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Module 6

Using Multiple Filaments with the Bambu Lab P1S



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The purpose of this module is to introduce you to a feature in Bambu Studio to print using multiple filaments.

The AMS (Automatic Material System)

The AMS allows the P1S printer to print up to 4 different colours

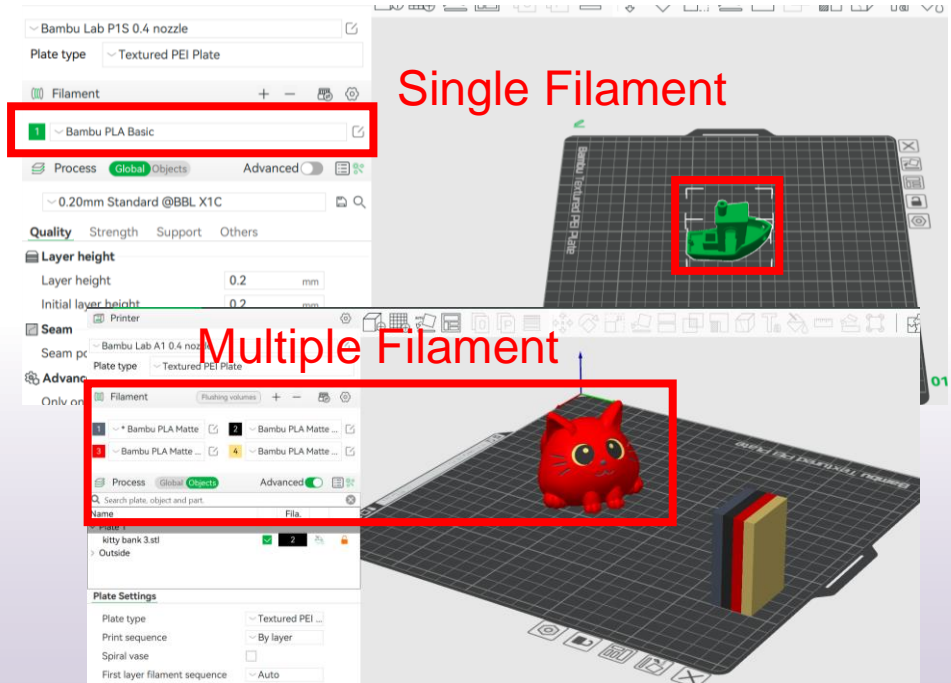
However, depending on how many colours you use and how often the printer needs to switch it can greatly increase the print time so make sure it doesn't exceed your appointment time (3 hours max)



Choosing Colours in Bambu Studio

Some prints are already divided into different segments that you can assign a separate colour to

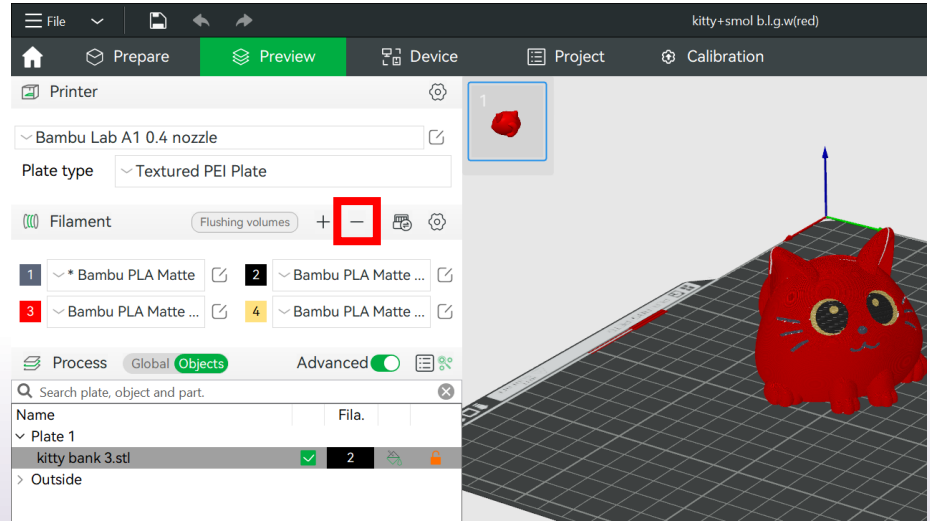
When you open or import your file, check to see if the model is already divided into different colours



