3D printers

Bambu Lab H2D with AMS 2 Pro



The four printers



Printers, PC and CNC router

Process	FDM: melted filament laid down layer by layer, with two nozzles
Build volume	325 × 320 × 325 mm with one nozzle, 300 × 320 × 325 mm with both
Filament	1.75 mm. Up to four spools in the AMS 2 Pro on top
Temperatures	Nozzle up to 350 °C, bed up to 120 °C, chamber up to 65 °C
Build plate	Textured PEI on a flexible steel sheet
Software	Bambu Studio, Bambu Lab's free slicer

1. Prepare the file

1. Export your part from CAD as STEP, 3MF or STL.
2. Open it in Bambu Studio. Choose the H2D and the 0.4 mm nozzle.
3. Choose the filament that is actually loaded in the printer you will use.
4. Put the largest flat face on the plate. Add supports only where an overhang needs them.
5. Slice, then read the time and filament estimate before you send anything.

2. Check the printer

1. Look inside. The plate must be empty, clean and sitting flat against its stops.
2. Check the spool in the AMS: right material, right colour, enough left for your print.
3. To load a spool, open the AMS lid, drop the spool in and push the end of the filament into the feeder until it is pulled in. Close the lid.
4. Close the door and the top.

3. Print

1. Send the job from Bambu Studio and match each colour to its AMS slot, or start the file from the touchscreen.
2. Stay for the first few layers. If the plastic is not sticking, or drags behind the nozzle, stop the print.
3. After that you can leave it. Check progress on the touchscreen.

4. Take the part off

1. Wait until the screen shows the bed has cooled.
2. Open the door, lift the plate out and flex it. The part pops off.
3. Put the plate back against its stops and close the door.
4. Remove supports with cutters, away from your body. Bin the supports and the purged filament.

Which material

Material	Good for	Note
PLA	Prototypes, fixtures, most parts	Easiest to print. Softens around 60 °C
PETG	Tougher parts, some heat and moisture	A little stringier than PLA
TPU	Flexible parts: gaskets, feet, grips	Prints slowly
ABS, ASA	Heat-resistant parts	More fumes. Ask Nitai first

If it goes wrong

Problem	Try
First layer won’t stick	Clean the plate. Check that the plate type in the slicer matches the plate in the printer
Corners lift	Add a brim. For large flat parts, ask about a warmer chamber
Strings and blobs	The filament may be damp. Ask for a dry spool
AMS or filament error	Follow the message on the screen. If it repeats, stop and ask Nitai