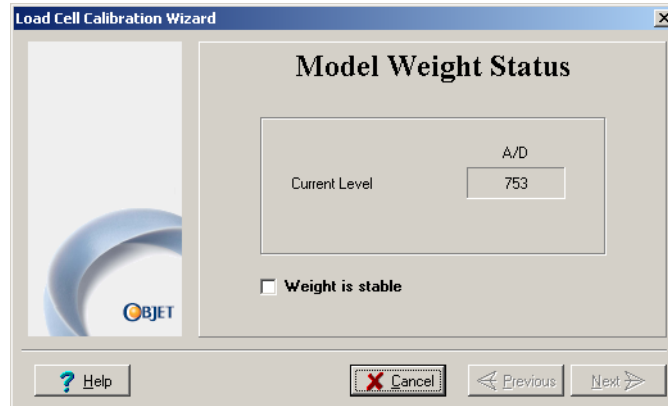


Figure 6-78: Load cell calibration screen

5. Select the *Weight is stable* check box, and click Next.
If you need to calibrate more than one load cell, the next calibration screen appears. Repeat steps 4 and 5 until all of the load cells are calibrated.
6. Click Done in the final wizard screen.

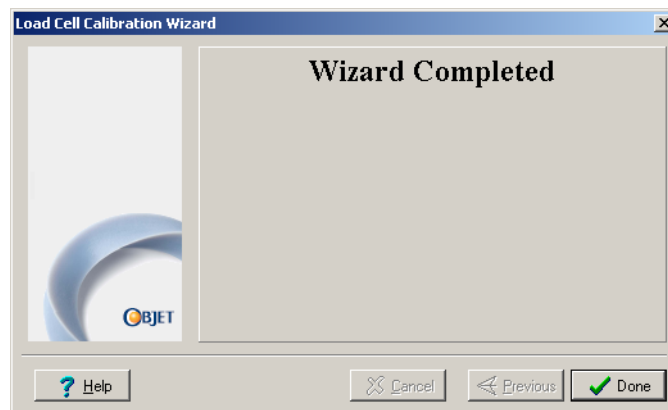


Figure 6-79: Final wizard screen

Replacing the Odor Filter

If the printer exhaust is not connected to an external ventilation system, a built-in activated-carbon filter removes odors from printing materials. This filter should be replaced regularly (about once a year, as necessary) to keep your working environment pleasant. This is normally done during the yearly preventive-maintenance service visit.

Replacing the UV Lamps

The UV lamps used for curing models have a long, but limited, working life. The service engineer tests their effectiveness during regular maintenance checks, and replaces them, if necessary. If, for any reason, you need to replace a UV lamp, follow these instructions:

Note: The printer application includes a wizard for user-calibration of UV lamps. When this user guide was prepared, the UV Calibration Wizard was not fully tested with an approved UV radiation sensor. For this reason, you should not use the wizard at this time.

1. Make sure the printer is in *offline* mode.

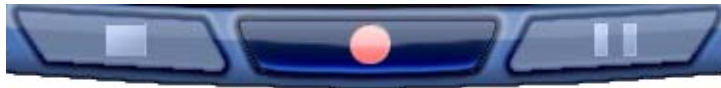


Figure 6-80: Offline mode indicator (red)

The *online/offline* button at the bottom of the printer interface should be red. If not, click it to switch the printer to *offline* mode.



WARNING: Before continuing, make sure that the safety interlock in the printer cover is not defeated, and that the lamp is not hot.

2. Start the UV Lamp Replacement Wizard.
 - From the *Options* menu of the printer interface (see figure 6-25 on page 23), select Wizards > UV Lamp Replacement.
3. Make sure that the build tray is empty, and confirm this in the wizard screen. Then, close the printer cover and click Next.



Figure 6-81: "Empty tray" confirmation screen

The axes move to the "home" position.

