

ProJet[®] MJP 5600

Composite multi-material 3D printer



ProJet MJP 5600

Printing Modes UHD Mode UHDS Mode XHD Mode XHDS Mode	Ultra High Definition Ultra High Definition-Single Xtreme High Definition Xtreme High Definition-Single
Net Build Volume (xyz)*	20.4 x 15 x 11.8 in (518 x 381 x 300 mm)
Resolution (xyz) UHD Mode UHDS Mode XHD Mode XHDS Mode	600 x 600 x 1600 DPI; 16 μ layers 600 x 600 x 1600 DPI; 16 μ layers 750 x 750 x 2000 DPI; 13 μ layers 750 x 750 x 2000 DPI; 13 μ layers
Accuracy (typical)	±0.001-0.002 inch per inch (0.025-0.05 mm per 25.4 mm) of part dimension. Accuracy may vary depending on build parameters, part geometry and size, part orientation, and post-processing.
Build Materials Visijet CR-BK Visijet CR-WT 200** Visijet CR-CL 200** Visijet CE-BK Visijet CE-NT	Rigid Plastic Black Rigid Plastic White Rigid Plastic Clear Elastomeric Black Elastomeric Natural
Support Material	Visijet S500 non-toxic wax material for hands- free melt-away supports
Material Packaging	Build and support materials in clean 4.41 lbs (2 kg) bottles (printer holds 4 build and 4 support bottles with auto-switching)
Electrical	110-127 VAC, 50/60 Hz, 15A, single phase 200-240 VAC, 50 Hz, 10A, single phase Single C14 receptacle
Dimensions (WxDxH) 3D Printer Crated 3D Printer Uncrated	79 x 65 x 80 in (2007 x 1650 x 2032 mm) 66.9 x 35.4 x 63.8 in (1700 x 900 x 1620 mm)
Weight 3D Printer Crated 3D Printer Uncrated	2600 lbs (1180 kg) 2060 lbs (935 kg)
3D Sprint[®] Software	Easy build job set-up, submission and job queue management; Automatic part placement and build optimization tools; Part stacking and nesting capability; Extensive part editing tools; Automatic support generation; Job statistics reporting tools
E-mail Notice Capability	Yes
Network Compatibility	Network ready with 10/100/1000 base Ethernet interface
Client Hardware Recommendation	Minimum 320Gb internal hard drive capacity OpenGL 1.1 Compatible 1280 x 1024 resolution or better USB 2.0 host, single USB type A receptacle / 3.0 USB thumb drives supported at 2.0 USB speeds for export of log files
Client Operating System	Windows [®] 7, Windows 8 or Windows 8.1 (Service Pack)
Input Data File Formats Supported	stl, cti, slc, 3dprint
Post-Processing	ProJet Finisher XL for easy removal of eco-friendly wax supports
Operating Temperature Range	64-82 °F (18-28 °C)
Noise	< 65 dBa estimated (at medium fan setting)
Certifications	CE

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

** Respectively replaces former Visijet[®] CR-WT and Visijet[®] CR-CL

VisiJet® Base Materials for the ProJet MJF 5600

The VisiJet composite family of materials is precisely mixed by the ProJet MJF 5600 print head on-the-fly to achieve superior mechanical properties and custom performance characteristics to meet your exacting specifications. This ingenious system simultaneously prints and blends together flexible and rigid material composites, layer-by-layer at the pixel level, in a variety of colors and shades including opaque, clear, black or white and numerous shades of gray.



