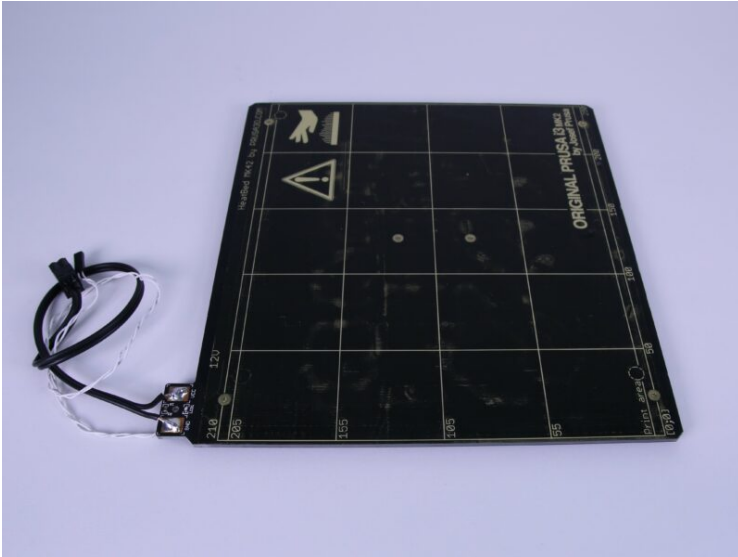


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Replacing the PEI sheet on the MK2/S

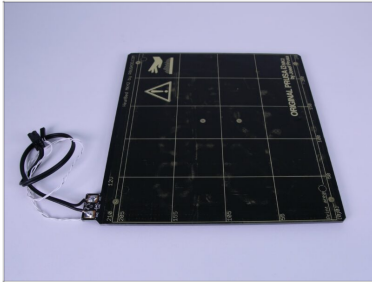


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STEP 1 Freezer preparation



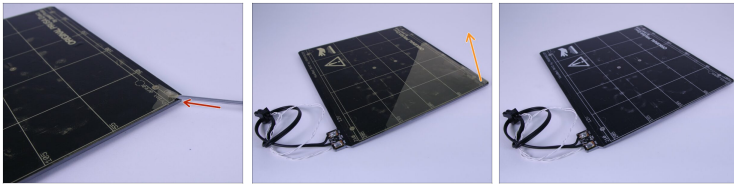
- Prepare some room in your freezer for dismantled heatbed.

STEP 2 Freezing

Timer	
	27
	28
	29
0 hours	30 min
1	31
2	32
3	33
When Timer Ends	Stop Playing >

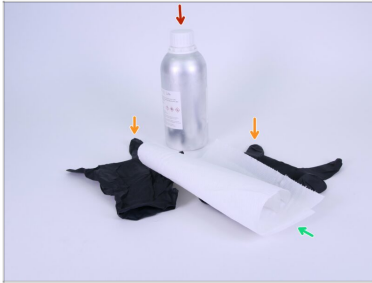
- Leave the heatbed inside the freezer for at least 30 minutes.

STEP 3 PEI sheet detach



- ◆ Use something sharp to lift one corner of the PEI sheet from the heatbed.
- ◆ Grab the lifted corner with your hand and completely remove the PEI sheet. Frozen glue will remain on the bed.
- ⚠ Be careful not to scratch the bed itself!

STEP 4 Safety FIRST!



- Limonene (Limonene, D-limonene or something similar)

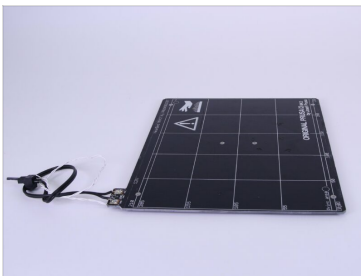
⚠ Keep in mind that Limonene can be extremely toxic for your pets, keep them out!

- Nitrile gloves

- Paper towels

ⓘ Limonene can often be found in woodworking or hardware stores.

STEP 5 Placing paper towels



- Place the paper towels on the heated bed as shown in the picture. The whole glue surface has to be covered.

STEP 6 Glue dissolve preparation



- Spill Limonene on the paper towels until they are totally saturated with it
- Place the whole thing in a plastic bag to prevent Limonene evaporation

STEP 7 Glue dissolving

Timer	
	37
	38
	39
0 hours	40 min
1	41
2	42
3	43
	44
When Timer Ends	Stop Playing >

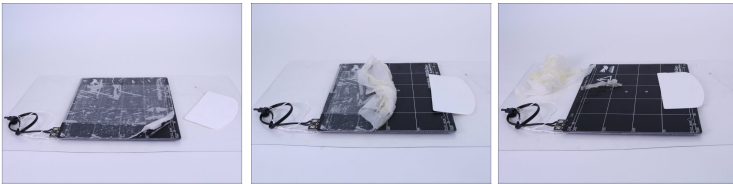
- Let the Limonene do it's magic for at-least 40 minutes.

