



S-series

Introduction of Melt Dissolvable Support And Midas Build Material

Summary

In an effort to address customer requests and to simplify our material offerings we will be consolidating our 3Z Support, Melt- J and Melt-I dissolvable support materials into a single product, **Melt**.

Melt will feature all the same support characteristics and post processing steps as its predecessors, however Melt has a lower melting point.

Melt is available for Solidscape High Precision 3D Printers as the following:

970174 Melt Tray (1 Tray of 10 crayons)

970174-6 Melt Case (1 Case of 6 Trays)

3Z Model (Build) material will also change to **Midas** build material for all 3Z printers (except 3Z Lab).

Midas provides the same castability features as 3Z Model material, so there is no change to model quality or your current casting process.

Midas is available for Solidscape High Precision 3D Printers as the following:

970169 Midas Tray (1 Tray of 10 crayons)

970169-6 Midas Case (1 Case of 6 Trays)

The material will be available at the same price and color and will come in new packaging (Figure 1).



Figure 1

Melt material requires changes to defaulted temperature values and Operating set points.

Please find the details that match your machine type below.

Details for 3Z Studio, 3Z Pro, 3Z Max, 3Z Max², S350 & S370

1. Please continue to use your existing 3Z Support (970119), Melt-J (970172), and 3Z Model (970120). When you have used the last of these materials it is OK to add Melt (970174) or Midas (970169) right on top of existing material.

2. Temperature settings should remain at 3Z Support/Melt-J values until after the third crayon of Melt is added. Once the tank contains 3+ crayons of Melt, change temperature set points to:

- Support Printhead 105°C
- Support Heated Line 105°C
- Build Tank 115°C
- Support Tank (S350 & S370 only) 97°C

a. To change temperature setpoints, navigate to the **Thermal Screen** and press to open (Figure 2)*.

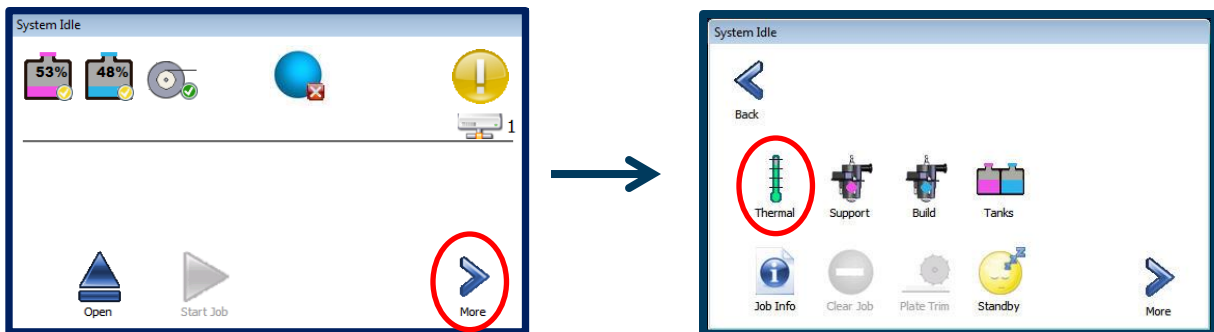


Figure 2

*Images represent S-Series printer interface. 3Z process is similar, except the thermal screen shows one tank temperature, which will be set to the Midas (build material) temperature setting.

- b. Press on each of the circled icons below, in turn, to change the setpoints of the Support Heated Line, Support Printhead, and Support Tank (Figure 3).

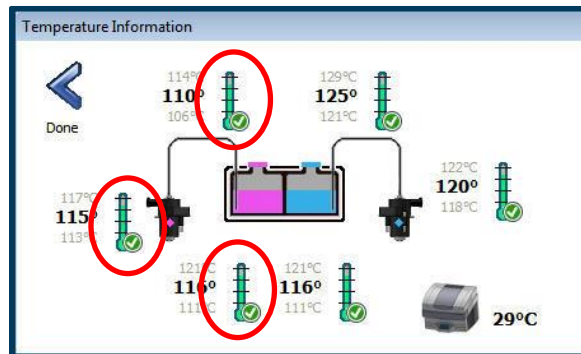


Figure 3

- c. Use the arrow buttons to adjust the setpoint temperature once the 3rd crayon of Melt material has been added. Press Apply once done (Figure 4).

