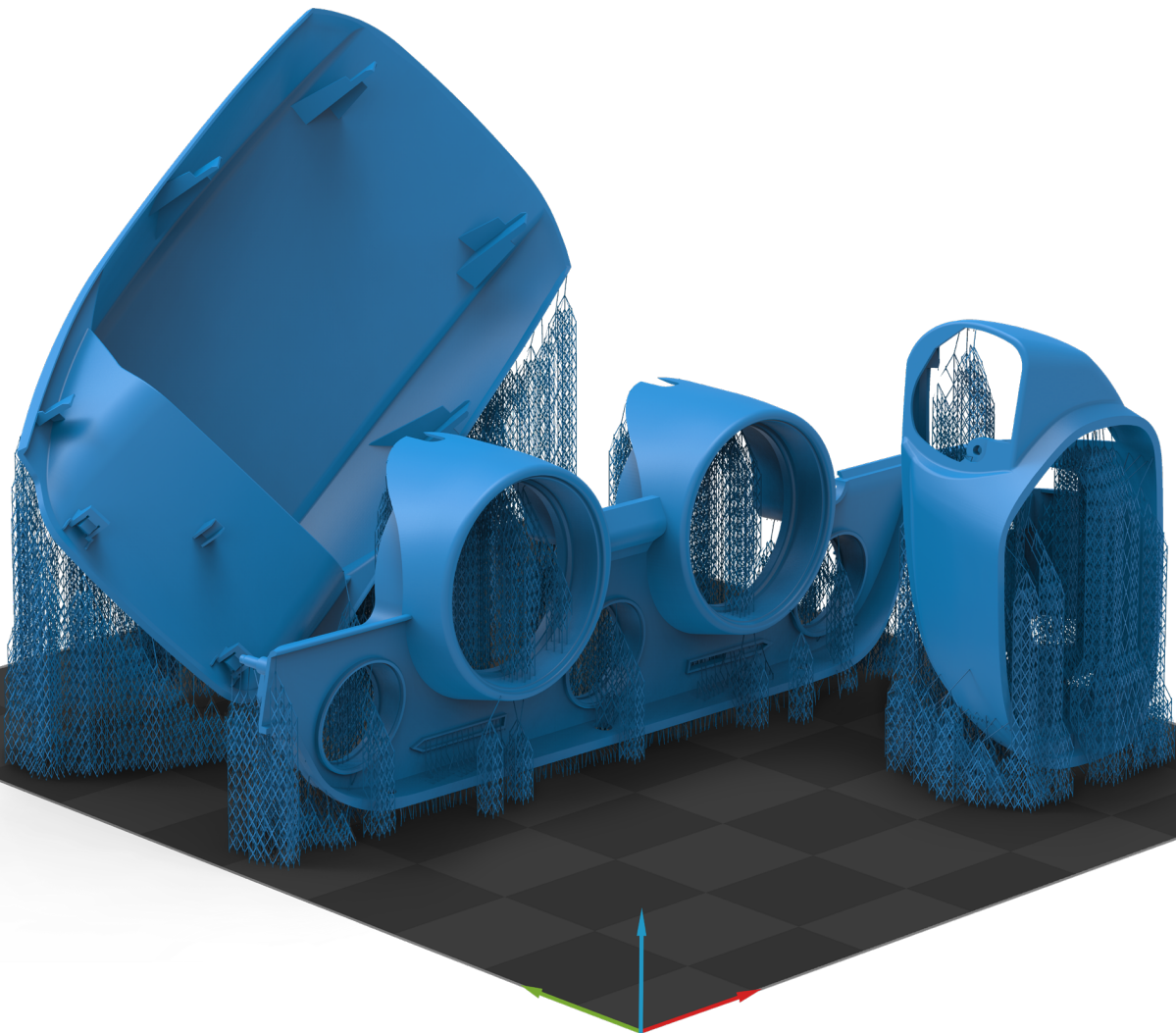


 **3D Sprint®**

## What's New 5.1

Release Date: November, 2023



Note: Features labeled with **SUBSCRIPTION** require a 3D Sprint Subscription for access. With the Basic or Subscription model, you can add specific licensed features labeled with **ADD-ON** as required.

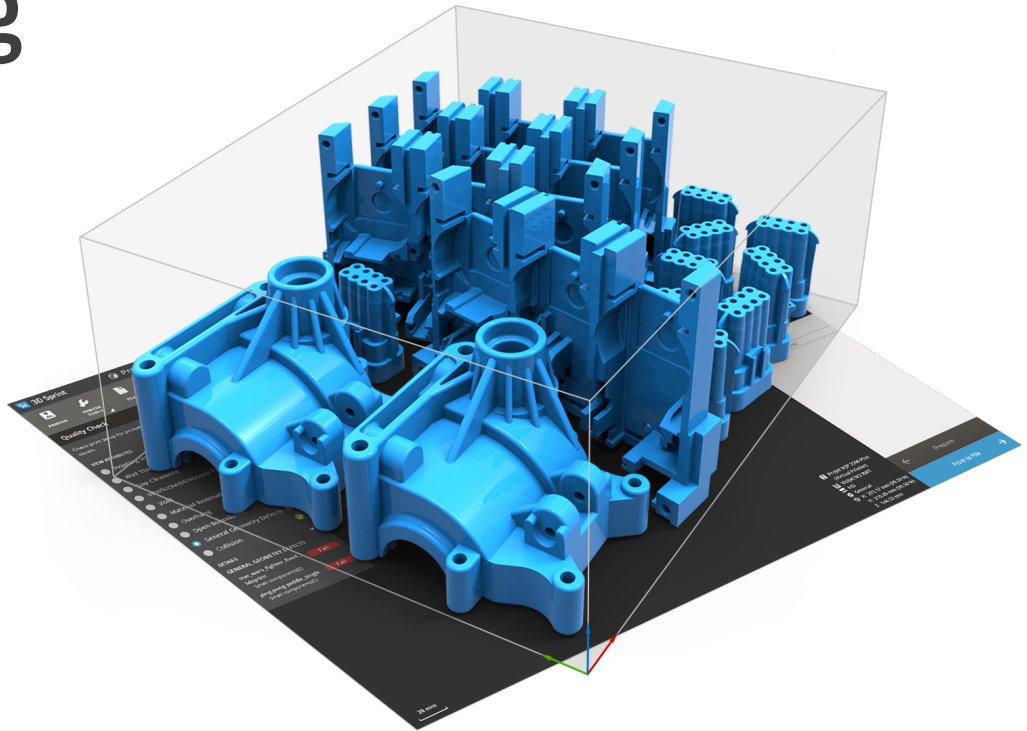
For assistance, please reach out to our technical support team at <http://www.3dsystems.com/support> or contact your regional sales manager.

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# Introducing 3D Sprint

Version 5.1



## Setting the New Standard in 3D Printing

Experience true productivity with exclusive additive manufacturing software for 3D Systems Plastic Printers.

3D Sprint® is 3D Systems' exclusive software for preparing and optimizing CAD & polygon data and managing the additive manufacturing process on its plastic 3D printers. Shipping with each supported 3D Systems printer, 3D Sprint delivers tools that allow you to 3D print better parts.

## 3D Sprint enables you to:

### Increase Productivity for 3D Systems Plastic Printer

Prepare and optimize CAD data and then manage the additive manufacturing process on your 3D Systems' plastic 3D printers.

### Print Better Parts

Eliminate geometry processing artifacts with smarter geometry processing and powerful slicing technology.

### Increase Productivity with Optimized Data Management

Estimate print time and optimize material levels and usage both before and during the print operation.

### Go from CAD to Print

3D Sprint delivers all the tools you need to go from design to 3D print, offering an unparalleled user experience across 3D Systems plastic printers.

### Streamline Time to Finished Parts

Save on material and post-processing time without compromising on part quality.

3D Sprint 5.1 includes key new features and enhancements that bring new value to these objectives with a special focus on capabilities that are required to move from rapid prototyping to serial production.

## 2 INSTALLATION

### System Requirements

For the latest system requirements information and to learn about specific qualified system configurations, go to the [System Requirements](#) page. Some users have had success running system configurations that deviate from the supported listed on our website. In such cases, these configurations are not officially supported by 3D Systems, Inc.

Additionally, we test a variety of hardware platforms in combination with the graphics subsystems. While we make every attempt to be as thorough as possible, hardware manufacturers change their products frequently and may be shipping newer products or have discontinued active support for others. Check the support section of the website for the latest system requirement information and specific qualified systems.

**NOTE: It is recommended to use the Microsoft Windows 10 Operating System. As of 3D Sprint 4.0 and newer versions, Windows 7 and Windows 8.0 are no longer supported. If you are on Windows 7, please refrain from upgrading to 3D Sprint 4.0 or newer. For those using Windows 8.0, please update to Windows 8.1 to ensure compatibility with 3D Sprint 4.0 or newer.**

### Download and Install Software

You can download and install 3D Sprint from the [getting started](#) page.

