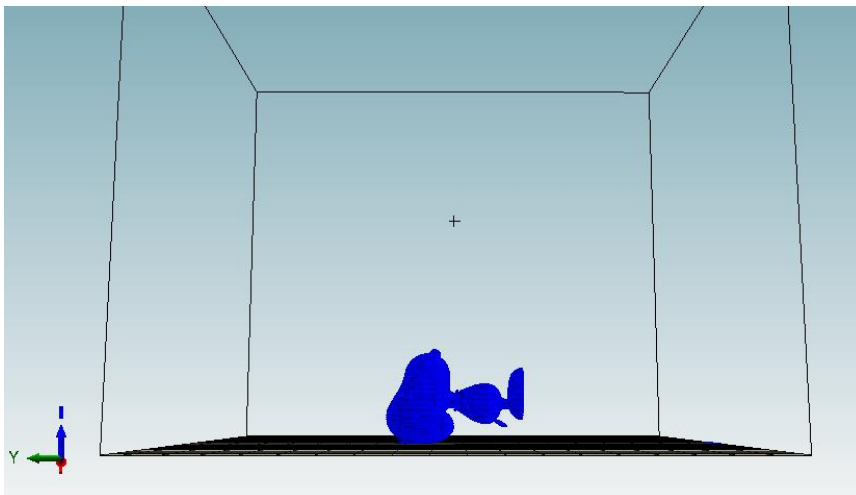


Not stick well for the base of printing

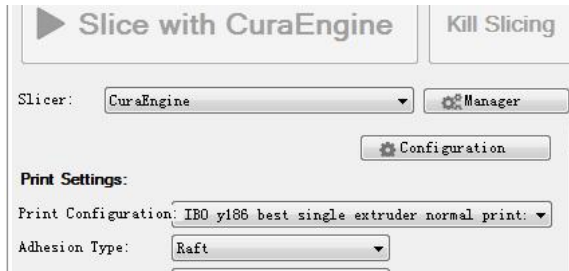
3D printing is similar to building a house. The base of the print is very very important. If the base of the print is not stick very well, there are some causes usually as below:

1. **Not enough glue applied.** Please apply more glue on the place where the print warped or not stuck.
2. **Two nozzles are not clean.** Please kindly keep the nozzle be clean. If they are dirty with filament, they will drag the filament during printing and the printing will be failed.
3. **The nozzles are a little far away from the bed during printing or the bed not leveled.** You should loose three wing nuts under the bed to let the bed rise a little or totally level the bed again. **Let a paper be very hard to pull away from the nozzles and build plate when Z axis is home** especially in the center area of the build plate (When you level the bed, please close the extruder heating and clean up the nozzles so that the distance between nozzles and bed will be accurate, equal to an A4 paper thickness).
4. **Put the object in slicing software in wrong direction.** One of our customer said that he printed our test gcode files successfully, but the object he sliced by himself will always not stick to the bed. He printed snoopy in a lying direction, please check the photo below:



In this case, there are just snoopy's ear contacted with the bed, and a lot of overhangs without support. It will be definitely failed to print. We should let the snoopy stand up and **feet contact the bed as a strong base for the print**, also we have to generate the support for its head and tail. **Yes, it is something like building a house. Meanwhile, we have to know not every object can be 3d printed.**

5. **The bed is not hot enough.** Usually for PLA, bed can be heated up to 30-50 degree with our glue. For ABS, bed can be heated up to 70-90 degree with our glue.
6. **Choose the wrong adhesion type or no adhesion type during slicing for some big size object with big size solid bottom such as bottle or printing ABS.** Plastic will shrink after cooling, so it will warp and cause the base of the printer have bad adhesion to the bed especially for big size solid bottom object. we should choose raft as adhesion type too add adhesion.

