Stratasys

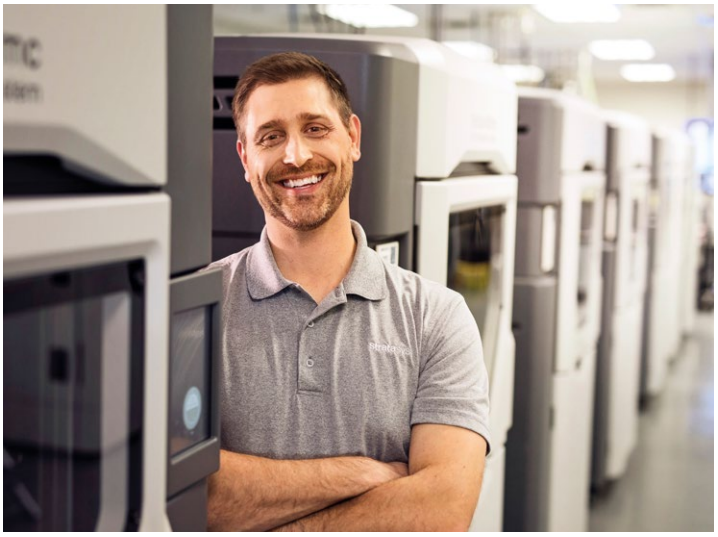
FDM 3D Printers and Materials.

Reliable. Repeatable. Exceptional.

FDM

Stronger. Faster. Better.

The FDM technology with unmatched versatility and proven performance.



Flexible options.
Durable results.

FDM® (fused deposition modeling) 3D Printers offer unparalleled versatility to turn your CAD files into durable parts. These parts are tough enough to be used as advanced conceptual models, functional prototypes, manufacturing tools and production parts. Engineers can produce a wide variety of products just by loading different files and materials. No traditional machining process can do that.

Superior materials.
Unrivalled repeatability.

FDM technology works with engineering-grade thermoplastics to build strong, long-lasting and dimensionally stable parts with the best accuracy and repeatability of any 3D printing technology. FDM machines make parts with the most commonly used thermoplastics, such as ABS, polycarbonate, a variety of blends, as well as engineered thermoplastics for aerospace, medical, automotive, electronic and other specialty applications. When using 3D printing for validation prototypes and the production of finished goods, using a durable, proven thermoplastic is all the more important, and it may be the only choice for many applications.

Bigger parts.
Improved designs.

FDM systems are as versatile and durable as the parts they produce. The most advanced FDM 3D Printers 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're true production workhorses, delivering the high throughput, duty cycles and utilization rates that make digital manufacturing not only possible, but practical.

Faster workflow.
Efficient processes.

FDM 3D Printers can streamline processes from design through manufacturing, reducing costs and eliminating traditional barriers along the way. With FDM, a designer can create an idea, and test it the same day. Industries can cut lead times and costs, products turn out better, and get to market faster. Breakthrough designs, process innovations, just-in-time manufacturing — whatever you can imagine, FDM can make it happen.

More materials. More benefits.

