

Esempio Stampa 3D Stratasys

Corso Materiali intelligenti e Biomimetici
10/05/2018

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File in
formato
STL



Insight - PIASTRA_INF

File Edit View Modelers STL Slice Support Toolpaths Help

Open...
Close
Paste Job from clipboard

Save
Save As...
Delete...

Print...

Build...
Preferences...
Customize

Exit

Modeler Setup

Configure the modeler to build the part.

Fortus 250mc	0.2540 slice height
Model T14 tip	ABS P430
Support T16 tip	ABS SR30

Part interior style Sparse - high density

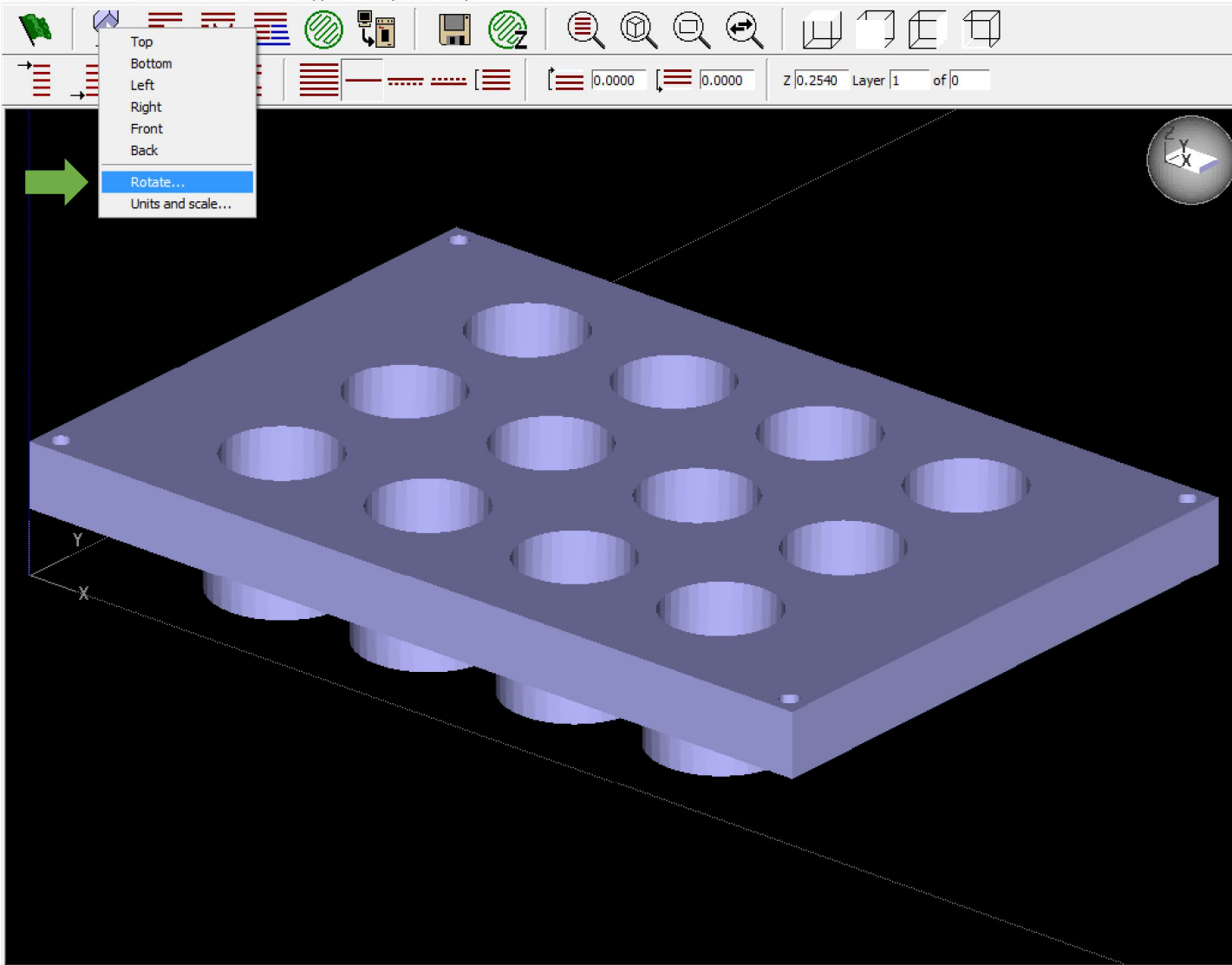
Visible surface style Enhanced

Support style SMART

STL size mm X = 135.0010 Y = 89.9998 Z = 20.0000

STL | 135.00; 89.9998; 20.0000 | Z | 0.2540

FORTUS 250mc



- Top
- Bottom
- Left
- Right
- Front
- Back
- Rotate...**
- Units and scale...

STL Rotate

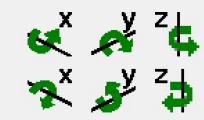
Rotate the STL model by specifying rotation angles or incrementally nudging the model using the buttons. STL display under the STL menu must be checked.

