

Thank you for purchasing a XTR Pre-Installed Wham Bam ULTEM Powder Painted PEI Flexi Plate for the Bambu Lab X1 and P1P.

You are going to love this system!

Included:**1 Double Sided, Powder Painted Ultem Build Surface on a Flexi Plate**

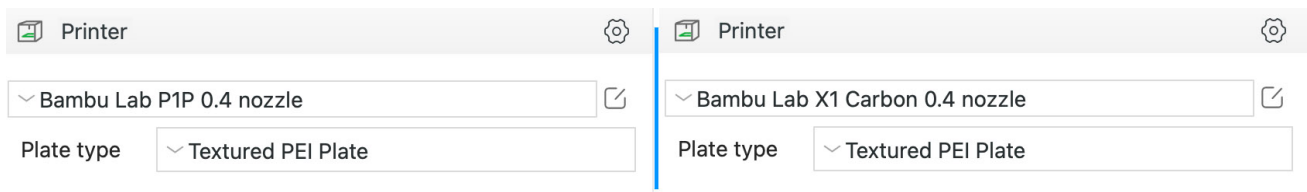
Authentic ULTEM PEI powder painted and kiln baked onto our robust, high quality 0.6 spring steel Flexi Plate.

It has the same treatment on both sides so you can use one for testing and the other for pristine results.

5 ArUco Code Stickers for Textured PEI Plate

Set of 5 stickers to add to your Flexi Plate for the X1 to recognize it as a Textured PEI Plate. (these are only needed for the X1 with Lidar).

Make sure to tell slicer to use **Textured PEI Plate**.

**Mounting Instructions:**

1. Prepare the **Powder Painted 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.
2. Apply one **ArUco Code Sticker** to the front left tab of the Flexi Plate inside of the etched box. Orientation is not important. You may put one on each side of the plate. Should your sticker ever get damaged, keep the other 4 on hand to replace as needed.
3. You are ready lay the **Flexi Plate** onto the magnetic bed and begin printing!

Use:

You may have to heat your bed higher than previous temperatures, do a bit of testing to find your best bed temps with the Powder Painted PEI Plates. Our **PEI Build Surface** is specially formulated to resist much higher temps than any PC build surface. It has great physical bond to the parts without them ever melting into the surface.

After printing you can lift the **Flexi Plate** by the handles and remove and set somewhere to cool.

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. Also never pry parts off, wait for the plate and the part to fully cool and flex off to remove.

Maintenance:

After every print we suggest wiping with isopropyl alcohol and fresh paper towel. 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.

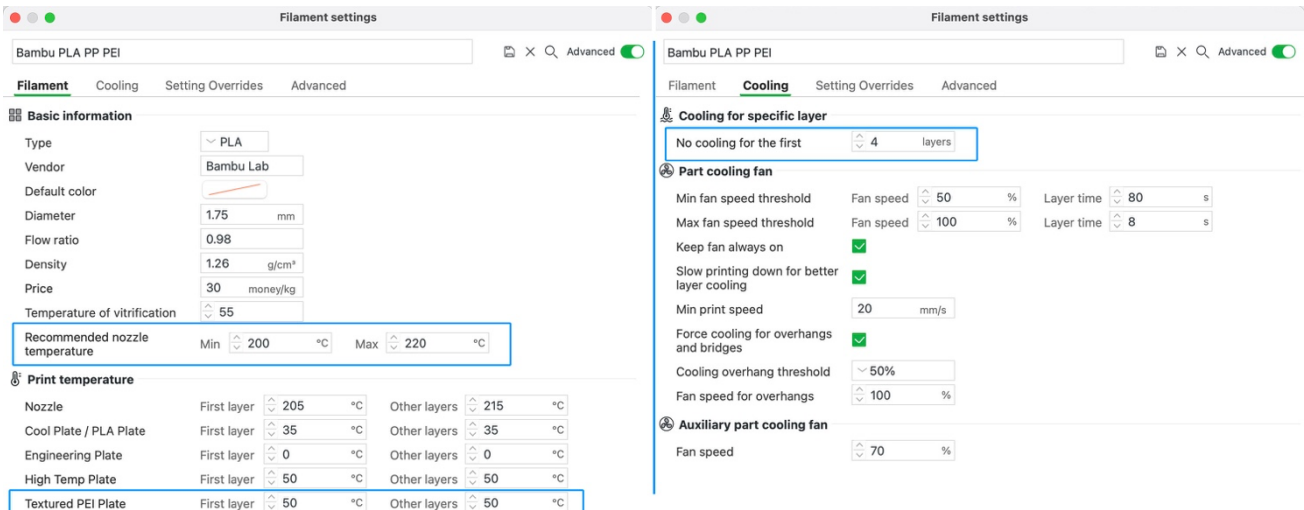
Should the PEI ever loose its grip, you may also try common dish detergent or vinegar and clean with water as these help break fats added to filaments with effects. You can also lightly pass over the plate with 600 grit wet dry sandpaper to revitalize, then clean with IPA and fresh paper towel.

Suggested Temperatures and Settings for 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, see examples of PLA settings below:

Filament	Bed Temp °C	Hot End °C
PLA	50	200-220
PLA Plus	50	205-230
PETG	60	240-260
ABS/ASA	110	230-260

*may need glue stick as barrier layer
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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!