

INDUSTRY F421

SPECIFICATION



PRINTING

Print technology:	FFF
Build volume:	15 × 15 × 16.5 in 380 × 380 × 420 mm (60 648 cm ³)
Min. layer height:	50 µm
Number of printheads:	2, purging system
Nozzle diameter:	0.5/0.5 mm or 0.4/0.4mm
Filament diameter:	1.75 mm
Printhead temperature:	500°C (932°F)
Buildplate temperature:	180°C (356°F)
Chamber temperature:	195°C (356°F) (active heating)
Filament chamber temperature:	50°C (122°F)
Achievable part accuracy:	Parts are printed with an accuracy of 0.125 mm or 0.0014 mm/mm, whichever is greater. Accuracy in Z-axis includes an additional tolerance of 0.000/+ layer

SPEED

Travel move:	1000 mm/s
Printing speed:	up to 400 mm/s

DIMENSIONS AND MASS

External dimensions:	1900 × 940 × 900 mm
Mass:	365 kg

CONSTRUCTION

Chassis:	steel
External:	steel and vacuformed ABS, chamber lined with satin stainless steel
Build surface:	borosilicate glass / vacuum sealed plastic sheets

ENVIRONMENT

Working temperature:	18-30°C
Storage temperature:	-20-54°C

POWER

Power requirements:	- 230V 1ph with 32A (3n+p+e) IEC 60309 plug (recommended) - 230V 1ph 20A direct connection
Max power draw:	4600 W
Average power draw:	1500 W
Communication:	ethernet, Wi-Fi, USB drive

SOFTWARE

Slicing software:	3DGence SLICER 4.0
Cloud based services:	3DGence CLOUD

SAFETY

Advanced Filtration Unit:	yes, optional
Sensors:	main chamber door, top access hatch, thermal sensors, emergency switch
UPS device:	yes, optional
Others:	software access overdrive - remote shut down

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MODULES

M280

TEMPERATURE:

up to 280°C (536°F)

NOZZLE DIAMETER:

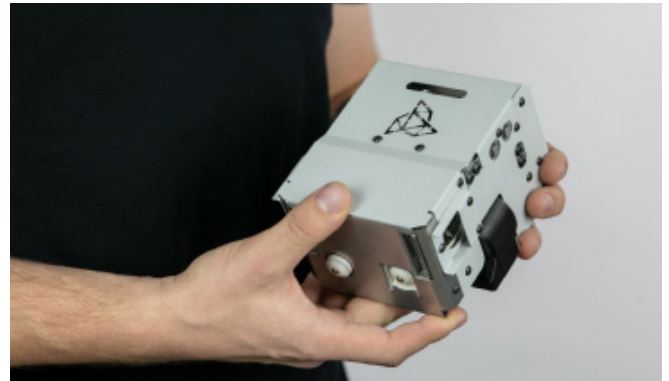
0,5 mm/0,5 mm

MODEL MATERIAL:

PLA, ABS, ABS-ESD, ASA, PA6,
PA-CF

SUPPORT MATERIAL:

ESM-10, HIPS



M360

TEMPERATURE:

up to 360°C (680°F)

NOZZLE DIAMETER:

0,4 mm/0,4 mm

MODEL MATERIAL:

LEXAN, PC, PC-ABS, PEKK-CF,
ULTEM 9085

SUPPORT MATERIAL:

ESM-10



M500

TEMPERATURE:

up to 500°C (932°F)

NOZZLE DIAMETER:

0,4 mm/0,4 mm

MODEL MATERIAL:

PEEK, PEKK, VICTREX AM™ 200

SUPPORT MATERIAL:

ESM-10



Flexibility and performance

Job-specific printing
modules and developed
printing profiles