

7. Press **Level Print Tray**.
8. The system will pump material from the bottle into the cart reservoir and into the print tray. The GUI will notify the user as additional bottles of material are needed.
9. Fill times when starting with an empty cart and print tray:
  - Large print tray - Approximately 45 minutes
  - Small print tray - Approximately 30 minutes

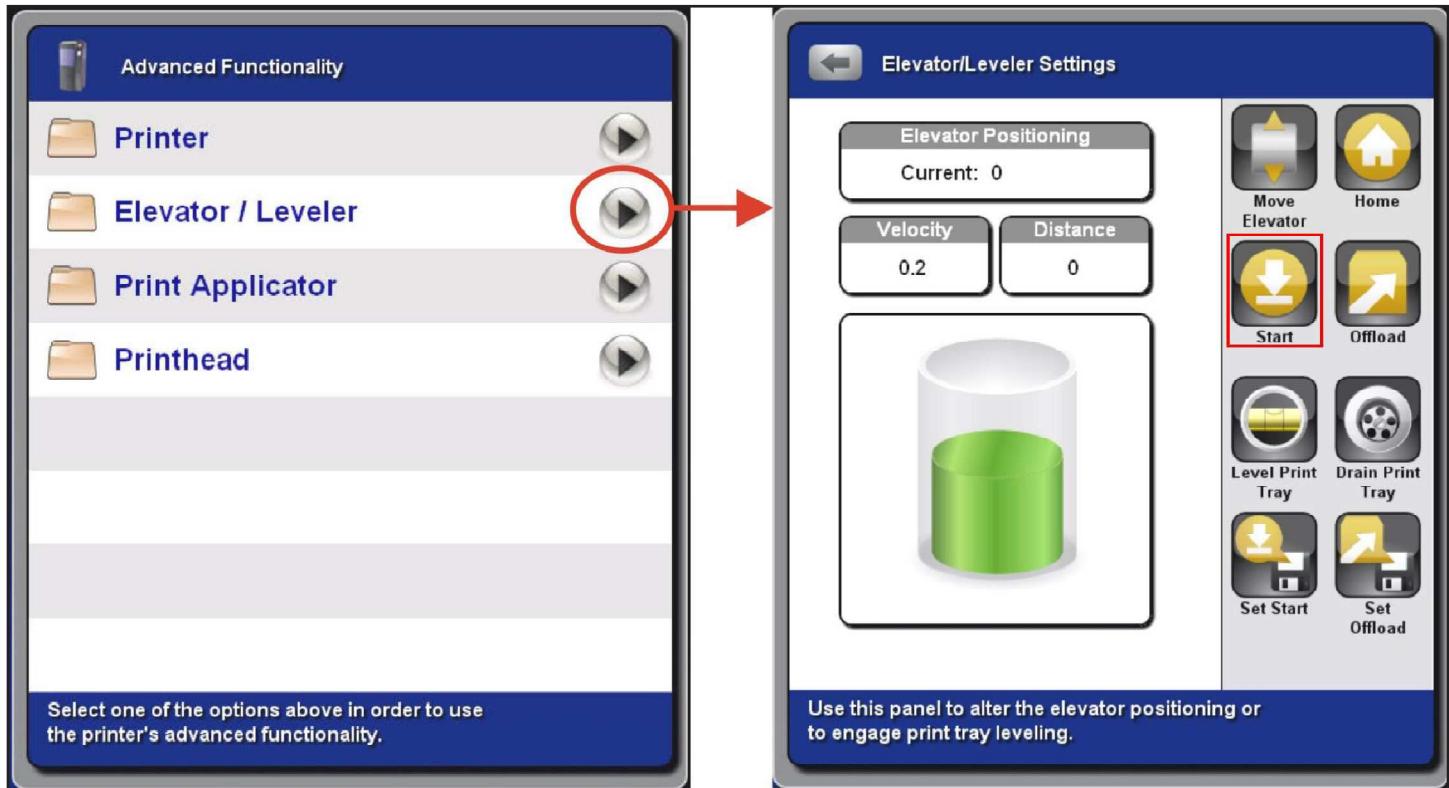
## LEVEL PRINT PLATFORM

1. Lower the print platform to the **Start** position as follows:

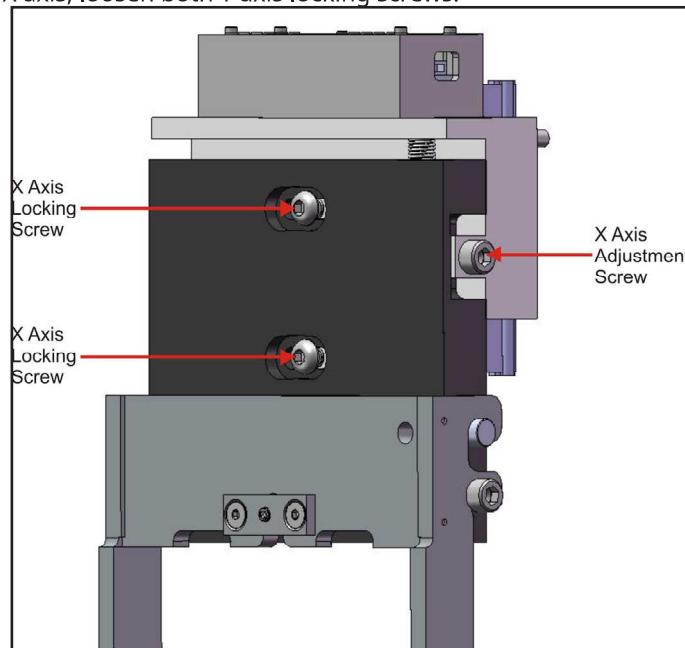
a. On the front panel, select **Advanced**

b. Select **Elevator/Leveler**.

