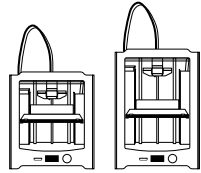


Repair manual



Replacing the build plate clamps



Instructions

The build plate clamps hold the glass plate in place on the heated bed. There are two fixed in place at the back of the heated bed and two at the front that can both be opened. When the glass plate is installed, it is pushed into the clamps at the back.

After removing and reinstalling the glass plate many times, the back build plate clamps may lose their grip on the glass plate. If that happens, the glass plate can move during printing, leading to print issues such as shifted layers.

If excessive force is applied to the clamps, they could break off. This can happen if the print is removed from the glass without taking the plate out of the printer first.

If the clamps are damaged, it is recommended to replace them to retain optimal print quality. The following steps describe how to correctly replace the back build plate clamps.

Caution: Make sure the build plate is cold, the Ultimaker is turned off and the power supply is disconnected before you start the replacement.

Equipment/supplies needed

Tools

- Pliers or socket wrench

Parts

- 1 or 2x 1256 - Build plate clamp (back)

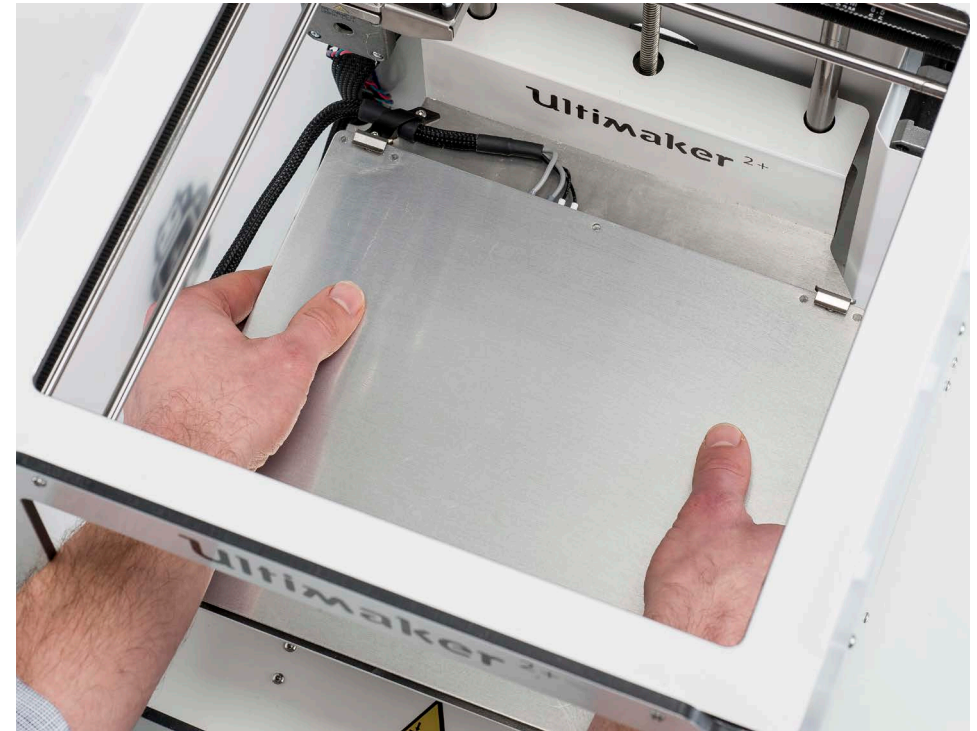
Time

- 15 minutes

Disassembly

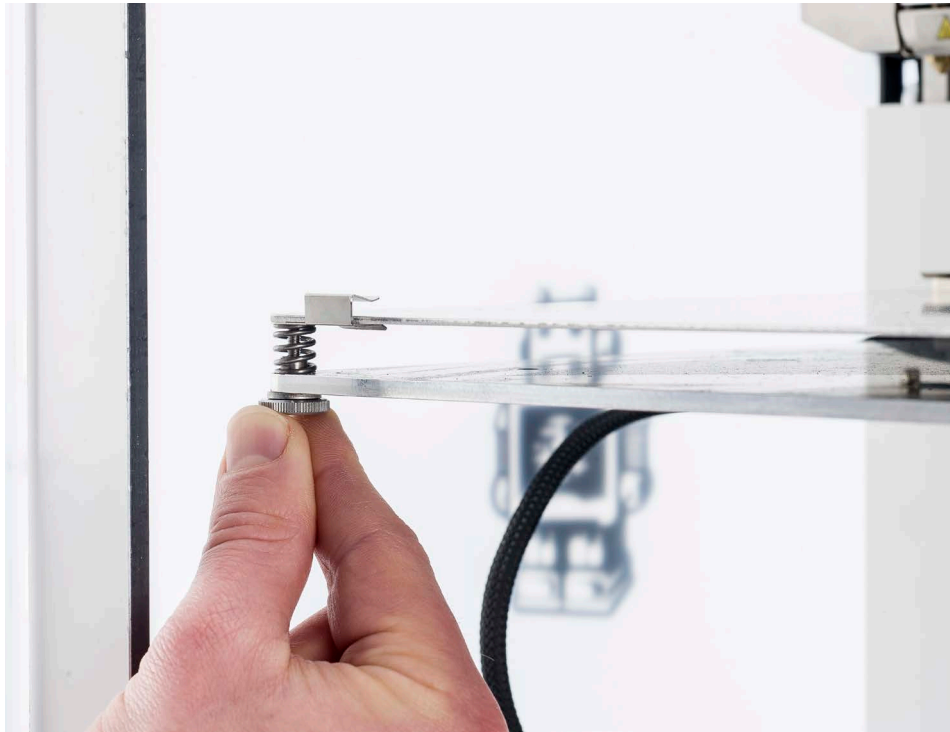


- 1. Remove the glass plate**
 - Open the front two build plate clamps.
 - Gently slide the glass plate out of the printer.



- 2. Move the Z stage up**