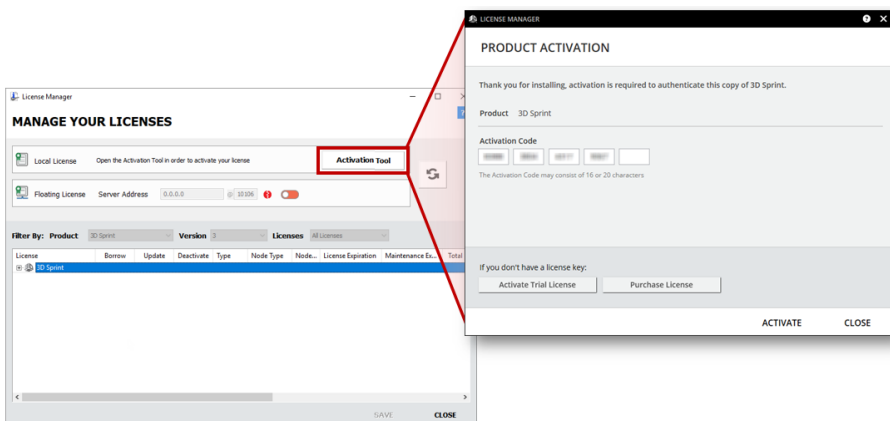
In addition, automatic software updates are available if you set the Check for updates on launch option to **True** in **Preferences** and a valid activation code is activated, and your computer is connected to the Internet. 3D Sprint will check if a newer version is available and will download it automatically for installation.

You can also visit [support.3dsystems.com](http://support.3dsystems.com), select your printer, then download 3D Sprint for the Software Downloads section on your printer's site.

### Activate License

3D Sprint requires license activation to run the application on your PC. You can activate a permanent license by using an activation code.

After you start 3D Sprint, the License Manager window opens. The License Manager allows you to activate and use the 3D Sprint software. For more information, read the [CimLM Licensing Guide](#).



If you have a 3D Systems printer, but do not have the activation code for 3D Sprint, please request it from the 3D Sprint registration page here:

<https://support.3dsystems.com/s/get-3d-sprint> \*

\*This request will go into a system, and we will produce activation codes within 24 hours (excluding weekends).

If you are an existing user and have already activated the license on your PC with the previous version of 3D Sprint, all the existing activation codes will be retained in the new license system, so you can run the newer version of 3D Sprint without re-activating the license.

## 3 NEW PRINTERS, FEATURES AND IMPROVEMENTS

### Requirement Notice

Please note that printers must be running the required printer firmware version to be able to submit print jobs with 3D Sprint 5.1. For the latest firmware version please consult the [3D Sprint - Minimum Firmware Guide](#).

# Common

**Note:** Features labeled with **SUBSCRIPTION** require a 3D Sprint Subscription for access. With the Basic or Subscription model, you can add specific licensed features labeled with **ADD-ON** as required.

For assistance, please reach out to our technical support team at <http://www.3dsystems.com/support> or contact your regional sales manager.

## Key Improvements

### Subscription & Add-on Licensing

**3D Sprint** has introduced a new **Subscription** and **Add-on** licensing model, allowing customers to purchase licenses for multiple years based on their maintenance date. With the basic or subscription license, you can add specific licensed features as required. This new model provides a more affordable option for you to work with **3D Sprint**.

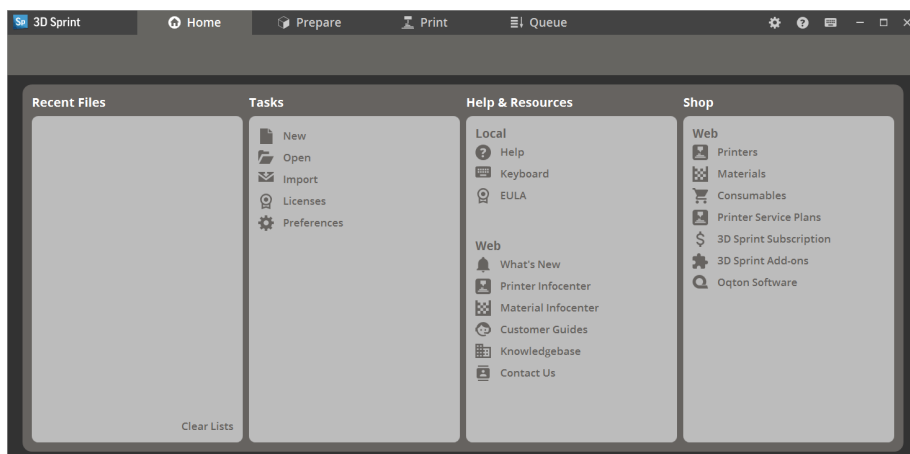
**Note:** Please be aware that periodic reminders will prompt customers to renew their subscription to ensure uninterrupted access to the application.

## Home Tab

Introducing the new **Home** tab. Upon launching the application, you now have access to the **Home** tab, designed to be your resource hub.

The **Home** page offers a clean and intuitive space to meet your printing requirements. It also features convenient web links that allow you to:

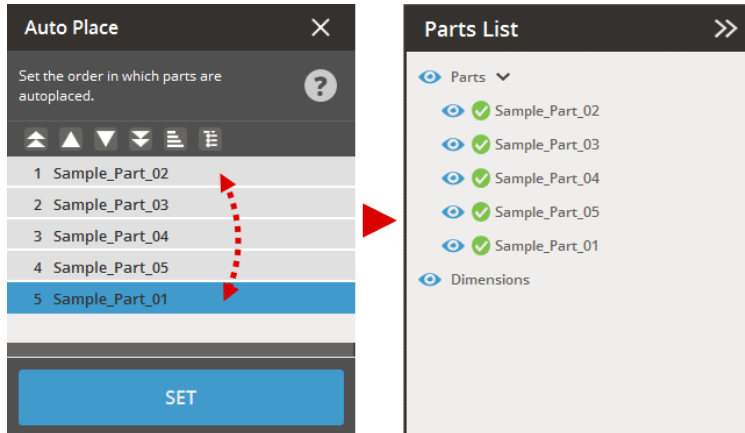
- Access recently used files
- Perform basic tasks for your printing job, such as:
  - Creating new documents
  - Opening files
  - Importing data
  - Managing licenses
  - Accessing Preferences
- Navigate through Help resources
- Access printer and material details
- Find customer guides
- Consult the Knowledge Base
- Connect with technical support
- Explore shopping details



All these links can be easily found within the **Home** tab interface.

## User Defined Priority in Auto Place SUBSCRIPTION

The priority of parts for auto-placing can now be manually reordered through a user-friendly interface within the **Auto Place** command. Furthermore, any changes made to the order of parts can be synchronized with the **Parts List**.

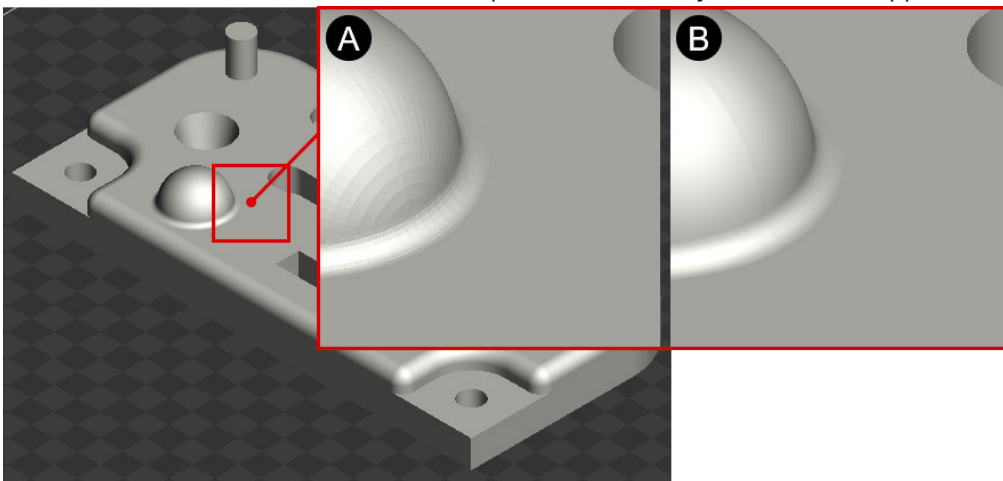


## View Overlay Enhancements

The **View Overlay** now includes new tools that enhance object visibility and provide quick measurements.

- **Smooth Shading Tool**

This tool improves object visualization by displaying objects with smooth shading, reducing the visibility of unnecessary tessellation. The result is a more realistic representation of objects within the application.



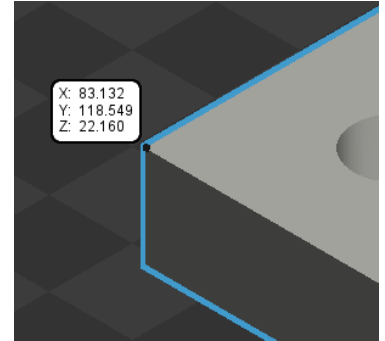
*Basic View (A) vs. Basic View with Smooth Shading (B)*

- Quick Measure Tools** SUBSCRIPTION

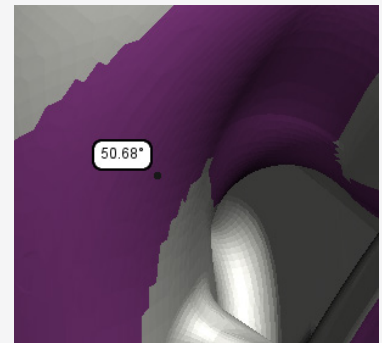
The new Quick Measure tools provide dynamic and rapid measurements for various applications:



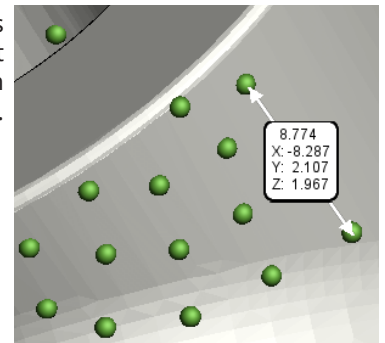
- **Coordinate** : Checking X, Y, and Z coordinates of a specific point of interest.