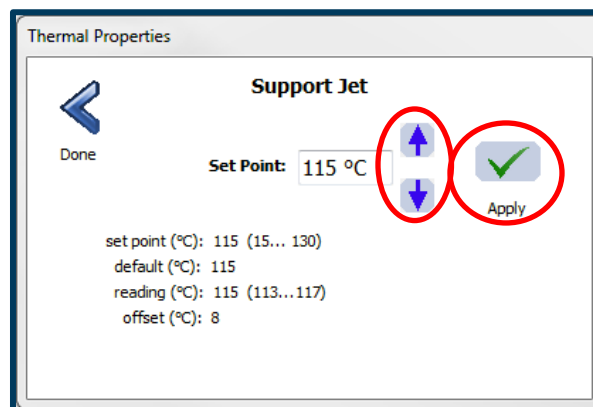


Figure 4

- d. Repeat this step for the Support Heated Line, Support Printhead, and Support Tank.

3. **Midas** can be added immediately after your last 3Z Model crayon is used.
- Once the printer is using Midas, change the temperature setpoint of the Build Tank to **115°C**, following the steps above.



3Z Printer Patch instructions are below.

S350/S370 Printer Patch instructions, refer to page 5

S390/S500 Printer Patch instructions, refer to page 6

3Z Printers

For **3Z Studio, 3Z Pro, 3Z Max, and 3Z Max²** a yellow check mark will appear next to each component because the new set points do not match the default set points. A patch is required to correct this.

- Operating set points will still need to be changed manually to the new values. Refer to **Step 2** on page 2 for this process.
- Printers will show yellow check marks on the thermal screen for components until the default set point patch is installed (Figure 5a and 5b).

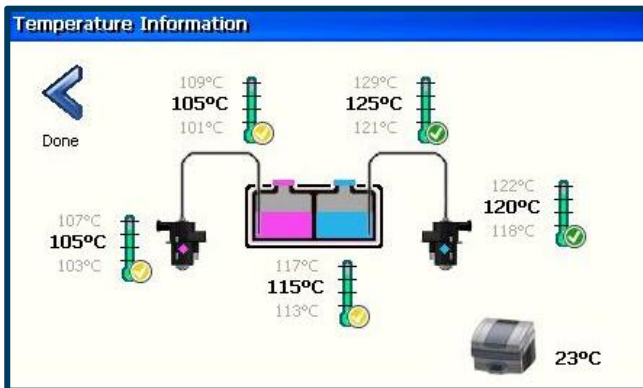


Figure 5a:

A 3Z at the proper temperatures prior to installing the default set point patch.

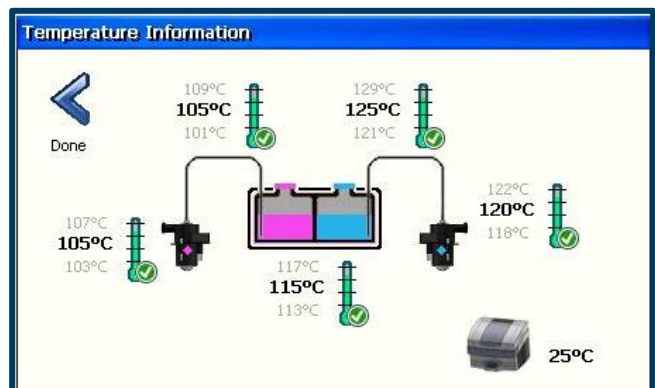


Figure 5b:

A 3Z at the proper temperatures after installing the default set point patch.

The required patch will change the default setpoints for both the Melt and Midas components as outlined above.

Patch Installation:

1. Download the patch required based on your printer type from the links below.
2. The patch consists of two files, these should be added to the root of a flashdrive; they cannot be in a folder.
3. Turn off your printer and insert the flashdrive into the USB port.
4. Turn on your printer and follow the onscreen prompts to install the patch.
5. Restart your printer.
6. If successful, the checkmark on the temperature screen will turn green (Figure 5a and 5b).

