



Gluing Magnets on to Build Plate

This guide will explain the correct method of gluing magnets onto a build plate so that it rests securely on the spring bolts.

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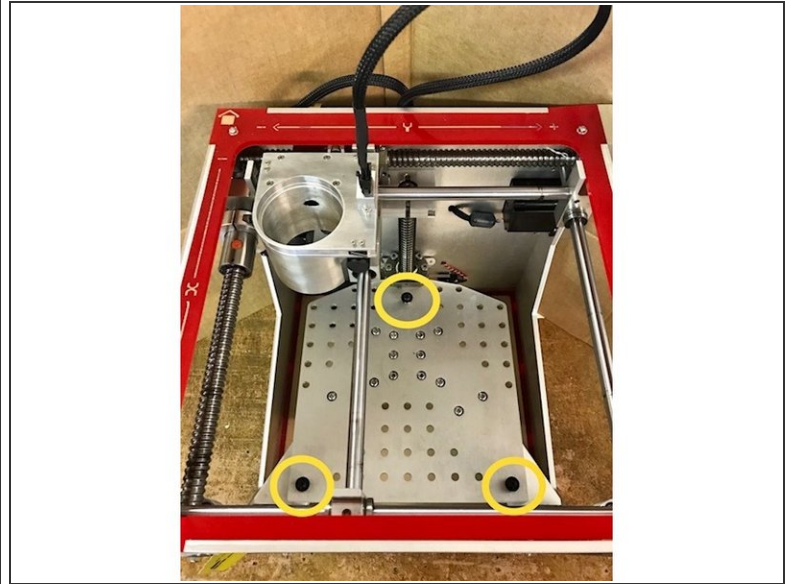




PARTS:

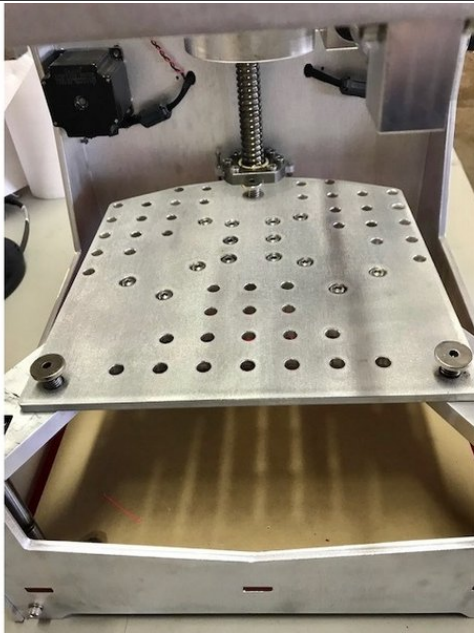
- all purpose cleaner or degreaser (1)
 - glue (1)
 - lubricant (1)
 - build plate magnet (3)
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Step 1 — Grease the spring bolts



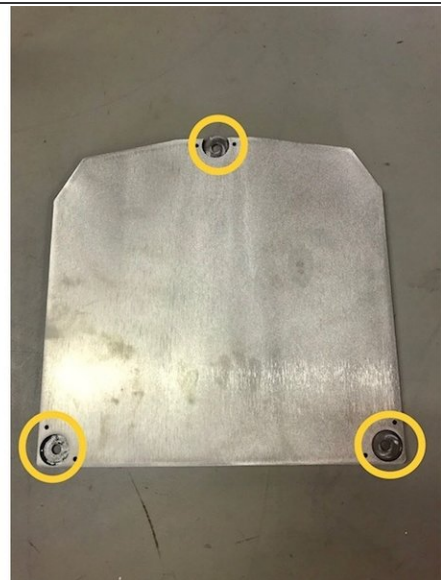
- ☑ We recommend that you level BoXZY's print bed before gluing the magnets. Large differences in the height of the spring bolts can change where the magnet is going to rest. Its very important for 3D printing and laser etching that the magnets are securely over the spring bolts and the print bed is level.
 - This can be accomplished by following steps 1-4 of the [3D Printing with BoXZY](#) guide. Just for the leveling process you will need to temporarily place a magnet over each spring bolt and rest the unglued print bed on top.
 - Now to start the process of gluing the magnets, you first apply grease or lubricant to the head of each spring bolt. There are 3 of these that are found in each corner of the Z axis platform. This will prevent excess glue from sticking to the bolts.

Step 2 — Place magnets on spring bolts



- Place one magnet squarely on each spring bolt.
- Magnets should be oriented on the spring bolts such that the concave side is resting on the head of the bolt and the flat side is facing up.

Step 3 — Clean magnets and build plate



- It is important to remove excess grease and/ or dirt from the magnets before applying the glue.
- Use a degreasing solution or all purpose cleaner to clean the the top and sides of the magnets as well as the recessed corners on the underside of the build plate.

Step 4 — Apply glue to build plate



- We recommend using a cyanoacrylate type glue, such as the one linked to at the top of this guide.
- Apply a moderate amount of glue onto the circular recessed corners of the build plate.
 - Do not completely fill the pocket with glue.
 - If you apply the glue in a circular shape that is centered in the pocket, then there should be a thin amount of visible aluminum on either side of the glue.

Step 5 — Carefully place glued build plate on top of the magnets

- Be sure that each magnet is resting perfectly in the glued pockets of the build plate. And that the magnets remain centered on the spring bolts.
- Apply medium pressure downward on the build plate to allow the glue to spread evenly over the magnet.
- A good guide to determine if enough glue was used is to look down at the top of the build plate. A small portion of the magnets will be visible through holes in the corners. The glue should have spread over the visible area of the magnet. If no glue is visible from above you will want to carefully remove the build plate and add more glue.

Step 6 — Allow glue time to fully cure



- Do not remove the build plate from the spring bolts for at least 2 hours while the glue cures and dries completely.
 - Its always a safe bet to leave it alone for even longer. Consider allowing the glue to set over night.
- After waiting several hours it will be safe to remove your build plate and wipe off any grease/ lubricant on the spring bolts.
- You're done! Now you are ready to 3D print and laser etch using your magnetic build plate!