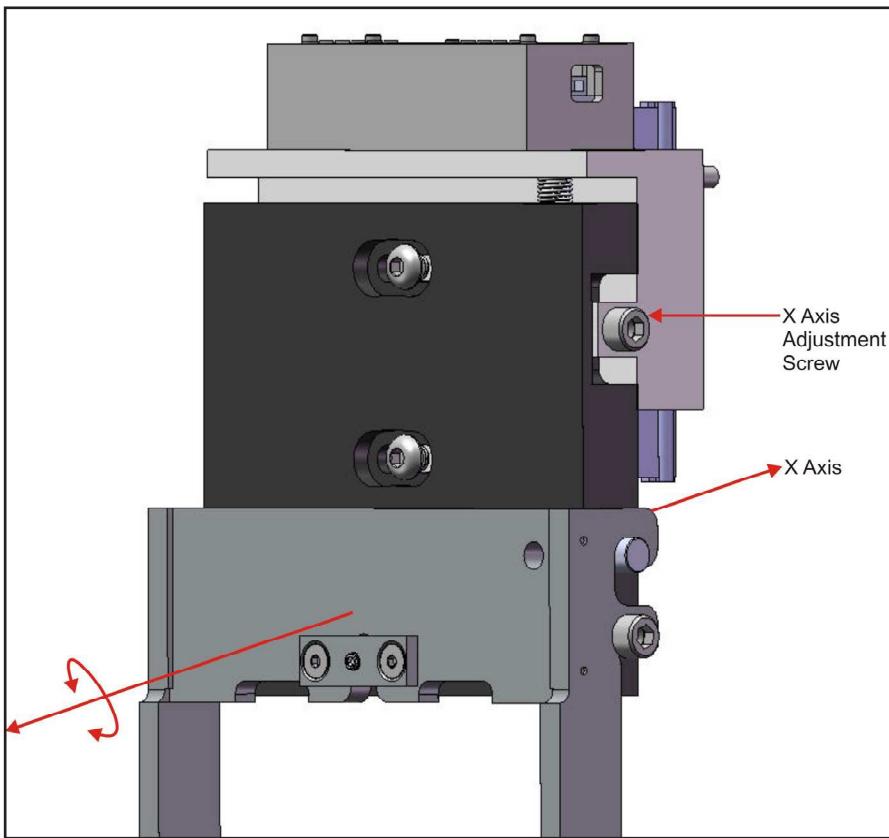
c. Press the **Start** key.



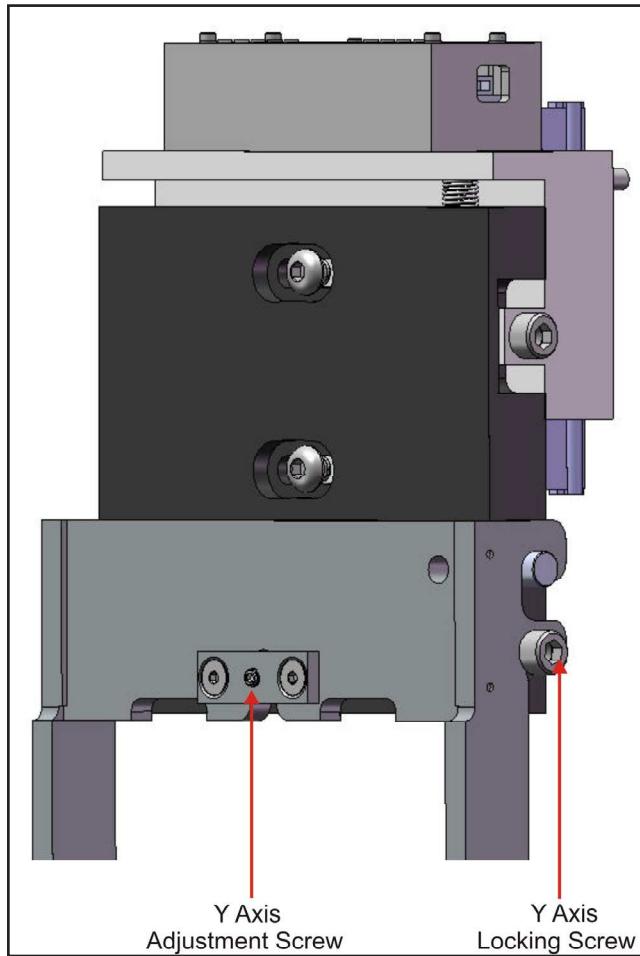
2. To adjust the platform in the X axis, loosen both Y axis locking screws.



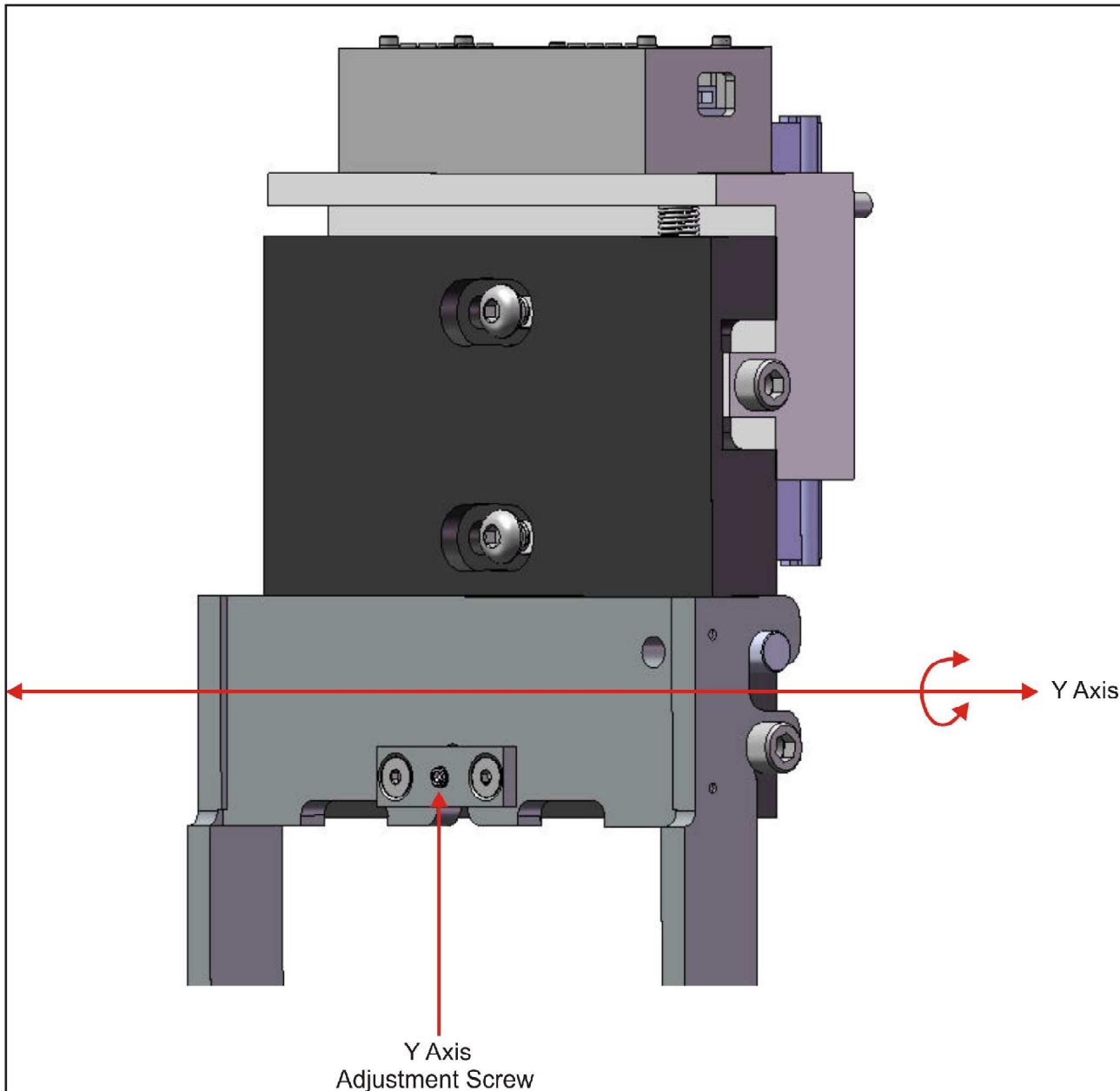
3. Turn the X axis adjustment screw clockwise (or counter-clockwise) to achieve level in the X axis.



