Thank you for purchasing a Wham Bam Carbon Fiber Build Plate.
You are going to love this system!

For most updated instructions, information, videos, tips, please visit this QR code:
or https://www.whambamsystems.com/pages/fbs-kits-support-page

Preparation Instructions:

1. Before first use, Clean the Carbon Fiber surface well with isopropyl alcohol (95% or higher) and fresh paper towels. Try to avoid touching the surface with your fingers after cleaning. If you ever need deeper cleaning try some strong dish soap without any hand lotion, and rinse well with water and clean with paper towels.
   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 Carbon Fiber Build Plate onto your magnetic bed and begin printing!

Use:

Your hot end temperatures should be set within the range printed on the side spool of filament, and the first 3 layers should be toward lower temperatures range and keep below 270°C to avoid damaging the surface. You may increase hot end temperatures once the base layers have been printed.

You should set your bed temperature according to the chart below. Use the table as a base line guide, however, each filament and printer are different so you may need to adjust your settings.

Carbon Fiber takes a bit longer to fully heat. If you notice curling or bad adhesion, your printer may be sending the file to print before the Carbon Fiber has completely heated. To remedy this, try preheating for 5 minutes before sending the print, this is more common for PLA.

Do not drop bed temperature during print as this will release the print.
Make sure to turn off part fan for the first 4 layers in the slicer to allow first layers to bond well.

Suggested Temperatures and Settings:

Filament	Bed Temp °C	Hot End Temp 1st layers °C	Enclosure	Glue Stick
PLA	60	210	none	optional
PLA Plus / HS	60	220	none	optional
TPU	50	220	none	none
PETG	80	245	none	none
ABS	100	250	needed	needed
ASA	100	260	needed	needed
Nylon	90	250	needed	needed
PC	100	260	needed	needed
PP	90	230	needed	needed

Glue Stick and Enclosures:
You may need build surface adhesives such as; glue stick, Nano Polymer, Magigoo to help adhesion for certain filaments.
All of these wash off with warm water after use.

PLA is a bit less sticky to the Carbon Fiber and may need some glue stick for certain brands.

If you're using filaments prone to significant shrinkage, such as ABS, it's recommended to use an enclosure like the Wham Bam HotBox to maintain a controlled ambient temperature of around 45-50°C. This will help to prevent parts from curling up off the surface and or delaminating during print.

Bed Leveling:
For printers with touch or tap bed leveling systems, set the nozzle temperature to no more than 140°C during leveling to avoid damaging the surface.
While some systems tap lightly and work fine up to 170°C, others tap with more force and may leave marks at temperatures as low as 150°C.

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 cleaning well with isopropyl alcohol and fresh paper towel before reusing. This will prevent contaminants from the filaments from building up on the Carbon Fiber.

If you notice halos of filament or containment building up or notice less grip, you should wash with strong dish detergent and or vinegar and rinse with water, as these help break fats and contaminants in many filaments.

If you have stubborn build-up, you can also use some very very fine wet/dry sandpaper 600 or 1000 grit. Wet the surface of your Carbon Fiber Plate with water and use the sand paper very lightly in circular motions. Clean very well after sanding.

Bottom Surface of Prints:
We developed our authentic Carbon Fiber Build Surface for its incredible performance and durability. Please note, it does not leave a pronounced pattern effect like the imitation 'carbon fiber' sheets.

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!