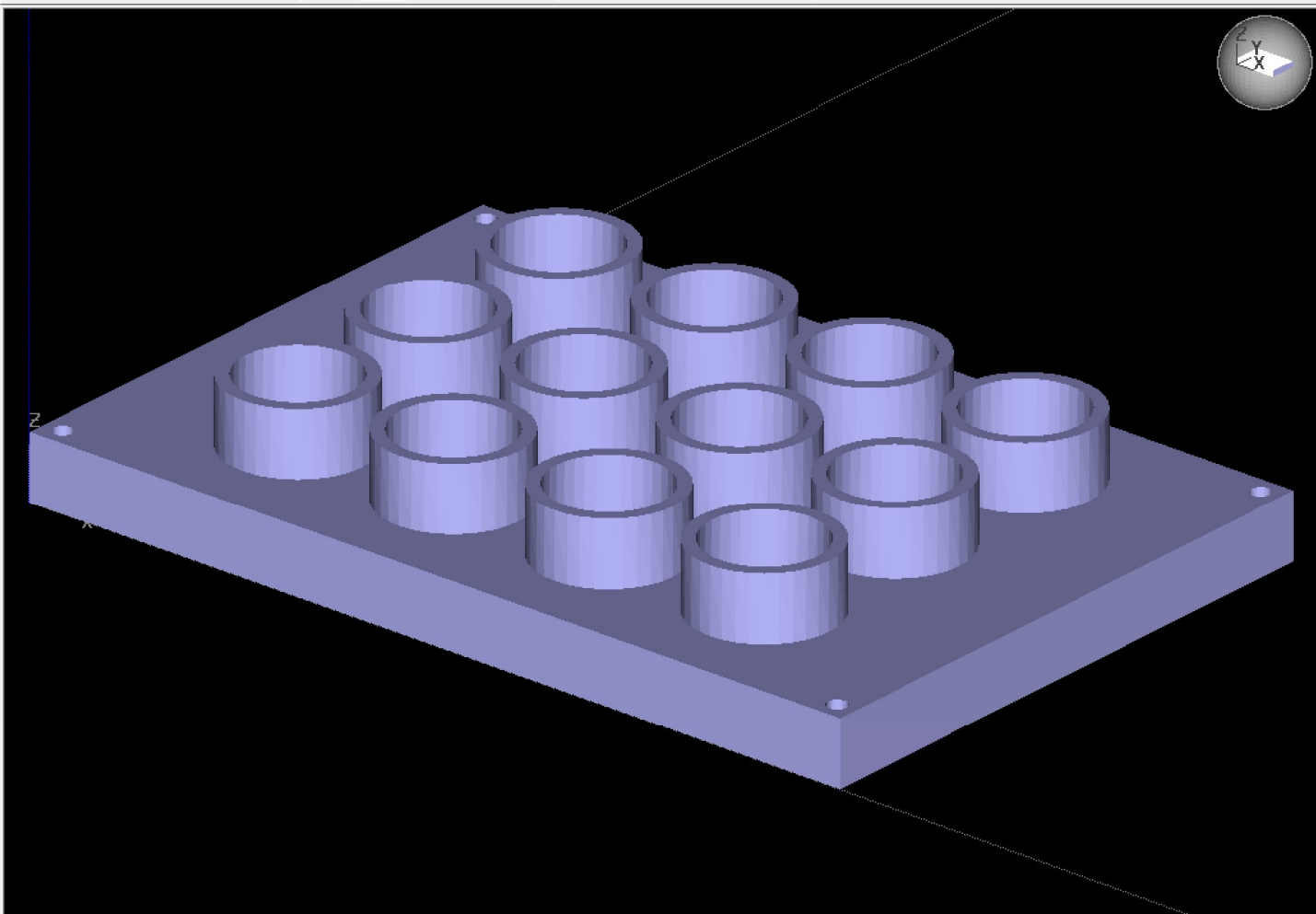
Rotation about X

about Y

about Z

Rotate increment





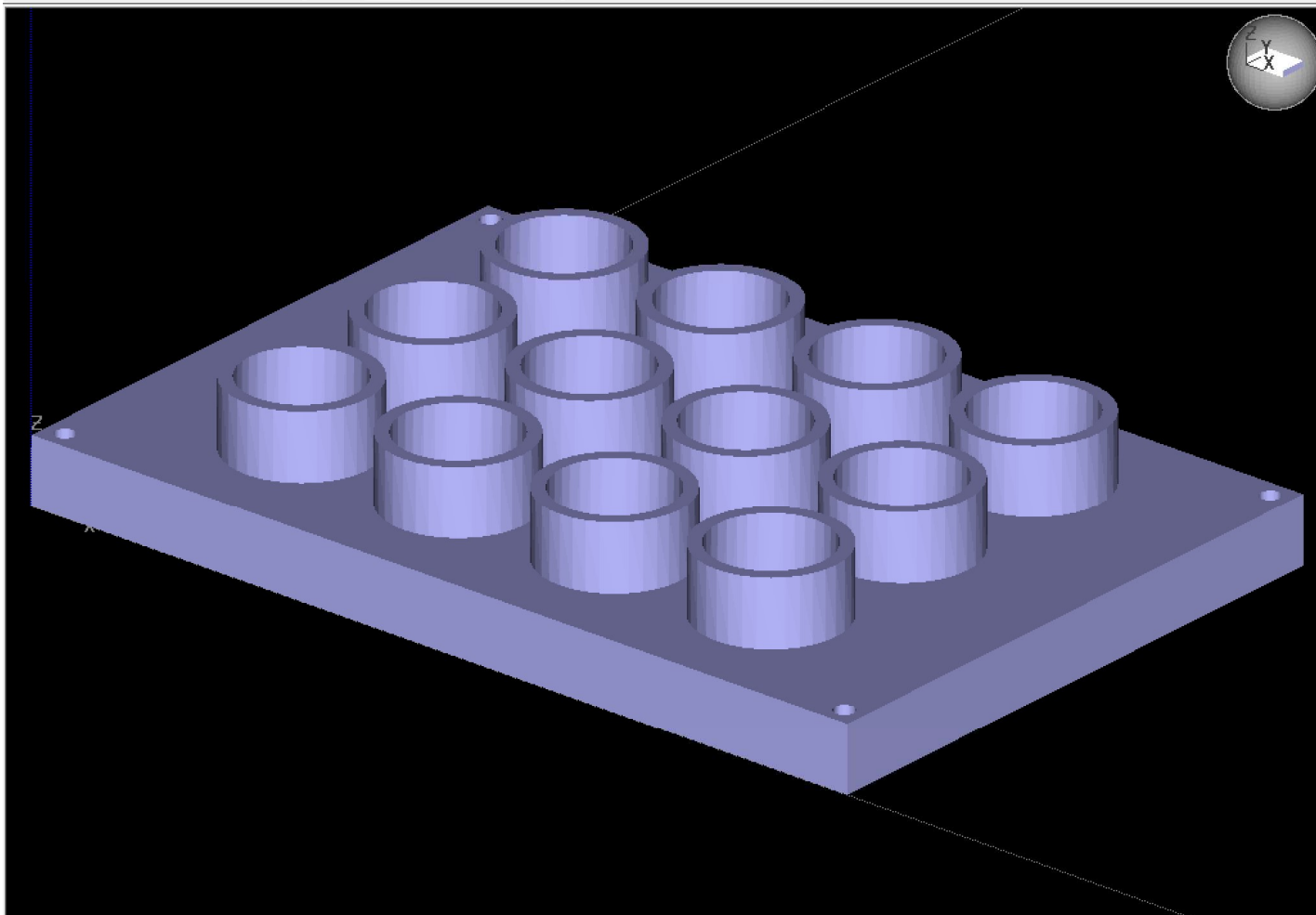
STL Rotate

Rotate the STL model by specifying rotation angles or incrementally nudging the model using the buttons. STL display under the STL menu must be checked.