Material	Highlights
Antero™ 800NA (polyetherketoneketone)	• High heat and chemical resistance • Low outgassing and high dimensional stability • Excellent strength, toughness and wear-resistant properties
Antero™ 840CN03	• Excellent ESD (electrostatic dissipative) properties • High heat and chemical resistance • Low outgassing and high dimensional stability • Excellent strength, toughness and wear-resistant properties
ULTEM™ 1010 resin (polyetherimide)	• Food safety and bio-compatibility certification • Highest heat resistance, chemical resistance and tensile strength • Outstanding strength and thermal stability
ULTEM™ 9085 resin (polyetherimide)	• FST (flame, smoke, toxicity)-certified thermoplastic • High heat and chemical resistance; highest flexural strength • Ideal for commercial transportation applications such as airplanes, buses, trains and boats
PPSF (polyphenylsulfone)	• Mechanically superior material, greatest strength • Ideal for applications in caustic and high heat environments
ST-130™ (Sacrificial Tooling)	• Designed specifically for hollow composite parts • Fast, hands-free dissolution time • High heat and autoclave pressure resistance
FDM Nylon 6™ (polyamide 6)	• Combines strength and toughness superior to other thermoplastics • Produces durable parts with a clean finish and high break resistance
FDM Nylon 12™ (polyamide 12)	• The toughest nylon in additive manufacturing • Excellent for repetitive snap fits, press fit inserts and fatigue-resistance applications • Simple, clean process – free of powders
FDM Nylon 12CF™ (polyamide 12CF)	• Carbon fiber reinforced thermoplastic with excellent structural characteristics • Highest flexural strength • Highest stiffness-to-weight ratio
PC (polycarbonate)	• Most widely used industrial thermoplastic with superior mechanical properties and heat resistance • Accurate, durable and stable for strong parts, patterns for metal bending and composite work • Great for demanding prototyping needs, tooling and fixtures
PC-ISO™ (polycarbonate - ISO 10993 USP Class VI biocompatible)	• Biocompatible (ISO 10993 USP Class VI)[1] material • Sterilizable using gamma radiation or ethylene oxide (EtO) sterilization methods • Best fit for applications requiring higher strength and sterilization
PC-ABS (polycarbonate - acrylonitrile butadiene styrene)	• Superior mechanical properties and heat resistance of PC • Excellent feature definition and surface appeal of ABS • Hands-free support removal with soluble support
ASA (acrylonitrile styrene acrylate)	• Build UV-stable parts with the best aesthetics of any FDM material • Ideal for production parts for outdoor infrastructure and commercial use, outdoor functional prototyping and automotive parts and accessory prototypes
ABS-ESD7™ (acrylonitrile butadiene styrene - static dissipative)	• Static-dissipative with target surface resistance of 10^7 ohms (typical range 10^9 – 10^6 ohms)[2] • Makes great assembly tools for electronic and static-sensitive products • Widely used for functional prototypes of cases, enclosures and packaging
ABS-M30i™ (acrylonitrile butadiene styrene - ISO 10993 USP Class VI biocompatible)	• Biocompatible (ISO 10993 USP Class VI)1 material • Sterilizable using gamma radiation or ethylene oxide (EtO) sterilization methods • Best fit for applications requiring good strength and sterilization
ABS-M30™ (acrylonitrile butadiene styrene)	• Versatile material: good for form, fit and functional applications • Familiar production material for accurate prototyping
Diran™ 410MF07	• Good mechanical properties and toughness • Smooth texture with low sliding friction • Best fit for production of jigs, fixtures and manufacturing aids
PLA (Polylactic acid)	• Fast printing • Good tensile strength • Economical and user-friendly • Ideal for concept models
FDM™ TPU 92A (thermoplastic polyurethane)	• Elastomer material with Shore A value of 92 • Extremely flexible, durable and resilient • Compatible with soluble support • Accelerates elastomer prototyping without the need for molds

[1] 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.

[2] Actual surface resistance may range from 109 to 106 ohms, depending upon geometry, build style and finishing techniques.

A printer for every purpose.

	F120™	F170™	F270™
Build Envelope	10 x 10 x 10 in. (254 x 254 x 254 mm)	10 x 10 x 10 in. (254 x 254 x 254 mm)	12 x 10 x 12 in. (305 x 254 x 305 mm)
System Size/Weight	35 x 35 x 29 in. (889 x 889 x 721 mm), 275 lbs (124 kg)	64 x 34 x 28 in. (1626 x 864 x 711 mm) 500 lbs (227 kg) with consumables	64 x 34 x 28 in. (1626 x 864 x 711 mm) 500 lbs (227 kg) with consumables
Material Options	ABS-M30, ASA	ABS-M30, ASA, PLA, FDM TPU 92A	ABS-M30, ASA, PLA, FDM TPU 92A
Throughput Comparison	1.5 x (standard mode) 3 x (fast-draft mode)	1.5 x (standard mode) 3 x (fast-draft mode)	1.5 x (standard mode) 3 x (fast-draft mode)
Part Accuracy[1]	Parts are produced within an accuracy of +/- .008 in. (.200 mm), or +/- .002 in./in. (.002 mm/mm), whichever is greater.	Parts are produced within an accuracy of +/- .008 in. (.200 mm), or +/- .002 in./in. (.002 mm/mm), whichever is greater.	Parts are produced within an accuracy of +/- .008 in. (.200 mm), or +/- .002 in./in. (.002 mm/mm), whichever is greater.
Software	**GrabCAD Print™:** GrabCAD Print simplifies the traditional 3D print preparation workflow and provides intelligence around printer usage so your team can get quality prints, faster. Print directly from CAD, organize print queues, monitor material levels and work with detailed views of your model. The tray and slice preview feature supports adjustments before going to print.		

