

WHAM BAM

flexible build system Resin Mounting and Use Instructions

Thank you for purchasing a Wham Bam Flexible Build System for Resin Printers!
You are going to love this system!

Included in the **Flexible Build System** for Resin Kit:

- 1 **WB Flexi Plate** - Spring steel build plate with dual sided laser treated surface for ideal grip.
- 1 **WB Magnetic Base** - High strength magnetic sheet backed with solvent resistant 3M adhesive.
- 1 **Piece 400 Grit Sandpaper** – wet/dry 400 grit sand paper to refurbish Flexi Plate as needed.
- 2 **Wham Bam Stickers**

Included in the **Double Wham** for Resin Kit:

- 2 **WB Flexi Plate** - Spring steel build plate with dual sided laser treated surface for ideal grip.
- 1 **WB Magnetic Base** - High strength magnetic sheet backed with solvent resistant 3M adhesive.
- 1 **Piece 400 Grit Sandpaper** – wet/dry 400 grit sand paper to refurbish Flexi Plate as needed.
- 2 **Wham Bam Stickers**

Installation QR link:



Mounting Instructions:

Before you install any parts, please do a practice run, by placing components in place without removing 3M backing to see if everything aligns correctly and that you understand the best order of assembly.

1. Clean your Build Plate thoroughly, this is the most important part. Scrub in an alcohol bath, wipe dry, perhaps even cure under sun or UV to ensure there is no resin residue, and clean one more time with alcohol and let dry thoroughly.
2. Once your bed is perfectly clean, it's time to apply your **WB Magnetic Base**. First test fit to make sure it is a good match to your plate, it is easy to cut with a cutter knife if needed.
Then peel back a 1" / 20mm strip of the paper backing from the adhesive being very careful not to attract dust or dirt to the glued surface. Keep the whole **WB Magnetic Base** elevated above the Build Plate and only touch the far back side to line it up with the Build Plate, then while keeping the side near you elevated begin to push down in the center rear while slowly working the **WB Magnetic Base** down against the Build Plate. Pull the backing paper as you wipe from center outward. Continue working from back toward front and pushing from center and spreading outward till the whole sheet is down. Burnish down with a bit of pressure, you can put a sheet of paper on top and rub it hard.
It is best practice to allow the 3M bond to cure for 72 hours for maximum adhesion, but 24 hours gets you about 90% of ultimate adhesion.
3. Now position the **WB Flexi Plate** on top of the **WB Magnetic Base**.
4. You may need to adjust your Z stop. As you are adding about 2.6 mms to the bottom of your build plate, you may need to physically move your Z stop Sensor to accept this extra distance. Some Build plates have enough play to absorb this, each machine is different.
5. You may need to re-level your Build Plate if you forced your build plate in any way during installation.

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Maintenance:

Make sure your **WB Magnetic Base** stays free of debris and especially metal scraps.

Keep the surfaces of your build plates clean.

If your Flexi Plate becomes scratched you can always refresh it with the 400 grit sandpaper and clean with isopropyl alcohol afterward.

Use:

- Simply ensure your **Magnetic Base** is clean and dry, affix the **Flexi Plate** into position.
- Ensure that when the **Build Plate** is fully lowered there is no interference between the sides of the vat and the small lift tab protruding from the **Flexi Plate**. If there is you may need to reposition your vat to leave room.
- Print as usual, you may want to decrease bottom layer exposure time if you feel parts stick too well.
- Once printed simply use the tab on the **Flexi Plate** to lift it and model off of the machine. Pay attention not to pry the **Magnet** off of the build plate when removing **Flexi Plate**.
- Now you can wash and cure parts on the **Flexi Plate** or remove from **Flexi Plate** and cure parts separately.
- You will find that large rigid parts pop off as soon as you flex the **Flexi Plate**, but smaller individual supports may stick a bit well, in this case use a spatula to help them to release from the **Flexi Plate**.
- If you have 2 **Flexi Plates** you can send the second immediately to print while cleaning the first.
- If there are any areas still stuck to the **Flexi Plate** you can scrape these carefully with a spatula, chisel, or razor blade, if needed retouch the surface with 400 grit sandpaper.
- Clean your **Flexi Plate** well with isopropyl alcohol and dry.

Support and Help:

Should you have any issues please refer to our installation guide, video instructions, FAQ's, and additional support information on our website:

www.WhamBamSystems.com

Support QR link:



Wham Bam thanks you man!!!