Rotation about X: 180.0000
about Y: 0.0000
about Z: -180.0000

Rotate increment: 90.0000

A set of six icons for axis rotation: X, Y, and Z axes, each with a green arrow indicating the direction of rotation.



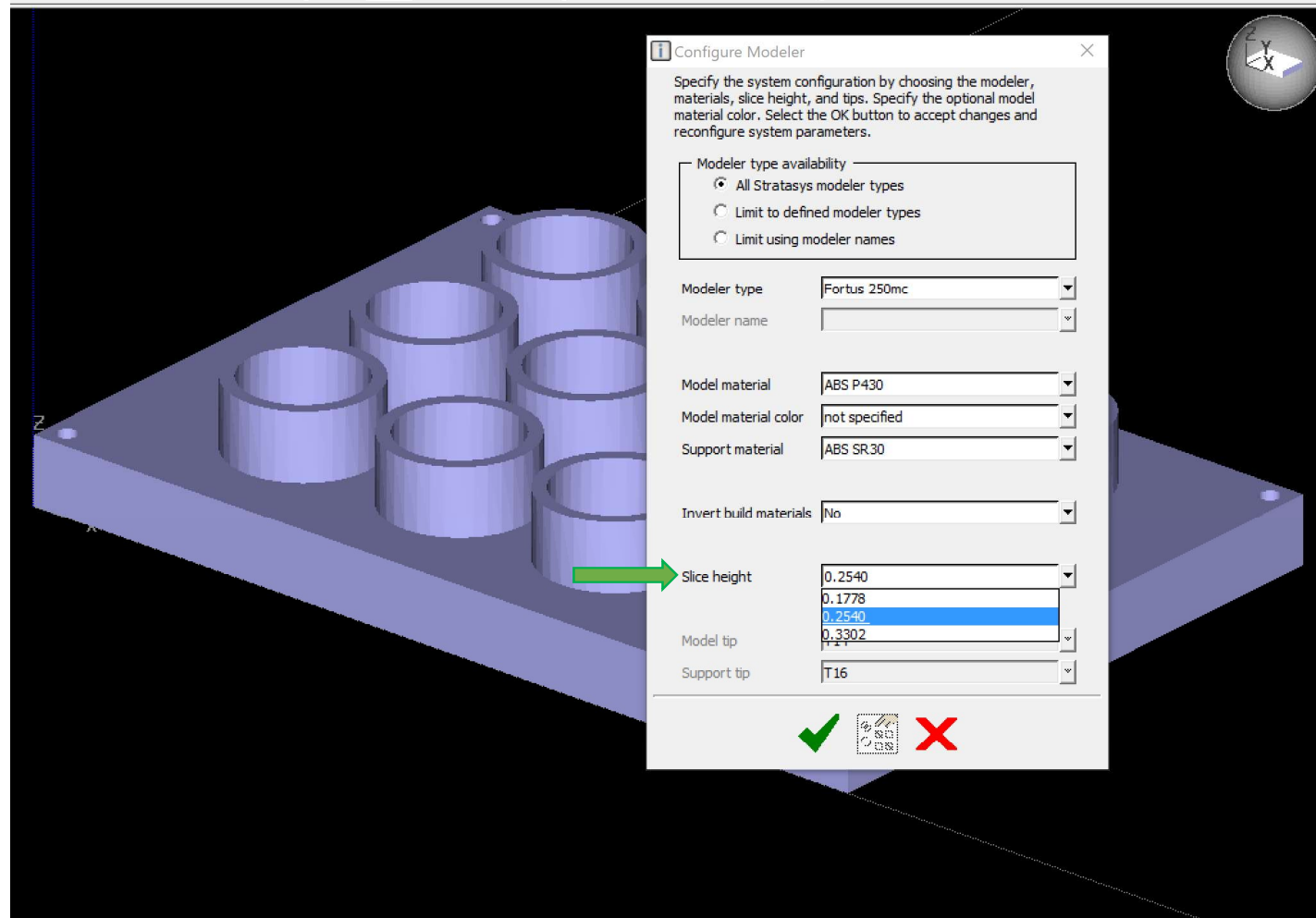
Modeler Setup

Configure the modeler to build the part.

Fortus 250mc 0.2540 slice height
Model T14 tip ABS P430
Support T16 tip ABS SR30

- Part interior style Sparse - high density
- Visible surface style Solid - normal
- Sparse - high density
- Sparse - low density
- Support style Sparse - double dense





Configure Modeler

Specify the system configuration by choosing the modeler, materials, slice height, and tips. Specify the optional model material color. Select the OK button to accept changes and reconfigure system parameters.

Modeler type availability

- All Stratasys modeler types
- Limit to defined modeler types
- Limit using modeler names

Modeler type: Fortus 250mc

Modeler name: [empty]

Model material: ABS P430

Model material color: not specified

Support material: ABS SR.30

Invert build materials: No

Slice height: 0.2540 (highlighted)

Model tip: 0.3302

Support tip: T16

Buttons: [OK] [Cancel] [Apply]

