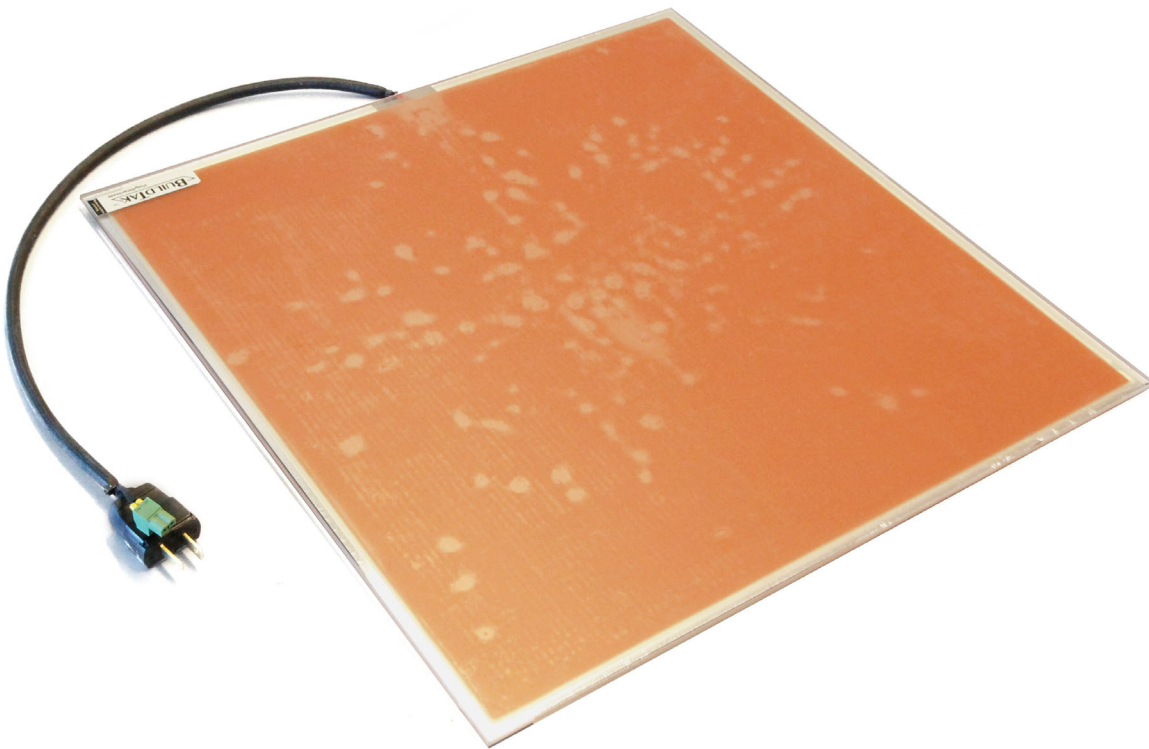


# gMax 2

# Heated Bed Setup

v190730



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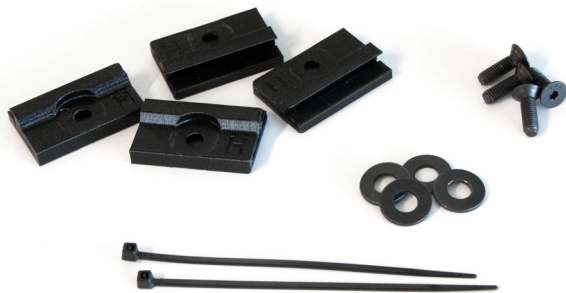
*This guide should be used for the initial unboxing and setup of your gMax2 heated bed*

**Make sure to inspect the print bed for loose wires or shipping damage.  
Retain the original packaging for future use.**

# Whats Included

*The gMax heated bed is designed to be controlled by an external IoT relay controlled by the gMax printer. It is heated by a single zone silicone heated pad.*

Max Bed Temperature (Do not set above)	100C (212F)
Controller	IoT Relay controlled by gMax Printer
Print Surface	Original BuildTak or PEI
Power Consumption	600 Watts (110V only)