STEP 8 Preparing for taking out the glue



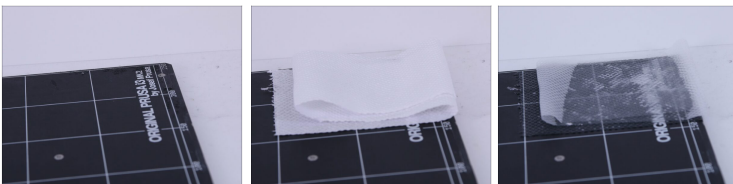
- ◆ Remove the bed from the plastic bag and place it on something disposable (old newspaper).

STEP 9 Scraping the glue



- ◆ Get a plastic scraper and start peeling the glue from one corner.
- ◆ Paper towel partially soaked in the glue provides an easy way to manipulate the glue.

STEP 10 Finishing up



- ◆ Process can be repeated for the remaining glue.

STEP 11 Water cleaning



- ◆ Clean the heatbed using water and paper towel.

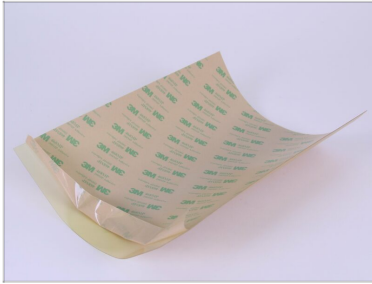
STEP 12 IPA cleaning



- ◆ Clean the heatbed using IPA (or something similar that can clear out grease marks) and paper towel.

⚠ After doing this, make sure that no dust and fibres from paper remain on the heatbed surface!

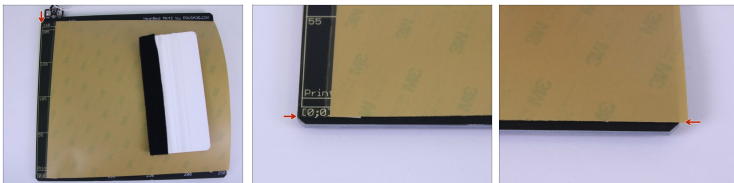
STEP 13 PEI sheet preparation



- ◆ Peel out about 2 cm (1 inch) of glue protector from the SHORTER side of PEI sheet as shown in the picture

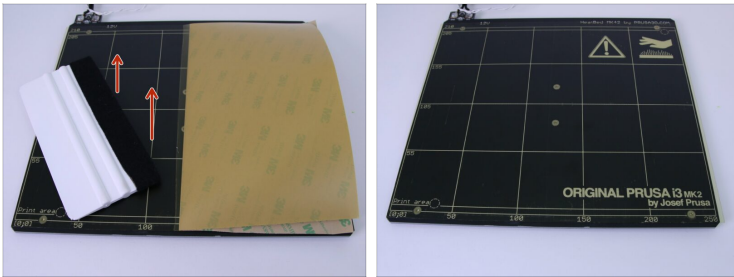
⚠ DO NOT try to peel out the sheet when it's glued, even in small area, it'll ruin the glue at that place!

STEP 14 PEI sheet bonding



- ◆ Bond the PEI sheet on the edge of the heatbed shown in the picture.
- ⚠ Make sure that the PEI sheet is placed as shown in the pictures (bottom edge of the sheet has to end at bevel of the heatbed and left side has to be aligned with edge of heatbed) or covering whole printing area at least.
- ◆ Rub the rest of the exposed glue with scraper covered in soft fabric as shown in the picture.

STEP 15 Finishing bonding



- Peel about one cm of glue protector and rub it with the scraper. Repeat several times, do not try to peel and glue large areas at once, it'll will highly complicate the process!

STEP 16 Cutting the edges



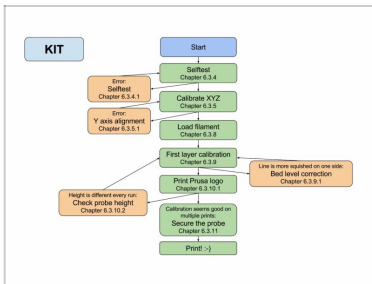
- Cut the extra PEI using sharp knife or razor blade

STEP 17 ALL DONE!



- ◆ Sparkling new print surface, just mount the heatbed back on the the printer and you can print!

STEP 18 Recalibrate



- ◆ As the geometry of the printer might have slightly changed, you need to recalibrate the printer.
- ◆ Please follow the chapter **6.3.1 Calibration flow** and use the KIT version.
