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Z-Corp Spectrum 510

Guide to Contract Services Offered by NextFab Studio

Overview

We accept contract work for our Z-Corp Spectrum 510 3D printer, which uses a specialty powder and binder to create products in a 10"x14.5"x10" bed. Because the Z-Corp builds the object layer by layer, it is capable of producing complex and organic shapes, as well as linked and fully assembled parts, such as chains, gear-boxes, curved tubes and bottles – essentially any form imaginable. The overall process is similar to the Dimension SST 1200es but each printer has its own benefits in time and post processing (detailed below)

Here's how the contract process works:

1. Submit your design to NextFab Studio in a file conforming to the specific file guidelines listed below in the File Setup section.
2. We will estimate job setup and material costs based upon cubic inches and will then provide a quote for your approval.
3. Upon approval, we will run the job and you will be notified when the product is ready for pickup (rush jobs upon request). See reverse for payment terms.

Materials:

The Z-Corp Spectrum uses a plaster-like ZP 150 powder, which can be dyed to a variety of colors during the printing process. At this time, we are unable to experiment with homemade materials.

Please include the following information in your Z-Corp quote request:

1. A file containing the appropriate information (see the file setup guidelines);
2. The desired resolution for the vertical layering along with the interior fill type;
3. The date parts are needed by; typical job turn-around is 2-3 business days depending on the job size, complexity and post-processing time.

Modeling Concerns

- Object size: The build bed is 10"x14"x8". We can digitally split larger parts for printing, then assemble them in a post-process step.
- Layer Thickness: Low resolution - .005 in. (draft) / Medium resolution .004 in. (standard) / High resolution- .0035 in. (premium)
- Mesh: Create all objects in a 3D program with depth (thickened walls not just surfaces). The object should be able to exist in the real world.
- Dimensions: Please check your file size when creating the part and again when exporting the file.
- Orientation: there will be slightly visible lines (cross-section lines) in your completed part (these can be hand sanded.) Think about which axis these should run along your part. Generally parts are stronger in the horizontal direction.

Email questions, files and contract work to: quotes@nextfabstudio.com.

Post Processing

Once your part is removed from its build bed it will be brushed off and cleaned. Once cleaned it can be sanded, drilled, and adjusted as you see fit. The object can then be either left alone or infiltrated. Infiltration will shine up the surface and harden the piece for durability and field testing. The object can then be touched up and painted to get a large range of finishes.

File Preparation

File Preparation is 95% of the work to create your final product. Please convert items to one of the required formats for submission. NextFab staff can also transform a sketch on paper or a description of the required parts in a variety of formats (please be sure to include dimensions on your drawing).

Acceptable file types are:

.stl .3ds
.vrmf .ply

ZBD	(Z Corp ZPrint file format)
ZPR	(Z Corp ZEdit & ZEdit Pro File Format)
VRML (.WRL)	Supports color and texture map import
3DS (.3DS)	Supports color and texture map import
STL	Does not support color or texture map import
PLY	Supports color import

Pricing / Payment Terms

Pricing for Spectrum Z510 3D printing is determined by the amount of raw material used and the labor required for file preparation, job setup, and post-processing. The amount of material used will depend on the dimensions of the object, and your choice of interior fill. Very large and/or delicate objects may require significant labor in job setup and post-processing. The Job Setup / Post-Processing fees include verifying and processing your file, preparing the machine for the job, post-process cleanup, and labor for infiltration (if desired) of your object.

Jobs over \$500 require 25% deposit prior to initiation of work. Payment is due in full upon delivery. All major credit cards accepted.