Modeler Setup

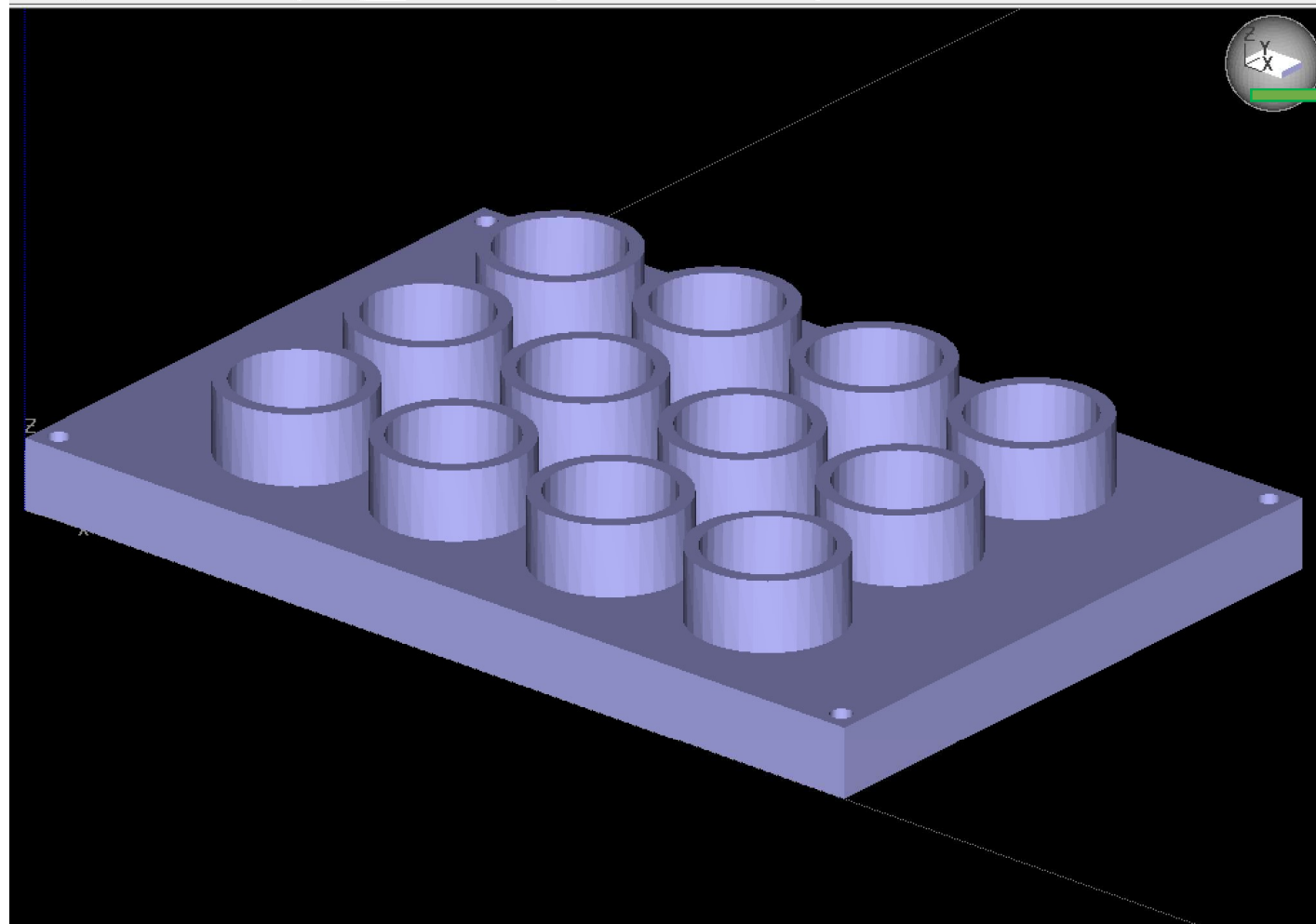
Configure the modeler to build the part.

Fortus 250mc	0.2540 slice height
Model T14 tip	ABS P430
Support T16 tip	ABS SR.30

- Part interior style: Sparse - low density
- Visible surface style: Enhanced
- Support style: SMART



FORTUS 250mc



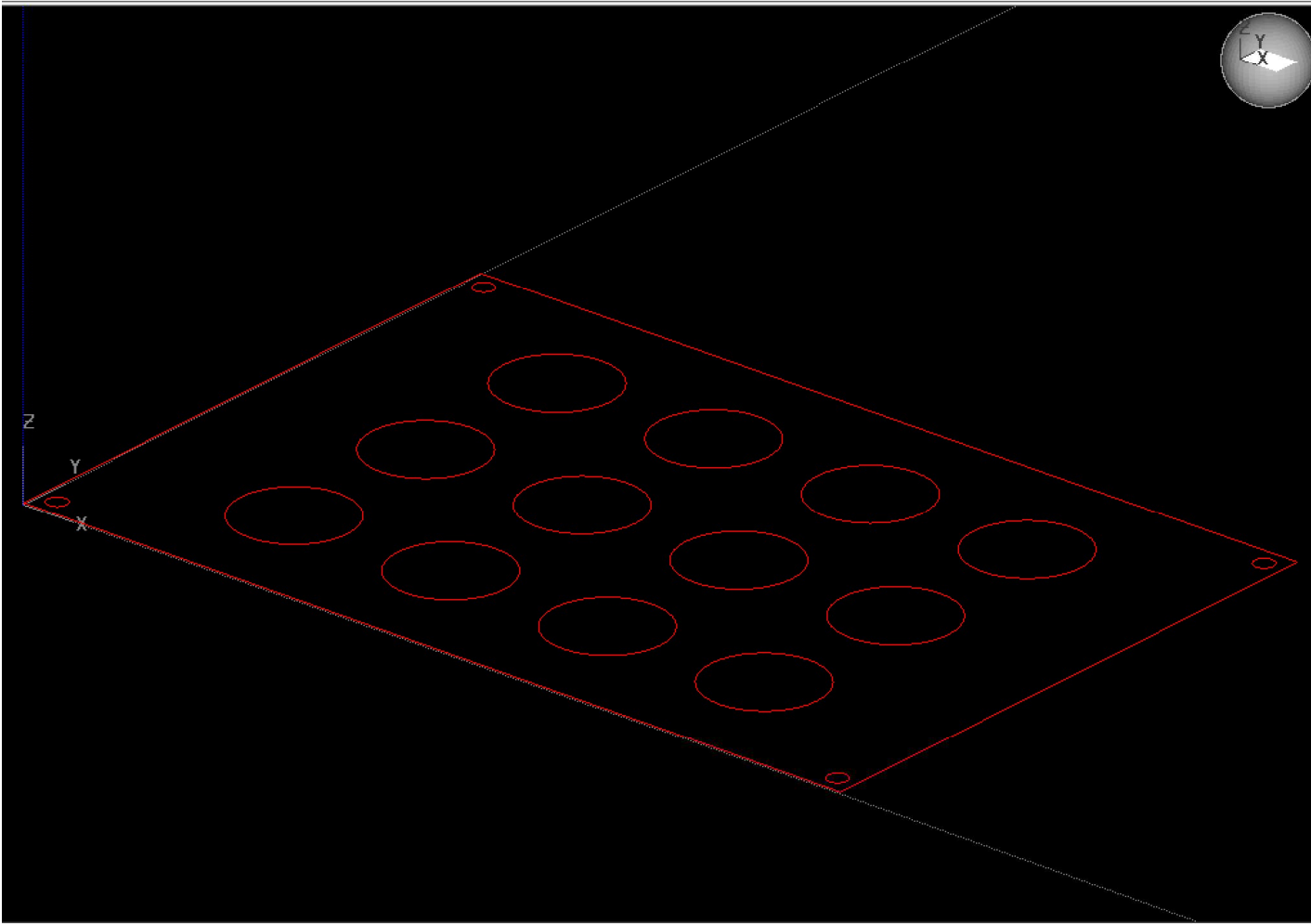
Toolpath Setup

Fortus 250mc 0.2540 slice height
Model T14 tip ABS P430
Support T16 tip ABS SR30

Part fill style	One contour / rasters
Contour width	0.5080
Number of contours	0.3556 0.3806
Part raster width	0.4056 0.4306
Part interior style	0.4556 0.4806
Number of interior contours	0.5056
Visible surface style	0.5306
Visible surface rasters	0.5556 0.5806
Internal rasters	0.6056 0.6306



FORTUS 250mc



Modeler Setup



Processing Model

The current calculation can be halted at any time with the stop button. Use the minimize button to hide Insight until processing is complete.

