



FORTUS 250mc™



FORTUS 360mc™



FORTUS 400mc™



FORTUS 900mc™

## REAL PARTS™ MEAN REAL POSSIBILITIES.

### Real Advancements in additive manufacturing

Fortus 3D Production Systems offer unparalleled versatility and capability to turn your CAD files into real parts. These parts are tough enough to be used as advanced conceptual models, functional prototypes, manufacturing tools and end-use parts. Engineers can produce a wide variety of products just by loading different files and materials. No traditional machining process can do that. And no other additive manufacturing system delivers the same advanced performance and production-grade parts as a Fortus 3D Production System.

### Nothing less than Real Parts

Whether it's a functional prototype or end-use part, everything a Fortus system produces is a real part. That's because they're built with the same durable thermoplastics as traditional injection-molded plastic parts. Only with Fortus systems can end-use thermoplastic parts be produced directly from CAD files without expensive tooling.

### Meet the demands of Real Production

Fortus systems are as versatile and durable as the real parts they produce. They boast the largest build envelopes and material capacities in their class, delivering longer, uninterrupted build times, bigger parts and higher production run quantities than other additive manufacturing systems. Plus, they are true production workhorses, delivering the high throughput, duty cycles and utilization rates that make direct digital manufacturing (DDM) not only possible, but practical.

### Opening the way for Real Possibilities

Fortus 3D Production Systems can streamline processes from design through manufacturing, reducing costs and eliminating traditional barriers along the way. With Fortus, you can build CAD designs, streamline production with custom fabrication and assembly tools and tooling masters, and eliminate tooling costs for short runs. Breakthrough designs, process innovations, just-in-time manufacturing — whatever you can imagine, Fortus can make it real.

### Real Results.



**Advanced prototypes:**  
For this and other sprinkler projects at Toro, Fortus systems helped reduce product development time by 283 weeks — and saved \$500,000.



**Advanced manufacturing tools:**  
At BMW, costs for producing manufacturing tools dropped significantly when engineers started producing tools with Fortus systems.



**Advanced end-use parts:**  
Klock Werks uses direct digital manufacturing to build custom motorcycle parts on their Fortus system, saving nearly \$13,000. FDM parts cost less than a quarter the price to injection mold or cast them.

# FORTUS SYSTEMS OVERVIEW

**FORTUS**<sup>®</sup>  
3D PRODUCTION SYSTEMS



	FORTUS 250mc™	FORTUS 360mc™	FORTUS 400mc™	FORTUS 900mc™
<b>Build Envelope</b>	10 x 10 x 12 in (254 x 254 x 305 mm)	Base envelope: 14 x 10 x 10 in (355 x 254 x 254 mm)  Optional upgrade: 16 x 14 x 16 in (406 x 355 x 406 mm)	Base envelope: 14 x 10 x 10 in (355 x 254 x 254 mm)  Optional upgrade: 16 x 14 x 16 in (406 x 355 x 406 mm)	36 x 24 x 36 in (914 x 610 x 914 mm)
<b>System Size/ Weight</b>	33 x 29 x 45 in (838 x 737 x 1143 mm)  With crate: 409 lbs. (186 kg) Without crate: 326 lbs. (148 kg)	50.5 x 35.3 x 77.3 in (1281 x 896 x 1962 mm)  With crate: 1511 lbs. (687 kg) Without crate: 1309 lbs. (593 kg)	50.5 x 35.3 x 77.3 in (1281 x 896 x 1962 mm)  With crate: 1511 lbs. (687 kg) Without crate: 1309 lbs. (593 kg)	109.1 x 66.3 x 79.8 in (2772 x 1683 x 2027 mm)  With crate: 7247 lbs. (3287 kg) Without crate: 6325 lbs. (2869 kg)
<b>Material Options</b>	ABSplus -P430	ABS-M30 PC-ABS PC	ABSi      PC-ISO ABS-M30    PC ABS-M30i    ULTEM* 9085 ABS-ESD7    PPSF PC-ABS	ABSi      PC-ISO ABS-M30    PC ABS-M30i    ULTEM* 9085 ABS-ESD7    PPSF PC-ABS
<b>Throughput Comparison</b>	1.0 x	1.7 x	2.0 x	2.1 x
<b>Achievable Accuracy<sup>1</sup></b>	Parts are produced within an accuracy of: ± .0095 in (± .241 mm)	Parts are produced within an accuracy of: ± .005 in (± .127 mm) or ± .0015 in/in (± .0015 mm/mm) whichever is greater. <sup>2</sup>	Parts are produced within an accuracy of: ± .005 in (± .127 mm) or ± .0015 in/in (± .0015 mm/mm) whichever is greater. <sup>2</sup>	Parts are produced within an accuracy of: ± .0035 in (± .089 mm) or ± .0015 in/in (± .0015 mm/mm) whichever is greater. <sup>3</sup>
<b>Software</b>	<p><b>Insight™</b> Insight software prepares 3D digital part files (output as an STL) to be manufactured on a Fortus system by automatically slicing and generating support structures and material extrusion paths in a single push of a button. If necessary, users can override Insight's defaults to manually edit parameters that control the look, strength and precision of parts as well as the time, throughput, expense and efficiency of the FDM process.</p> <p><b>Control Center™</b> Control Center is the software that communicates between the user workstation(s) and the Fortus system(s), managing jobs and monitoring the production status of Fortus systems. This software application provides the control to maximize efficiency, throughput and utilization while minimizing response time. Control Center is included with Insight software.</p>			