Removing Colours

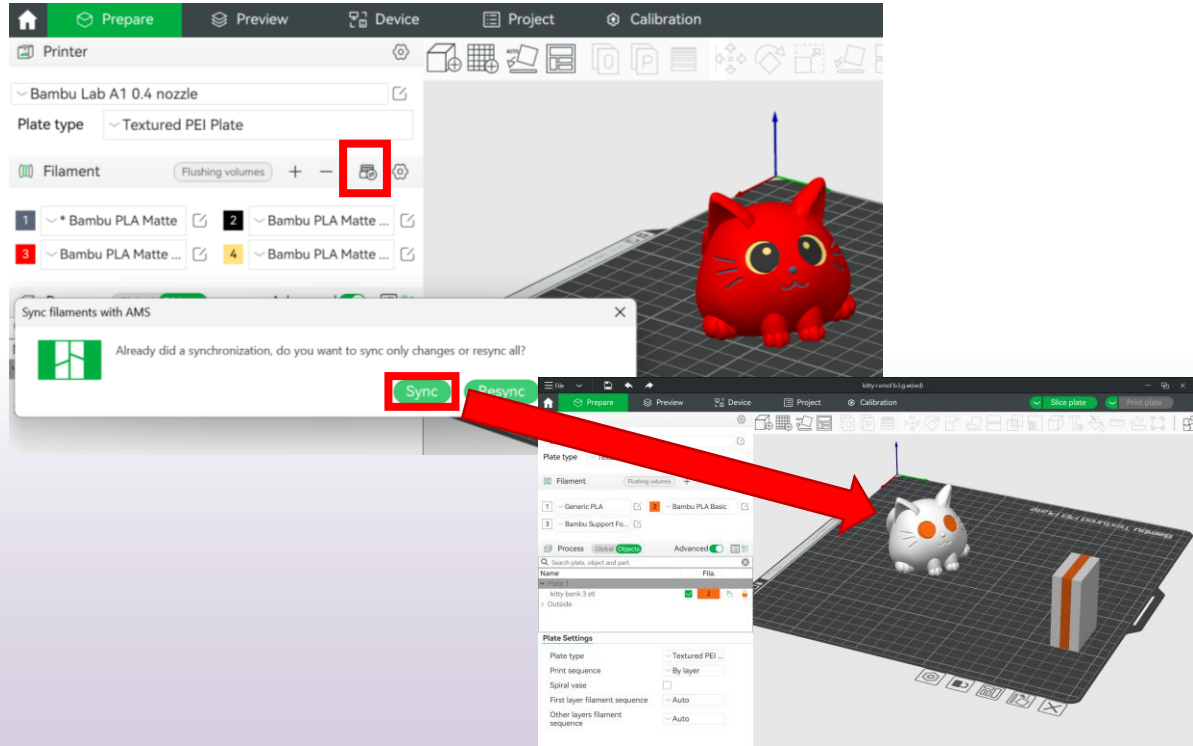
If a file has extra filament colours you don't need or you want the print to be a single colour, you can remove them by clicking the “-” button

