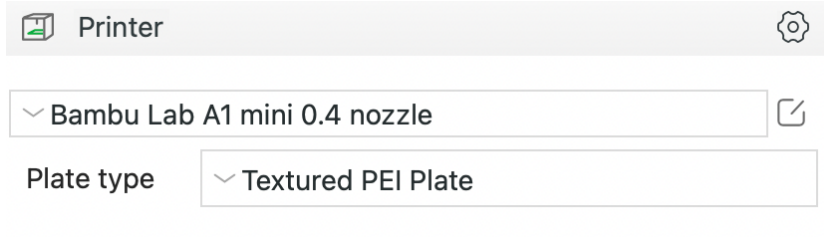



Thank you for purchasing a Powder Painted ULTEM™ PEI Flexi Plate for the Bambu A1 mini. You are going to love this system!

**Specs:**

Comprised of authentic **ULTEM™ PEI Powder** painted on both sides and kiln baked at high temperatures onto our robust, high quality, high chromium spring steel Flexi Plate. It has the same treatment on both sides so you can use one for testing and the other for pristine results.

**Make sure to select Textured PEI Plate under Plate Type in slicer.**



Printer 


▼ Bambu Lab A1 mini 0.4 nozzle 

Plate type ▼ Textured PEI Plate

**Preparation Instructions:**

1. Prepare the **Powder Painted ULTEM PEI** by cleaning with bit of isopropyl alcohol (common high percentage rubbing alcohol from your pharmacy is fine). Then 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.
2. Lay the **Powder Painted ULTEM PEI Flexi Plate** onto the magnetic bed and begin printing!

**Use:**

Do a bit of testing to find your best bed temps with the Powder Painted PEI Plates. Our **ULTEM PEI Build Surface** is specially formulated to resist much higher temps than any PC or other PEI build surfaces. It has great physical bond to the parts without them ever melting into the surface. Turn off part fan for the first 4 layers to allow first layer to bond well.

**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 wiping with isopropyl alcohol and fresh paper towel. Do not use microfiber, wipes, or rags as these may propagate the contaminants back to the PEX.

If you have small bits, such as purge lines, stuck to the surface you can try with a steel spatula with corners rounded to carefully remove these. Do not use Acetone as this will damage the surface.

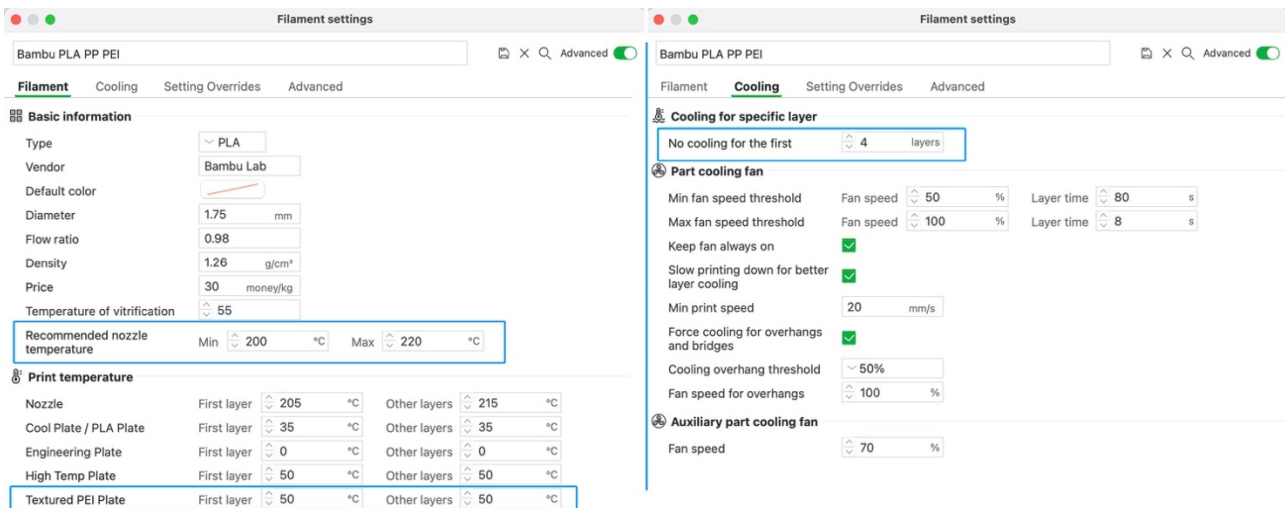
Should the PEI ever loose its grip, you may also try strong dish detergent or vinegar and clean with water. These help break fats added to filaments. You can also lightly pass over the plate with 600 grit wet dry sandpaper to revitalize, then clean with IPA and fresh paper towel.

## Suggested Temperatures and Settings for Bambu, in °C:

Filament	Bed Temp	First Layer	Other Layers
PLA	50-60	200	210
PLA Plus	50-60	210	220
PETG *	50-55	245	255
ABS /ASA	100-110	235	245

## Suggested Temperatures and Settings for the Bambu Lab X1:

We have found that PLA and other materials stick very well to our Powder Painted ULTEM Surface and suggest limiting Bed Temps and Nozzle Temps. Use the filament manufacturer’s hot end range from the spool to set your settings in the slicer, see examples of PLA settings below:



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

### 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>

for more support and resources, and feel free to write us with any questions:

ordering/ shipping: [info@whambamsystems.com](mailto:info@whambamsystems.com)

technical support: [technical@whambamsystems.com](mailto:technical@whambamsystems.com)



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