

# INSTRUCTION SHEET

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**COROPad™**

MAGNETIC FLEX SYSTEM

## Instruction:

- 1) Prepare the work platform for gluing COROPad™ Magnetic Base. Remove all dirt and degrease surfaces. The surface should be smooth and dry - wait until the degreasing agent is completely evaporated.
- 2) Remove the protective adhesive film from the COROPad™ Magnetic Base and glue the magnetic base to the printer's working platform. It is recommended to use a pressure roller to tighten the base and eliminate the possibility of air bubbles.
- 3) The COROPad™ Flex Plate should be placed directly on the COROPad™ Magnetic Base and calibrate the distance between the nozzle and pad. Recommended distance: 0.1-0.2mm.
- 4) After correct calibration, you can start the 3D printing process. If you are using materials that require a heated bed, wait until the platform temperature drops below 35°C after finishing printing and then remove the COROPad™ Flex Plate.

## Useful information:

- 1) Use isopropyl alcohol, silicone cleaners or other solvents to degrease the table surface.
- 2) If the printer's construction allows it, dismantle the work platform for the duration of COROPad™ Magnetic Base application.
- 3) It is recommended to use COROPad™ Magnetic Base directly on glass tables due to their tolerance of straightness and flatness. COROPad™ Magnetic Base can also be glued to other types of surfaces, however, it should be remembered that often used aluminum tables under the influence of temperature (in the case of using heated platforms) significantly deform so that the distance between the pad and the nozzle can vary significantly depending on position of the trolley in the X and Y axes.
- 4) COROPad™ surfaces can be mechanically cleaned using a steel spatula and isopropyl alcohol. Do not use solvents as they may damage the COROPad™ surface. The spatula should have rounded corners to avoid cutting the COROPad™ surface.
- 5) If the COROPad™ surface is damaged, it can be replaced by itself. In order to easily remove COROPad™ together with the adhesive layer from the flexible plate, it is recommended to heat COROPad™ Flex Plate to a temperature of approx. 35-40 °C (you can use a heated printer table or a dryer for example). Small adhesive residue on the surface of the elastic sheet can be removed with isopropyl alcohol or silicone remover.

## Recommended temperatures:

- 1) PLA - **No heating or up to 40°C**
- 2) PET - **45-60°C**
- 3) FLEXY - **60-100°C**
- 4) HIPS - **70-90°C**
- 5) ABS, ASA - **70-100°C**

The selection of appropriate temperatures is great importance for the lifetime of the COROPad™. Due to the wide range of available materials and their variations, design solutions for printer tables - their thermal conductivity and the quality of the measuring sensors themselves, these values are a reference point for the selection of appropriate parameters for a given material and 3D printer. Too high working bed temperature in relation to the material used may prevent separation of the model from the COROPad™ or lead to its damage during the separation of the model from COROPad™ Fles Plate.