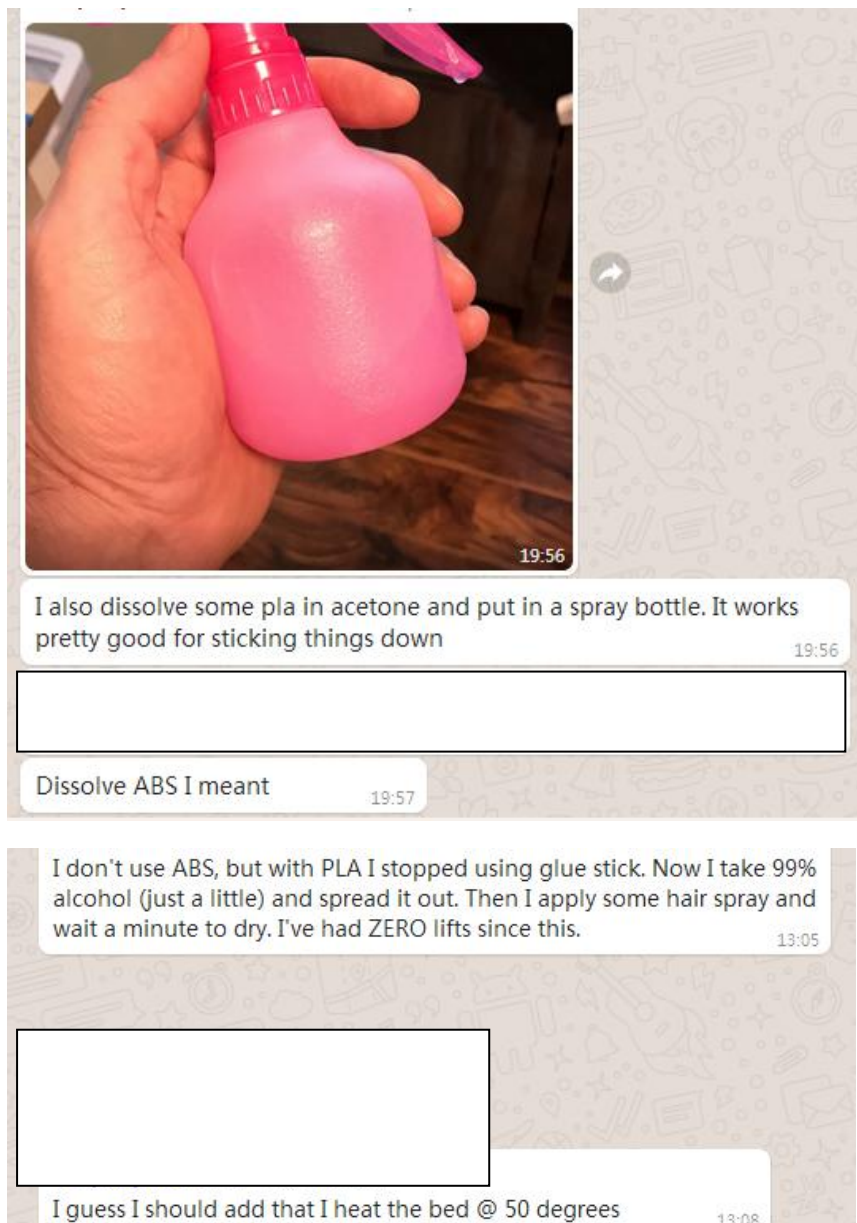


7. **Choose the wrong material for adhesion base.** For example, One of our customer use polymaker support material to print adhesion raft base. Polymaker support material can be easily removed as support material, so it is also can be easily removed as the printing adhesion base. The base is not strong and can be removed easily, and the printing will be failed too.
8. **If the problem still not solved, you can preheat the other extruder which is not for printing and load the filament first then finally unload the filament before your printing.** In this case, the other nozzle not for printing will be always hot, even it hits the print, it will not ruin the print.
9. **You can use cyanoacrylate super glue and painters tape to stick the print.** This tip is from our customer:





Here are some advices from our customers:



10. Other causes can be checked on this link:
<http://support.3dverkstan.se/article/23-a-visual-ultimaker-troubleshooting-guide#nostick>