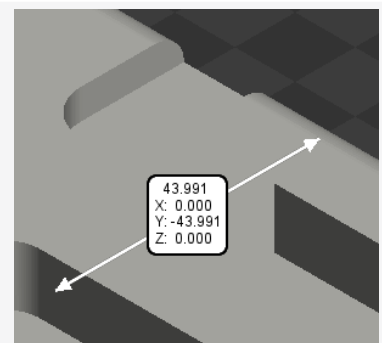
- **Down Face Angle** : Measuring precise down face angle with reference to the Printer Platform.



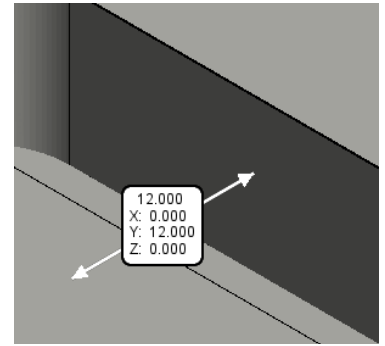
- **Distance**: Measuring linear distances between features while using various commands. For example, measuring distances between anchor points or support beams in Smart Supports to determine printability. Also, measuring distances on the part to decide if supports are needed when using the Smart Support command.



- **Thickness** : Measuring the thickness of a feature.

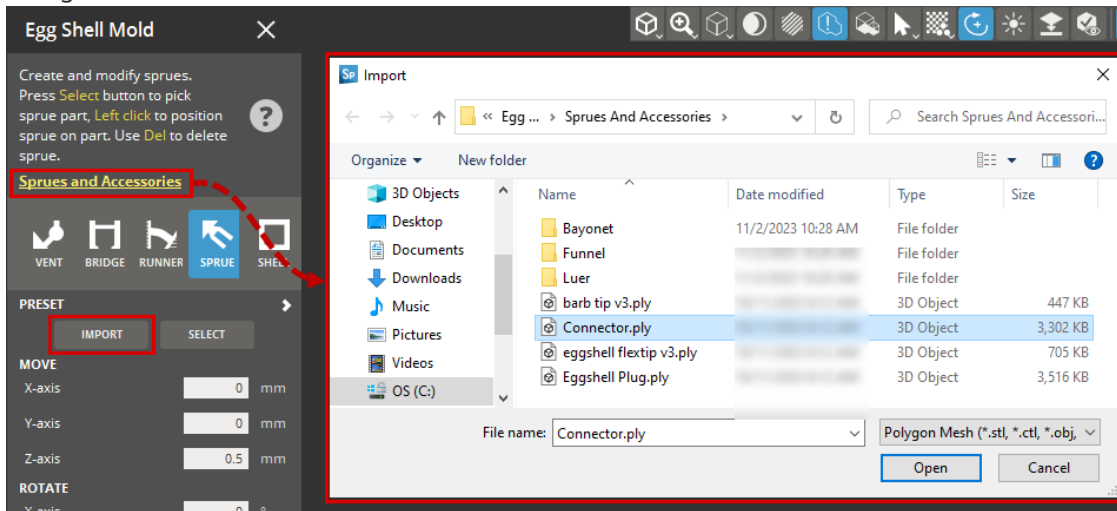


- **Gap Clearance** : Measuring the gap distance between two opposing faces.



## Egg Shell Improvements ADD-ON

The **Egg Shell Mold** command has been improved to offer a selection of pre-defined sprues and accessories, making it easier to create an egg shell mold. You can now import these preset sprues and accessories directly into the Printer Platform by using the **Import** button in the command. Alternatively, you can access them via a convenient **“Sprues and Accessories”** link within the dialog.



**Note:** This command is available with a 'Eggshell' Add-On.

## File Import

Native CAD File Import has been updated to support the following versions.

CAD Application	File Extension	Supported Versions
STEP	.stp, .step	AP203, AP214, AP242
IGES	.iges, .igs	Up to 5.3
Parasolid	.x_t, .x_b	9.0 - 35.0.149
ACIS Text / Binary <span style="background-color: #0070C0; color: white; padding: 2px 5px; border-radius: 3px;">SUBSCRIPTION</span>	.sat, .sab	R1 - 2023.1.0
CATIA V4 <span style="background-color: #0070C0; color: white; padding: 2px 5px; border-radius: 3px;">SUBSCRIPTION</span>	.model	4.1.9 - 4.2.4
CATIA V5 Part / Assembly <span style="background-color: #0070C0; color: white; padding: 2px 5px; border-radius: 3px;">SUBSCRIPTION</span>	.catpart, .catproduct	V5 R8 - V5-6 R2023
Creo (Pro/E) Part / Assembly <span style="background-color: #0070C0; color: white; padding: 2px 5px; border-radius: 3px;">SUBSCRIPTION</span>	.prt, .asm	Pro/E 16 - Creo 9.0
Siemens NX <span style="background-color: #0070C0; color: white; padding: 2px 5px; border-radius: 3px;">SUBSCRIPTION</span>	.prt, .asm	11 - NX 2212
SOLIDWORKS Part / Assembly <span style="background-color: #0070C0; color: white; padding: 2px 5px; border-radius: 3px;">SUBSCRIPTION</span>	.sldprt, .sldasm	98-2023
VDA-FS <span style="background-color: #0070C0; color: white; padding: 2px 5px; border-radius: 3px;">SUBSCRIPTION</span>	.vda	1.0 - 2.0



## Miscellaneous Enhancements

- **View Overlay Consolidation** - The **View Overlay** has been streamlined by implementing a fly-out style combo for mutually exclusive options, ensuring a more organized interface with the addition of new tools and options.



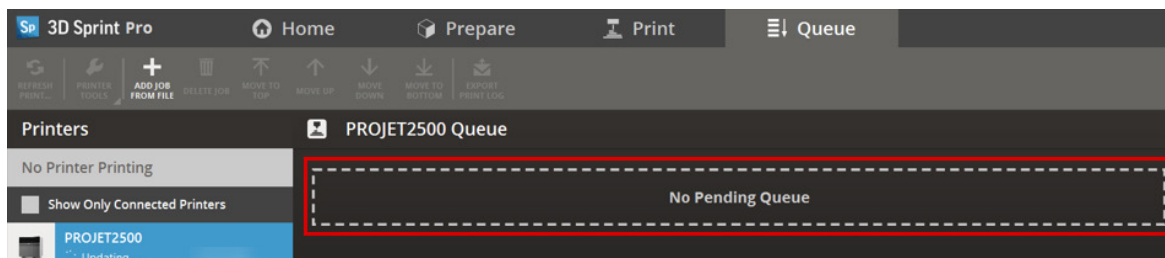
- **Random Priority in Auto Place** - When the Priority type is set to **"Random,"** the **Apply** button can be repeatedly used to obtain different results. Each time it's clicked, a new priority sequence will be applied.
- **Improved Object Visibility during Auto-Placement** - Objects to be placed can now be temporarily hidden until they are ready to be placed. When the update process begins, all movable objects will be hidden and then made visible when they are being placed.
- **Volume Information for SLC Files** - Volume details for **SLC** files are now included in the Property pane, providing easy access for reference. Additionally, this information is available in the generated report.
- **Mesh Random Color** - Addressed the inconsistency in mesh random coloring during part copying, preventing unexpected color assignments. Additionally, the range of random colors has been expanded from 32 to 40 for better variety. New random colors are now managed as document properties, enhancing color control.
- **Enhancements to Copy/Pattern** - Copy numbering now increases per part, ensuring consistent naming. For example, when copying objects A and B, the resulting names are A\_Copy\_1, B\_Copy\_1, A\_Copy\_2, B\_Copy\_2, and so on.
- **Progress Control** - The progress bar has been enhanced to display informative behavior and status text.



- **Mouse Wheel Support for Option Values** - Improved to adjust increments of option values with mouse wheels. Most values now increment by 0.1mm, although some options increase by 1mm or 1 degree, depending on their specific meaning.
- **Display of Printer Mode in Printer Queue** - The Printer Mode name is now centered within the Printer Queue column to ensure it remains within the column separator bars.

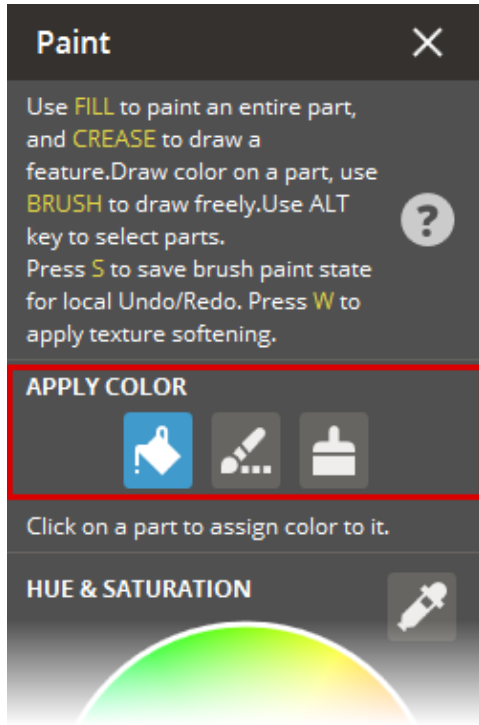
COMPLETED				
Small_Job	Visijet M2 CAST	XHD		PRINTED 6/20/2023...
Test	Visijet M2 CAST	XHD		ABORTED 6/19/2023 1:11:...
Test	Visijet M2 CAST	XHD		FAILED 4/27/2023 4:32:12 PM

- **Empty Pending Queue** - If there are no pending jobs in the queue, a message stating "No Pending Queue" is now displayed to provide a more intuitive user experience.