Properties	Condition	VisiJet CR-BK	VisiJet CR-WT 200*	VisiJet CR-CL 200*	VisiJet CE-NT	VisiJet CE-BK
Composition		UV curable plastic	UV curable plastic	UV curable plastic	UV curable elastomeric	UV curable elastomeric
Description		Rigid ABS-like	Rigid ABS-like	Rigid polycarbonate-like	Elastomeric	Elastomeric
Color		Opaque black	Opaque white	Translucent clear	Translucent natural	Opaque black
Bottle Quantity (kg)		2	2	2	2	2
Solid Density (g/cm³)		1.16	1.16	1.16	1.12	1.12
Tensile Strength (MPa)	ASTM D638	37-48	33-40	30-43	0.2-0.4	0.2-0.4
Tensile Modulus (MPa)	ASTM D638	1800-2500	1500-2000	1400-2100	0.27-0.43	0.27-0.43
Elongation at Break	ASTM D638	5-11 %	12-22 %	14-22 %	160-230 %	160-230 %
Flexural Strength (MPa)	ASTM D790	67-80	47-52	40-60	N/A	N/A
Flexural Modulus (MPa)	ASTM D790	1800-2300	1200-1700	1100-2000	N/A	N/A
Impact Strength (Notched Izod) (J/m)	ASTM D256	17-24	21-24	21-30	N/A	N/A
Shore A Hardness	ASTM 2240	N/A	N/A	N/A	27-33	27-33
Shore D Hardness	ASTM 2240	78-83	77-80	77-80	N/A	N/A
24 hr Water Absorption	ASTM D570	0.5%	0.5%	0.5%	0.9%	0.6%
Heat Distortion Temp @ 0.45 MPa @ 1.82 MPa	D648	54-61 °C 48-49 °C	42-47 °C 40-44 °C	42-50 °C 40-44 °C	N/A N/A	N/A N/A
Tear Resistance (kN/m)	ASTM D624	N/A	N/A	N/A	3.1 - 3.7	3.1 - 3.7

* Respectively replaces former VisiJet® CR-WT and VisiJet® CR-CL

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

VisiJet® Composite Combinations for the ProJet MJP 5600

In addition to printing in pure base materials, the ProJet MJP 5600 can mix any two base materials together pixel-by-pixel to achieve your targeted properties, in up to twelve different composite ratios. An entire object can be printed in any of these composites, or a user can easily select a specific region of a part to be any number of different material combinations.

PROPERTIES	ASTM	MULTI-MATERIAL COMPOSITES (VisiJet CR-BK + VisiJet CE-BK)										
Material Name		RBK-EBK-D75	RBK-EBK-D70	RBK-EBK-D65	RBK-EBK-D60	RBK-EBK-D55	RBK-EBK-A90	RBK-EBK-A80	RBK-EBK-A70	RBK-EBK-A60	RBK-EBK-A50	RBK-EBK-A40
Description		Very rigid	Slightly rigid	Rigid	Rigid	Slightly rigid	Slightly flexible	Slightly flexible	Flexible	Flexible	More flexible	Very flexible
Appearance*		Black	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
Tensile Strength (MPa)	D638	19-27	12-16	8-10	4-5	2-3	1.4-1.9	1.3-1.7	.75-1.1	.48-.77	.35-.48	.23-.32
Flexural Strength (MPa)	D790	18-21	12-13	7-7.4	3.9-4.2	1.6-1.9	N/A	N/A	N/A	N/A	N/A	N/A
Flexural Modulus (MPa)	D790	450-750	350-550	150-250	70-180	30-80	N/A	N/A	N/A	N/A	N/A	N/A
Impact Strength (J/m) (Notched Izod)	D256	18-25	22-30	32-52	29-42	74-114	N/A	N/A	N/A	N/A	N/A	N/A
Shore A Hardness, Scale A	D2240	N/A	N/A	N/A	N/A	N/A	86-92	75-85	65-75	55-65	45-55	35-45
Shore D Hardness, Scale D	D2240	70-80	65-75	60-70	55-65	50-60	N/A	N/A	N/A	N/A	N/A	N/A
Tear Resistance (kN/m)	D624	N/A	N/A	N/A	N/A	N/A	44-62	25-32	18-23	11-17	6.6-9.3	6.5-8.5

*Visual approximation. No guarantee that part output will match exactly to software or datasheet values.