4. Select the UV lamp(s) to be replaced and click Next.

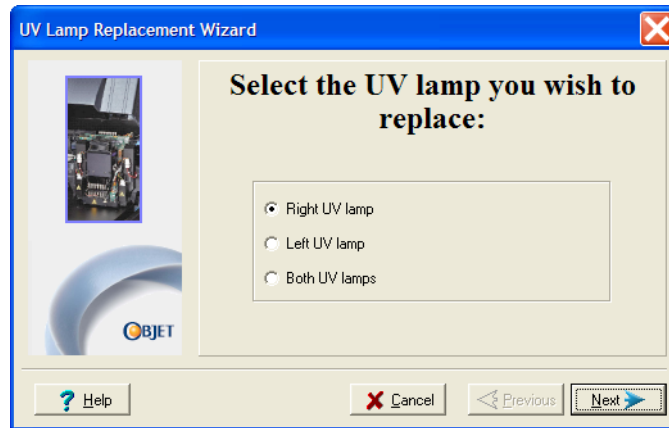


Figure 6-82: UV lamp selection screen

5. Disconnect the power connection to the UV lamp.

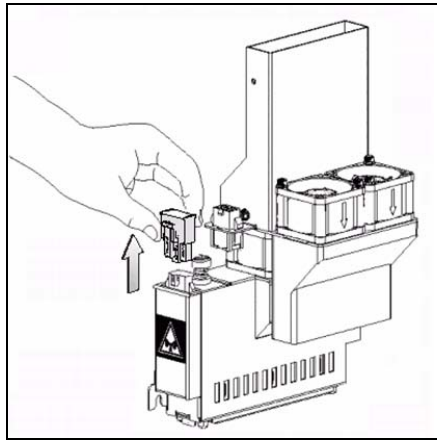


Figure 6-83: Disconnecting the UV lamp

Note: Do *not* disconnect the power connection to the cooling fans.

6. Loosen the screw securing the UV lamp cover (A), and pull the cover up (B), then out (C).

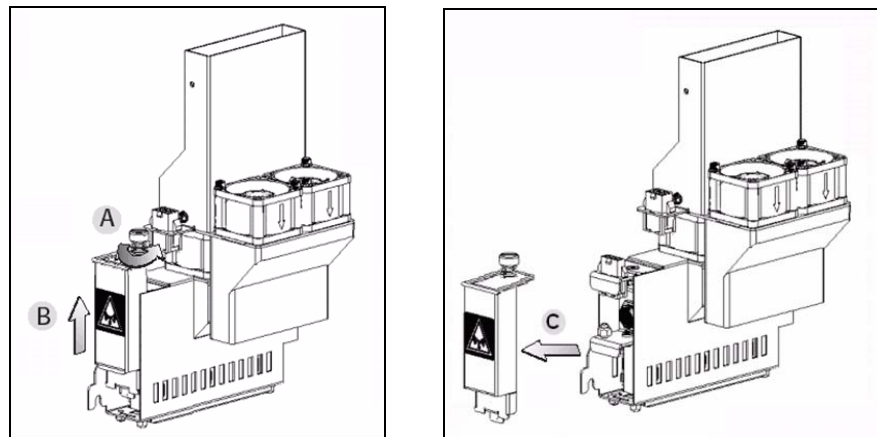


Figure 6-84: Removing the UV lamp cover

7. Pull the lamp reflector out of the print block.

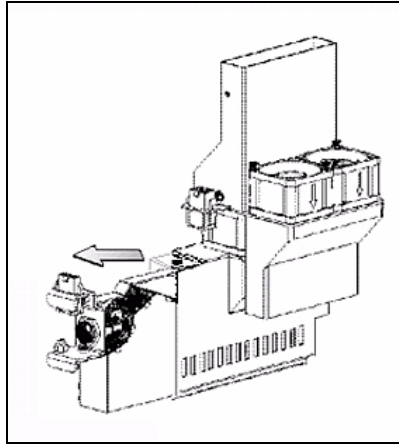


Figure 6-85: Removing the UV lamp reflector

8. Inspect the new lamp reflector, and make sure that a black strip is attached to the inside of it. If not, install one—on the side of the reflector *opposite* (not next to) the print block.