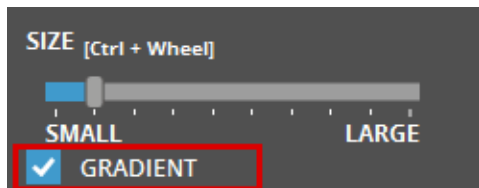


- **Enhancements to Paint**

- **Toggle Buttons** - Toggle buttons now sport a smaller format, matching the other command's style for consistent visuals.



- **Local Undo and Redo** - Local **Undo** and **Redo** features are now available, providing you with enhanced control over your workflow.
- **Global Texture Smoothing Parameters** - You can now conveniently adjust global texture smoothing parameters directly in the iniml file, ensuring smoother textures throughout the application.
- **Brush Gradient** - Introducing the new **Gradient** option for the Brush tool, enhancing your painting process with the ability to smoothly blend colors for seamless transitions.



## Bug Fixes

The following is a list of issues that have been resolved since the last version of 3D Sprint:

- **GW-34322, GW-34179:** Split connectors update issue that occurred when switching between Grid and Boundary.
- **GW-34320:** The application would crash when copying a part after undoing a group.
- **GW-34295:** The application would crash when using the Duplicate tool on a part in a sub-group.
- **GW-34248:** The Split tool caused the application to crash in some models.
- **GW-33997:** The "S" keyboard shortcut key did not work to select multiple stilts.
- **GW-33883:** The application would crash when switching to eggshell from the Paint dialog.
- **GW-33802:** The application would crash when using the Adjust Color command.
- **GW-33775:** The application would crash during the execution of the Hollow command with minimal values on a specific file.
- **GW-33762:** Various issues related to the model manager affected functionality.
- **GW-33750:** Texture glitches were appeared after boolean operations or mesh hollowing.
- **GW-33724:** Progress bar remained at 100% upon entering the Adjust Color dialog.
- **GW-33666:** The application would crash while applying texture softening using custom values.
- **GW-33160:** The Update Firmware window was not centered when clicking on "Check for Updates."
- **GW-33151:** The application locked up the computer when attempting to import an NX files (.prt).
- **GW-33150:** Error messages appeared when importing SOLIDWORKS files (.sldprt).
- **GW-33120:** 3D Sprint UI elements were left behind when switching to a different display with the Shift + Windows + Arrow keys.
- **GW-32715:** Parts would disappear when using the "Multi Platform" option in the Auto Place command.
- **GW-32583:** Explanation about CAD import options was missing in the Help documentation.
- **GW-32536:** The application would crash in cases of auto placement involving all possible rotations.
- **GW-32518:** Parts disappeared after applying noise.
- **GW-32355:** Inability to import STEP files with Korean file names.
- **GW-30149:** An incorrect "<Part Name> is too far from origin. Move it to the origin?" warning was shown after importing the part even if the part was already on the Printer Platform by the auto-place process on import.
- **GW-28839:** The application would crash when the Fix command was used multiple times.
- **GW-27085:** Creating a hole resulted in a bad part.
- **GW-22326:** No warning was observed when jumping from the Split command to another command with unsaved changes.
- **GW-20113:** DXF files were not imported correctly in the Engrave tool.
- **GW-8123:** The button for the PART NORMAL FIX tool remained enabled even after the completion of the part normal fix.

# SLA

Note: Features labeled with **SUBSCRIPTION** require a 3D Sprint Subscription for access. With the Basic or Subscription model, you can add specific licensed features labeled with **ADD-ON** as required.

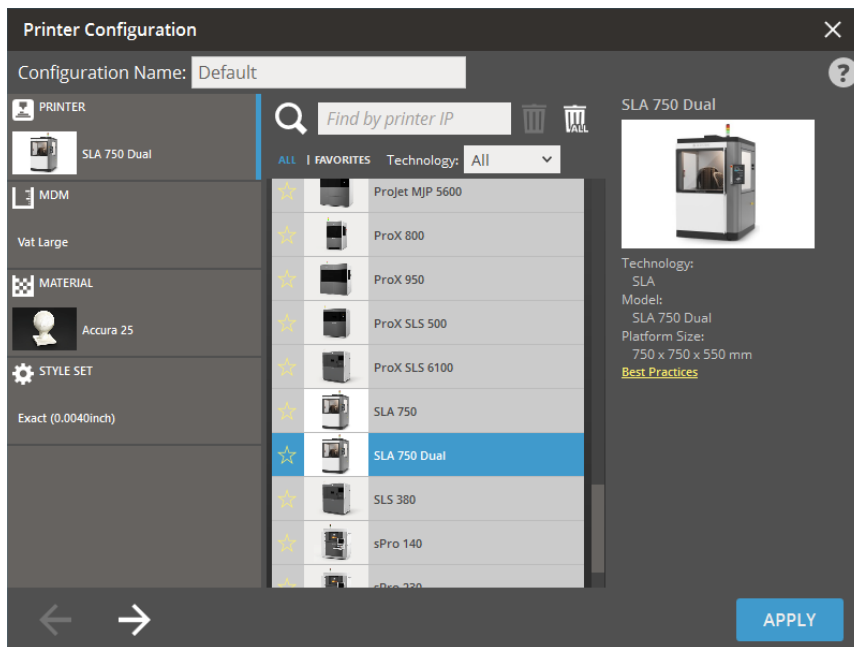
For assistance, please reach out to our technical support team at <http://www.3dsystems.com/support> or contact your regional sales manager.

## Key New Features

### New SLA 750 Dual Printer Support

3D Sprint 5.1 now supports the new **SLA 750 Dual Printer**.

The SLA 750 Dual printer is the world's first synchronous dual-laser SLA printer delivering up to twice the speed and triple the throughput of current SLA printers, using dual imaging systems together with a proprietary scan algorithm, **Hyper-Scan™ vector** technology, developed especially for efficient, high-quality production manufacturing.



The following is available in 3D Sprint to support SLA 750 Dual printer higher throughput printing:

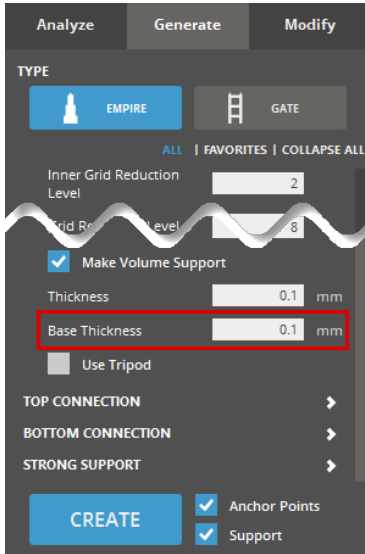
- All the common SLA toolset
- The Remote Print function in the Queue tab
- Slicing infrastructure and enhancements

# Key Improvements

## Smart Support Improvements

The following improvements have been implemented in **Smart Support** to optimize support structure controls and enhance productivity.

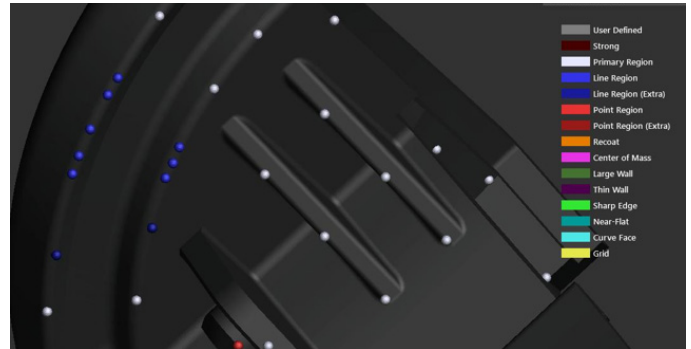
- **Base Thickness of Empire's Volume Support** - Introducing a new control for the base thickness of Empire's volume support. Actual base thickness will now be determined by the maximum values of both support thickness and base thickness. This option is particularly useful when working with **high-temperature AMX** materials.



- **Enhanced Anchor Point Generation and Filtering** - Introducing an enhanced method for filtering anchor points. This filtering process has been seamlessly integrated as a post-processing step in anchor point generation, designed exclusively for SLA printing. Importantly, this enhancement leaves edited anchor points unaffected, preserving your customized adjustments.