4. Tighten the X axis locking screws.



5. To adjust the platform in the Y axis, slightly loosen the Y axis locking screw.



6. Turn the Y axis adjustment screw clockwise (or counter-clockwise) to achieve level in the Y axis.
7. Tighten the Y axis locking screw.
8. Repeat steps 2 through 7 until the print platform is level with the surface of the print material.

## INSTALL THE PROJET™ 6000 IN 3DSPRINT 2.5

3D SPRINT™ is the 3D Systems' software application used for preparing CAD models to be printed on an SLA printer. It is installed on a standalone computer which is provided by the customer. Double-click the 3D SPRINT icon on your computer/laptop, or select it from your list of available programs loaded on your computer. For detailed information on the features of 3D

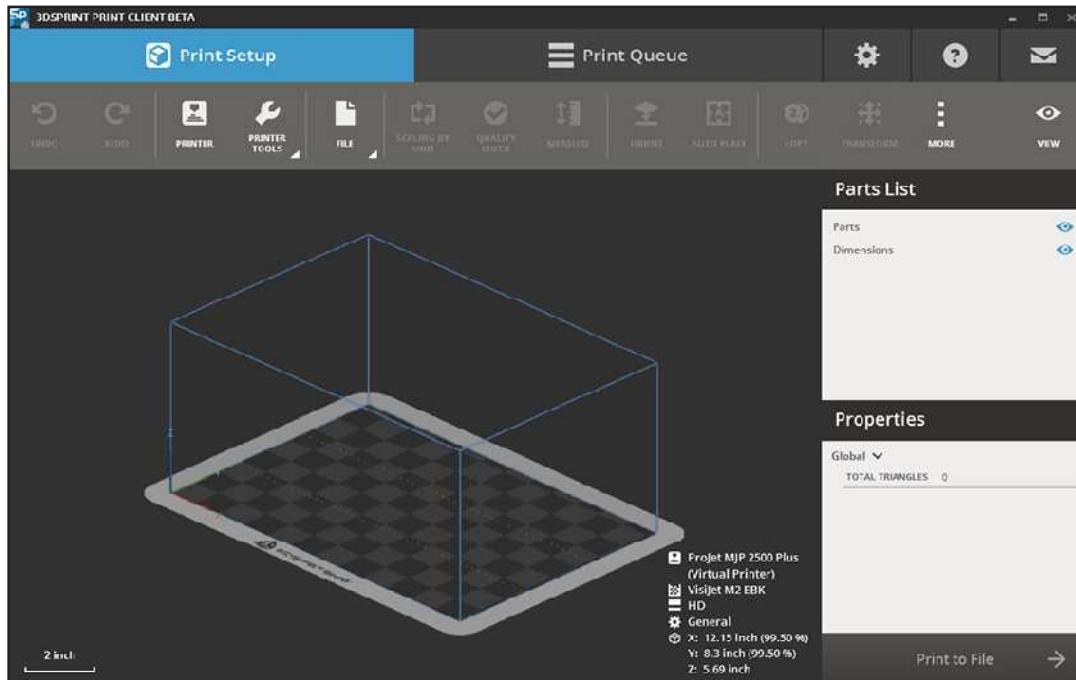
SPRINT, as well as user guides for part preparation, you can access the full help document by clicking on the  icon inside the 3D SPRINT software.



**NOTE:** If you do not have 3DSPRINT loaded on your computer you can obtain a copy at <http://infocenter.3dsystems.com/product-library/projet-6000#software-downloads>.



**NOTE:** Although there are QC styles in 3D SPRINT, it will not currently generate good QC parts. For printing with QC styles, revert to using 3D Manage software until the next version of 3D SPRINT is available.

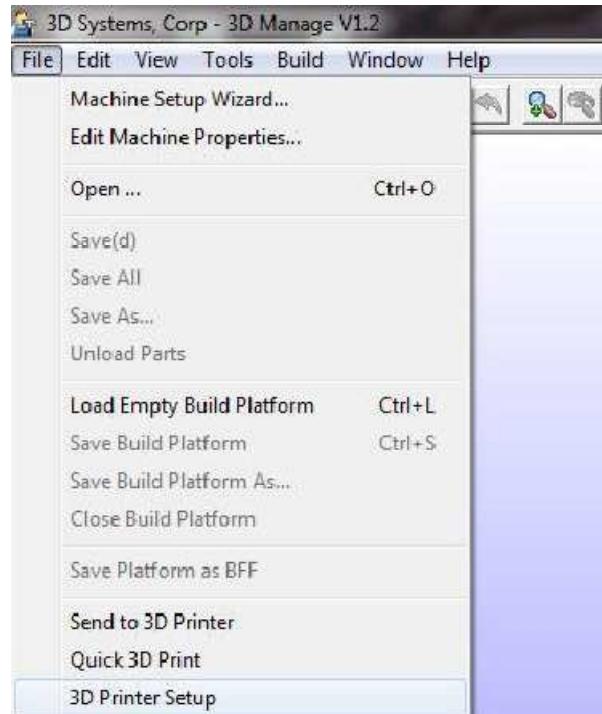


3DSprint Home Screen

## INSTALL THE PROJET™ 6000 IN 3D MANAGE

3D Manage is Legacy Software for the Projet 6000. If you are still using 3D Manage, consider upgrading your computer to prepare it for 3DSprint.