<sup>1</sup>Accuracy is geometry dependent. Achievable accuracy specification derived from statistical data at 95% dimensional yield.

<sup>2</sup>See Fortus 360mc/400mc accuracy study white paper for more information.

<sup>3</sup>See Fortus 900mc accuracy study white paper for more information.

# FORTUS MATERIALS OVERVIEW

Fortus 3D Production Systems use a variety of production-grade thermoplastics to manufacture functional parts direct from digital data. Fortus thermoplastics are environmentally stable, so overall shape and part accuracy don't change with ambient conditions over time, unlike the resins and powders in competitive processes. Materials are easy to change on Fortus systems, with no mess or complicated processes. When combined with Fortus systems, Fortus thermoplastics give you production quality thermoplastic parts that are ideal for concept modeling, functional prototyping, manufacturing tools, or end-use parts.



Material:	ABSplus-P430	ABSi	ABS-M30	ABS-M30i	ABS-ESD7	PC-ABS	PC-ISO	PC	ULTEM* 9085	PPSF
<b>System Availability</b>	Fortus 250mc	Fortus 400mc Fortus 900mc	Fortus 360mc Fortus 400mc Fortus 900mc	Fortus 400mc Fortus 900mc	Fortus 400mc Fortus 900mc	Fortus 360mc Fortus 400mc Fortus 900mc	Fortus 400mc Fortus 900mc	Fortus 360mc Fortus 400mc Fortus 900mc	Fortus 400mc Fortus 900mc	Fortus 400mc Fortus 900mc
<b>Layer Thickness:</b>										
0.013 inch (0.330 mm)	X	X	X	X		X	X	X	X <sup>3</sup>	X <sup>4</sup>
0.010 inch (0.254 mm)	X	X	X	X	X	X	X	X	X	X
0.007 inch (0.178 mm)	X	X	X	X	X	X	X	X		
0.005 inch (0.127 mm)		X <sup>1</sup>	X <sup>1</sup>	X <sup>1</sup>		X <sup>1</sup>		X <sup>1,6</sup>		
<b>Support Structure</b>	Soluble	Soluble	Soluble	Soluble	Soluble	Soluble	BASS	BASS, Soluble	BASS	BASS
<b>Available Colors</b>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #f0f0f0; border: 1px solid #ccc; margin-right: 5px;"></span> Ivory</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #fff; border: 1px solid #ccc; margin-right: 5px;"></span> White</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #000; border: 1px solid #ccc; margin-right: 5px;"></span> Black</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #444; border: 1px solid #ccc; margin-right: 5px;"></span> Dark Grey</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #f00; border: 1px solid #ccc; margin-right: 5px;"></span> Red</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #00f; border: 1px solid #ccc; margin-right: 5px;"></span> Blue</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #808000; border: 1px solid #ccc; margin-right: 5px;"></span> Olive Green</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #ffa500; border: 1px solid #ccc; margin-right: 5px;"></span> Nectarine</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #ffff00; border: 1px solid #ccc; margin-right: 5px;"></span> Fluorescent Yellow</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #fff; border: 1px solid #ccc; margin-right: 5px;"></span> Custom Colors</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #ccc; border: 1px solid #ccc; margin-right: 5px;"></span> Translucent Natural</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #ffa500; border: 1px solid #ccc; margin-right: 5px;"></span> Translucent Amber</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #f00; border: 1px solid #ccc; margin-right: 5px;"></span> Translucent Red</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #f0f0f0; border: 1px solid #ccc; margin-right: 5px;"></span> Ivory</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #fff; border: 1px solid #ccc; margin-right: 5px;"></span> White</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #000; border: 