	F370™	Fortus 380mc™[3]	Fortus 450mc™	F900™
Build Envelope	14 x 10 x 14 in. (355 x 254 x 355 mm)	14 x 12 x 12 in. (355 x 305 x 305 mm)	16 x 14 x 16 in. (406 x 355 x 406 mm)	36 x 24 x 36 in. (914 x 610 x 914 mm)
System Size/Weight	64 x 34 x 28 in. (1,626 x 864 x 711 mm) 500 lbs (227 kg) with consumables	50 x 35.5 x 76.5 in. (1,270 x 901.7 x 1,984 mm) 1,325 lbs (601 kg)	50 x 35.5 x 76.5 in. (1,270 x 901.7 x 1,984 mm) 1,325 lbs (601 kg)	109.1 x 66.3 x 79.8 in. (2,772 x 1,683 x 2,027 mm) 6,325 lbs (2,869 kg)
Material Options	**F370:** ABS-M30, ASA, PC-ABS, PLA, Diran 410MF07, ABS-ESD7, FDM TPU-92A	ABS-M30, ABS-M30i, ABS-ESD7, ASA, PC-ISO, PC, PC-ABS, FDM Nylon 12 **Fortus 380mc Carbon Fiber Edition:** ASA and FDM Nylon 12CF	ABS-M30, ABS-M30i, ABS-ESD7, Antero 800NA, ASA, PC-ISO, PC, PC-ABS, FDM Nylon 12, FDM Nylon 12CF, ST-130, ULTEM™ 9085 resin, ULTEM™ 1010 resin	ABS-M30, ABS-M30i, ABS-ESD7, Antero 800NA, Antero 840CN03, ASA, PC-ISO, PC, PC-ABS, PPSF, FDM Nylon 12, FDM Nylon 12CF, FDM Nylon 6, ST-130, ULTEM™ 9085 resin, ULTEM™ 1010 resin
Throughput Comparison	1.5 x (standard mode) 3 x (fast-draft mode)	2.0 x	2.0 x	2.1 x
Part Accuracy[1]	Parts are produced within an accuracy of: +/- .008 in. (.200 mm), or +/- .002 in./in. (.002 mm/mm), whichever is greater.	Parts are produced within an accuracy of ± .005 in. (.127 mm) or ± .0015 in./in. (.0015 mm/mm), whichever is greater.	Parts are produced within an accuracy of ± .005 in. (.127 mm) or ± .0015 in./in. (.0015 mm/mm), whichever is greater.	Parts are produced within an accuracy of: ± .0035 in. (.09 mm) or ± .0015 in./in. (.0015 mm/mm), whichever is greater.[2]
Software	**Insight™:** Insight software prepares 3D digital part files (output as an STL) to be manufactured on an FDM 3D Printer by automatically slicing and generating support structures and material extrusion paths in one 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. **Control Center™:** Control Center is the software that communicates between the user workstation(s) and the FDM system(s), managing jobs and monitoring the production status of FDM systems. This software application provides the control to maximize efficiency, throughput and utilization while minimizing response time. Control Center is included with Insight software. **GrabCAD Print:** GrabCAD Print simplifies the traditional 3D print preparation workflow and provides intelligence around printer usage so your team can get quality prints, faster. Print directly from CAD, organize print queues, monitor material levels and work with detailed views of your model. The tray and slice preview feature supports adjustments before going to print.			

[1] Accuracy is geometry-dependent. Achievable accuracy specification derived from statistical data at 95% dimensional yield. Z part accuracy includes an additional tolerance of -0.000/+slice height.

[2] See Fortus 900mc accuracy study white paper for more information.

[3] Fortus 380mc Carbon Fiber Edition runs only ASA and FDM Nylon 12CF, but is identical to the Fortus 380mc otherwise.

Premium materials. Premium performance.