Note: Extra black strips are included in the printer Start-up Kit. If necessary, you can remove the black strip from the old reflector and install it in the new reflector (as long as the black paint has not faded).

9. Discard the old reflector and lamp.



Dispose of the used UV lamp in accordance with environmental and safety requirements.

10. Insert the new UV lamp/reflector unit into the housing next to the print block.

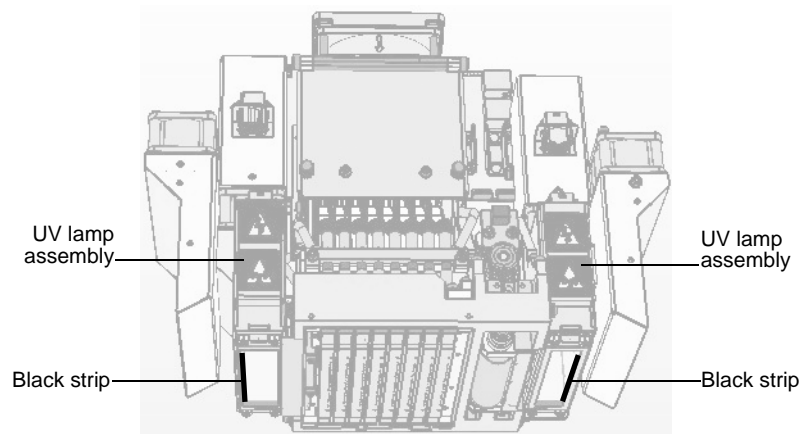


Figure 6-86: Print block and UV lamp assembly, showing correct placement of black strip

11. Replace the lamp cover by inserting it into the slot on the bottom of the housing, and tighten the securing screw on top.

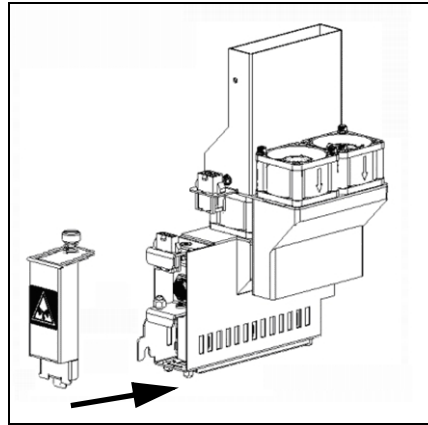


Figure 6-87: Replacing the lamp cover

12. Reconnect the power connection to the UV lamp.

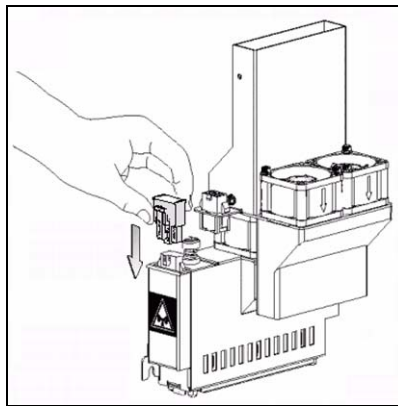


Figure 6-88: Connecting power to the UV lamp

13. In the wizard screen, confirm that you have replaced the lamp(s) and that the black strip is attached, then click Next.

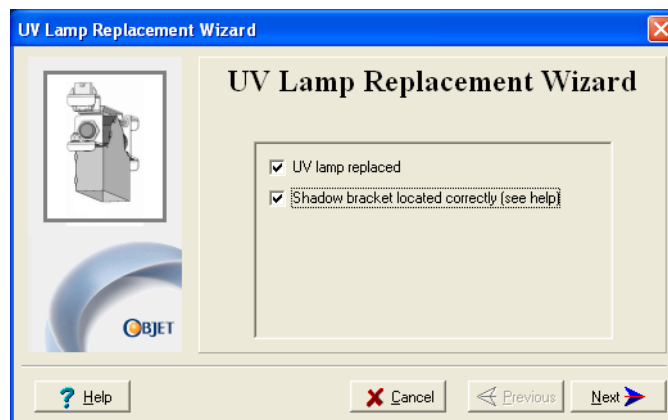


Figure 6-89: UV-installation confirmation screen

The wizard operates the lamps and checks if their power is within the acceptable range for each printing mode. (The mode currently being checked appears in the lower-left corner of the printer interface.)