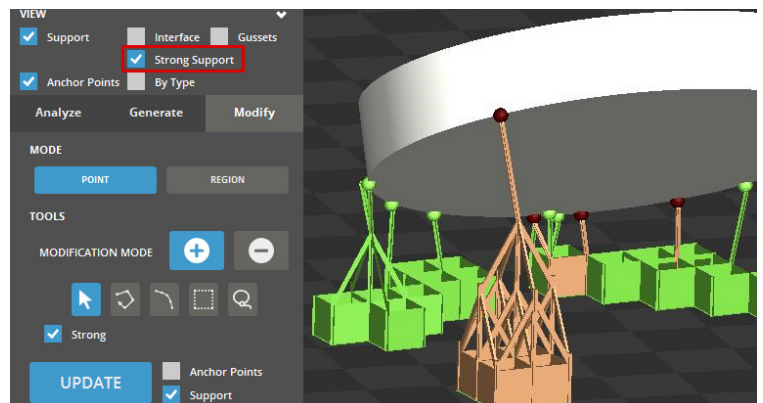


Pre-Implementation of Enhanced Anchor Point Generation and Filtering

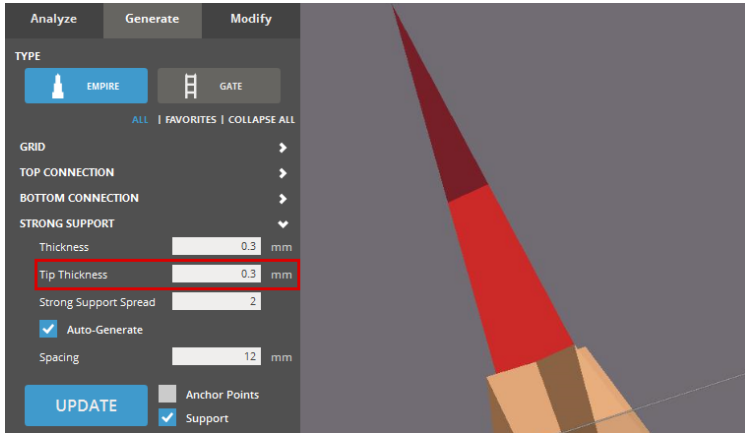


Post-Implementation of Enhanced Anchor Point Generation and Filtering

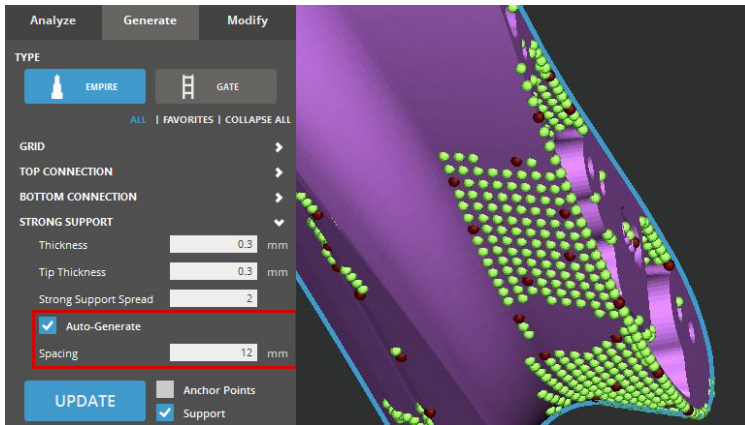
- **New Strong Support View Option** - Enhanced visibility by introducing the **“Strong Support”** view option, which uniquely colors and highlights strong supports, making them effortlessly distinguishable.



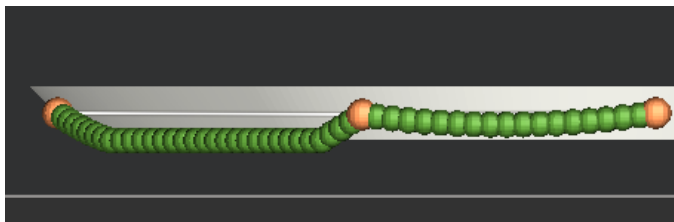
- **Enhanced Tip Thickness Control for Empire's Strong Support** - Introducing an advanced setting that allows precise adjustment of the tip thickness, working alongside thickness, spread level, and spacing parameters to refine the strong support's structure.



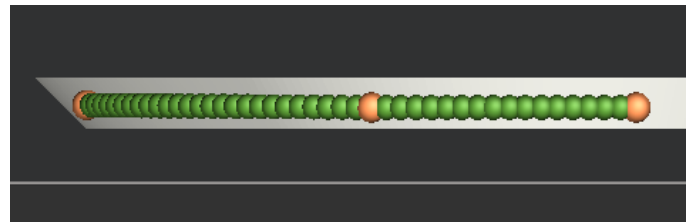
- **Automatic Strong Anchors for Low Regions** - **Strong Anchors** can now be applied automatically to local low regions around point and line anchors. To revert this feature, simply utilize the existing unassigned workflow.



- **Anchor Point Projection on Polyline** **SUBSCRIPTION** - Improved anchor point placement accuracy on polylines by adding interpolation points during anchor polyline drawing. This optimization assists in projecting onto the part, leading to more precise anchor placement.

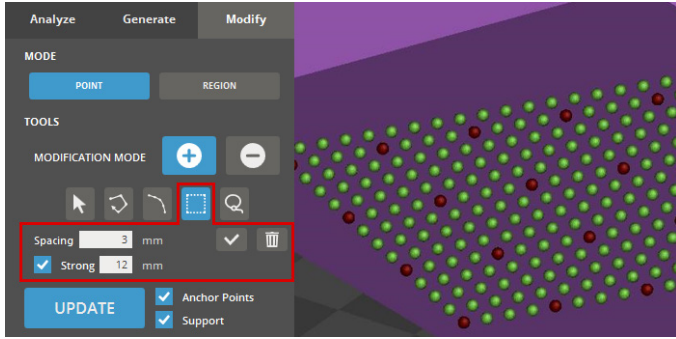


Before

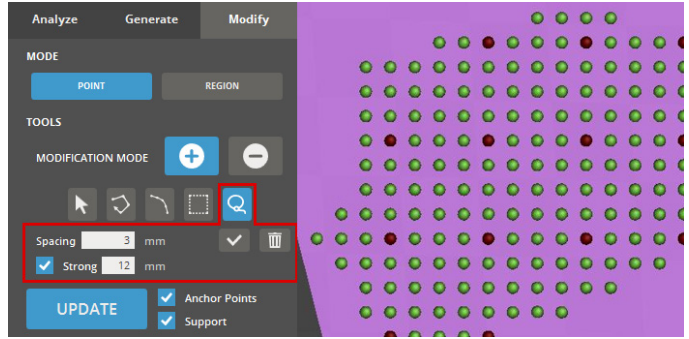


After

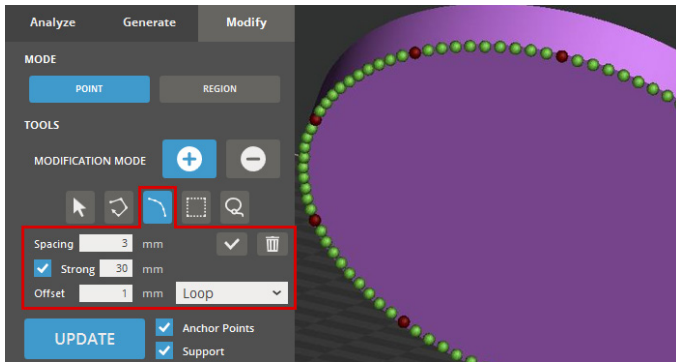
- Flexible Strong Anchor Intervals** - Introducing enhanced control with strong anchor intervals. In the **Modify** tab, a new **"Strong"** option allows you to fine-tune Strong Anchor intervals. When manually editing anchors using tools like Box, Lasso, Edge, or Polygon, this feature enables you to position strong anchor points flexibly between point or line anchors.