PROPERTIES	ASTM	MULTI-MATERIAL COMPOSITES (VisiJet CR-BK + VisiJet CE-NT)											
Material Name		RBK-ENT-D78	RBK-ENT-D75	RBK-ENT-D70	RBK-ENT-D65	RBK-ENT-D60	RBK-ENT-D55	RBK-ENT-A90	RBK-ENT-A80	RBK-ENT-A70	RBK-ENT-A60	RBK-ENT-A50	RBK-ENT-A40
Description		Very rigid	Slightly rigid	Rigid	Rigid	Slightly rigid	Slightly rigid	Slightly flexible	Slightly flexible	Flexible	Flexible	More flexible	Very flexible
Appearance*		Translucent dark brown	Translucent dark brown	Translucent brown	Translucent brown	Light brown	Light brown	Light brown	Light tan	Light tan	Light tan	Light amber	Light amber
Tensile Strength (MPa)	D638	30-39	19-27	12-16	8-10	4-5	2-3	1.4-1.9	1.3-1.7	.75-1.1	.48-.77	.35-.48	.23-.32
Flexural Strength (MPa)	D790	18-21	12-13	7-7.4	3.9-4.2	1.6-1.9	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Flexural Modulus (MPa)	D790	450-750	350-550	150-250	70-180	30-80	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Impact Strength (J/m) (Notched Izod)	D256	18-25	22-30	32-52	29-42	74-114	N/A	N/A	N/A	N/A	N/A	N/A	N/A
Shore A Hardness, Scale A	D2240	N/A	N/A	N/A	N/A	N/A	N/A	86-92	75-85	65-75	55-65	45-55	35-45
Shore D Hardness, Scale D	D2240	75-81	70-80	65-75	60-70	55-65	50-60	N/A	N/A	N/A	N/A	N/A	N/A
Tear Resistance (kN/m)	D624	N/A	N/A	N/A	N/A	N/A	N/A	44-62	25-32	18-23	11-17	6.6-9.3	6.5-8.5

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VisiJet® Composite Combinations Continued

PROPERTIES	ASTM	MULTI-MATERIAL COMPOSITES (VisiJet CR-WT 200** + VisiJet CE-BK)										
Material Name		RWT-EBK-D75	RWT-EBK-D70	RWT-EBK-D65	RWT-EBK-D60	RWT-EBK-D55	RWT-EBK-A90	RWT-EBK-A80	RWT-EBK-A70	RWT-EBK-A60	RWT-EBK-A50	RWT-EBK-A40
Description		Very rigid	Slightly rigid	Rigid	Rigid	Slightly rigid	Slightly flexible	Slightly flexible	Flexible	Flexible	More flexible	Very flexible
Appearance*		Very light grey	Lighter grey	Light grey	Light grey	Light grey	Medium light grey	Grey	Medium dark grey	Dark grey	Darker grey	Very dark grey
Tensile Strength (MPa)	D638	19-27	12-16	8-10	4-5	2-3	1.4-1.9	1.3-1.7	.75-1.1	.48-.77	.35-.48	.23-.32
Flexural Strength (MPa)	D790	18-21	12-13	7-7.4	3.9-4.2	1.6-1.9	N/A	N/A	N/A	N/A	N/A	N/A
Flexural Modulus (MPa)	D790	450-750	350-550	150-250	70-180	30-80	N/A	N/A	N/A	N/A	N/A	N/A
Impact Strength (J/m) (Notched Izod)	D256	18-25	22-30	32-52	29-42	74-114	N/A	N/A	N/A	N/A	N/A	N/A
Shore A Hardness, Scale A	D2240	N/A	N/A	N/A	N/A	N/A	86-92	75-85	65-75	55-65	45-55	35-45
Shore D Hardness, Scale D	D2240	70-80	65-75	60-70	55-65	50-60	N/A	N/A	N/A	N/A	N/A	N/A
Tear Resistance (kN/m)	D624	N/A	N/A	N/A	N/A	N/A	44-62	25-32	18-23	11-17	6.6-9.3	6.5-8.5

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** Respectively replaces former VisiJet® CR-WT and VisiJet® CR-CL

PROPERTIES	ASTM	MULTI-MATERIAL COMPOSITES (VisiJet CR-WT 200** + VisiJet CE-NT)										
Material Name		RWT-ENT-D75	RWT-ENT-D70	RWT-ENT-D65	RWT-ENT-D60	RWT-ENT-D55	RWT-ENT-A90	RWT-ENT-A80	RWT-ENT-A70	RWT-ENT-A60	RWT-ENT-A50	RWT-ENT-A40
Description		Very rigid	Slightly rigid	Rigid	Rigid	Slightly rigid	Slightly flexible	Slightly flexible	Flexible	Flexible	More flexible	Very flexible
Appearance*		Very light white	Lighter white	Light tan	Light tan	Light tan	Medium tan	Medium tan	Tan	Tan	Amber	Amber
Tensile Strength (MPa)	D638	19-27	12-16	8-10	4-5	2-3	1.4-1.9	1.3-1.7	.75-1.1	.48-.77	.35-.48	.23-.32
Flexural Strength (MPa)	D790	18-21	12-13	7-7.4	3.9-4.2	1.6-1.9	N/A	N/A	N/A	N/A	N/A	N/A
Flexural Modulus (MPa)	D790	450-750	350-550	150-250	70-180	30-80	N/A	N/A	N/A	N/A	N/A	N/A
Impact Strength (J/m) (Notched Izod)	D256	18-25	22-30	32-52	29-42	74-114	N/A	N/A	N/A	N/A	N/A	N/A
Shore A Hardness, Scale A	D2240	N/A	N/A	N/A	N/A	N/A	86-92	75-85	65-75	55-65	45-55	35-45
Shore D Hardness, Scale D	D2240	70-80	65-75	60-70	55-65	50-60	N/A	N/A	N/A	N/A	N/A	N/A
Tear Resistance (kN/m)	D624	N/A	N/A	N/A	N/A	N/A	44-62	25-32	18-23	11-17	6.6-9.3	6.5-8.5