1. Open 3D Manage.
2. Select **File > 3D Printer Setup**.

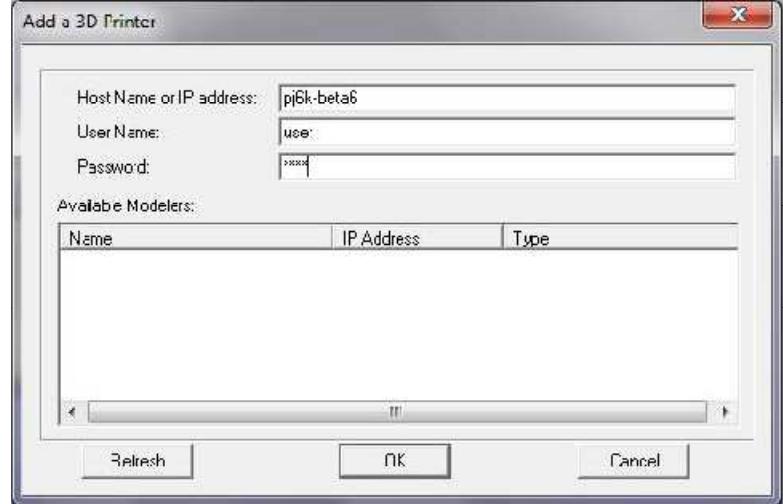


3. Click Add 3D Printer.

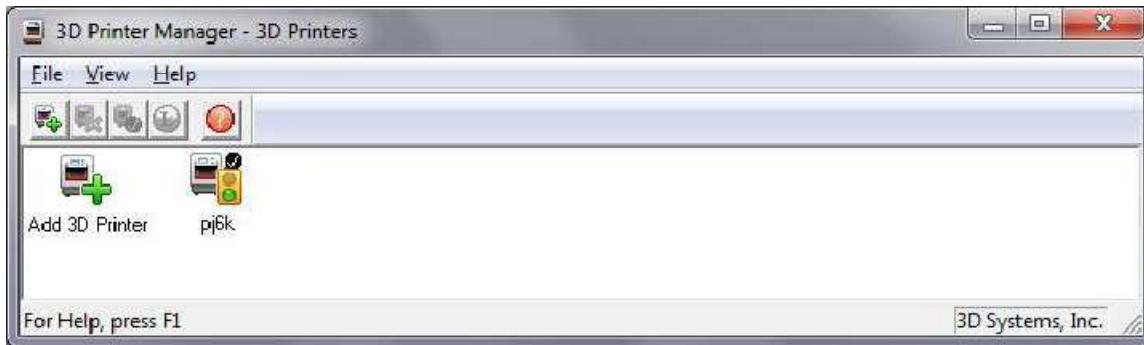


4. Enter the following information:

- Host Name or IP Address of the printer you wish to install
- User Name and password you will use to access the printer.
- Click **OK**.

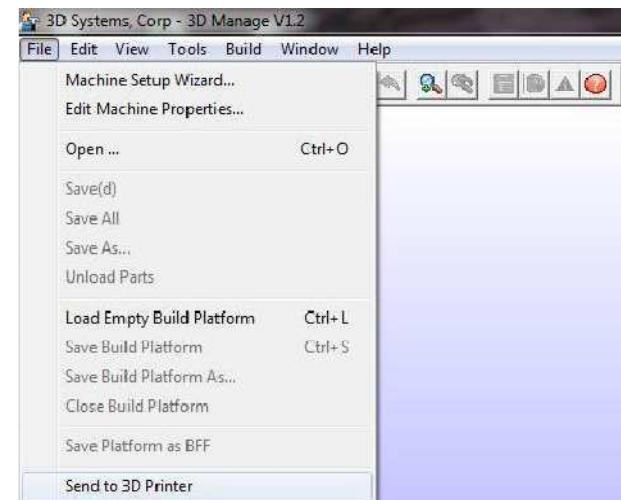


5. 3D Manage will show the printer as installed and available.

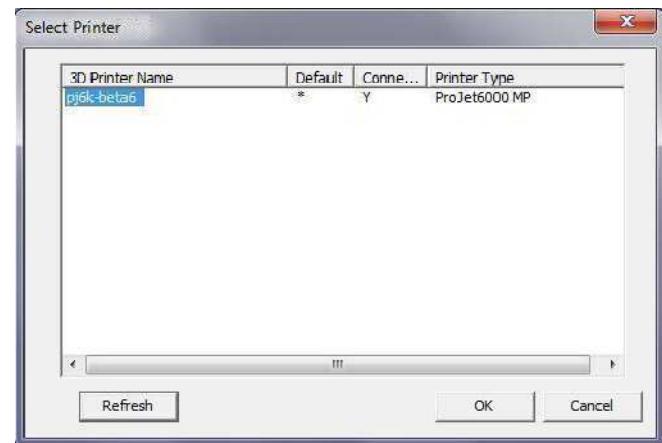


## SUBMIT A PRINT JOB

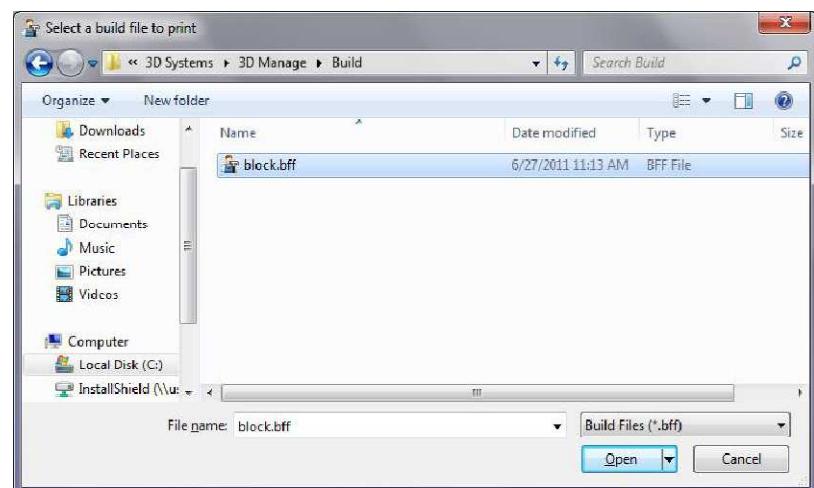
- Start 3D Manage.
- Select **File > Send to 3D Printer**.