Figure 6-90: Status screen during UV lamp check

14. When the final wizard screen appears, click Done.



Figure 6-91: Final wizard screen

Built-in Tests

The software that runs the printer contains a suite of tests for regularly checking the hardware and software, and for troubleshooting. You can configure basic communications and environment tests to run automatically, when the Eden software opens. In addition, you can run a more comprehensive set of tests before processing a print job, as a system check, to ensure optimum printing results.

Because running the tests effects the operation of the printer, you can only open the Built-in Tests interface when the system is not printing.

The test suite features:

- The organization of printing-related tasks in categories:
 - Communications
 - Data cards
 - Temperatures
 - Voltages
 - Encoder repeatability
 - Print-head heating
 - Print-head filling
- A clear display of test results and the source of any failures, enabling you to determine if printing is possible or worthwhile.
- The ability to monitor test results for specific components.
- Troubleshooting tips.

Running these tests can help identify problems in the printer hardware and software. A large number of hardware defects (or near-defects) warns you of possible printing problems, either for current or future jobs.



Stratasys recommends running the built-in tests in the following cases:

- as a routine test, once every two weeks
- as a system check, before major (long) jobs
- as needed, for troubleshooting

- Accessing Built-in Tests To open the Built-in Tests screen, do one of the following:
- From the *Options* menu, select Built-In Tests.
 - Press Ctrl+Alt+B.

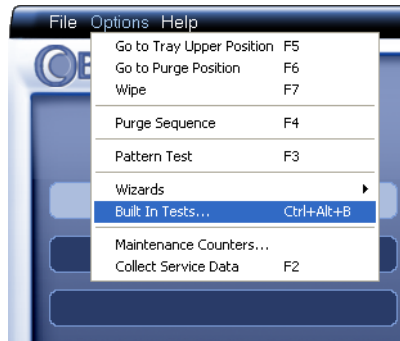


Figure 6-92: Selecting *Built-In Tests* from the *Options* menu

- Test Interface The *Built In Tests* screen lists pre-configured tests, grouped by component categories. In this screen, you select and run tests, and the results are displayed.