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** Respectively replaces former VisiJet® CR-WT and VisiJet® CR-CL

VisiJet® Composite Combinations Continued

PROPERTIES	ASTM	MULTI-MATERIAL COMPOSITES (VisiJet CR-CL 200** + VisiJet CE-BK)										
Material Name		RCL-EBK-D75	RCL-EBK-D70	RCL-EBK-D65	RCL-EBK-D60	RCL-EBK-D55	RCL-EBK-A90	RCL-EBK-A80	RCL-EBK-A70	RCL-EBK-A60	RCL-EBK-A50	RCL-EBK-A40
Description		Very rigid	Slightly rigid	Rigid	Rigid	Slightly rigid	Slightly flexible	Slightly flexible	Flexible	Flexible	More flexible	Very flexible
Appearance*		Clear	Clear	Light clear	Light clear	Light clear	Medium light clear	Medium clear	Medium clear	Dark clear	Darker clear	Very dark clear
Tensile Strength (MPa)	D638	19-27	12-16	8-10	4-5	2-3	1.4-1.9	1.3-1.7	.75-1.1	.48-.77	.35-.48	.23-.32
Flexural Strength (MPa)	D790	18-21	12-13	7-7.4	3.9-4.2	1.6-1.9	N/A	N/A	N/A	N/A	N/A	N/A
Flexural Modulus (MPa)	D790	450-750	350-550	150-250	70-180	30-80	N/A	N/A	N/A	N/A	N/A	N/A
Impact Strength (J/m) (Notched Izod)	D256	18-25	22-30	32-52	29-42	74-114	N/A	N/A	N/A	N/A	N/A	N/A
Shore A Hardness, Scale A	D2240	N/A	N/A	N/A	N/A	N/A	86-92	75-85	65-75	55-65	45-55	35-45
Shore D Hardness, Scale D	D2240	70-80	65-75	60-70	55-65	50-60	N/A	N/A	N/A	N/A	N/A	N/A
Tear Resistance (kN/m)	D624	N/A	N/A	N/A	N/A	N/A	44-62	25-32	18-23	11-17	6.6-9.3	6.5-8.5

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** Respectively replaces former VisiJet® CR-WT and VisiJet® CR-CL

PROPERTIES	ASTM	MULTI-MATERIAL COMPOSITES (VisiJet CR-CL 200** + VisiJet CE-NT)										
Material Name		RCL-ENT-D75	RCL-ENT-D70	RCL-ENT-D65	RCL-ENT-D60	RCL-ENT-D55	RCL-ENT-A90	RCL-ENT-A80	RCL-ENT-A70	RCL-ENT-A60	RCL-ENT-A50	RCL-ENT-A40
Description		Very rigid	Slightly rigid	Rigid	Rigid	Slightly rigid	Slightly flexible	Slightly flexible	Flexible	Flexible	More flexible	Very flexible
Appearance*		Very clear white	Light clear white	Light clear white	Light clear tan	Light clear tan	Medium clear tan	Medium clear tan	Medium clear tan	Translucent tan	Translucent amber	Translucent amber
Tensile Strength (MPa)	D638	19-27	12-16	8-10	4-5	2-3	1.4-1.9	1.3-1.7	.75-1.1	.48-.77	.35-.48	.23-.32
Flexural Strength (MPa)	D790	18-21	12-13	7-7.4	3.9-4.2	1.6-1.9	N/A	N/A	N/A	N/A	N/A	N/A
Flexural Modulus (MPa)	D790	450-750	350-550	150-250	70-180	30-80	N/A	N/A	N/A	N/A	N/A	N/A
Impact Strength (J/m) (Notched Izod)	D256	18-25	22-30	32-52	29-42	74-114	N/A	N/A	N/A	N/A	N/A	N/A
Shore A Hardness, Scale A	D2240	N/A	N/A	N/A	N/A	N/A	86-92	75-85	65-75	55-65	45-55	35-45
Shore D Hardness, Scale D	D2240	70-80	65-75	60-70	55-65	50-60	N/A	N/A	N/A	N/A	N/A	N/A
Tear Resistance (kN/m)	D624	N/A	N/A	N/A	N/A	N/A	44-62	25-32	18-23	11-17	6.6-9.3	6.5-8.5