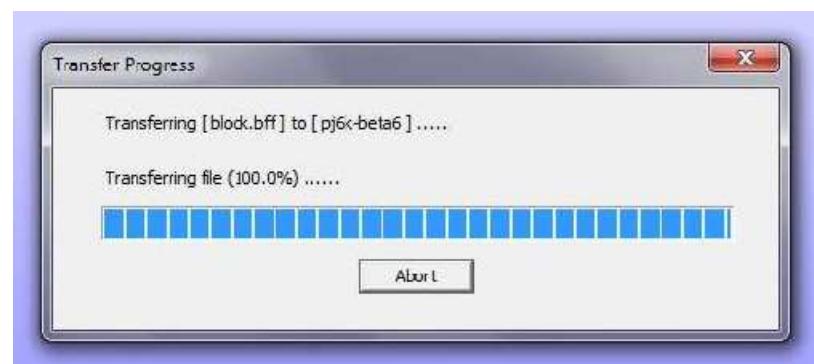
3. The system will ask you to select a printer.



4. The system will ask you to select a part to build.



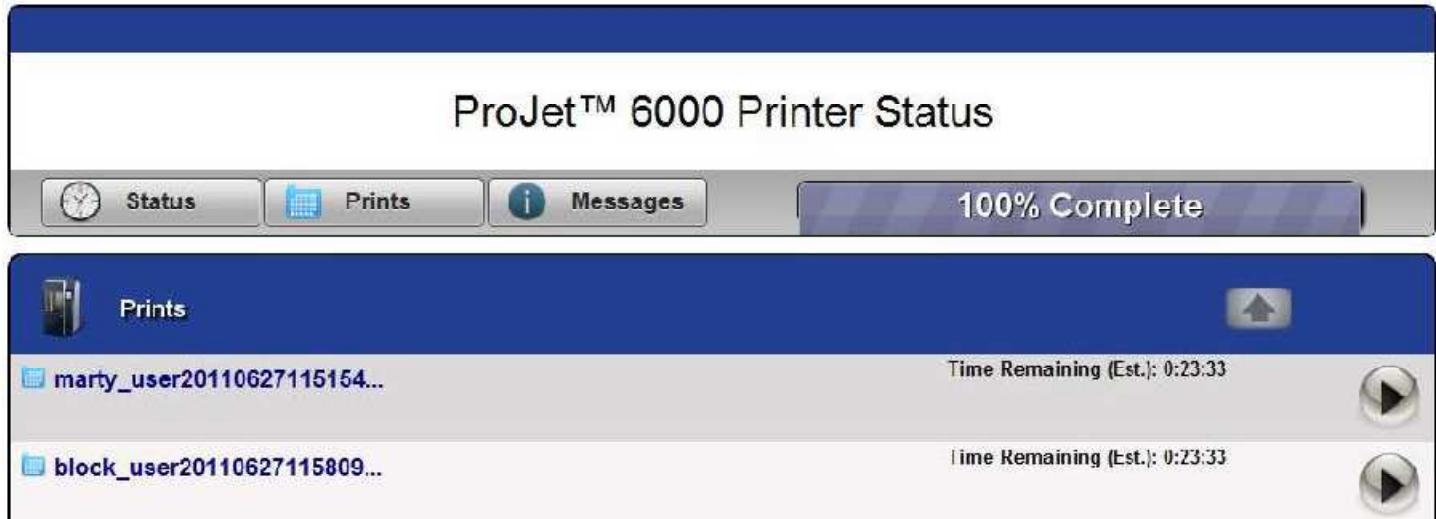
5. The following screen is displayed after selecting a part.



6. The system will request a username and password before displaying the **ProJet™ 6000 Printer Status** screen.



7. The **ProJet™ 6000 Printer Status** screen is displayed with the **block.bff** part displayed in the print queue.



### START A PRINT JOB

After print jobs have been submitted to the printer, the user may use the front panel to select and start a particular print job.

1. Press the **Prints** key.
2. The system will display the **Prints** screen.
3. Select a print job by touching the name on the display.
4. Press the **Start Print** key.



1. When a print job completes, the system will display the message and the system will also indicate an alert. Press the key to display the alert screen.
2. Press the right arrow key beside the print job.
3. Press the key to raise the print platform to the offload position. Do not open the chamber door until instructed to do so.



4. Open the chamber door and release the print platform from the forks.
5. Notches in the forks allow you to position the platform as shown. To allow all excess resin to drain, leave the platform in this position for approximately five minutes.
6. Carefully tilt the platform forward to drain print material that may be trapped in recessed areas or cavities within the parts.