1px solid #ccc; margin-right: 5px;"></span> Black</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #444; border: 1px solid #ccc; margin-right: 5px;"></span> Dark Grey</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #f00; border: 1px solid #ccc; margin-right: 5px;"></span> Red</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #00f; border: 1px solid #ccc; margin-right: 5px;"></span> Blue</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #f0f0f0; border: 1px solid #ccc; margin-right: 5px;"></span> Ivory</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #000; border: 1px solid #ccc; margin-right: 5px;"></span> Black</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #000; border: 1px solid #ccc; margin-right: 5px;"></span> Black</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #fff; border: 1px solid #ccc; margin-right: 5px;"></span> White</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #ccc; border: 1px solid #ccc; margin-right: 5px;"></span> Translucent Natural</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #fff; border: 1px solid #ccc; margin-right: 5px;"></span> White</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #808000; border: 1px solid #ccc; margin-right: 5px;"></span> Tan</li> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #000; border: 1px solid #ccc; margin-right: 5px;"></span> Black</li> </ul>	<ul style="list-style-type: none"> <li><span style="display: inline-block; width: 10px; height: 10px; background-color: #808000; border: 1px solid #ccc; margin-right: 5px;"></span> Tan</li> </ul>
<b>Tensile Strength<sup>2</sup></b>	5,300 psi (37 MPa)	5,400 psi (37 MPa)	5,200 psi (36 MPa)	5,200 psi (36 MPa)	5,200 psi (36 MPa)	5,900 psi (41 MPa)	8,265 psi (57 MPa)	9,800 psi (68 MPa)	10,390 psi (72 MPa)	8,000 psi (55 MPa)
<b>Tensile Elongation<sup>2</sup></b>	3.0%	4.4%	4.0%	4.0%	3.0%	6.0%	4.3%	4.8%	5.9%	3.0%
<b>Flexural Stress</b>	7,600 psi (53 MPa)	8,980 psi (62 MPa)	8,800 psi (61 MPa)	8,800 psi (61 MPa)	8,800 psi (61 MPa)	9,800 psi (68 MPa)	13,089 psi (90 MPa)	15,100 psi (104 MPa)	16,700 psi (115 MPa)	15,900 psi (110 MPa)
<b>IZOD Impact, notched</b>	2.0 ft-lb/in (106 J/m)	1.8 ft-lb/in (96 J/m)	2.6 ft-lb/in (139 J/m)	2.6 ft-lb/in (139 J/m)	2.1 ft-lb/in (111 J/m)	3.7 ft-lb/in (196 J/m)	1.6 ft-lb/in (86 J/m)	1.0 ft-lb/in (53 J/m)	2.0 ft-lb/in (106 J/m)	1.1 ft-lb/in (59 J/m)
<b>Heat Deflection</b>	204°F (96°C)	188°F (87°C)	204°F (96°C)	204°F (96°C)	204°F (96°C)	230°F (110°C)	271°F (133°C)	280°F (138°C)	333°F (167°C)	372°F (189°C)
<b>Unique Properties</b>	Variety of color options	Translucent material	Variety of color options	ISO 10993 USP Class VI <sup>5</sup>	Static dissipative, target surface resistance of 10 <sup>7</sup> ohms <sup>†</sup>	Highest impact resistance	ISO 10993 USP Class VI <sup>5</sup>	Highest tensile strength	Flame, smoke, toxicity (FST) certified	Highest heat and chemical resistance

<sup>†</sup>Actual surface resistance may range from 10<sup>9</sup> to 10<sup>6</sup> ohms, depending upon geometry, build style and finishing techniques.

<sup>1</sup> 0.005 inch (0.127 mm) layer thickness not available for Fortus 900mc.

<sup>2</sup> See individual material spec sheets for testing details.

<sup>3</sup> 0.013 inch (0.330 mm) layer thickness for ULTEM not available on Fortus 400mc.

<sup>4</sup> 0.013 inch (0.330 mm) layer thickness for PPSF not available on Fortus 900mc.

<sup>5</sup> It is the responsibility of the finished device manufacturer to determine the suitability of all the component parts and materials used in their finished products.

<sup>6</sup> PC can attain 0.005 inch (0.127mm) layer thickness when used with SR-100 soluble support.

