

Tips for successful printing with FlowTech™ Hotend

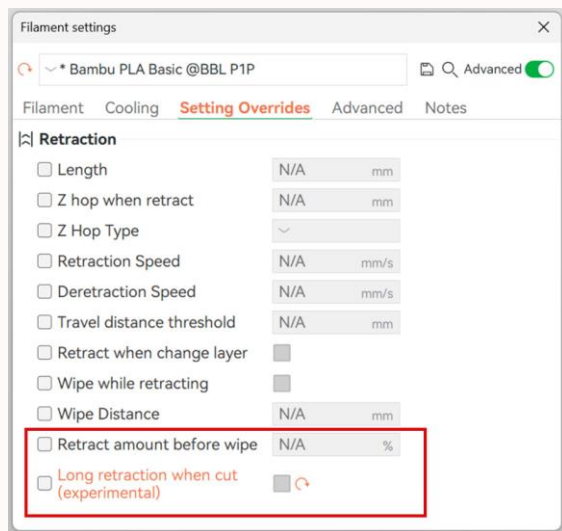
PLA Printing Guidelines:

- ✓ Always keep the door open and the top cover propped up when printing with filaments that have a low glass transition temperature, like PLA, to minimize clog risks.
- ✓ The heated bed temperature should not exceed 55°C.
- ✓ Use either the **Bambu Lab Cool Plate SuperTack** or a compatible aftermarket alternative.
- ✓ Keep the room temperature between 20C and 25C.

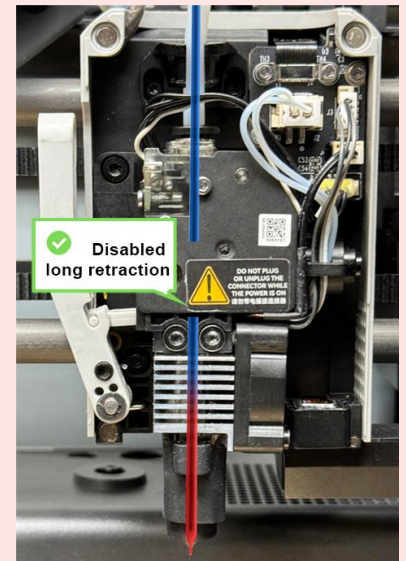
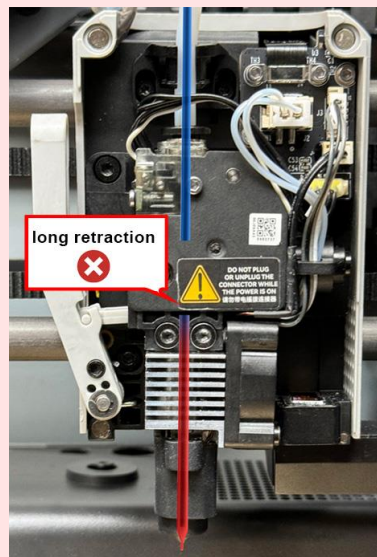
Slicer Settings:

✗ Avoid using long retraction when cut

The 'Disable Long Retraction' setting can be found under **Filament Settings → Settings Overrides**

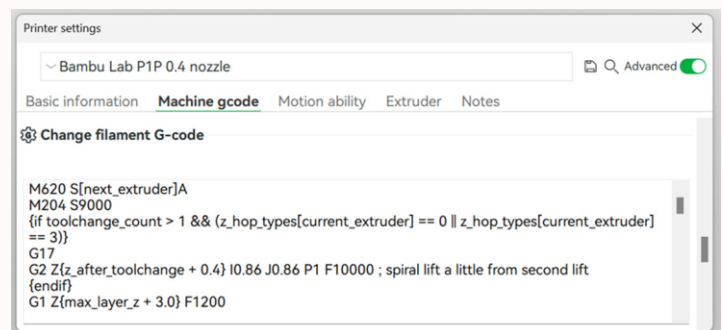


A long retraction can pull softened filament into the cutter, causing it to deform instead of being cleanly cut. This can lead to the filament getting stuck and potentially causing an AMS failure.



✓ Change Filament G-Code:

Some older versions of Bambu Studio and Orca Slicer have a long retraction coded into the Change Filament G-code. This retraction will occur even if the setting is disabled under Filament Settings. We recommend updating to the latest version of the slicer and starting with the default system presets under Printer Settings for your specific printer model.



The Change Filament G-code can be found in the **Machine Gcode** tab of the Printer settings window.

Nozzle Tips:

- ✓ **Printing with 0.2mm nozzle:** Due to the reduced flow rate of small nozzles, proper enclosure ventilation is essential. Keep the front door open and the top cover removed, especially when printing with PLA.
- ✓ **Nozzle Change:** Use the provided torque limit knob when changing the nozzle, as it is preset to a 4 in-lb torque limit. This is crucial to avoid deforming the hotend mounts.