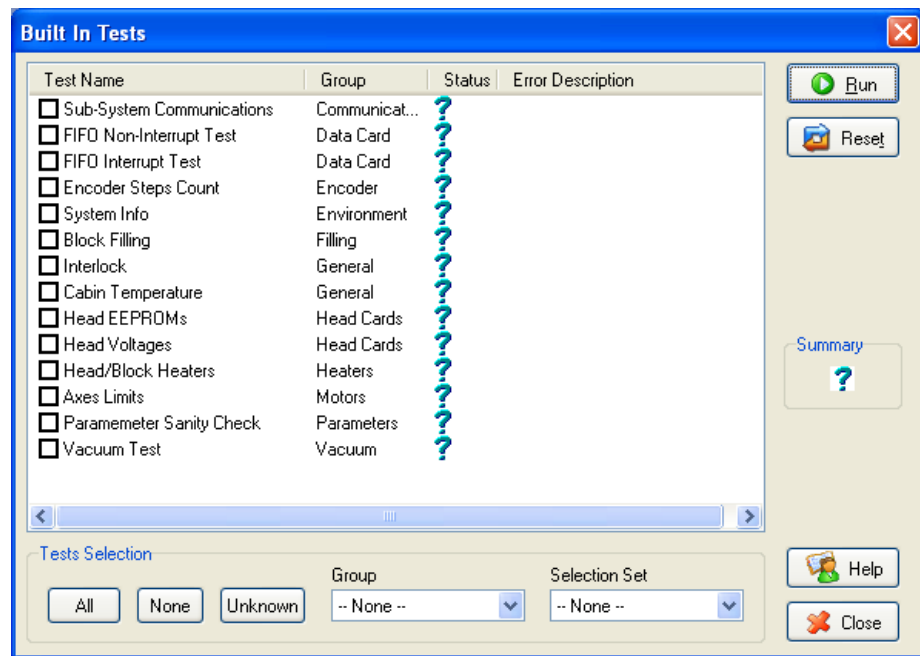


Figure 6-93: *Built In Tests* screen

Test List **Test Name**




This column lists all of the tests, together with selection check boxes. Click the check boxes to select the tests you want to run. To remove a selection, click the check box again. To quickly select all of the tests in a component category, use the *Group* pull-down menu at the bottom of the screen.

Group

This column shows the component categories for each test. This tells you which tests are run when selecting a category from the *Group* pull-down menu at the bottom of the screen.

Status

This column shows the status of each test after you run it:

-  Test successfully completed.
-  Test failed. (Double-click on a failed test's line to review the failure details.)
-  Unknown results. (The test has not been run yet.)

Test Selection Area In the *Test Selection* area, at the bottom of the screen, you can quickly select or de-select tests by their characteristics:

All	Click to select all of the tests in the list.
None	Click to de-select all of the tests in the list.
Unknown	Click to select all test that have not been run yet (Status = ?).
Group	Use this menu to select tests by component category.
Selection Set	Use this menu to select a pre-configured set of tests to run at specified times (computer startup, before printing, etc.).

Running Tests To run the selected tests:

- Click .

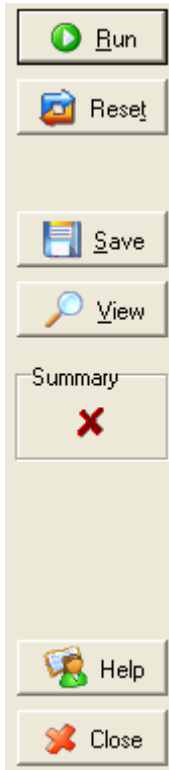


After you run a test, the *Save* and *View* command buttons are added to the *Built In Tests* screen (see below).

Test Results To save and view a report of all of the tests:

- Use the *Save* and *View* command buttons (see below).

Command Buttons You click the command buttons, on the right side of the screen, to perform the following operations:



Run

Click to run the selected tests.

Reset

Click to clear previously run tests. This returns the status of each test to *Unknown (?)*.

Save

Click to save a report that summarizes the tests run. The report is saved as an HTML file. You can save any number of reports for the tests you run; the name of the file saved is *BITReport [date][time].htm*. By default, these files are saved in the Eden installation folder, but you can save it in any other folder.




View

Click to display the latest test report that you saved. (You can view other test reports by opening the relevant files in your Web browser. To do so, open Windows Explorer, and double click the *BITReport* file.)

Close

Click to close the *Built-in Tests* screen.

Summary On the right side of the screen, a symbol represents the combined results of all the tests run, using the symbols from the *Status* column.

-  All tests successfully completed.
-  At least one test failed.
-  Not all tests performed.

Test Descriptions and Troubleshooting The following table lists the name of each test in the Built-in Tests suite, together with its description and a possible reason for its failure. If you need assistance, contact your Stratasys service provider.

