Thank you for purchasing a Pre-Installed Wham Bam PEX 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. **Remove** the protective film from the top of the **PEX Build Surface**.

2. Prepare the **PEX Build Surface** sheet surface using included Composite Abrasive Pad, 000 steel wool or a Scotch-Brite 7447 pad. Use a bit of isopropyl alcohol (95% or higher) and scuff with pad for 4-5 minutes until the surface has an even, semi-matte finish and you do not see individual scratches. 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.

3. Lay the Pre-Installed Wham Bam PEX onto the 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 to avoid damaging the PEX.

You should set your bed temperature for 70° for PLA, TPU, PETG and many filaments, but you may need higher for ABS, Nylon, PP, etc, see the chart below.

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.

PLA requires the first layer to be squished to half the nozzle size or more and very flat topped, PETG and TPU need much less squish.

Printing in PETG , ASA and specialty filaments:
PETG is molecularly similar to PEX and PEI and likes to bond to the build surfaces. Some brands of ASA also may be stickier than others.
Some slicers set their default temperature settings high in order to achieve faster prints, you need to be careful with settings especially on PETG and ASA and lower these according to filament manufacturer recommendations – as written on the side of each spool.
For PETG we find that **245 hot end first layers** is ideal and up to **255 for other layers** gets max speed and reduces bonding.

Suggested Temperatures and Settings:

FILAMENT	BED TEMP °C	HOT END TEMP °C	ENCLOSURE	GLUE STICK	FIRST LAYER % NOZZLE SIZE
PLA	70	190-210	not needed	no	40-50
PLA PLUS	70	210-220	not needed	no	40-50
TPU	60	210-230	not needed	no	60-70
PETG *	70	240-250	not needed	optional as barrier layer	70
ABS / ASA	100-130	235-245	necessary	optional	50-60
NYLON	90-100	230-250	necessary	Yes	50

Test all new filaments, especially PETG or ASA on a small corner area, each are different, if you have bonding drop temperature settings or use some glue stick as a barrier layer. Elmer's Purple glue stick works well and washes off the build surface and parts with warm water.

For a comprehensive explanation see pdf (found on Wham Bam Systems Support Page):
https://www.whambamsystems.com/pages/fbs-kits-support-page

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 the Composite 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, wash with strong dish detergent and or vinegar and rinse with water, as these help break fats and contaminants in many filaments.

See this video 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 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!