**Thank you for purchasing a Wham Bam Flexible Build System for Resin.**
You are going to love this system!

Included in the **Flexible Build System** for Resin Kit:
**1 XTR Flexi Plate** -    Spring steel build plate with dual sided etched surface for ideal grip.

**1 XTR Magnetic Base** - High strength magnetic sheet backed with solvent resistant 3M adhesive.

**1 Piece 400 Grit Sandpaper – (small sheet)** wet/dry 400 grit sand paper to refurbish Flexi Plate as needed.

**1 Piece 220 Grit Sandpaper – (large sheet)** wet/dry 220 grit sand paper to prepare the machine build plate.

**2 Wham Bam Stickers**


Included in the **Double Wham** for Resin Kit:

**2 XTR Flexi Plate**    -    Spring steel build plate with dual sided etched surface for ideal grip.

**1 XTR Magnetic Base** - High strength magnetic sheet backed with solvent resistant 3M adhesive.

**1 Piece 400 Grit Sandpaper – (small sheet)** wet/dry 400 grit sand paper to refurbish Flexi Plate as needed.

**1 Piece 220 Grit Sandpaper – (large sheet)** wet/dry 220 grit sand paper to prepare the machine build plate.

**2 Wham Bam Stickers**


**Mounting Instructions:**
Before you install any parts, please do a practice run, by placing components in place without removing 3M backing to see if everything aligns correctly and that you understand the best order of assembly.
*    You may need to print a Z stop spacer, see step 5, before you begin installation.    *
**Attention:  It is the user's responsibility to prepare the build plate well before installing magnet, failure to do so may result in adhesive coming off at a later time, follow below directions very carefully.**

1.  Thoroughly clean the whole build head by letting it soak in 90% or higher Isopropyl Alcohol. If Isopropyl Alcohol is difficult to find, pure Acetone, or 90% or higher Ethyl Alcohol will work. Do not use Mean Green or other detergents for this.  Wipe dry.

2.  Sand the bottom of your build plate with included 220 grit sand paper to remove any irregularities and contaminants and open the pores.    Clean again with 90% or higher Isopropyl Alcohol and fresh paper towel. Do not reuse old shop rags or sponges.  Repeat cleaning a few times. Allow to dry completely.

3.  Once your build plate is perfectly clean, it's time to apply your **WB Magnetic Base**.  First test fit to make sure it is a good match to your plate, it is easy to cut with a cutter knife if needed.  Then peel back a 1" / 20mm strip of the paper backing from the adhesive being very careful not to attract dust or dirt to the glued surface.  Keep the whole **WB Magnetic Base** elevated above the Build Plate and only touch the far back side to line it up with the Build Plate, then while keeping the side near you elevated begin to push down in the center rear while slowly working the **WB Magnetic Base** down against the Build Plate.  Pull the backing paper as you wipe from center outward.  Continue working from back toward front and pushing from center and spreading outward till the whole sheet is down.  Burnish down with a bit of pressure, you can put a sheet of paper on top and rub it hard.  Allow the 3M adhesive bond to cure for 72 hours for full adhesion.

4.  Now position the **WB Flexi Plate** on top of the **WB Magnetic Base**.

5.  You may need to adjust your Z stop. As you are adding about 3.8 mms to the bottom of your build plate, you may need to physically move your Z stop Sensor to accept this extra distance. Some Build plates have enough play to absorb this, each machine is different.  check our support section for more information about your specific machine https://whambamsystems.com/support

6.  You must relevel your build plate, make sure it is not too tight or you may experience base layer shifting.

**Maintenance:**

Make sure your **WB Magnetic Base** stays free of debris and especially metal scraps.

Keep the surfaces of your build plates clean.

If your Flexi Plate becomes scratched you can always refresh it with the 400 grit sandpaper and clean with isopropyl alcohol and fresh paper towel afterward.

**Use:**

- Simply ensure your **Magnetic Base** is clean and dry, affix the **Flexi Plate** into position.

- Ensure that when the **Build Plate** is fully lowered there is no interference between the sides of the vat and the small lift tab protruding from the **Flexi Plate**.  If there is you may need to reposition your vat to leave room.

- Print as usual, you may want to increase bottom layer exposure time if you feel parts need more adhesion.

- Once printed simply use the tab on the **Flexi Plate** to lift it and model off the machine. Pay attention not to pry the **Magnet** off the build plate when removing **Flexi Plate**.

- Now you can wash parts on the **Flexi Plate** or remove from **Flexi Plate** and wash parts separately, always cure parts off plate to avoid depositing cured resin on flexi plate.

- You will find that large rigid parts pop off as soon as you flex the **Flexi Plate**, but smaller individual supports may stick a bit well, in this case use a spatula to help them to release from the **Flexi Plate**.

- If there are any areas still stuck to the **Flexi Plate** you can scrape these carefully with a spatula, chisel, or razor blade, if needed retouch the surface with 400 grit sandpaper.

- Clean your **Flexi Plate** well with isopropyl alcohol and dry.

- Clean your Magnet with isopropyl alcohol and dry before replacing the Flexi Plate.

- Do not leave your Flexi Plate on the Magnet with resin between the two for periods longer than a few hours.

**Support and Help:**

If you experience shifting in flexi plate on base layers, is usually due to too tight of a level.  Relevel your machine, and do not push down too hard on the build plate.  After tightening build head screws the paper between the build plate and the screen should be able to move.

To increase with bed adhesion, try increasing base layer exposure or you can sand one side of the Flexi Plate with 400 grit sandpaper or even 320 for more grip, clean with IPA and paper towel well after sanding.

Should you have any issues please refer to our installation guide, video instructions, FAQ's, and additional support information on our website:    www.WhamBamSystems.com

**Installation QR link:**                                                                              **Support QR link:**





**Wham Bam thanks you man!!!**