- Slice
- Create supports
- Write boundary curves
- Create toolpaths
- Write CMB file

Supports at Z = 10.160

Processing time

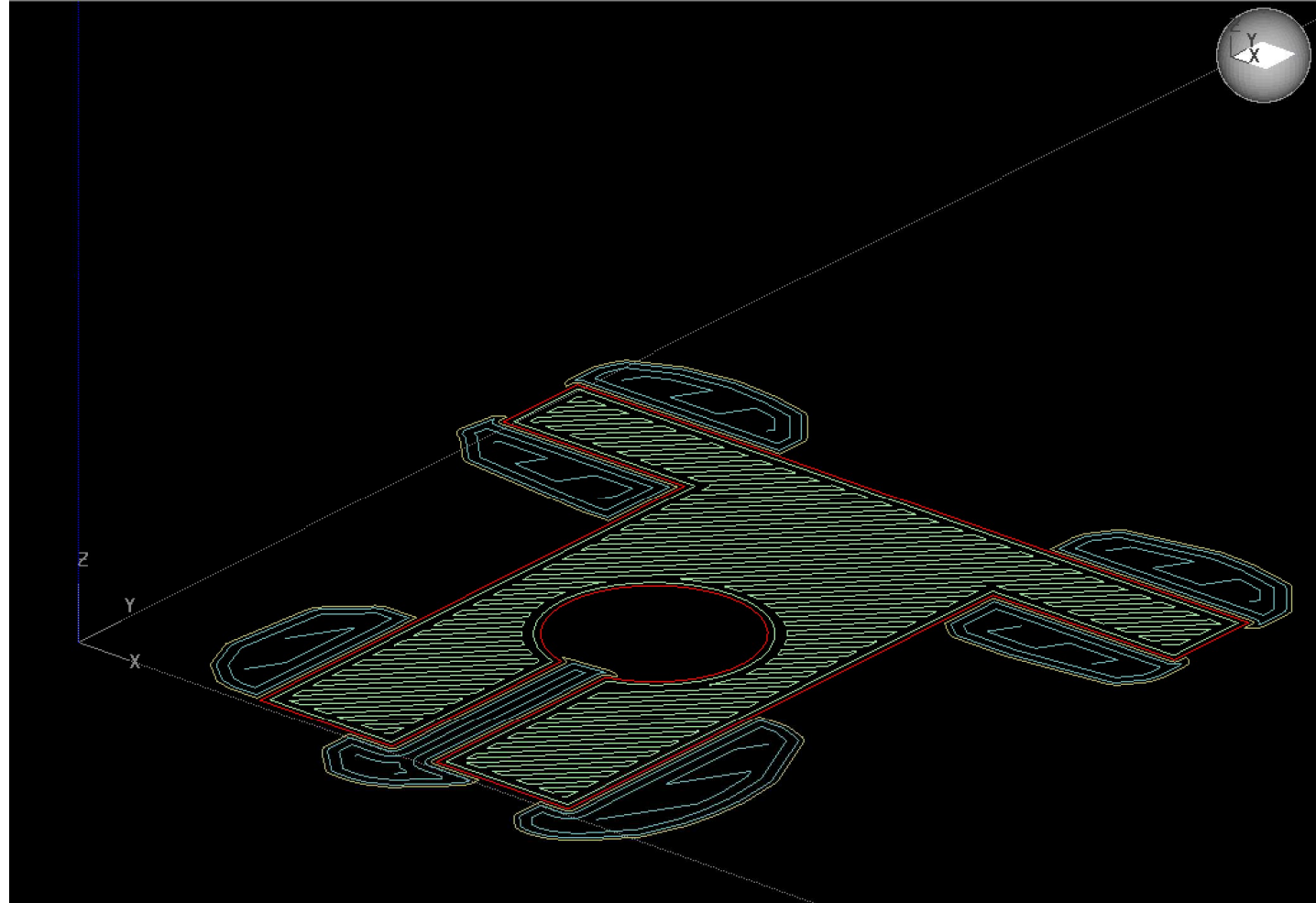
Insight - PINZA

— □ ×

File Edit View Modelers STL Slice Support Toolpaths Help



↑ 0.0000 ↓ 0.0000 Z 0.2540 Layer 11 of 66



Modeler Setup

Configure the modeler to build the part.

Fortus 250mc	0.2540 slice height
Model T14 tip	ABS P430
Support T16 tip	ABS SR30

Part interior style

Visible surface style

Support style



FORTUS 250mc

Saved job: C:/Users/ludov/OneDrive - University of Pisa/Lezioni/2018 Materiali Intelligenti/SW/7/STL/ssys_PINZA/PINZA.sjb, approximate build time 54 min STL 30.500;27.000;14.000 Z 0.2540



- Insert CMB...
- Print Screen Image...
- Exit

Items View Services

Name: Manage FDM Systems
Material: Model: P430_RED T14: 622,10 cm³ Support: SR30 T16: 423,56 cm³
Status: Building - print_ruote_dentate_gemma1

Platen X: 254,00 mm Y: 254,00 mm

		○		
○				○
		○		
○				○

- Insert CMB
- Copy
- Remove
- Repack
- 90
- Center
- CMB Info

Pack Details

Name:
Model Material: 0,00 cm³
Support Material: 0,00 cm³
Time: 0:00
Notes:

ID	Name

- Options
- Clear Pack
- Estimate Pack
- Save As



Build Job Cancel

Add Model to the Pack

« Lezioni » 2018 Materiali Intelligenti » SW » 7 » STL » ssys_PIASTRA_INF

Cerca in ssys_PIASTRA_INF

Nome	Stato	Ultima modifica	Tipo	Dimensione
PIASTRA_INF	✓	10/05/2018 09:00	Stratasys CMB File	2.129 KB

Nome file: PIASTRA_INF Toolpath Files (*.cmb.gz; *.cmb)

Apri Annulla

Insert CMB

Copy

Remove

Repack

90

Center

CMB Info

Pack Details

Name: PIASTRA_INF

Model Material: 59,48 cm³

Support Material: 9,75 cm³

Time: 5:06

Notes: ...

