



flexible build system

Bambu Lab X1 258 x 258 v1

Thank you for purchasing a Pre-Installed Wham Bam PEX for the Bambu Lab X1 and P1P.

You are going to love this system!

Included:

1 PEX Build Surface or mounted to a Flexi Plate

Sheet Build Surface mounted to a Spring Steel Flexi Build 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. (these stickers are only needed for the X1 with Lidar)

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 fine Scotchbrite pad and a 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.
3. Apply one **ArUco Code Sticker** to the front left tab of the Flexi Plate inside of the etched box. Orientation is not important. Should your sticker ever get damaged, keep the other 4 on hand to replace as needed.
4. 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 PEX. Our **PEX 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. Smaller parts may need a bit more bending or slight help with a spatula. Never dig into the surface if you can help it.

Maintenance:

After every print we suggest wiping with isopropyl alcohol and fresh paper towel, or even better, quickly scuff and clean with 000 Steel Wool and alcohol and paper towel before reusing. This will prevent contaminants from the filaments from building up.

Should the PEX ever loose its grip, use some Acetone and steel wool to remove any residue that may have permeated the PEX top layer. You may also try common dish detergent or vinegar and clean with water as these help break fats added to filaments with effects.

Suggested Temperatures and Settings for the Bambu Lab X1:

Filament	Bed Temp °C	Hot End °C
PLA	60-65	190-220
* PETG	50	240-250
ABS/ASA	110	230-250

* For PETG there is a molecular similarity with PEX and PEI, Bambu sets their default temp settings way too high in order to achieve faster prints, you need to be more careful with settings on PETG and lower these.

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

Test all PETG on a small 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>

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!