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

	Antero 800NA	Antero 840CN03	ULTEM™ 1010 resin	ULTEM™ 9085 resin	PPSF	ST-130
System Availability	Fortus 450mc F900	F900	Fortus 450mc F900	Fortus 450mc F900	F900	Fortus 450mc F900
Layer Thickness	0.010 in. (0.254 mm)	0.010 in. (0.254 mm)	0.020 in. (0.508 mm)[11] 0.013 in. (0.330 mm) 0.010 in. (0.254 mm)	0.013 in. (0.330 mm)[10] 0.010 in. (0.254 mm)	0.013 in. (0.330 mm)[3] 0.010 in. (0.254 mm)	0.013 in. (0.330 mm)
Support Structure	Breakaway	Breakaway	Breakaway	Breakaway	Breakaway	Breakaway
Available Colors	■ Natural	■ Black	■ Natural	■ Tan ■ Black	■ Tan	■ Natural
Tensile Strength (Ultimate)[2]	**XZ:** 13,504 psi (94 MPa) **ZX:** 6,650 psi (47 MPa)	**XZ:** 13,610 psi (95 MPa) **ZX:** 7,320 psi (50 MPa)	**XZ:** 11,735 psi (81 MPa) **ZX:** 5,400 psi (37 MPa)	**XZ:** 9,950 psi (69 MPa) **ZX:** 6,100 psi (42 (MPa)	**XZ:** 8,000 psi (55 MPa)	N/A
Tensile Elongation[2]	**XZ:** 6.40 ± 1.05% **ZX:** 1.22 ± 0.28%	**XZ:** 6% **ZX:** 1.8%	**XZ:** 3.3% **ZX:** 1.3%	**XZ:** 5.8% **ZX:** 2.2%	**XZ:** 3.0%	N/A
Flexural Stress	**XZ:** 20,548 ± 477 psi (142 ± 3 MPa) **ZX:** 9,349 ± 1,514 psi (64 ± 10 MPa)	**XZ:** 19,620 psi (135 MPa) **ZX:** 9,760 psi (70 MPa)	**XZ:** 20,835 psi (144 MPa) **ZX:** 11,184 psi (77 MPa)	**XZ:** 16,200 psi (112 MPa) **ZX:** 9,900 psi (68 MPa)	**XZ:** 15,900 psi (110 MPa)	N/A
IZOD Impact, notched	**XZ:** 0.69 ± 0.12 ft-lb/in (37 ± 6 J/m) **ZX:** 0.51 ± 0.09 ft-lb/in (27 ± 5 J/m)	**XZ:** 0.90 ft-lb/in (48 J/m) **ZX:** 0.5 ft-lb/in (28 J/m)	**XZ:** 0.8 ft-lb/in (41 J/m) **ZX:** 0.4 ft-lb/in (24 J/m)	**XZ:** 2.0 ft-lb/in (120 J/m) **ZX:** 0.9 ft-lb/in (48 J/m)	**XZ:** 1.1 ft-lb/in (59 J/m)	N/A
Heat Deflection at 264 psi	297 °F (147 °C)	306 °F (153 °C)	415 °F (213 °C)	307 °F (153 °C)	372 °F (189 °C)	226 °F (108 °C)
Unique Properties	High strength, and heat and chemical resistance, low outgassing	Electrostatic dissipative (ESD) properties	Food-safety and bio-compatibility certification	Flame, smoke, toxicity (FST) certified, ULTEM™ 9085 resin Aerospace grade available	Highest heat and chemical resistance	Sacrificial tooling