ID	Name
1	PIASTRA_INF

Options

Clear Pack

Estimate Pack

Save As

Build Job Cancel

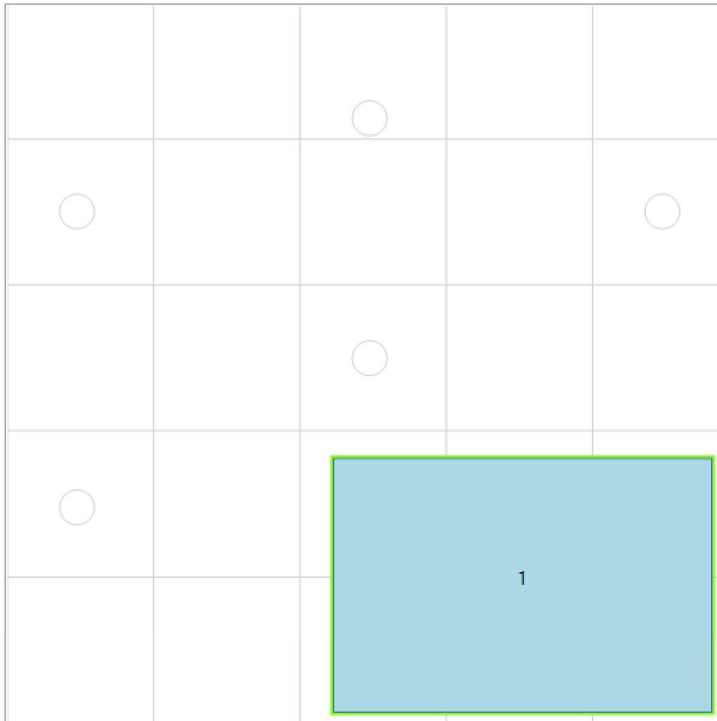
Pack Queue Systems View Services

Fortus 250mc

Name:
Material: **Model: P430_RED T14: 621,94 cm³ Support: SR30 T16: 422,94 cm³**
Status: Building - print_roots_dentate_gamma.1

Sparse-low density

Platen X: 254,00 mm Y: 254,00 mm



-
-
-
-
-
-
-

Pack Details

Name:
Model Material: 59,48 cm³
Support Material: 9,75 cm³
Time: 5:06
Notes:

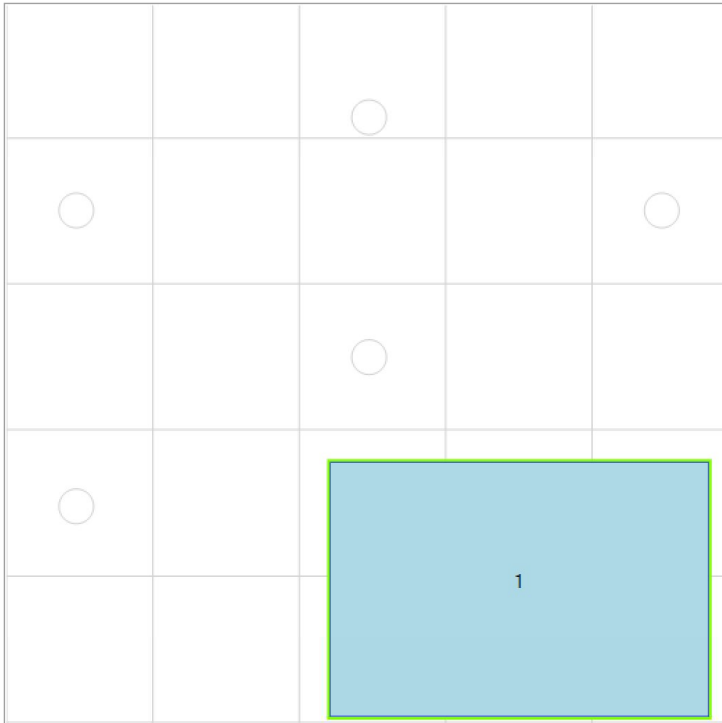
ID	Name
1	PIASTRA_INF

-
-
-
-

Fortus 250mc

Name: Manage FDM Systems
Material: Model: P430_RED T14: 621,90 cm³ Support: SR30 T16: 422,91 cm³
Status: Building - print_ruote_dentate_gemma1

Platen X: 254,00 mm Y: 254,00 mm



Solid

- Insert CMB
- Copy
- Remove
- Repack
- 90° rotation controls
- Center
- CMB Info

Pack Details

Name:
Model Material: 108,32 cm³
Support Material: 9,75 cm³
Time: 5:37
Notes:

ID	Name
1	PIASTRA_INF2

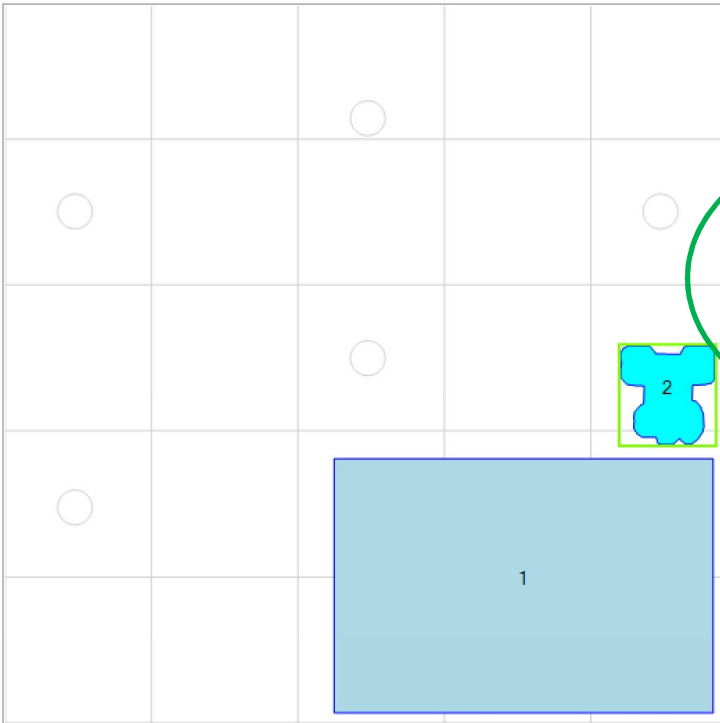
- Options
- Clear Pack
- Estimate Pack
- Save As