Another option is to change each filament to use the same filament roll



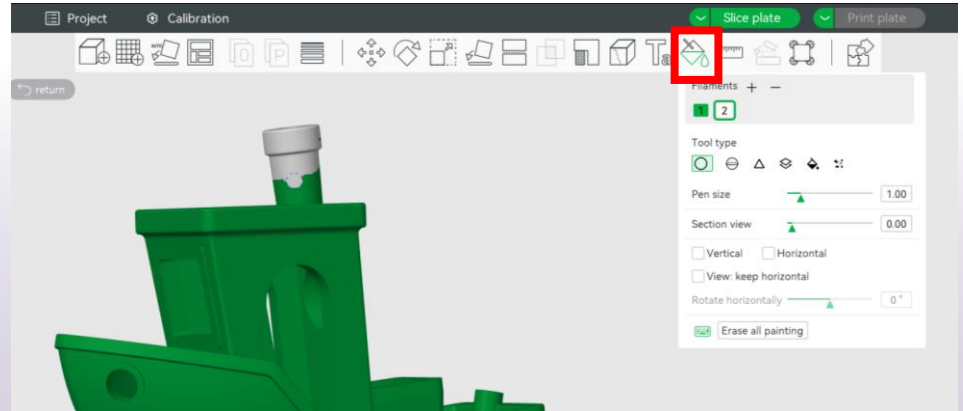
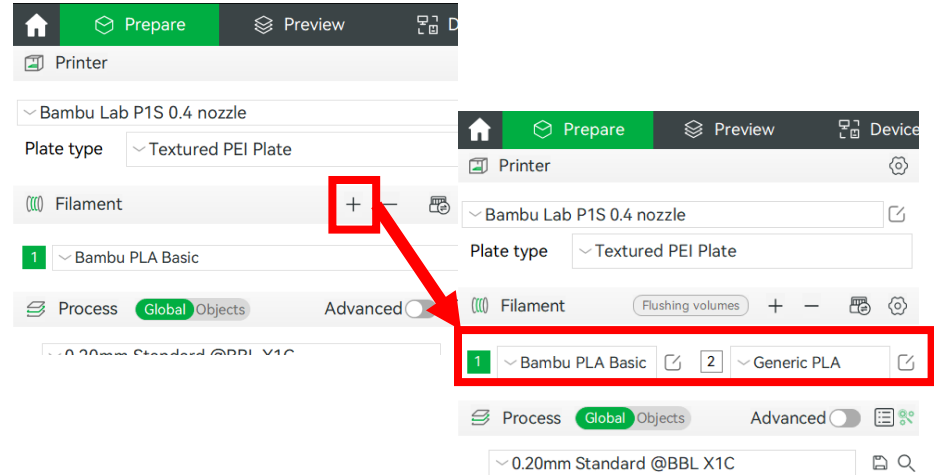
Changing Colours in Bambu Studio

If the print is already divided into different colours you can update the colours to match the ones loaded into the printer by clicking the Synchronize button or manually change each filaments to a loaded colour



Adding Colours

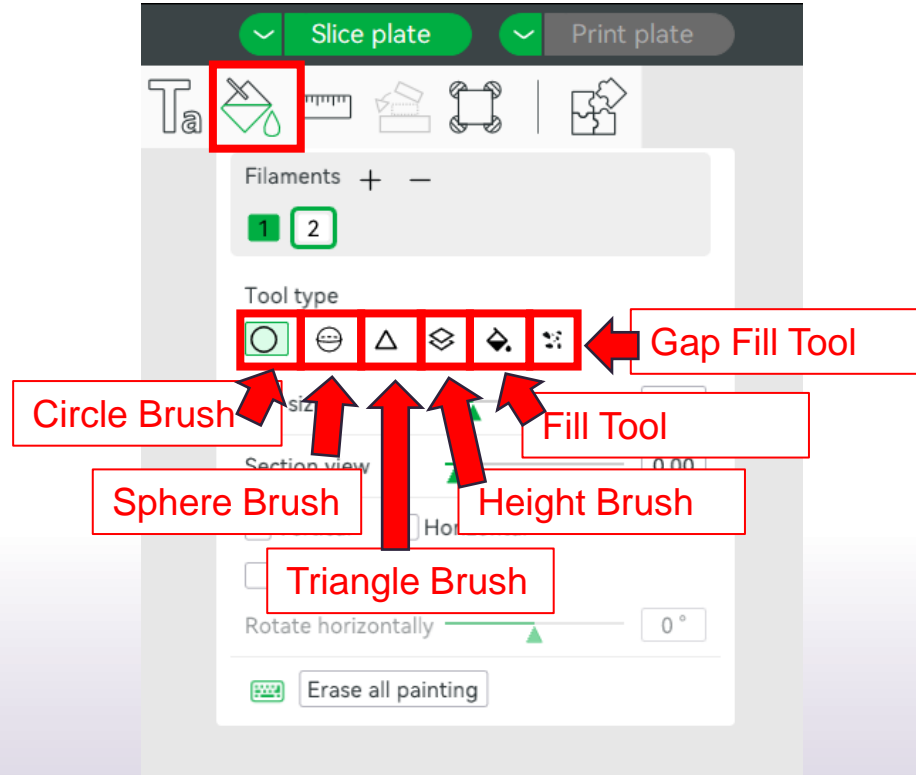
To add multiple colours you can use the Colour Painting Tool. First, click the “+” to add another filament. Then click the paint bucket in the toolbar.