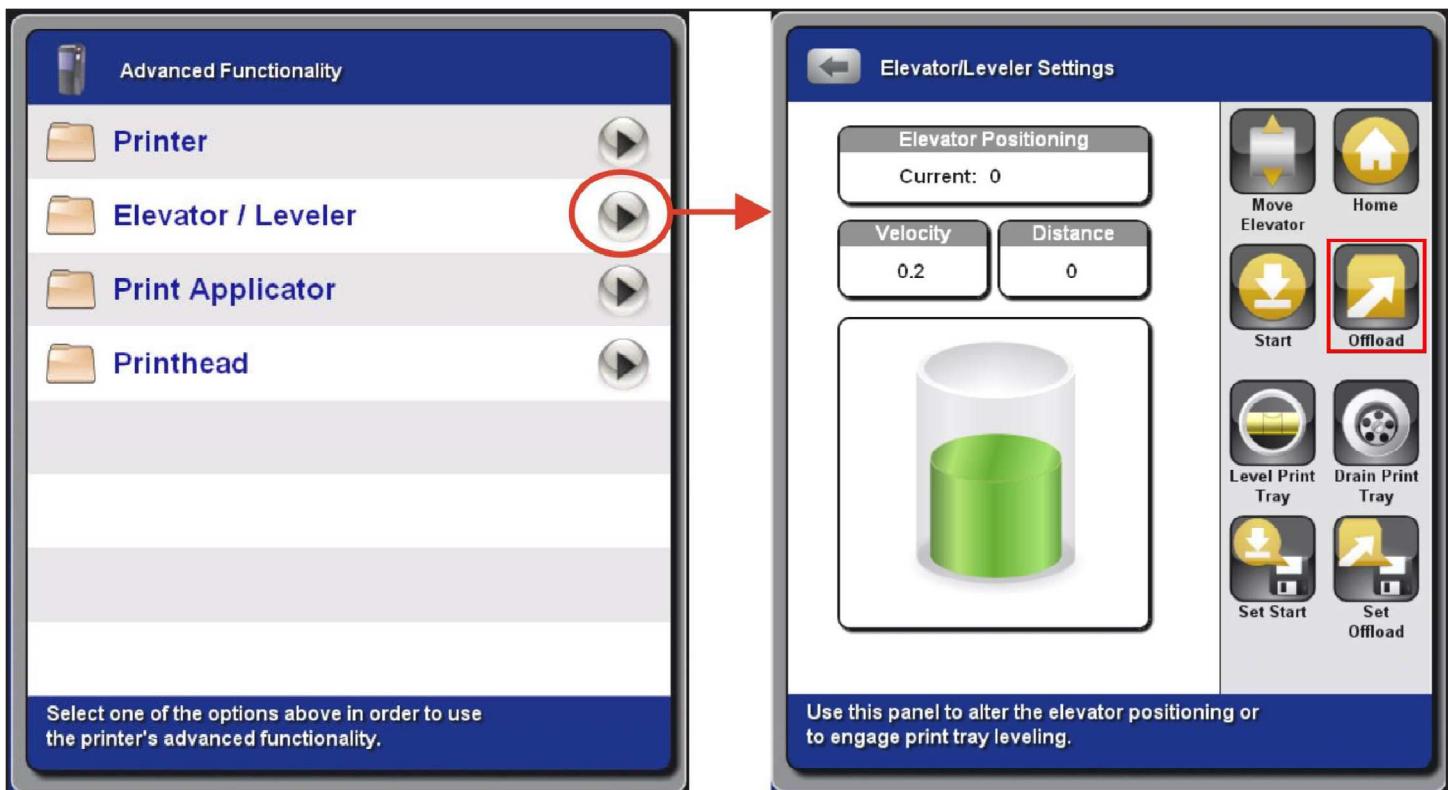


7. Remove the print platform for post processing.

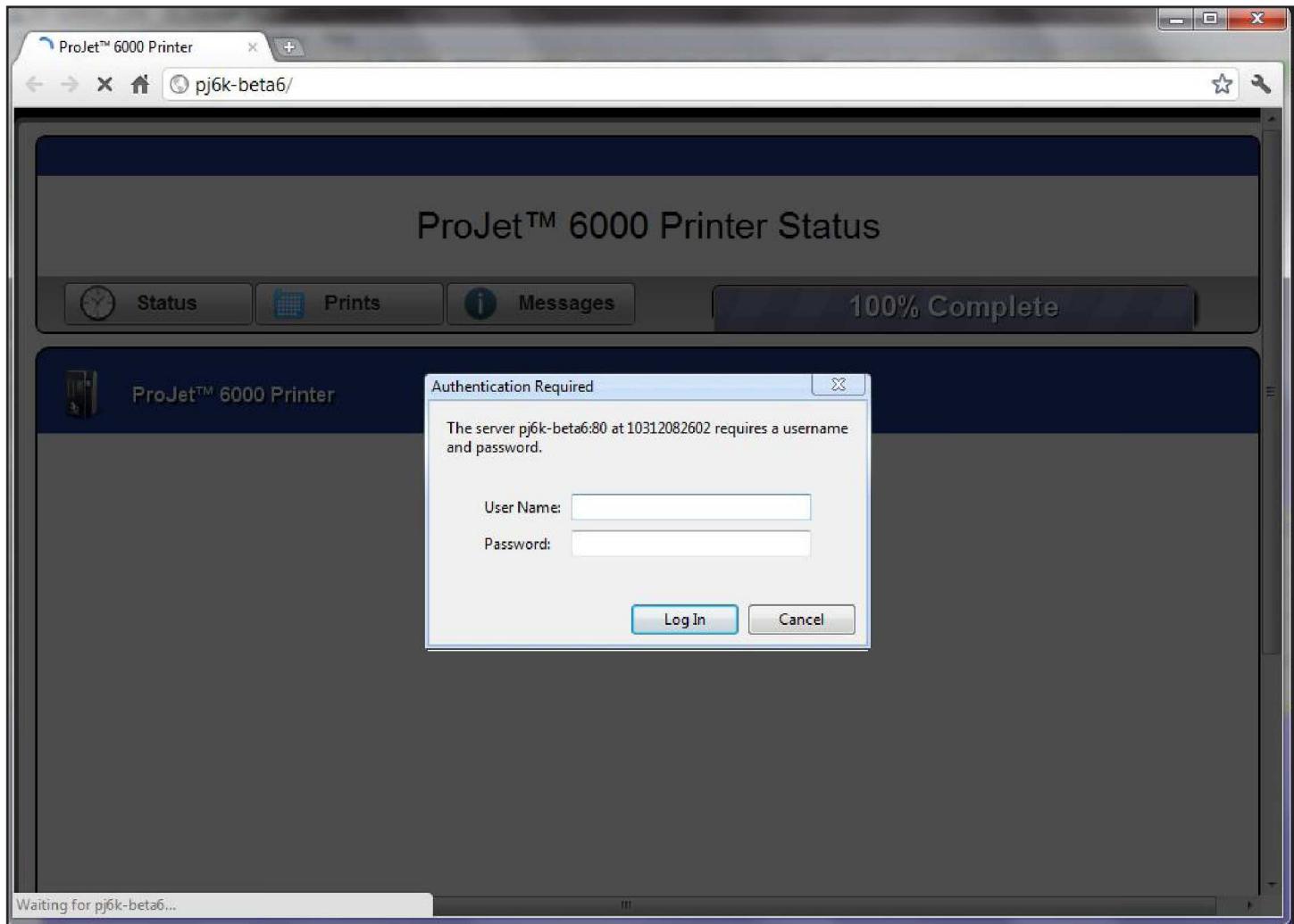
### Move Print Platform to Offload Position using Elevator Controls



1. On the status screen, press **Advanced**.
2. Press **Elevator/Leveler > Offload**. Do not open the chamber door until instructed to do so.



1. To remotely access the ProJet™ 6000, enter the IP address or the system name for the printer into the internet browser. The default system name is \*pj6k-xxxxx, where xxxx is the last five digits of the printer's serial number.
2. The printer will require you to enter a user name and password. Use the same user name and password you would use if logging in on the front panel of the printer.