Test Name	Description	Possible Reason for Failure
Sub-System Communication	Tests communications between Eden components.	Disconnected communications cable. Faulty cable.
FIFO Non-Interrupt/ FIFO Interrupt	Tests the data queue in the DATA PCI card.	Faulty DATA_PCI card.
Encoder	Tests the encoder's reliability by comparing readings from multiple runs along the X-axis.	Faulty encoder.
System Info	Compares the following parameter values with the minimum requirements. <ul style="list-style-type: none"> • Physical memory • Available memory • Free space on disk • Monitor resolution 	Failure of RAM memory allocation in the Eden computer.
Block Filling	Analyzes the thermistor readings when the block is full and when it is empty.	Faulty thermistor.
Interlock	Tests the interlock in the printer cover.	Failure of interlock mechanism. Faulty latch. Disconnected cables.
Cabin Temperature	Tests the temperature level in the build-tray area.	Faulty temperature sensor (OHDB).
Head EEPROM	Tests the read/write capabilities of the print-head driver cards.	Faulty print-head driver card.
Head Voltage	Checks the control of voltages supplied to the print heads.	Faulty print-head driver card.
Tray Heater	Not used for this printer	—
Head/Block Heaters	Tests the heaters in the print heads and in the print-block body.	Faulty heaters or thermistors.
Axes Limit	Tests the hardware and software limits of all axes.	Faulty hardware sensors. Wrong <i>Max Position</i> parameter.
Parameter Sanity Check	Compares the values of all printer parameters (in cfg files) to the required values.	One or more of the printer parameters is not within the required range. You can view details in the BIT report.
Vacuum	Tests the vacuum level in the print block.	Faulty vacuum sensor. Vacuum leakage. Wrong parameters.

Replacing the Waste Container

The waste container contains partially cured polymeric material produced during normal operation and maintenance of the printer. For safety and environmental reasons, this material is kept in a special leak-proof, disposable container.

The container has a capacity of about eight kilograms of waste material—usually enough for several months of printer use. The printer software displays a warning message when there is 7.3 kilograms of material in the container, and stops the printing when the net weight reaches 7.8 kilograms. Above 7.3 kilograms, the software does not allow you to start a print job (or a printing activity) until you replace the waste container. You can monitor the weight of the waste container in the *Maintenance* screen of the printer interface.

To monitor the waste weight (and other indicators) in the printer:

- In the main printer interface screen, click the display toggle to view the printer indicators.



Figure 6-94: Printer interface, showing waste weight (red background indicates operator alert)

The waste container consists of a sealed bag inside a cardboard box. You typically dispose of the entire waste container—including the box. Therefore, you must assemble a new box and insert a new waste bag before you can install it in the printer.



Replacement boxes, waste bags, and sealing caps are supplied in the Eden printer start-up kit and in the preventive-maintenance kit.

To prepare a new waste container:

1. Assemble the cardboard box, making sure to punch out the perforated sections.
2. Fold a new waste bag—so it fits in the box—and insert the bag's screw-connector into the hole in the top of the box.

Note: Do not close the box until you connect the waste drain tube from the printer (see below).

To replace the waste container:

1. Push the door of the lower printer compartment to open it.

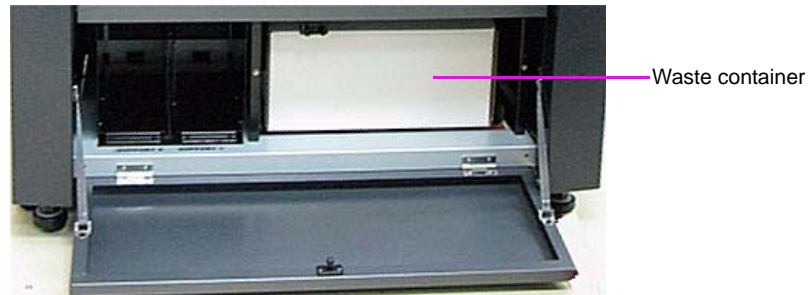


Figure 6-95: Waste container under the printer

2. Carefully slide out the waste container to remove it from the printer.



Figure 6-96: Waste container removed from the printer

3. Place the new waste container next to the full container.
4. Unscrew the cap securing the waste drain tube and connect it to the new container.

- Close the full container with a sealing cap.

Note: The sealing cap contains an inner stopper that prevents leakage when the cap is tightened. Do not be concerned that air can still flow through the opening on the top of the cap, since the inner stopper seals the waste container.



Figure 6-97: Waste container sealing cap

- Close the new waste-container box.
- Position the waste container under the printer, on the load cells.

Note: Make sure that the waste drain tube is not crimped and that it is not pinched by the container.

- Close the compartment door.



Dispose of the full waste container in accordance with environmental and safety requirements.

Cleaning the Exterior Panels

The painted exterior plastic panels of Eden 3-D printers have a durable finish, offering excellent chemical resistance to common cleaning agents. However, follow the recommendations below when cleaning these areas of the printer.