Adding Colours

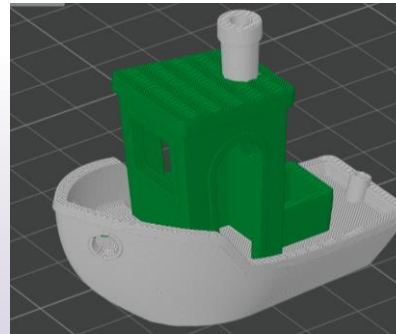
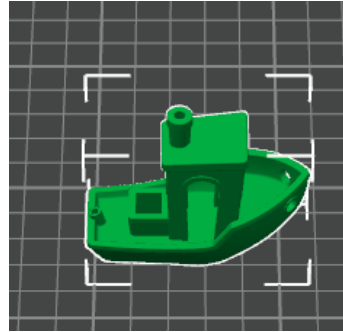
Select the colour filament you want to use, adjust the pen size and then manually paint on the model where you want that colour to be.

You can choose different tool types to change how you colour the model. **Staff will not colour the model for you.**



Time

Please keep in mind that the time will be increased when you add colours to print. Please keep your appointment time and the 3 hour limit in mind if you choose to do this.

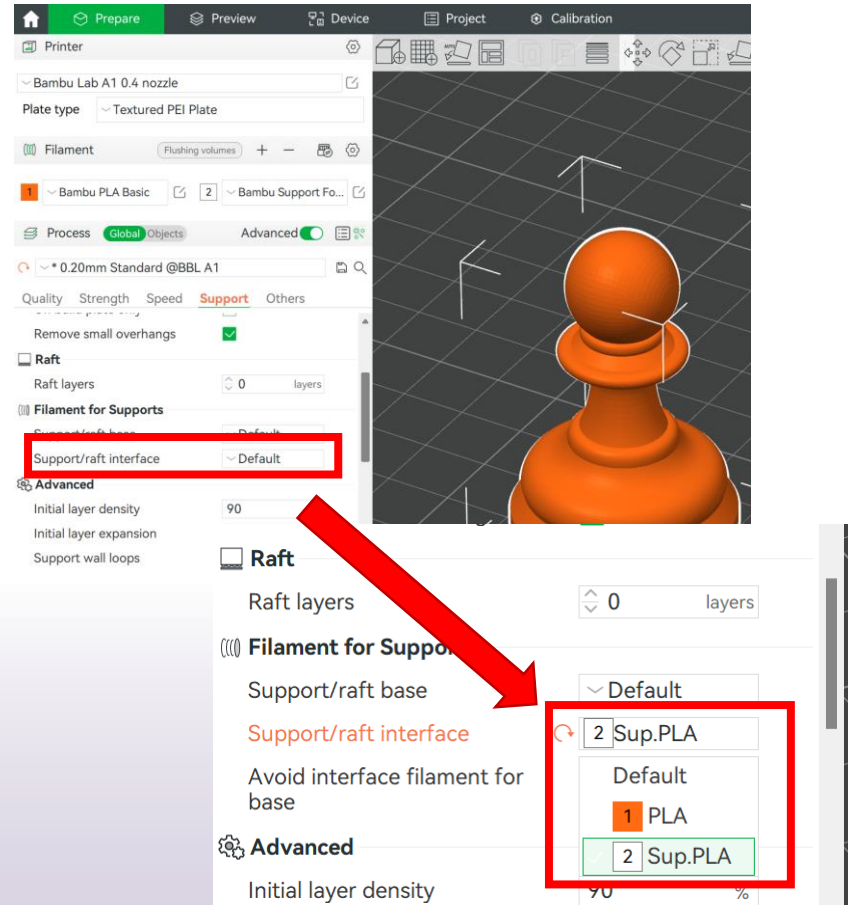


Category	Value 1	Value 2	Value 3	Value 4
Custom	0m15s	10.2%	0.03 m	0.10 g
Travel	5m22s	14.5%		
Retract				
Unretract				
Wipe				
Seams				
Total Estimation				
Total Filament:	3.88 m	11.76 g		
Model Filament:	3.88 m	11.76 g		
Cost:	0.29			
Prepare time:	5m46s			
Model printing time:	31m21s			
Total time:	37m7s			
<hr/>				
	6.79 g	76 g	6.01 g	56.56 g
Total	3.90 m	54 m	4.17 m	30.71 m
	11.71 g	90 g	12.54 g	92.15 g
Filament change time:	1:31			
