Ultrabase 平台不粘材料怎么解决？

1、 首先确保调平完美，并用酒精清洁平台。

2、 降低首层打印速度，建议设置为 10-15mm/s。

Speed	
Travel speed (mm/s)	60
Bottom layer speed (mm/s)	**15**
Infill speed (mm/s)	0.0
Top/bottom speed (mm/s)	0.0
Outer shell speed (mm/s)	0.0
Inner shell speed (mm/s)	0.0

3、 PLA 材料热床温度设置为 65 ，ABS 材料建议热床温度 95。

PLA

Speed and Temperature	
Print speed (mm/s)	45
Printing temperature (C)	205
Bed temperature (C)	**65**

ABS

Speed and Temperature	
Print speed (mm/s)	45
Printing temperature (C)	240
Bed temperature (C)	**95**

4、 增加附着类型：Brim 或 raft。

Support	
Support type	None
Platform adhesion type	**Brim**

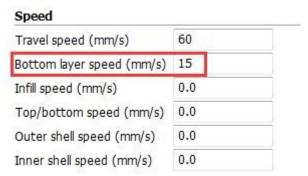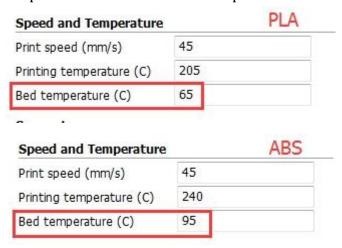| Support	
Support type	None
Platform adhesion type	**Raft**

Problem description : the filament doesn't stick on the ultrabase properly , and sometimes run out of a ball.

The following are some suggestions for solution :

1. Make sure platform leveling is perfect ,   and clean the ultrabase with alcohol if possible

2. Set a lower bottom print speed to improve adhesion , recommanded speed is around 10-15mm/s

Speed	
Travel speed (mm/s)	60
Bottom layer speed (mm/s)	15
Infill speed (mm/s)	0.0
Top/bottom speed (mm/s)	0.0
Outer shell speed (mm/s)	0.0
Inner shell speed (mm/s)	0.0

3: recommanded print temp of heatend and heatbed temp

Speed and Temperature	PLA
Print speed (mm/s)	45
Printing temperature (C)	205
Bed temperature (C)	65

Speed and Temperature	ABS
Print speed (mm/s)	45
Printing temperature (C)	240
Bed temperature (C)	95

4: Add the adhesion type :

Support	
Support type	None
Platform adhesion type	Brim

5: Manually remove the filament that overflows before printing from the nozzle to ensure it would not damage the print if possible