Acceptable Cleaning Agents

- mild soap solution
- common household cleaners and window cleaners
- common commercial and industrial detergents, 5% solution in water
- alcohol (ethanol, isopropanol), 10% to 40% solution in water

Wipe the exterior of the printer, using a soft cloth moistened with the cleaning solution.

Unacceptable Materials

- industrial solvents
- cleaning agents containing hydrocarbons, ketones, esters and lacquer thinners
- spray disinfectants
- abrasives and agents which could wear away the panel finish

7

Handling Printed Models

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Removing Models After Printing

After printing models, you should allow them to cool as much as possible before handling them. If additional models do not have to be produced on the printer, it is best to let the printed models cool in the printer, with the cover closed, as long as possible.

If the printer must be used to produce additional models as soon as possible:

1. Let the printed models cool on the build tray for at least 10 minutes.
2. Very carefully, remove the models from the tray with a scraper or spatula (supplied in the tool kit), taking care not to pry or bend the model.



WARNING: Wear protective gloves when handling printed models before they are washed.

3. Place the models on a flat surface, and cover them with a cardboard box or paper hood.

This allows the models to cool slowly and evenly.

4. Let the models cool for several hours.

Removing the Support Material

After printed models have cooled, the support material must be removed. This can be done by different methods, depending on the size of the model, how delicate it is, the amount and location of the support material, and other factors. Use the following methods as a guide, and adapt them (or a combination of them) for finishing the models you are handling.

Removing Excess Support Material by Hand

While wearing protective gloves, break away excess support material on the outside of the model. For delicate models, use a toothpick, pin or small brush after dipping the model in water.

Removing Support Material with Water Pressure

For most models, the most efficient way to remove support material is by using a high-pressure water jet. One suitable system is the Objet WaterJet cleaning unit, shown in figure 7-1 on page 7-3.

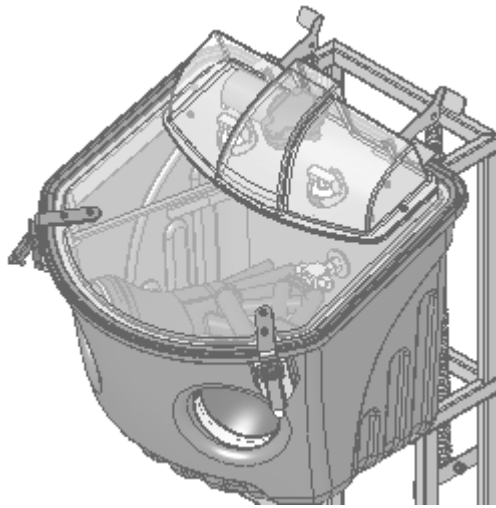


Figure 7-1: Objet WaterJet Cleaning Unit

To clean a model using this device, you place it in the chamber, and you manipulate it and the jet using the built-in, waterproof sleeves. A pump turns ordinary tap water into a high-pressure jet, and a wiper keeps the window clear.



Use caution when cleaning delicate models with high-pressure water systems.

Removing Support Material with Caustic Soda

Soak models in a 2-percent solution of caustic soda (sodium hydroxide) to remove support material from difficult-to-reach areas and to give the model a smooth, clean finish. The amount of time you soak the model in the solution depends on how delicate it is and how much support material needs to be removed, but it is typically between half-an-hour and several hours. In any case, you should remove as much support material as possible before the caustic soda treatment, and rinse the model thoroughly (with a water jet) afterwards.



WARNING: Caustic soda may cause chemical burns, scarring and blindness. Mixing it with water generates heat that could ignite other materials. Take adequate safety precautions; always use nitrile gloves when handling caustic soda and models soaked in it.

Storing Models

Models are cured as they are printed, making them safe and stable for a long time. However, proper storage conditions are necessary to prevent deforming.

- Keep printed models at room temperature and in a low-humidity environment.
- Do not expose models to direct sunlight and other heat sources.