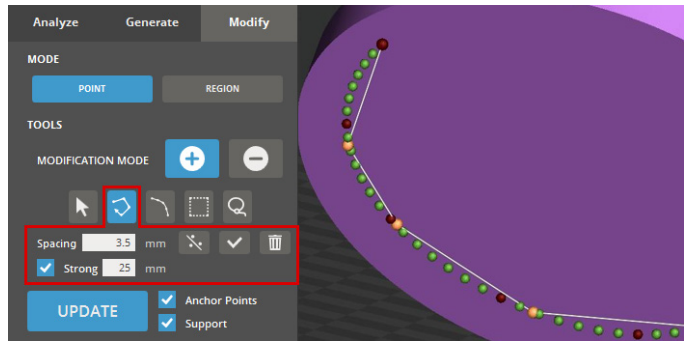
*Box Strong Anchor Intervals*



*Lasso Strong Anchor Intervals*

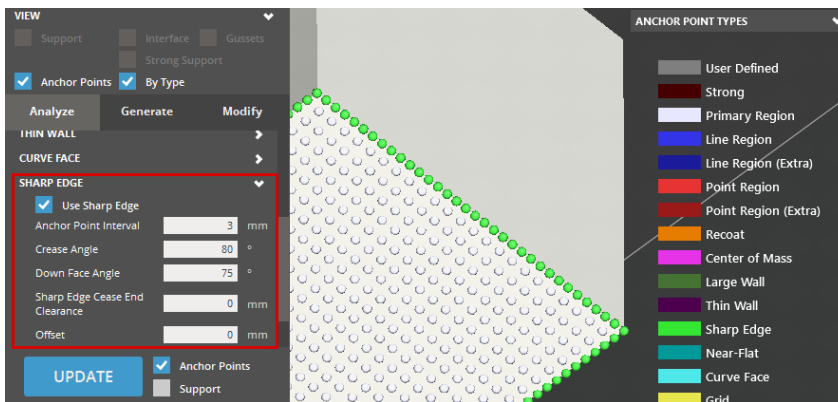


*Edge Strong Anchor Intervals*

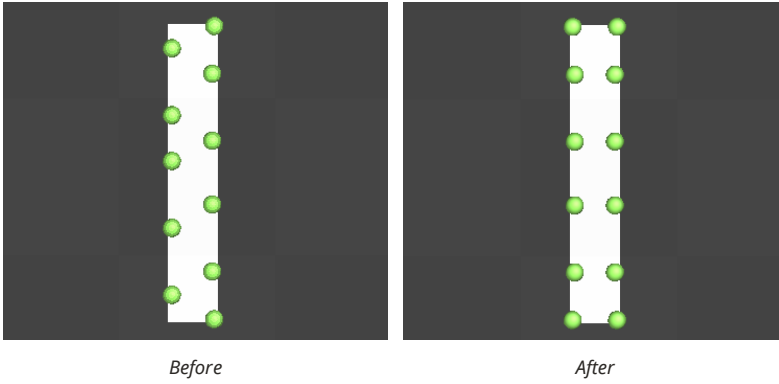


*Polygon Strong Anchor Intervals*

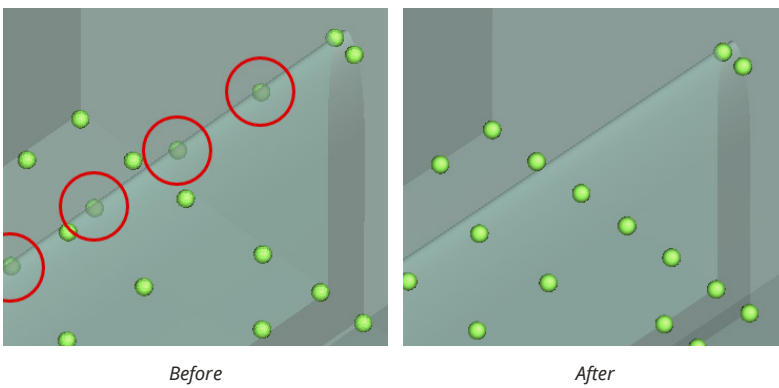
- Anchor Point Reprioritization** - Elevated the priority of primary region, line and point region anchors over sharp edge points so that lowest layers could be supported with a 0 offset. Additionally, there have been improvements made to sharp edge processing.



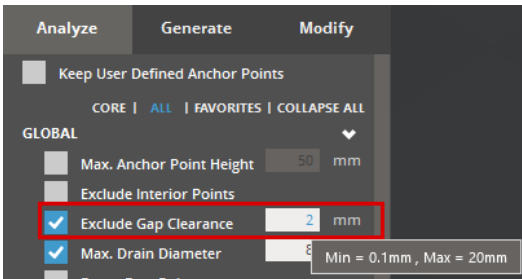
- **Enhanced Anchor Point Corner Alignment** - Enhanced corner alignment for anchor points, ensuring their consistent placement over edges.



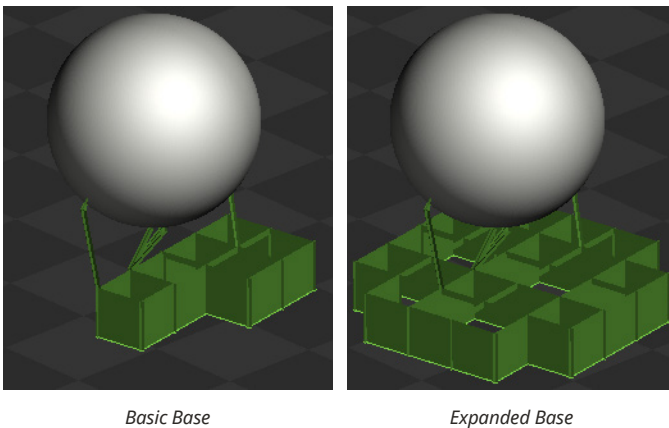
- **Exclude Gap Clearance** - Expanding coverage to concave areas through 3D analysis, the **Exclude Gap Clearance** now removes primary points found on the tops of arches within negative features.



Additionally, the max range value for the **Exclude Gap Clearance** parameter has been increased from 10 mm to 20 mm, resulting in broader coverage.



- **Expand Base to Part** - Introducing the new **“Expand Base To Part”** option, enabling you to expand the base for better part coverage and preventing sidewall quality reduction when the top connection meets the part at an angle.





- **Anchor Point Type Toggling** - Toggles have been added to the following options, allowing users to easily enable or disable the creation of anchor points for Thin Wall, Curve Face, and Sharp Edge.
  - Thin Wall
  - Curve Face **SUBSCRIPTION**
  - Sharp Edge
- **Snap Anchor Point to Boundary** - The “**Snap Anchor Point to Boundary**” option is now accessible to users with a **3D Sprint Basic** license.

## Miscellaneous Enhancements

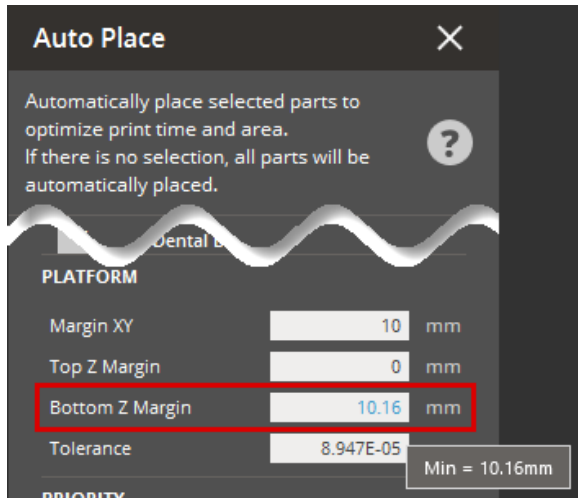
- **Support Accura AMX Tough FR V0 Black** - Exposed **Accura AMX Tough FR V0 Black** material for the following printers.



*Accura AMX Tough FR V0 Black*

- **ProJet 6000**
  - ◆ MDM - 125mm, 50mm, 250mm
- **ProJet 7000**
  - ◆ MDM - 250mm, 50mm
- **ProX 800**
  - ◆ MDM - MDM 750SH, MDM 750H, MDM 750F
- **iPro 8000**
  - ◆ MDM - MDM 750SH, MDM 750H, MDM 750F
- **iPro 9000 SV**
  - ◆ MDM - MDM 750SH, MDM 750F, MDM 750H
- **SLA 750**
  - ◆ MDM - Vat Short, Vat Large
- **SLA 750 Dual**
  - ◆ MDM - Vat Short, Vat Large
- **Support LLBP with QC-D** - Both the **Additional Large Borders** and **Multiple Large Border Offset** options are now accessible to provide enhanced support for **large layer border prime (LLBP)** with **QuickCast Diamond (QC-D)**.
- **Exclusive Smart Support Parameters in Sharp Edge Category** **SUBSCRIPTION** - The following Smart Support parameters listed below are now accessible exclusively with a **3D Sprint Pro** or **3D Sprint Subscription** license.
  - Crease Angle
  - Sharp Edge Cease End Clearance
  - Offset

- **Minimum Value of Bottom Z Margin for Auto Place** - The minimum value for the “Bottom Z Margin” in Auto Place has been aligned with the value specified in the “Minimum Z Height” of the Build Style.



- **Help Content for QuickCast Diamond Hatch and Fill Options** - Help descriptions have been added to assist with understanding **QuickCast Diamond Hatch and Fill** options within the QCD View Slice command.

## Bug Fixes

The following is a list of issues that have been resolved since the last version of 3D Sprint:

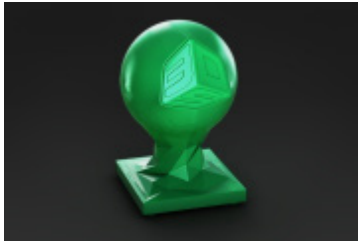
- **GW-34310:** The application became unresponsive with high GPU usage when copying a region in the recoat style dialog.
- **GW-34199:** The application would crash when attempting to import a custom Part Build Style.
- **GW-34144:** After using the View Slice command, the Save command became unavailable.
- **GW-34097:** The drain size changed when moving the mouse to the top surface of a model while running the Vent Drain command.
- **GW-34094:** Anchor points couldn't be selected using the Lasso or Box tool when the “Transparent” shading option was enabled.
- **GW-33844:** A large vent on the up-facing angle had a missing sidewall in the model when using the View Slice command.
- **GW-33808:** Supports remained on the Printer Platform even after deleting all parts from the parts list.
- **GW-33701:** Smart Support was not generated for a specific file (.REG).
- **GW-33664:** Tiny redundant support structures were being created.
- **GW-33650:** Supports were being generated inside the interior of closed parts.
- **GW-33649:** Tip normal orientation was inconsistent.
- **GW-33606:** Duplicate style was being imported from the Style Set in the Printer Configuration.
- **GW-33198:** Custom build size was causing issues for support and build style generation.
- **GW-33168:** The application lacked proper Z control for high step values during sectioning.
- **GW-32965:** Anchor points were misclassified.
- **GW-32901:** Sharp edge points were created on sidewalls.