# FORTUS MATERIALS OVERVIEW

Material	Highlights
 <p><b>ABS-M30, ABSplus-P430</b> <i>(acrylonitrile butadiene styrene)</i></p>	<ul style="list-style-type: none"> <li>• Greater tensile, impact, and flexural strength than standard Stratasy's ABS</li> <li>• Layer bonding is significantly stronger for a more durable part than standard Stratasy's ABS</li> <li>• Versatile Material: Good for form, fit and functional applications</li> </ul>
 <p><b>ABS-ESD7</b> <i>(acrylonitrile butadiene styrene - static dissipative)</i></p>	<ul style="list-style-type: none"> <li>• Static dissipative with target surface resistance of <math>10^7</math> ohms (typical range <math>10^9 - 10^6</math> ohms)<sup>†</sup></li> <li>• Makes great assembly tools for electronic and static sensitive products</li> <li>• Widely used for functional prototypes of cases, enclosures and packaging</li> </ul>
 <p><b>ABS-M30i</b> <i>(acrylonitrile butadiene styrene - ISO 10993 USP Class VI biocompatible)</i></p>	<ul style="list-style-type: none"> <li>• Biocompatible (ISO 10993 USP Class VI)<sup>1</sup> material</li> <li>• Sterilizable using gamma radiation or ethylene oxide (EtO) sterilization methods</li> <li>• Best fit for applications requiring good strength and sterilization</li> </ul>
 <p><b>ABSi</b> <i>(acrylonitrile butadiene styrene - translucent)</i></p>	<ul style="list-style-type: none"> <li>• Translucent material</li> <li>• Good blend of mechanical and aesthetic properties</li> <li>• Available in translucent natural, red and amber colors</li> </ul>
 <p><b>PC-ABS</b> <i>(polycarbonate - acrylonitrile butadiene styrene)</i></p>	<ul style="list-style-type: none"> <li>• Superior mechanical properties and heat resistance of PC</li> <li>• Excellent feature definition and surface appeal of ABS</li> <li>• Highest impact strength</li> </ul>
 <p><b>PC</b> <i>(polycarbonate)</i></p>	<ul style="list-style-type: none"> <li>• Most widely used industrial thermoplastic</li> <li>• Accurate, durable, and stable for strong parts</li> <li>• Superior mechanical properties and heat resistant</li> </ul>
 <p><b>PC-ISO</b> <i>(polycarbonate - ISO 10993 USP Class VI biocompatible)</i></p>	<ul style="list-style-type: none"> <li>• Biocompatible (ISO 10993 USP Class VI)<sup>1</sup> material</li> <li>• Sterilizable using gamma radiation or ethylene oxide (EtO) sterilization methods</li> <li>• Best fit for applications requiring higher strength and sterilization</li> </ul>
 <p><b>ULTEM* 9085</b> <i>(polyetherimide)</i></p>	<ul style="list-style-type: none"> <li>• FST (flame, smoke, toxicity) certified thermoplastic</li> <li>• High heat and chemical resistance; highest tensile and flexural strength</li> <li>• Ideal for commercial transportation applications in airplanes, buses, trains, boats, etc.</li> </ul>
 <p><b>PPSF/PPSU</b> <i>(polyphenylsulfone)</i></p>	<ul style="list-style-type: none"> <li>• Highest heat and chemical resistance of all Fortus materials</li> <li>• Mechanically superior material, greatest strength</li> <li>• Ideal for applications in caustic and high heat environments</li> </ul>

<sup>†</sup>Actual surface resistance may range from  $10^9$  to  $10^6$  ohms, depending upon geometry, build style and finishing techniques.

<sup>1</sup>It is the responsibility of the finished device manufacturer to determine the suitability of all the component parts and materials used in their finished products.

For more information about Fortus systems, materials and applications, call **888.480.3548** or visit [www.fortus.com](http://www.fortus.com)

**Fortus 3D Production Systems  
Stratasys Incorporated**  
7665 Commerce Way  
Eden Prairie, MN 55344  
+1 888 480 3548 (US Toll Free)  
+1 952 937 3000  
+1 952 937 0070 (Fax)  
[info@stratasys.com](mailto:info@stratasys.com)

**Fortus 3D Production Systems  
Stratasys GmbH**  
Weismüllerstrasse 27  
60314 Frankfurt am Main  
Germany  
+49 69 420 994 30 (Tel)  
+49 69 420 994 333 (Fax)  
[europe@stratasys.com](mailto:europe@stratasys.com)

ISO 9001:2008 Certified

©2012 Stratasys Inc. All rights reserved. Stratasys, FDM and Fortus are registered trademarks and Real Parts, Fused Deposition Modeling, FDM Technology, Fortus 250mc, Fortus 360mc, Fortus 400mc, Fortus 900mc, Insight, Control Center and FDM TEAM are trademarks of Stratasys Inc., registered in the United States and other countries. \*ULTEM 9085 is a trademark of SABIC Innovative Plastics IP BV. All other trademarks are the property of their respective owners. Product specifications subject to change without notice. Fortus-SS-SystemsMaterialsOverview-8-12

**FORTUS**  
3D PRODUCTION SYSTEMS