Cold Print Plate Instructions

Cautions

- Do not use sprays or glue sticks on this plate
- Do not use alcohol or solutions containing acids or alkalis to clean the plate. (such as soap, laundry powder, laundry detergent, dishwashing liquid, etc.) Do not use hot water to clean the surface.
- Do not use sharp objects such as scrapers to treat the surface.
- It is not recommended to set the nozzle too low when leveling to avoid scratching the surface
- The coating of the plate is a consumable. After long-term use, the performance of the coating will decrease. If the adhesion decreases, it is recommended to wipe it with a soft cloth and clean water.
- It is normal to have white marks on the plate after printing. It does not affect the printing quality.
- Remove the print after it is cooled down to lower than 30℃.

Printer setting recommendations

1. First layer leveling: After replacing the build plate, nozzle, hot end, etc., the heat bed needs to be re-leveled.
2. First layer height: It is recommended to set the first layer of the print slice to 0.2mm
3. First layer speed: 10~50mm/s is recommended. For PLA filament, turn off the cooling fan for the first layer. For ABS and PETG filament, turn off the cooling fan for the first 3 layers.
4. First layer temperature: For PLA, PETG, ABS, it can be tested at room temperature of 30-40 ℃ at first. If not working well, please increase the temperature appropriately or follow the recommended parameters of the filament.
5. Not recommended for use above 90°

Heat bed temperature reference

- ✧ TPU: no heating or 30-50℃
- ✧ PLA: 30-40 or 45-60℃
- ✧ PETG: 35-40 or 50-68℃
- ✧ ABS: 55-70 or 80-100° (using above 90° may affect the service life)

Recommendation for open 3D printers

1. Adjust the fill mode angle (please note the slice fill direction: do not select a 90° fill angle for the print)

2. When the ambient temperature of the open printer is too low, please pay attention to the insulation measures when printing, or increase the temperature of the heat bed (the open printer has no temperature protection. Pay attention to the impact of ambient temperature changes on the printing material, which will cause increased stress during printing and lead to printing failure. For example: the size of a cube print printed at an ambient temperature of about 30 degrees is 20mm, and the size printed at an ambient temperature of 15 degrees may be 19-19.8mm)

3. If warping is found after taking off the print while there is no warping before it, please print at an ambient temperature suitable for this material (this situation mostly occurs on materials with large shrinkage rates that require a certain temperature protection, such as PETG. When the ambient temperature is extremely low, it can also occur on some PLA brands with higher shrinkage rates. It depends on the brand of consumables used.)

4. The temperature setting of PETG printing on open machines is 50-68 degrees with a brim of about 3mm. Most prints can be printed stably on open machines. The default distance can be set to 0.1mm (except for individual round or irregular small polygonal bottom shapes. Prints with warehouse temperature can even print most prints without brim)

5. If the PETG print is warping, please adjust the printing environment temperature appropriately. For open printers, a heat preservation cover can be used to greatly improve the situation (for example, when a plastic bag is put on, when the temperature of the build plate has not dropped at the end of printing, you can observe the state of the brim and corners to determine whether the edge is warping during printing. Or, after the print is cooled down after printing, the viscosity of the base plate is reduced. After the print is separated from the build plate, the low shrinkage area after heating is pulled up by the high shrinkage part of the print body, causing a deformation)