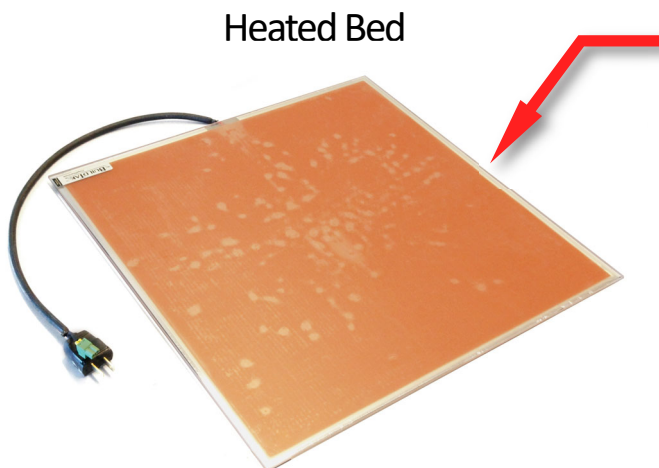
- (4) 3D Printed Clips for Heated Bed
- (4) M5 x 20mm Flat Head Bolts
- (4) 1/4" Washers
- (2) Zip Ties



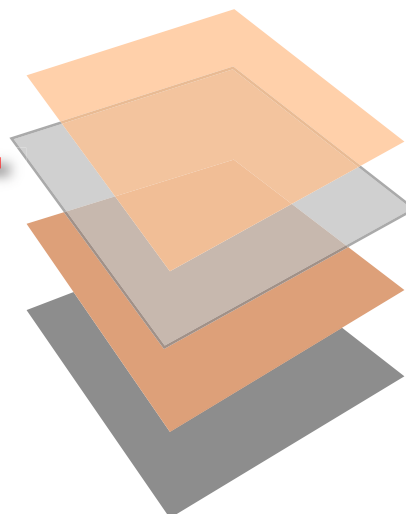
Power Cord



IoT External Relay



Heated Bed



BuildTak Original or PEI Sheet

Borosilicate Glass

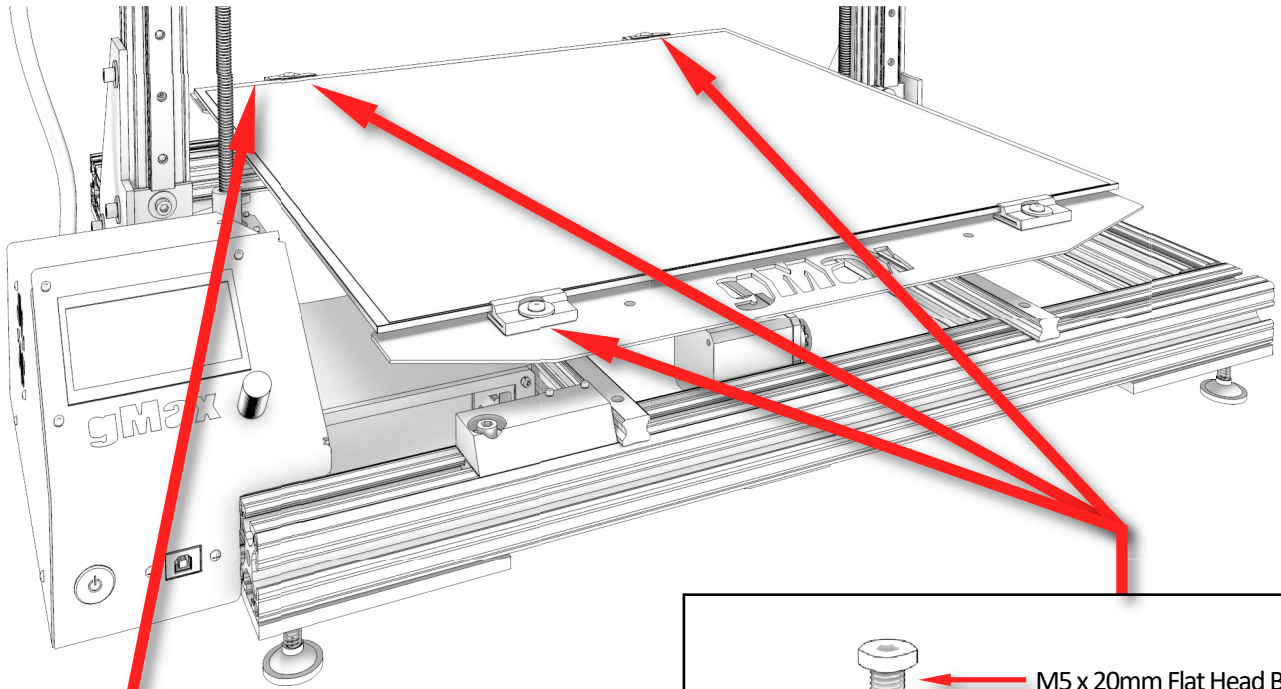
Silicon Heated Pad

Aluminized Fiberglass

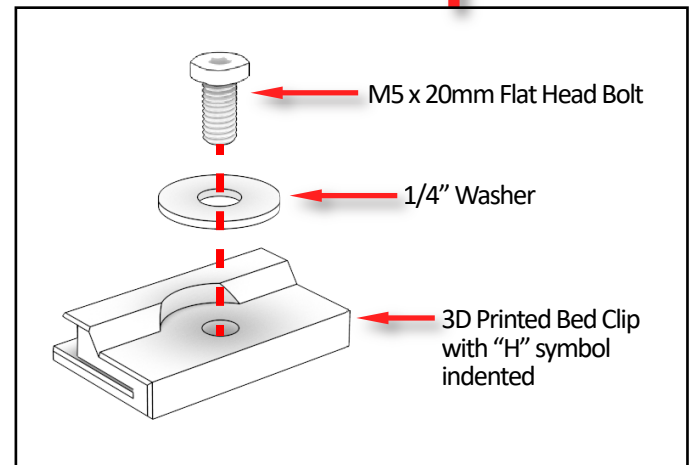
Fabric Insulation

# Install Heated Bed

1. Remove acrylic bed and bed clips if installed using a 3mm hex wrench.

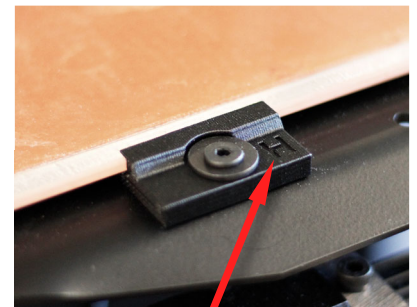


Zip tie heated bed cord on rear



2. Use the supplied hardware to install heated bed and bed clips on the bed carriage with a 3mm hex wrench.

- (4) 3D Printed Bed Clips with "H" on them
- (4) M5 x 20mm Flat Head Bolts
- (4) 1/4" Washers



## Note

Make sure 3d printed bed clips have "H" on them. They are different than the acrylic bed clips



# Plug in Relay

Follow the guide below to plug in the heated bed relay. Make sure the printer is off and make sure the relay is OFF before plugging everything in then turn on the relay.