 - Place the print head in the front-right corner.
 - Manually move the build plate halfway up.

Disassembly



3. Remove the knurled nuts

- Loosen and remove the three knurled nuts from the base plate.

Tip: Make sure to also remove the washers from the base plate; due to the copper grease, they may remain stuck to the plate. Put them around the knurled nuts with the greased side facing up.

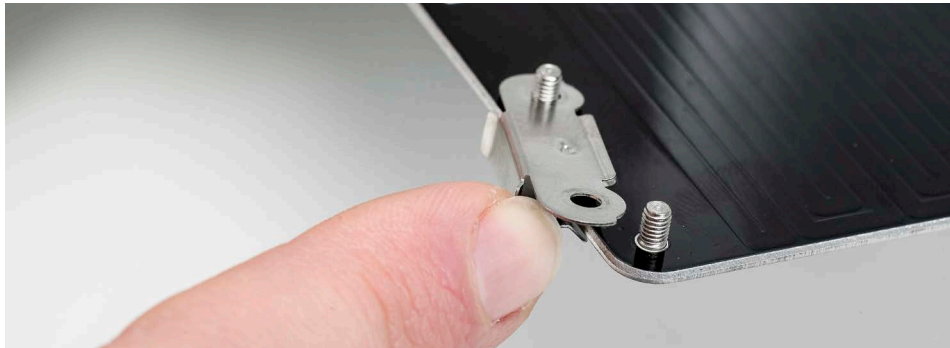


4. Remove the springs

- Lift up the heated bed.
- Remove the build plate springs from all three bolts.
- Remove the build plate clamps from the front two bolts.

Tip: Now move the build plate down again. This will create more room and makes performing the following steps easier.

Disassembly

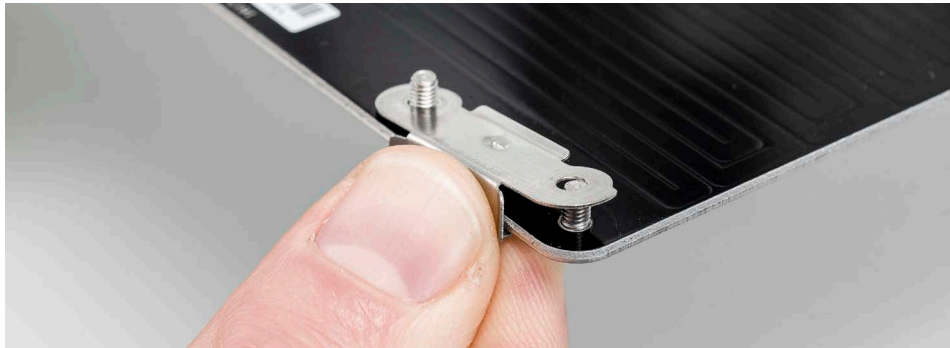


5. Remove the build plate clamps from the back of the heated bed

- Flip the heated bed over so the black side is facing towards you.
- Use pliers or a socket wrench to remove the two lock nuts from each of the build plate clamps at the back of the bed.
- Remove the clamps from the integrated bolts.

Tip: The bolts are integrated in the heated bed and the build plate clamp only just fits over them. Because of this, it can be difficult to remove. Press the build plate clamp against the top side of the heated bed. From the bottom side, first lift up the side of the clamp on the outside of the bed to be able to move it over the bolt. Now rotate the clamp approximately 45° and remove it from the other bolt.