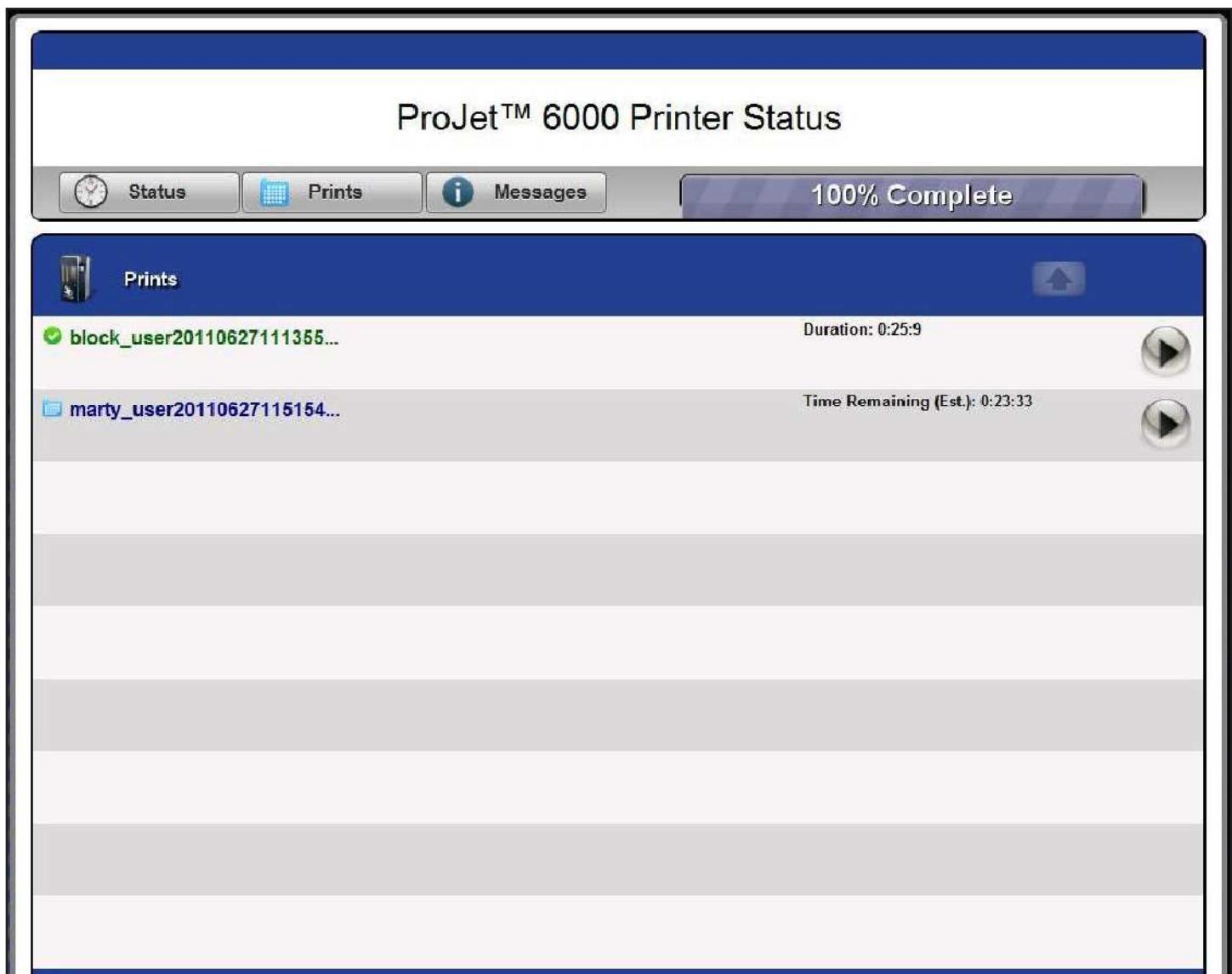
3. The system will display the screen shown below. The display provides three tabs you can view. The first screen displayed is the **Status tab** which contains the same information displayed on the printer GUI.

The screenshot shows the 'ProJet™ 6000 Printer Status' interface. At the top, there are three tabs: 'Status' (selected), 'Prints', and 'Messages'. A progress bar indicates '13.1% Complete'. The main area is titled 'Status' and contains the following data:

Air Temperature	28.757
Current Material	VisuJet Flex
Model Name	ProJet 6000 HD
Material Temperature	32.189
Print Height	0.388
Print Name	Flex-XHD-Marketing2_stacie20110922101440448
Printer Status	Printing
Estimated End Time	2011-09-24T13:30:48Z
Printer Action	Drawing Supports

At the bottom, a message says 'Click on any of the alerts above for the full message'.

4. The **Prints** tab displays all print jobs that have been submitted to the printer. Clicking the  key adjacent to a print job will provide detailed information about that print job. Although the remote access allows you to view detailed information, you cannot modify prints jobs (delete, parameter modification, etc.) through this feature.