	FDM Nylon 6	FDM Nylon 12	FDM Nylon 12CF	PC	PC-ISO
System Availability	F900	Fortus 380mc Fortus 450mc F900	Fortus 450mc F900 Fortus 380mc Carbon Fiber Edition	Fortus 380mc Fortus 450mc F900	Fortus 380mc Fortus 450mc F900
Layer Thickness	0.013 in. (0.330 mm) 0.010 in. (0.254 mm)	0.013 in. (0.330 mm) 0.010 in. (0.254 mm) 0.007 in. (0.178 mm)	0.010 in. (0.254 mm)	0.013 in.[5] (0.330 mm) 0.010 in. (0.254 mm) 0.007 in. (0.178 mm) 0.005 in. (0.127 mm)[1,5]	0.013 in. (0.330 mm) 0.010 in. (0.254 mm) 0.007 in. (0.178 mm)
Support Structure	Soluble	Soluble	Soluble	Breakaway, Soluble	Soluble
Available Colors	■ Black	■ Black	■ Black	❑ White	❑ White ■ Translucent Natural
Tensile Strength (Ultimate)[2]	**XZ:** 9,800 psi (67.6 MPa) **ZX:** 5,300 psi (36.5 MPa)	**XZ:** 6,650 psi (46 MPa) **ZX:** 5,600 psi (38.5 MPa)	**XZ:** 10,960 psi (75.6 MPa) **ZX:** 4,990 psi (34.4 MPa)	**XZ:** 8,300 psi (57 MPa) **ZX:** 6,100 psi (42 MPa)	**XZ:** 8,300 psi (57 MPa)
Tensile Elongation[2]	**XZ:** 38% **ZX:** 3.2%	**XZ:** 30% **ZX:** 5%	**XZ:** 1.9% **ZX:** 1.2%	**XZ:** 4.8% **ZX**: 2.5%	**XZ:** 4%
Flexural Stress	**XZ:** 14,100 psi (97.2 MPa) **ZX:** 11,900 psi (82 MPa)	**XZ:** 9,700 psi (67 MPa) **ZX:** 8,800 psi (61 MPa)	**XZ:** 20,660 psi (142 MPa) **ZX:** 8,430 psi (58.1 MPa)	**XZ:** 13,000 psi (89 MPa) **ZX:** 9,900 psi (68 MPa)	**XZ:** 13,100 psi (90 MPa)
IZOD Impact, notched	**XZ:** 2.0 ft-lb/in (106 J/m) **ZX:** 0.8 ft-lb/in (43 J/m)	**XZ:** 2.5 ft-lb/in (135 J/m) **ZX:** 1 ft-lb/in (53 J/m)	**XZ:** 1.6 ft-lb/in (85 J/m) **ZX:** 0.4 ft-lb/in (21.4 J/m)	**XZ:** 1.4 ft-lb/in (73 J/m) **ZX:** 0.5 ft-lb/in (28 J/m)	**XZ:** 1.6 ft-lb/in (86 J/m)
Heat Deflection Temp at 264 psi	199 °F (93 °C)	180 °F[6] (82 °C)[6]	289 °F (143 °C)	261 °F (127 °C)	260 °F (127 °C)
Unique Properties	Very high strength and toughness combined	Fatigue-resistant, high elongation at break	Highest flexural strength of any FDM material	Strong (tension)	ISO 10993 USP Class VI[4]

Premium materials.
Premium performance.
(Continued)

	PC-ABS	ASA	ABS-ESD7	ABS-M30i
System Availability	Fortus 380mc Fortus 450mc F370 F900	Fortus 380mc Fortus 450mc F120 F170 F270 F370 F900	Fortus 380mc Fortus 450mc F370 F900	Fortus 380mc Fortus 450mc F900
Layer Thickness	0.013 in. (0.330 mm) 0.010 in. (0.254 mm) 0.007 in. (0.178 mm) 0.005 in. (0.127 mm)[1]	0.020 in. (0.508 mm) 0.013 in. (0.330 mm) 0.010 in. (0.254 mm) 0.007 in. (0.178 mm) 0.005 in. (0.127 mm)	0.010 in. (0.254 mm) 0.007 in. (0.178 mm)	0.013 in. (0.330 mm) 0.010 in. (0.254 mm) 0.007 in. (0.178 mm) 0.005 in. (0.127 mm)[1]
Support Structure	Soluble	Soluble	Soluble	Soluble
Available Colors	■ Black □ White[2]	■ Ivory[12] ■ Black ■ Dark Gray ■ Light Gray □ White ■ Red ■ Orange ■ Yellow ■ Green ■ Dark Blue	■ Black	■ Ivory
Tensile Strength (Ultimate)[2]	**XZ:** 5,900 psi (41 MPa)	**XZ:** 4,750 psi (33 MPa) **ZX:** 4,300 psi (30 MPa)	**XZ:** 5,200 psi (36 MPa)	**XZ:** 4,650 psi (36 MPa)
Tensile Elongation[2]	**XZ:** 6%	**XZ:** 9% **ZX:** 3%	**XZ:** 3.0%	**XZ:** 4%
Flexural Stress	**XZ:** 9,800 psi (68 MPa)	**XZ:** 8,700 psi (60 MPa) **ZX:** 6,900 psi (48 MPa)	**XZ:** 8,800 psi (61 MPa)	**XZ:** 8,800 psi (61 MPa)
IZOD Impact, notched	**XZ:** 3.7 ft-lb/in (196 J/m)	**XZ:** 1.2 ft-lb/in (64 J/m)	**XZ:** 0.5 ft-lb/in (28 J/m)	**XZ:** 2.6 ft-lb/in (139 J/m)
Heat Deflection Temp at 264 psi	205 °F (96 °C)	196 °F (91 °C)	180 °F (82 °C)	180 °F (82 °C)
Unique Properties	Strong (impact)	UV stable with the best aesthetics of any FDM material	Static-dissipative, target surface resistance of 107 ohms[7]	ISO 10993 USP Class VI[4]