Reassembly



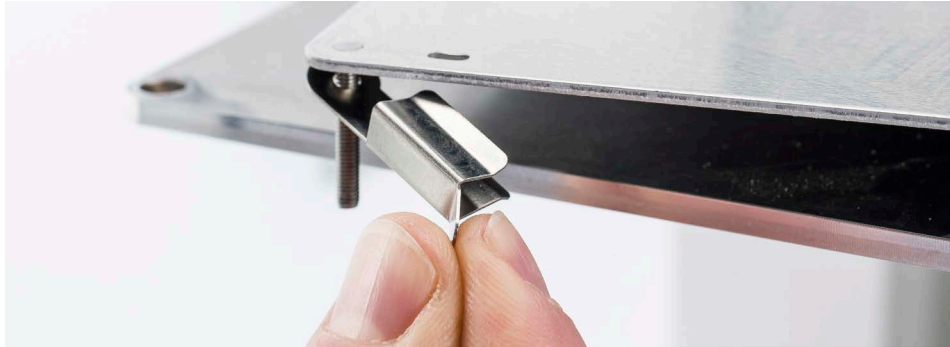
1. Attach the new build plate clamps

- First place the hole of the new build plate clamp around the bolt on the inside of the bed.
- Rotate the build plate clamp and slightly lift it up to place the other hole around the outermost bolt.
- Repeat this for the other side.
- Using pliers or a socket wrench, secure the clamps to the bed with two lock nuts each.

2. Secure the back of the bed

- Flip the heated bed around again and align the bolt in the back with the hole in the base plate.
- Place a spring around the bolt in the back.
- Place a knurled nut through the opening in the back of the base plate and turn it counter clockwise to secure the heated bed.

Reassembly



3. Prepare the front two bolts

- Put the front-left build plate clamp around the front-left bolt, then a spring.
- Put the front-right build plate clamp around the front-right bolt, then a spring.

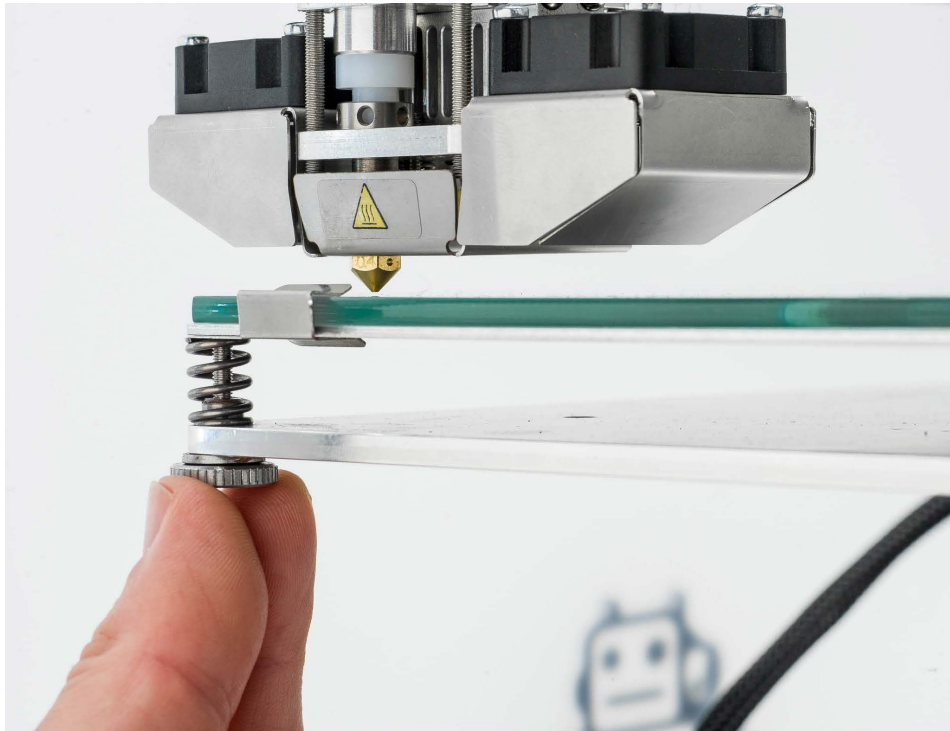


4. Secure the front of the bed

- Align the front two bolts with the holes in the base plate.
- Place a knurled nut through the openings in the base plate.
- Gently push the bed down and turn the knurled nuts counter clockwise to secure the heated bed.

Tip: *The bed is more stable if there is more tension on the springs. Tighten all three knurled nuts until the distance between the top of the base plate and the underside of the heated bed is approximately 10 mm.*

Reassembly



5. Level the build plate

- Slide the glass plate on the heated bed.
- Close the front two build plate clamps to secure it in place.
- Turn the printer on and go to "Maintenance > Build plate". Follow the leveling procedure to ensure that the build plate is correctly leveled.