Cost:	2.02			
Time Estimation				
Prepare time:	5m46s			
Model printing time:	5h25m			
Total time:	5h31m			

Support PLA

Some filaments are designed specifically for supports because they're easier to break off

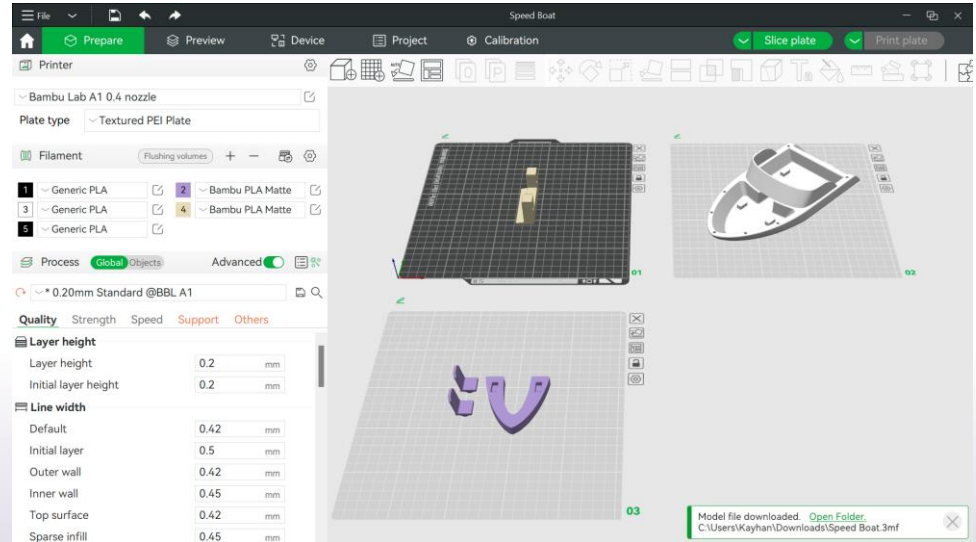
If you have that filament loaded you can turn on advanced settings and set the support filament to be used for the interfacing layers



Multiple Plates

Some prints are in parts that are divided into plates

These ones are printed plate by plate, you select the plate you want to print before slicing and sending the print and once it's done you can prepare and send the next one





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End of Module 6

Both manually adding colours and printing with multiple colours can take a long time, please take that into consideration when making your appointment.

Consider colouring the model using Bambu Studio on your own computer and export the finished 3mf file to bring in to make the most of your time.