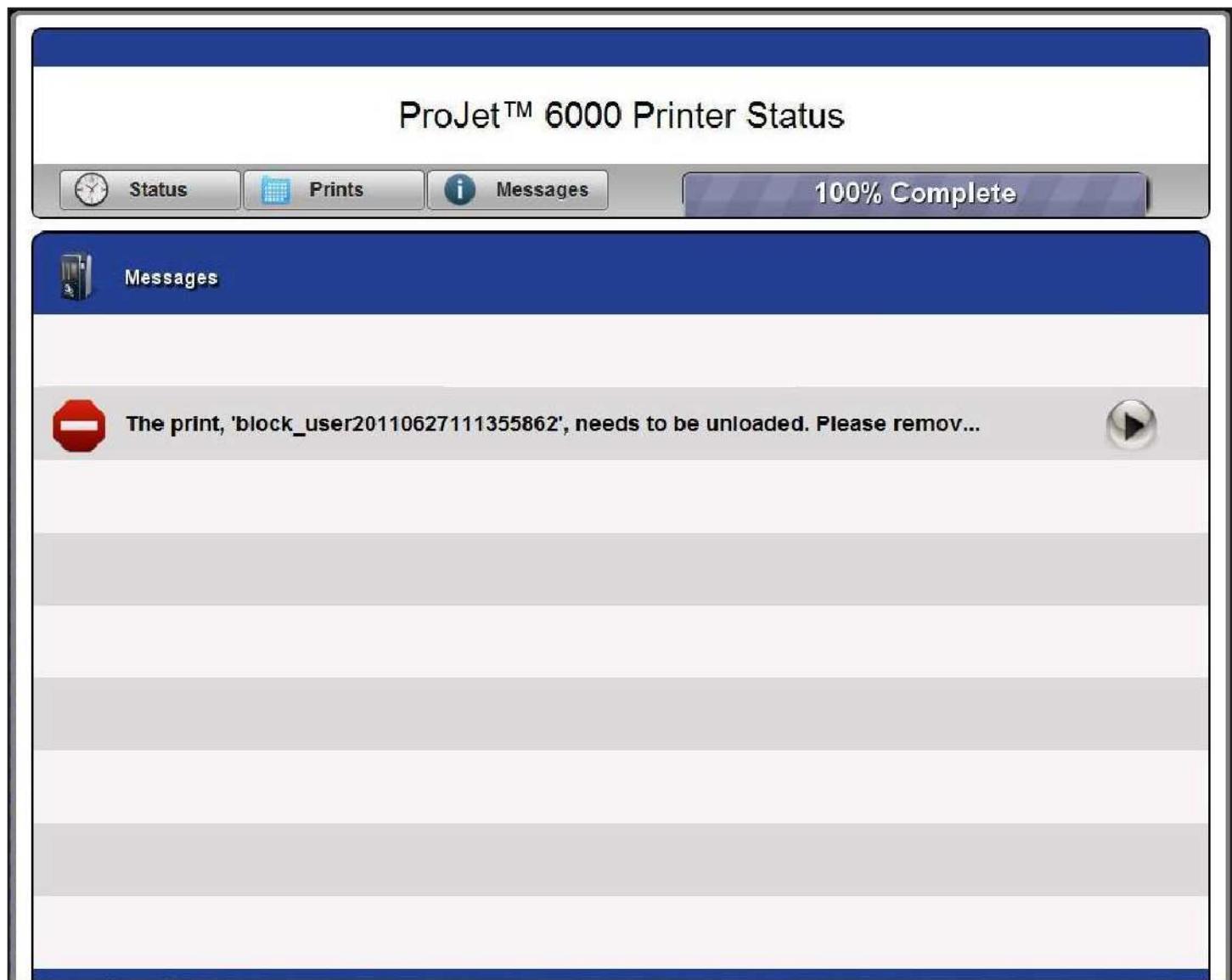
The screenshot shows the ProJet™ 6000 Printer Status software interface. At the top, there is a blue header bar with the title "ProJet™ 6000 Printer Status". Below the header, there is a navigation bar with three tabs: "Status" (with a clock icon), "Prints" (with a printer icon), and "Messages" (with a message icon). The "Prints" tab is selected, indicated by a blue background. A progress bar at the top of the "Prints" section shows "100% Complete".

The main content area is titled "Prints" and shows two print jobs:

- block\_user20110627111355...** Duration: 0:25:9 
- marty\_user20110627115154...** Time Remaining (Est.): 0:23:33 

The interface has a dark blue header and a light gray background for the main content area. There are several horizontal gray bars in the background of the content area.

5. The **Messages** tab provides the same information that is provided on the **Alerts** screen of the printer GUI. Similar to the **Prints** tab, you can view information but you cannot “acknowledge” the alert messages.



## 7 POST PROCESSING

For post processing, please refer to **ProJet™ Parts Finishing System User Guide** located on <http://support.3dsystems.com>.

## 8 BASIC REGULATIONS

3D Systems has tested this printer to electromagnetic emission and immunity standards. These standards are designed to mitigate interference caused or received by this printer in a typical 3D-printing environment.

### UNITED STATES

This equipment has been tested and found to comply with the limits for a Class A digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference when the equipment is operated in a commercial environment. This equipment generates, uses, and can radiate radio frequency energy. If it is not installed and used in accordance with these instructions, it may cause harmful interference to radio communications. Operation of this equipment in a residential area is likely to cause harmful interference in which case the user will be required to correct the interference at his/her own expense.

Changes or modifications to this equipment not approved by 3D Systems can void the authority of the user to operate this equipment.

### CANADA

Ce dispositif est conforme à la norme CNR-210 d'Industrie Canada applicable aux appareils radio exempts de licence. Son fonctionnement est sujet aux deux conditions suivantes: (1) le dispositif ne doit pas produire de brouillage préjudiciable, et (2) ce dispositif doit accepter tout brouillage reçu, y compris un brouillage susceptible de provoquer un fonctionnement indésirable.

This Class A digital apparatus complies with Canadian ICES-003.

Cet appareil numérique de la classe A est conforme à la norme NMB-003 du Canada.

### EUROPEAN UNION



**CAUTION: This is a Class A product. In a domestic environment, this product can cause radio interference in which case the user could be required to take adequate measures.**

In order to allow the equipment to operate in close proximity to Industrial, Scientific and Medical (ISM) equipment, the external radiation from the ISM equipment may have to be limited or special mitigation measures taken.

Changes or modifications to this equipment not approved by 3D Systems can void the authority of the user to operate this equipment.

## EC DECLARATION OF CONFORMITY



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## EC DECLARATION OF CONFORMITY (DoC)

We

Manufacturer: *3D Systems Corporation*  
 Address: *333 Three D Systems Circle Rock Hill, SC 29730*

declare under sole responsibility for issuing this declaration of conformity in relation to the following Product(s):

Product Description: *Stereolithography (SLA) 3D Printer*  
 Model: *ProJet® 6000 SD, ProJet® 6000 HD, and ProJet® 6000 HD*  
*ProJet® 7000 SD, ProJet® 7000 HD, and ProJet® 7000 HD*  
 Serial Number:

For the above given Product(s) is hereby declared that it conforms to the essential requirements set out in community harmonization legislation mentioned below:

*Machinery Directive 2006/42/EC of 17 May, 2006*

*Electromagnetic Compatibility Directive 2014/30/EU of 14 October 2014*

*Radio Equipment Directive 2014/53/EU of 13 June 2016*

Statement about the relevant harmonized standards that have been used, or statement about the specifications in relation to which conformity is declared (Standard: Date of Issue):

<i>EN 61010-1:2013</i>	<i>EN 60825-1:2014</i>
<i>EN 12100:2010</i>	<i>EN55011:2009 + A1:2010</i>
<i>EN 61000-6-1:2007</i>	<i>EN 61000-3-2:2014</i>
<i>EN 61000-3-3:2013</i>	<i>EN 301 489-1 v2.2.0</i>
<i>EN 301 489-3 v2.1.1</i>	

Additional Information: Reserved

Name of Person Authorized to compile the technical construction file:

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*des portes du Maine*  
*72 380 Joué L'Abbé, France*

Signed for and on behalf of:

*Wilsonville, OR, USA*  
*Place of issue*

*May 25, 2017*  
*Date of issue*

*David Heath*  
*David Heath, Regulatory Compliance TMP*



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