WHAM BAM

flexible build system

Bambu Lab 258 x 258 vt

Thank you for purchasing a Pre-Installed Wham Bam PEX for the Bambu Lab X1, X1C, X1E, P1P and P1PS. You are going to love this system!

**Included:**

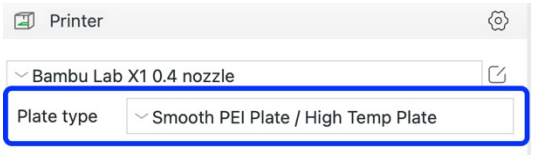
° **PEX Build Surface or mounted to a Flexi Plate**

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

° **5 ArUco Code Stickers for High Temp Plate**

Set of 5 stickers to add to your Flexi Plate for the X1 to recognize it as a High Temp Plate.

Make sure to tell slicer to use **Hi Temp Plate.**




**Mounting Instructions:**

1. **REMOVE** protective film from the top of the **PEX Build Surface**.

2. Prepare the **PEX Build Surface** sheet surface using 000 steel wool or a Scotchbrite 7447 pad and a bit of isopropyl alcohol (95% or higher). Scuff for 4-5 minutes until surface has an even, semi-matte finish. Clean the surface repetitively with fresh paper towel and alcohol. Do not use microfiber, wipes, or rags as these may propagate the contaminants back to the PEX.

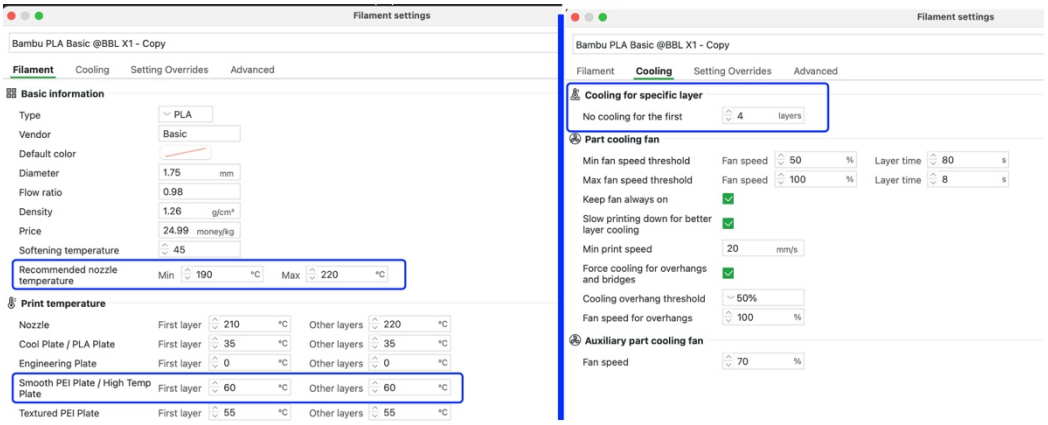
3. Apply one **ArUco Code Sticker** to the front left tab of the Flexi Plate inside of the etched box. Orientation is not important. Keep the other 4 on hand as replacements.

4. You are ready lay the **Flexi Plate** onto the magnetic 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 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.



WHAM BAM

flexible build system

Bambu Lab 258 x 258 vt

Turn off part fan for the first 4 layers to allow first layer to bond well.

**Suggested Temperatures and Settings for the Bambu:**

| **Filament** | **Bed Temp °C** | **First layer °C** | **Other layers** |
|---|---|---|---|
| PLA | 60-65 | 210 | 220 |
| * PETG | 50 | 245 | 255 |
| ABS/ASA | 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 too 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.
Test all new filaments, especially PETG on a small corner area, each are different, if you get bonding use some glue stick to create a barrier layer. For a comprehensive explanation see pdf (found on Wham Bam Systems Support Page): **https://whambamsystems.com/install**

**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 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, try washing with common strong dish detergent or vinegar and rinse with water, as these help break fats and contaminants in many filaments.

See this 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 additional support information on our website:

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!**