- 
- **GW-32900:** Anchor incident occurred outside cross sections on sharp edges.
  - **GW-32756, GW-32520:** Certain .RCS files were being rejected despite meeting the criteria.
  - **GW-32722:** Graphics issue with Smart Support visualization.
  - **GW-32712:** A user interface issue with the Smart Support View section.
  - **GW-32647:** Gap clearance was removing anchors on non-qualifying down-faces.
  - **GW-32646:** Supports were hitting sidewalls when gusset was turned off.
  - **GW-32387:** Unable to access the Update button in Modify under Smart Support.
  - **GW-32340:** Anchor points were occurring in close pairs.
  - **GW-32336:** Anchor points were appearing in holes.
  - **GW-31104:** Custom Layer Thickness values were uneditable in the Edit Build Style Parameters dialog.
  - **GW-31027:** The Laser hour in the Printer Properties pane showed as 0 for the SLA 750 printer.
  - **GW-30356:** The QCD build style could be imported into materials that didn't have the interior lattice anchor style available.
  - **GW-20997:** Minor differences were noticed in anchor points and Smart Support structures after regenerating support with SLC files.
  - **GW-15083:** Some anchor points were missing after saving .3dprint file while viewing in the main window.
  - **GW-15047:** When attempting to save printer log in SLA 750 printer, the Printer Tools > Save Log command was resulting in failure.
-

# Figure 4

## Miscellaneous Enhancements

- **Material Updates** - The following materials have been added and updated for 5.0 database.
  - **JCAST-GRN 20** - The "**JCAST-GRN 20**" material is now available for **Figure 4 Standalone** and **Figure 4 Jewelry** printers.



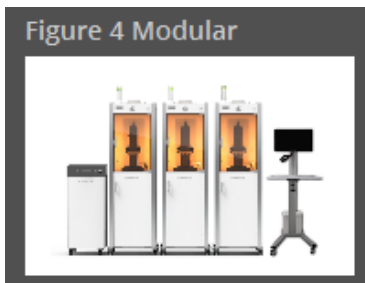
JCAST-GRN 20  
Print Mode - 20, 30 Micron

- **Tough FR V0 Black** - The "**Tough FR V0 Black**" material is now available for **Figure 4 Standalone** and **Figure 4 Modular** printers.

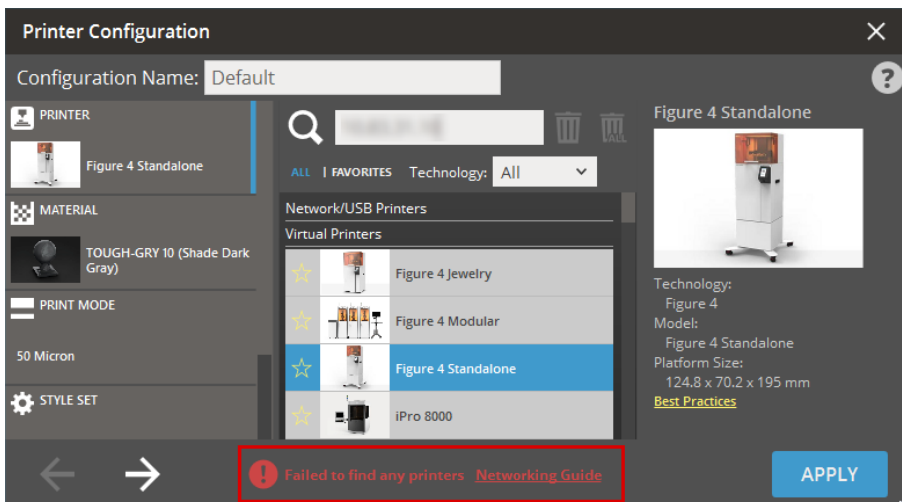


Tough FR V0 Black  
Print Mode - 20, 30, 50 Micron

- **Thumbnail Image of Figure 4 Modular Printer** - Updated the thumbnail image of the Figure 4 Modular printer in the Printer Configuration dialog.



- **Networking Troubleshooting Guide for Figure 4 Printers** - The networking failure message now provides a hyperlink to the Figure 4 Networking Guide when issues arise during printer discovery by IP.



## Bug Fixes

The following is a list of issues that have been resolved since the last version of 3D Sprint:

- **GW-34087:** Undoing unrolls of the last applied build style failed to trigger platform resizing as expected.
- **GW-33918:** Style name displayed "Standard" for the "For Ceramill" style.
- **GW-33156:** Upon connecting to a NextDent 5100 printer with old firmware 1.0.4-9, the main tabs in 3D Sprint became inaccessible.
- **GW-32923:** After using the View Slice command, the Prepare and Queue tab became inaccessible.
- **GW-32883:** The application incorrectly displayed product pictures for Figure 4 Standalone and Jewelry printers.
- **GW-32529:** The application would crash when clicking "Next" multiple times rapidly in Figure 4 Scale & Offset workflow.
- **GW-32521:** PXL file generation resulted in an error due to a slice layer mismatch in the printer profile.
- **GW-30406:** The status of the Figure 4 Modular Control Module did not update to "Disconnected" in the Queue tab, even after disconnecting the Ethernet cable from the Control Module.
- **GW-29311:** When selecting a part with supports, the Quality Check command displayed "Unknown" for collisions.
- **GW-29310:** Collision detection did not function properly for an SLC file in the Quality Check command.
- **GW-29288:** SLC files with supports were not auto-placed correctly after using the Linear Pattern tool in the Copy command.
- **GW-29116:** The "Scale by Unit" command was disabled when a stack existed on the Printer Platform.
- **GW-28814:** Renaming the printer was not allowed if it was not connected.
- **GW-20255:** The "Show Figure 4 Tips Prompt on Printer Selection" option was accessible in the preferences for a Basic license for NextDent.
- **GW-19350:** An error message was displayed when sending a job using the "Add Job From File" feature in the French OS.
- **GW-19233:** The application did not display different Z-height limits for different materials.

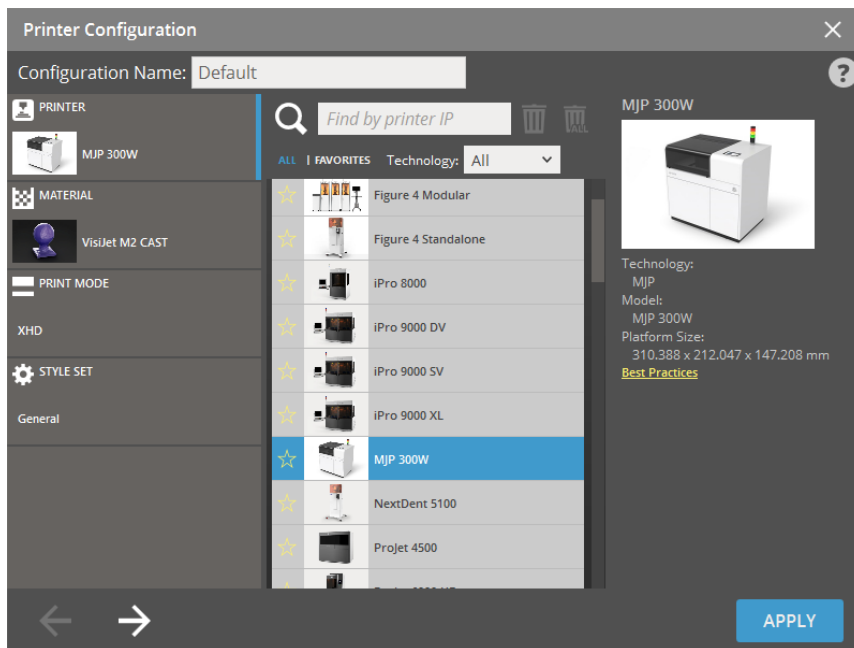
# MJP

## Key New Features

### New MJP 300W Printer Support

3D Sprint 5.1 now supports the new **MJP 300W Printer**.

The MJP 300W is the most advanced and flexible of its wax 3D printers, capable of addressing a variety of jewelry manufacturing workflows with enhanced productivity, efficiency, quality, and design freedom.



