

Thank you for purchasing a Pre-Installed Wham Bam PEX for the Bambu Lab A1 mini. You are going to love this system!

Included:

° **PEX Build Surface or mounted to a Flexi Plate**

PEX Build Surface mounted to a Spring Steel Plate with high temperature 3M adhesive.

° **Composite Abrasive Pad**

Composite Abrasive Pad, similar to Scotchbrite 7447, to prepare your PEX before first use and use between prints to keep contamination from building up on PEX over time.

Preparation Instructions:

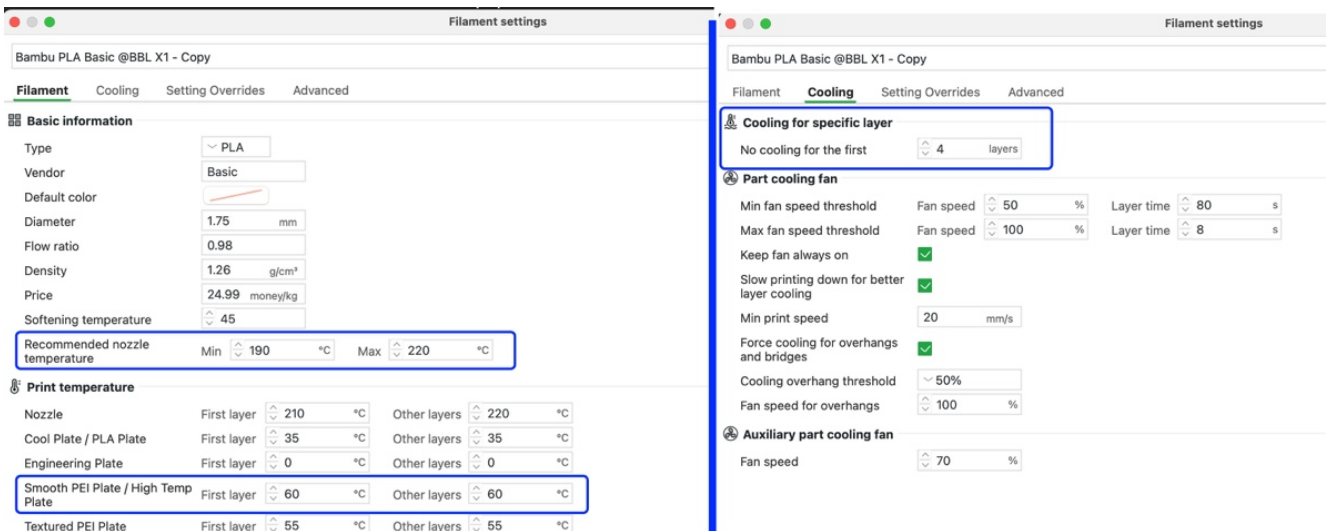
1. **REMOVE** protective film from the top of the **PEX Build Surface**.
2. Prepare the **PEX Build Surface** sheet surface using included Composite Abrasive Pad, 000 steel wool or a Scotchbrite 7447 pad. Use a bit of isopropyl alcohol (95% or higher). Scuff for 4-5 minutes until surface has an even, semi-matte finish and you do not see individual scratches. Clean the surface repetitively with fresh paper towel and alcohol. Use paper towel, and do not use microfiber cloths, wipes, or rags as these may propagate the contaminants back to the PEX.
3. Lay the Pre-Installed Wham Bam PEX onto the bed and begin printing!

Use:

Bambu Slicer tends to set default temperatures too high. Always check the settings on your filament spool for manufacturer's recommended temperatures.

Initially try setting **First layer** for the mid-point of the range on the spool and you may set **Other layers** up to the maximum recommended temperature.

Make sure to also limit the **Recommended nozzle temperature min** and **max** to that written on the spool.



Make sure to turn off part fan for the first 4 layers in the slicer to allow first layers to bond well.

Make sure to select High Temp Plate in Slicer.

Suggested Temperatures and Settings for Bambu, in °C:

Filament	Bed Temp	First Layer	Other Layers
PLA	60-70	200	210
PLA Plus	60-70	210	220
PETG *	50-60	245	255
ABS /ASA	100-110	235	245

* Please note PETG is molecularly similar to PEX and PEI and likes to bond to the build surfaces.

Bambu sets their default temp settings high in order to achieve faster prints, you need to be more careful with settings on PETG and lower these according to filament manufacturer recommendations. We find that **245 First layer** is ideal and **255 Other layers** gets max speed and reduces bonding.

Test all new filaments, especially PETG on a small corner area, each are different, if you have bonding use some glue stick as a barrier layer. For a comprehensive explanation see pdf (found on Wham Bam Systems Support Page): <https://www.whambamsystems.com/pages/fbs-kits-support-page>

Print Removal:

After printing, and once both Flexi Plate and parts **are completely cool!** Just bend the Flexi Plate on one axis, then on the other. Large parts should just pop right off. Smaller parts may need a bit more bending or slight help with a spatula. Never dig into the surface nor force prints off. Never remove prints while part or plate are warm or hot.

Maintenance:

After every print we suggest to quickly scuff and clean with the Composite Abrasive Pad or 000 Steel Wool and alcohol for 5-10 seconds, and clean well with isopropyl alcohol and fresh paper towel before reusing. This will prevent contaminants from the filaments from building up on the PEX.

Should the PEX ever loose its grip, wash with strong dish detergent and or vinegar and rinse with water, as these help break fats and contaminants in many filaments.

See this video for maintenance between prints:
<https://www.youtube.com/watch?v=GSJNOK6mgOo>



Resources, Help, and Support:

Should you have any issues please refer to our installation guide, FAQ's, and to find the most up to date instructions please go to our page:
<https://www.whambamsystems.com/pages/fbs-kits-support-page>

Please go to our page: <https://whambamsystems.com/install>
 for more support and resources, and feel free to write us with any questions.
 ordering / shipping: info@whambamsystems.com
 technical support: technical@whambamsystems.com



Wham Bam thanks you for your support and welcomes any and all feedback!