	ABS-M30**	Diran 410MF07	PLA	FDM TPU 92A
System Availability	Fortus 380mc Fortus 450mc F120 F170 F270 F370 F900	F370	F170 F270 F370	F170 F270 F370
Layer Thickness	0.013 in. (0.330 mm) 0.010 in. (0.254 mm) 0.007 in. (0.178 mm) 0.005 in. (0.127 mm)[1]	0.007 in. (0.178 mm) 0.010 in. (0.254 mm) 0.013 in. (0.330 mm)	0.010 in. (0.254 mm)	0.010 in. (0.254 mm)
Support Structure	Soluble	Breakaway	Breakaway	Soluble
Available Colors	Ivory White Black[13] Dark Gray Red Blue Orange[8] Yellow[8] Green[8] Custom Colors	Black	Black White Light Gray Medium Gray Red Blue Natural Translucent Red Translucent Blue Translucent Yellow Translucent Green Translucent	Black
Tensile Strength (Ultimate)[2]	**XZ:** 4,650 psi (32 MPa) **ZX**: 4,050 psi (28 MPa)	**XZ:** 6,490 psi (45 MPa) **ZX:** 4460 psi (30 MPa)	**XZ:** 6,990 psi (48 MPa) **ZX:** 3,830 psi (26 MPa)	**XZ:** 2,519 psi (17.4 MPa) **XY:** 2432 psi (16.8 MPa)
Tensile Elongation[2]	**XZ:** 7.0% **ZX:** 2%	**XZ:** 12% **ZX:** 3.1%	**XZ:** 2.5% **ZX:** 1.0%	**XZ:** 482% **XY:** 552%
Flexural Stress	**XZ:** 8,700 psi (60 MPa) **ZX:** 7,000 psi (48 MPa)	**XZ:** 8,800 psi (60 MPa) **ZX:** 6770 psi (45 MPa)	**XZ:** 12,190 psi (84 MPa) **ZX:** 6,750 psi (45 MPa)	**XZ:** 351 psi (2.4 MPa) **XY:** 255 psi (1.8 MPa)
IZOD Impact, notched	**XZ:** 2.4 ft-lb/in (128 J/m)	**XZ:** 7 ft-lb/in (380 J/m) **ZX:** 0.5 ft-lb/in (27 J/m)	**XZ:** 0.5 ft-lb/in (27 J/m)	–
Heat Deflection Temp at 264 psi	180 °F (82 °C)	158 °F (70 °C)	124 °F (51 °C)	100 °F (38 °C) (@ 66 psi)
Unique Properties	Variety of color options	Smooth, lubricious texture with low sliding friction	Low cost, fast-draft printing	Elastomer

[1] 0.005 in. (0.127 mm) layer thickness not available for Stratasys F900.

[2] See individual material spec sheets for testing details.

[3] 0.013 in. (0.330 mm) layer thickness for PPSF not available on Stratasys F900.

[4] 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.

[5] PC can attain 0.013 in. (0.330 mm) layer thickness when use with break away support. PC can attain 0.005 in. (0.127mm) layer thickness when used with SR-100 soluble support.

[6] Annealed.

[7] Actual surface resistance may range from 109 to 106 ohms, depending upon geometry, build style and finishing techniques.

[8] Available only on the Stratasys F123 Series.

[9] Available only on the Stratasys F370.

[10] Available on Fortus 400mc and Stratasys F900.

[11] Available on the F170, F270, F370 and F900.

[12] F120 is only available with ASA Ivory.

[13] ABS is only available in Black on F120.

** Mechanical properties are measured on the Fortus systems and may vary with other printers.

Advanced materials. Designed to give you more.

We not only provide the widest choice of materials, we'll also help you get the best out of them.

We're continually developing and investing in our hardware, software and services to help you get the best possible results. Improving accuracy, flexibility and reliability. All in less time, with less hassel.

Make it with Stratasys.

Get in touch.

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