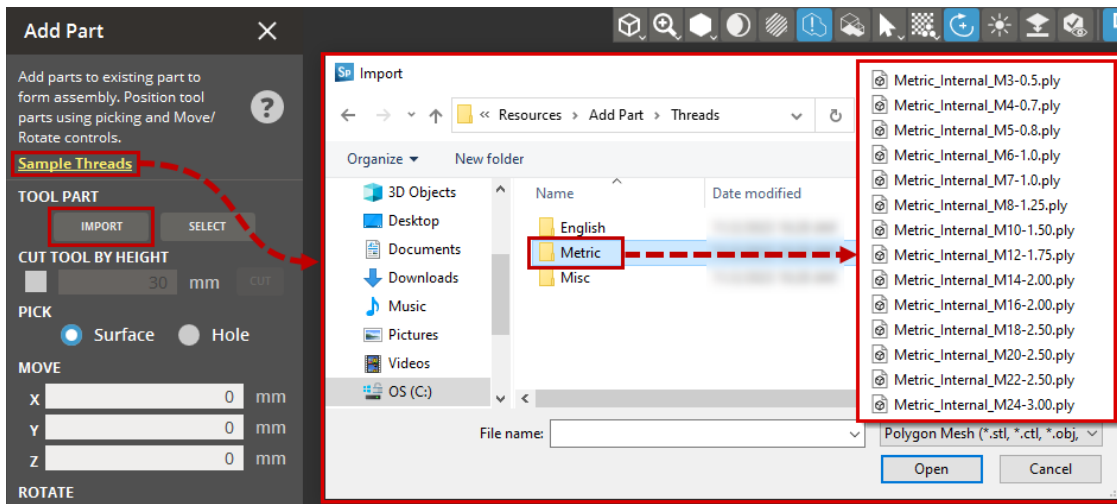
The following is available in 3D Sprint to support MJP 300W printer higher throughput printing:

- All the common MJP toolset
- VisiJet Wax Jewel Ruby material

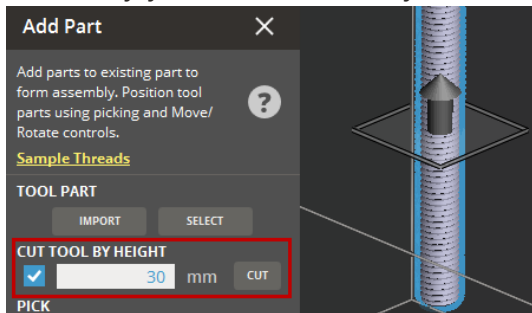
# Key Improvements

## Add Part Improvements ADD-ON

The **Add Part** command has been improved to offer a selection of pre-defined tool parts, simplifying the process of adding threads to target parts. You can now import these preset threads directly into the Printer Platform using the **Import** button within the command or access them conveniently via the **“Sample Threads”** link provided in the dialog.



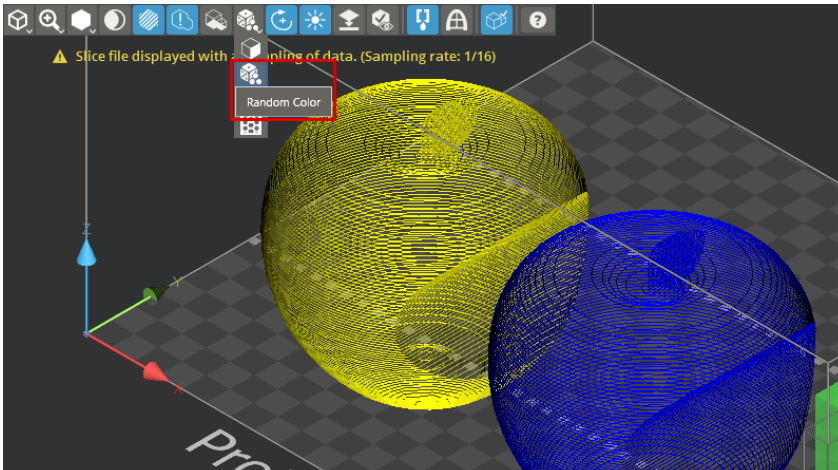
Additionally, you now have the ability to trim the selected tool part by specifying a desired height value and clicking **“Cut.”**



**Note:** This command is available with a 'MJP Advanced Slicing' Add-On.

## Miscellaneous Enhancements

- **Enhanced Random Color View for Slice Data** - The **Random Color View** option has been improved to support Slice data, providing enhanced identification capabilities of slice data.



## Bug Fixes

The following is a list of issues that have been resolved since the last version of 3D Sprint:

- 
- **GW-34321:** The build time for the ProJet 2500W Plus materials was identical in both XHD mode and ZHD mode.
  - **GW-34025:** The estimate incorrectly displayed the current material amount in the ProJet 2500 Plus printer.
  - **GW-33876:** The application would crash when selecting an SLC file during mesh fixings, causing instability.
  - **GW-33288:** Build file creation error after adding HDF mode for ProJet 2500 Plus printer.
  - **GW-32973:** Display artifact issues with lines appeared on ProJet 2500W/2500IC printers.
-

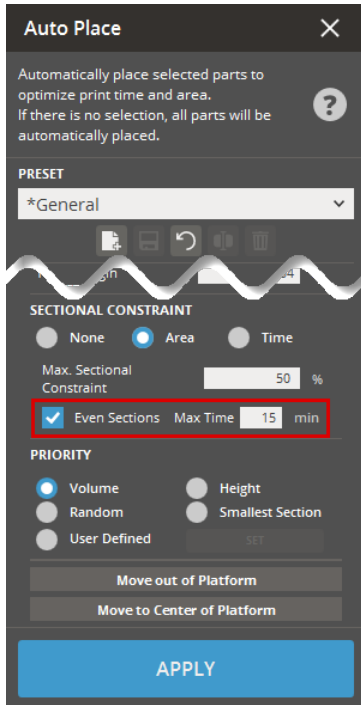


# SLS

## Key Improvements

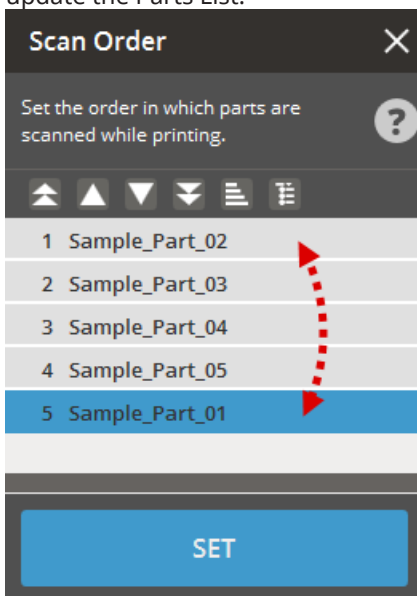
### Even Section Timeout for Auto Placing

You can now manage even sectioning, which ensures an even distribution of parts across the entire Print Platform when applying additional sectional constraints to auto-placed results, by setting the maximum timeout using the **Max Time** option. This feature is particularly useful for reducing prolonged processing durations.



## Miscellaneous Enhancements

- **User Defined Scan Order** - Added more options to the **Scan Order** command. You can now easily change the order of multiple selections by moving them up or down, dragging and dropping, or sorting them. Any changes you make will also update the Parts List.



- **Material and Configuration Updates** - The following material and build configuration have been added and updated for SLS 380 printer.

- **DuraForm PAx Black** - The new “**DuraForm PAx Black**” material is now available for **SLS 380** printer.



DuraForm PAx Black

- **Build Configuration Update** - All build configurations for **SLS 380** printer have been updated to **V7.4**.

- **Z Dimension of Printer Platform** - The default Z Dimension of the Printer Platform for the following printers has been updated to 460mm.

ProX SLS 500  
(Virtual Printers)  
DuraForm PAx NAT  
Advanced  
General  
X: 381 mm  
Y: 330.2 mm  
Z: 460 mm

ProX SLS 500

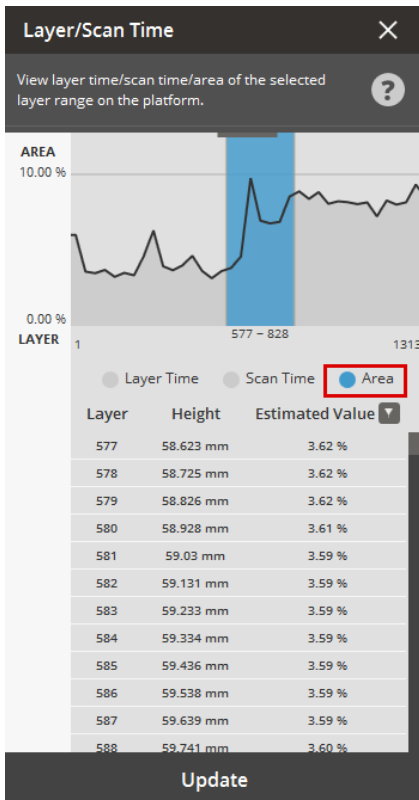
ProX SLS 6100  
(Virtual Printers)  
DuraForm ProX GF  
HP  
General  
X: 381 mm  
Y: 330.2 mm  
Z: 460 mm

ProX SLS 6100

SLS 380  
(Virtual Printers)  
DuraForm ProX GF  
Advanced  
General  
X: 381 mm  
Y: 330.2 mm  
Z: 460 mm

SLS 380

- **Layer Area Estimation** - Added an ‘Area’ option to the Layer/Scan Time command for visual inspection of part placement configurations to assist with optimization, whether through automatic or manual placement.



## Bug Fixes

The following is a list of issues that have been resolved since the last version of 3D Sprint:

- **GW-34281:** In the Part Properties, scaled extents were not visible for parts after importing.
- **GW-34000:** The Help icon was missing for the Layer Time command.
- **GW-33985:** The Help icon for the Estimate command incorrectly redirected to the Layer Time Help topic.
- **GW-33698:** The scroll bar couldn't be found or used when moved to the bottom in the Layer/Scan Time dialog.
- **GW-33502:** Inability to apply the NMI patch file to update SLS 6100 configurations in 3D Sprint 3.1 or 4.X.
- **GW-32411:** The application crashed after completing step 3 in the Scale&Offset wizard.
- **GW-29790:** The application would hang during auto-placement in certain cases.
- **GW-29590:** The Label option in the Cage command was not explained in the Help documentation.
- **GW-17056:** In both the Build Profile Editor and the Part Profile Editor, the Restore button would become enabled without any parameter edits for values in 'mm' and 'mm/sec' units.



Find out more at: <https://www.3dsystems.com/software/3d-sprint>

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