Pack Queue Systems View Services

Fortus 250mc

Name: Manage FDM Systems
Material: Model: P430_RED T14: 621,77 cm³ Support: SR30 T16: 422,91 cm³
Status: Building - print_ruote_dentate_gem m a 1

Platen X: 254,00 mm Y: 254,00 mm



Number of copies

Number of copies:

OK Cancel

- Insert CMB
- Copy
- Remove
- Repack
- 90
- Center
- CMB Info

Pack Details

Name:
Model Material: 64,67 cm³
Support Material: 11,62 cm³
Time: 6:00
Notes:

ID	Name
1	PIASTRA_INF
2	PINZA

- Options
- Clear Pack
- Estimate Pack
- Save As

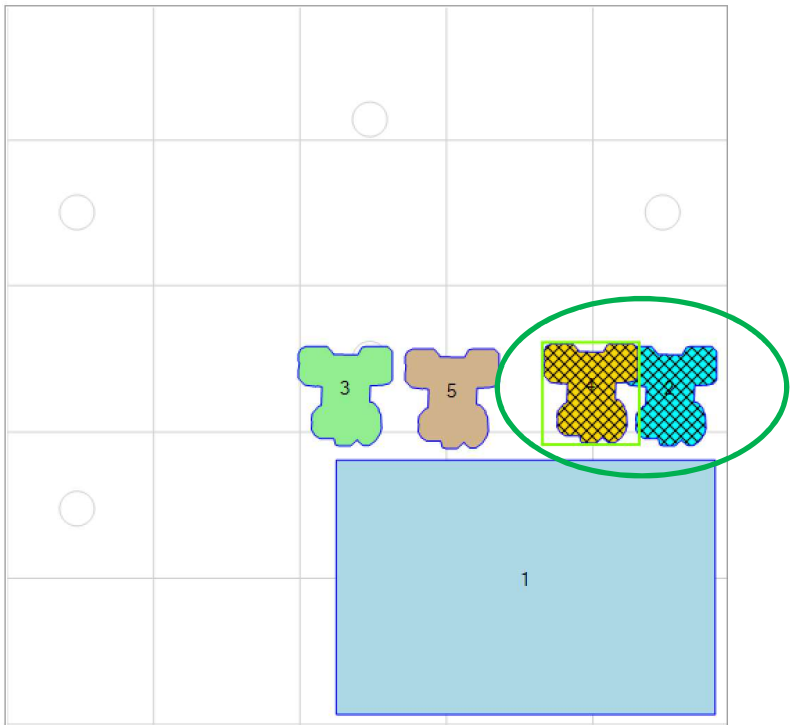


Build Job Cancel

Fortus 250mc

Name: Manage FDM Systems
Material: Model: P430_RED T14: 621,77 cm³ Support: SR30 T16: 422,91 cm³
Status: Building - print_ruote_dentate_gemma1

Platen X: 254,00 mm Y: 254,00 mm



- Insert CMB
- Copy
- Remove
- Repack
- 90° rotation controls
- Center
- CMB Info

Pack Details

Name:
Model Material: 80,24 cm³
Support Material: 17,25 cm³
Time: 8:42
Notes:

ID	Name
1	PIASTRA_INF
2	PINZA
3	PINZA
4	PINZA
5	PINZA

- Options
- Clear Pack
- Estimate Pack
- Save As

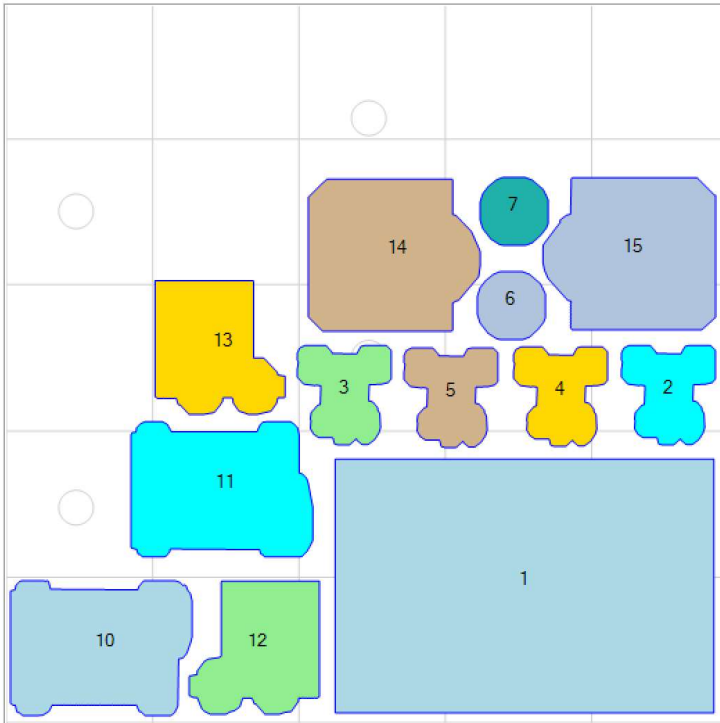
Fortus 250mc

Name:

Material: **Model: P430_RED T14: 621,25 cm³ Support: SR30 T16: 422,59 cm³**

Status: Building print_jobs_data_gamma1

Platen X: 254,00 mm Y: 254,00 mm



Pack Details

Name:

Model Material: **222,19 cm³**

Support Material: **50,95 cm³**

Time: **21:20**

Notes:

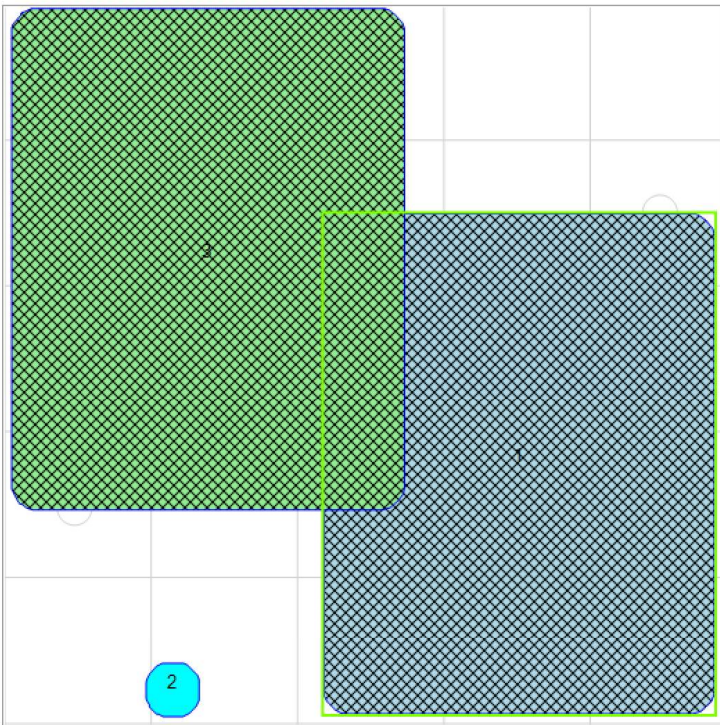
ID	Name
1	PIASTRA_INF
2	PINZA
3	PINZA
4	PINZA
5	PINZA
6	PISTONE
7	PISTONE
10	X-END-LEFT
11	X-END-RIGHT
12	Z-AXES-TOP-LEFT
13	Z-AXES-TOP-RIGHT
14	Z-AXIS-BOTTOM-LEFT
15	Z-AXIS-BOTTOM-RIGHT



Fortus 250mc

Name:
Material: **Model: P430_RED T14: 618,83 cm³** **Support: SR30 T16: 421,63 cm³**
Status: **Building - print_ruote_dentate_gemma1**

Platen X: 254,00 mm Y: 254,00 mm



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Pack Details

Name:
Model Material: **127,84 cm³**
Support Material: **76,36 cm³**
Time: **7:54**
Notes:

ID	Name
1	CARRELLINO
2	perno
3	poggia_perno

-
-
-
-

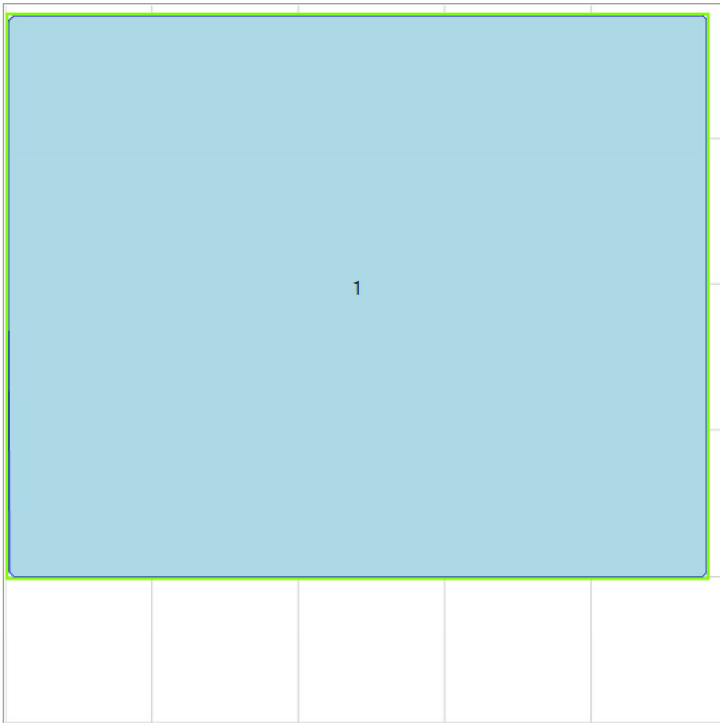
Fortus 250mc

Name:

Material: Model: P430_RED T14: 618,49 cm³ Support: SR30 T16: 421,45 cm³

Status: Building - print_ruote_dentate_gemma1

Platen X: 254,00 mm Y: 254,00 mm



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-
-
-
-

Pack Details

Name:

Model Material: 380,32 cm³

Support Material: 44,52 cm³

Time: 18:03

Notes: ...

ID	Name
1	assieme finale - Base-2

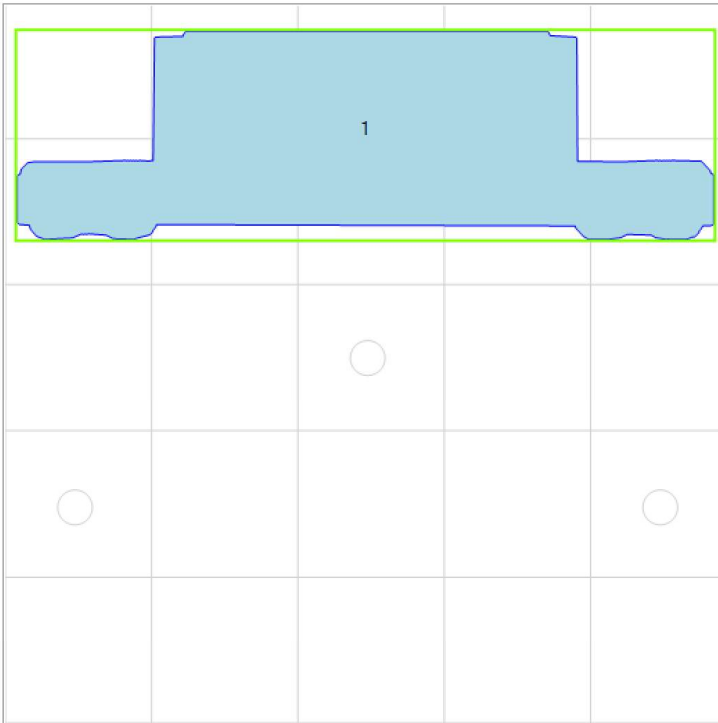
-
-
-
-



Fortus 250mc

Name: Manage FDM Systems
Material: Model: P430_RED T14: 617,72 cm³ Support: SR30 T16: 420,94 cm³
Status: Building - print_ruote_dentate_gemma1

Platen X: 254,00 mm Y: 254,00 mm



- Insert CMB
- Copy
- Remove
- Repack
- 90
- Center
- CMB Info

Pack Details

Name:
Model Material: 146,66 cm³
Support Material: 160,85 cm³
Time: 17:30
Notes: ...

ID	Name
1	piatto_base

- Options
- Clear Pack
- Estimate Pack
- Save As



NO (altrimenti lo mandate in cosa per la stampa)