*Visual approximation. No guarantee that part output will match exactly to software or datasheet values.

** Respectively replaces former VisiJet® CR-WT and VisiJet® CR-CL

Visijet® Composite Combinations Continued

PROPERTIES								MULTI-MATERIAL COMPOSITES (Visijet CE-BK + Visijet CE-NT)							
Material Name	EBK-ENT-R89		EBK-ENT-R78		EBK-ENT-R64		EBK-ENT-R50		EBK-ENT-R36		EBK-ENT-R22		EBK-ENT-R11		
Description	Very flexible		Very flexible		Very flexible		Very flexible		Very flexible		Very flexible		Very flexible		
Appearance*	Translucent dark brown		Translucent brown		Translucent brown		Light brown		Light brown		Light amber		Light amber		
Mechanical Properties	Similar properties to Visijet CE-NT or Visijet CE-BK base materials														

*Visual approximation. No guarantee that part output will match exactly to software or datasheet values.

PROPERTIES								MULTI-MATERIAL COMPOSITES (Visijet CR-WT 200** + Visijet CR-CL 200**)							
Material Name	RWT-RCL-R89		RWT-RCL-R78		RWT-RCL-R64		RWT-RCL-R50		RWT-RCL-R36		RWT-RCL-R22		RWT-RCL-R11		
Description	Rigid		Rigid		Rigid		Rigid		Rigid		Rigid		Rigid		
Appearance*	Translucent white		Translucent white		Translucent white-clear		Translucent white-clear		Translucent white-clear		Light white-clear		Light clear		
Mechanical Properties	Similar properties to Visijet CR-WT 200 or Visijet CR-CL 200 base materials														

*Visual approximation. No guarantee that part output will match exactly to software or datasheet values.

** Respectively replaces former Visijet® CR-WT and Visijet® CR-CL

PROPERTIES								MULTI-MATERIAL COMPOSITES (Visijet CR-BK + Visijet CR-CL 200**)							
Material Name	RBK-RCL-L10		RBK-RCL-L20		RBK-RCL-L30		RBK-RCL-L40		RBK-RCL-L50		RBK-RCL-L60		RBK-RCL-L70		
Description	Rigid		Rigid		Rigid		Rigid		Rigid		Rigid		Rigid		
Appearance*	Translucent black		Translucent black		Translucent dark clear		Translucent dark clear		Translucent clear		Translucent clear		Translucent clear		
Mechanical Properties	Similar properties to Visijet CR-BK or Visijet CR-CL 200 base materials														

*Visual approximation. No guarantee that part output will match exactly to software or datasheet values.

** Respectively replaces former Visijet® CR-WT and Visijet® CR-CL

PROPERTIES								MULTI-MATERIAL COMPOSITES (Visijet CR-BK + Visijet CR-WT 200**)							
Material Name	RBK-RWT-L10		RBK-RWT-L20		RBK-RWT-L30		RBK-RWT-L40		RBK-RWT-L50		RBK-RWT-L60		RBK-RWT-L70		
Description	Rigid		Rigid		Rigid		Rigid		Rigid		Rigid		Rigid		
Appearance*	Darker grey		Medium dark grey		Grey		Medium light grey		Light grey		Lighter grey		Very light grey		
Mechanical Properties	Similar properties to Visijet CR-BK or Visijet CR-WT 200 base materials														

*Visual approximation. No guarantee that part output will match exactly to software or datasheet values.

** Respectively replaces former Visijet® CR-WT and Visijet® CR-CL