3Z Printers serial number 1199 and lower: [3Z P2 Patch Here](#)

3Z Printers serial number 1200 and higher: [3Z P3 Patch Here](#)

S350 and S370 Printers

For S350 and S370 printers, a yellow check mark will appear next to each component because the new set points do not match the default set points. A patch is required to correct this.

- Operating set points will still need to be changed manually to the new values. Refer to **Step 2** on page 2 for this process.
- Printers will show yellow check marks on the thermal screen for components until the default set point patch is installed (Figure 6a and 6b)

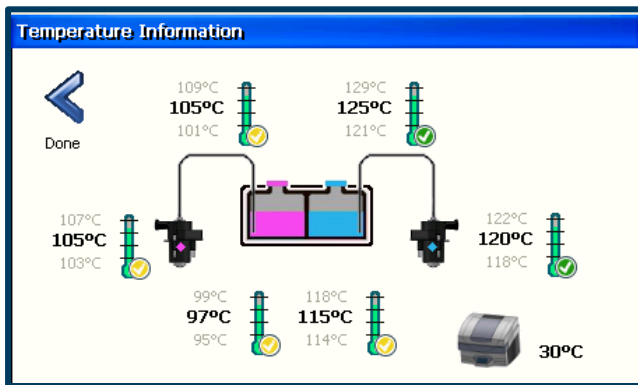


Figure 6a:

S-series at the proper temperatures prior to installing the default set point patch.

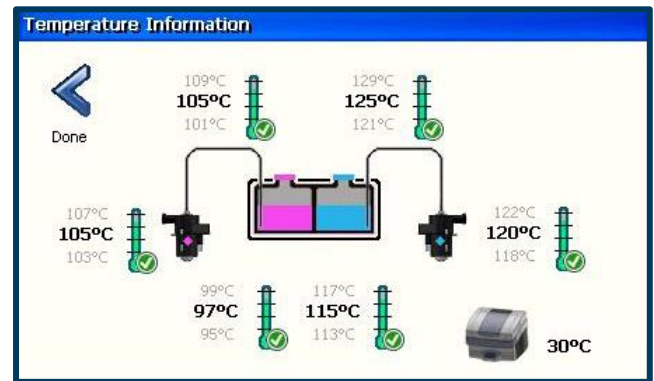


Figure 6b:

S-Series at the proper temperatures after installing the default set point patch.

The required patch will change the default setpoints for both the Melt and Midas components as outlined above.

Patch Installation:

1. Download the patch required based on your printer type from the links below.
2. The patch consists of two files, these should be added to the root of a flashdrive; they cannot be in a folder.
3. Turn off your printer and insert the flashdrive into the USB port.
4. Turn on your printer and follow the onscreen prompts to install the patch.
5. Restart your printer.
6. If successful, the checkmark on the temperature screen will turn green (Figure 6a and 6b).

S350 and S370 Printers: [Patch Here](#)



Introduction of Melt Dissolvable Support And Midas Build Material

S390 & S500 Printers

1. S390 and S500 models were shipped with the Melt material and new set points.
2. Use ONLY Melt material
3. Please ensure that set points are set to:

Do Not Use 3Z Support or Melt-J.

- Support Printhead	105°C
- Support Heated Line	105°C
- Build Printhead	115°C
- Build Heated Line	120°C
- Build Tank	115°C
- Support Tank	97°C

If your Build Tank temperature is incorrect, follow **Step 2 on page 2** to adjust the setpoint. Then install the patch as outlined below.

Patch Installation:

1. Download the patch required based on your printer type from the links below.
2. The patch consists of two files, these should be added to the root of a flashdrive; they cannot be in a folder.
3. Turn off your printer and insert the flashdrive into the USB port.
4. Turn on your printer and follow the onscreen prompts to install the patch.
5. Restart your printer.
6. If successful, the checkmark on the temperature screen will turn green (Figure 6a and 6b).

S390 and S500 Printers: [Patch Here](#)

3Z Lab Printers

1. 3Z Labs will continue to use LabCast and LabFill at existing temperatures. No action is necessary for these products.

If there are any questions, please call or email Solidscape Customer Support:

603-429-9700 ext. 505 || service@solidscape.com.