1. Turn OFF relay

7. Turn on relay AFTER everything is plugged in.  
Set to "RESET" to turn on.

2. Insert Power Wire from  
Wall Outlet Plug  
into side of relay

 **Note**

Double check wires  
and plugs before  
turning printer on

3. Insert Heated Bed  
Plug into "normally OFF"

6. Insert gMax printer  
Plug into "always ON"

5. Relay Signal Wire  
(Red and Yellow Wire)  
Plug into side of relay

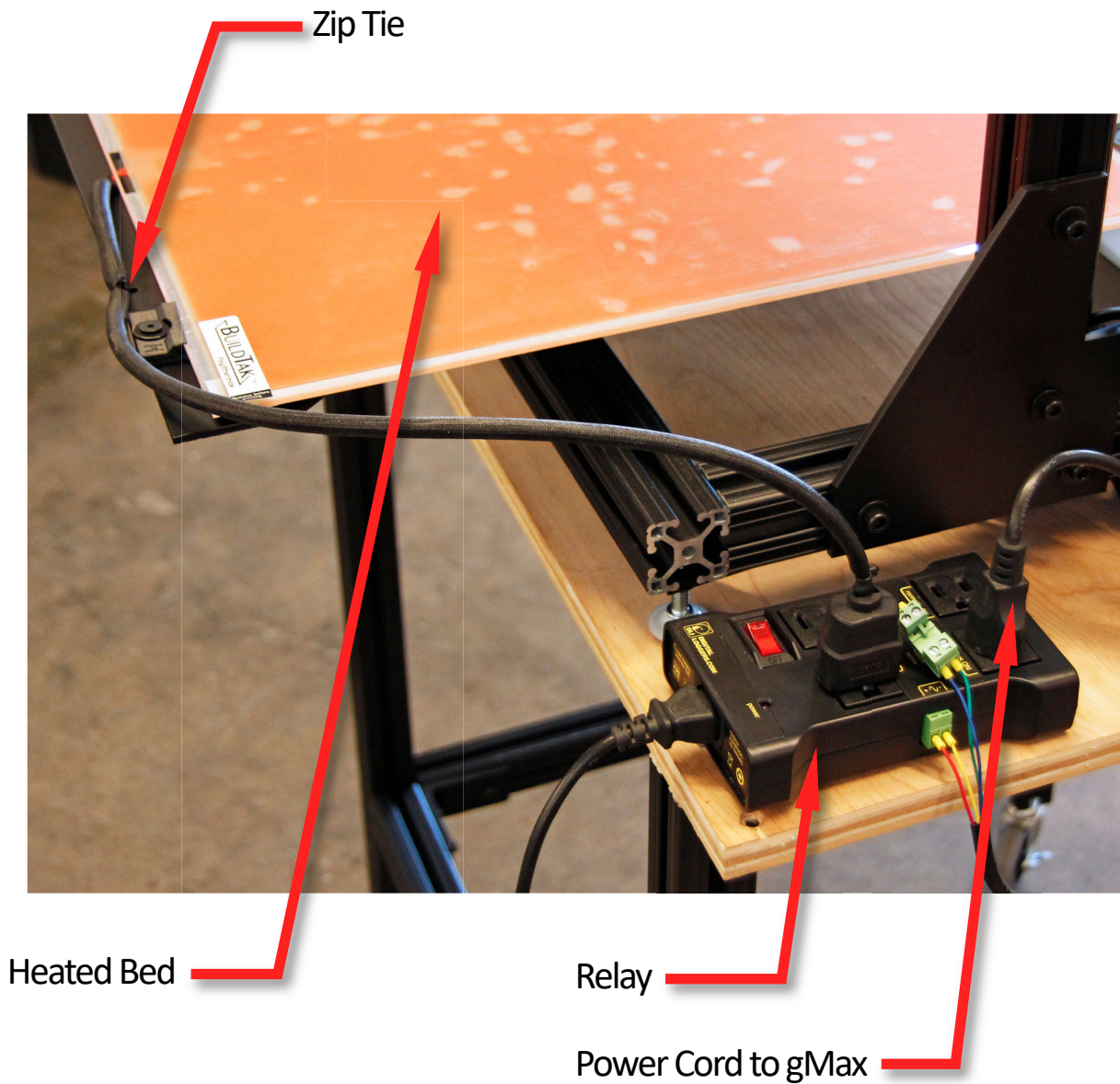
4. Bed Thermistor Wire  
(Blue and Green Wire)  
Plug into connector  
attached to power cord

## Warning

- Do not plug heated bed into "always on" or bed remain on indefinitely

# Relay Overview

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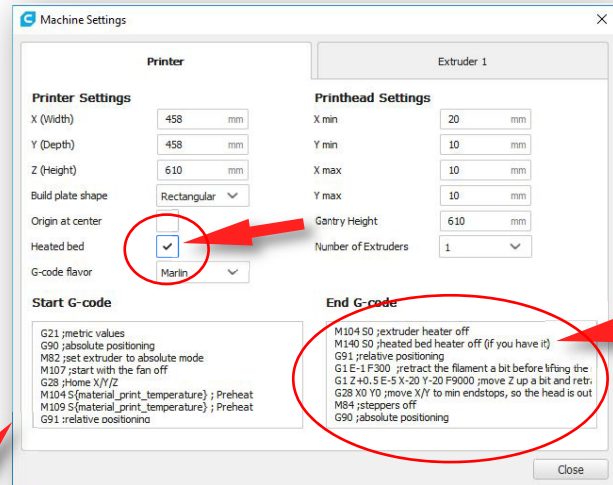
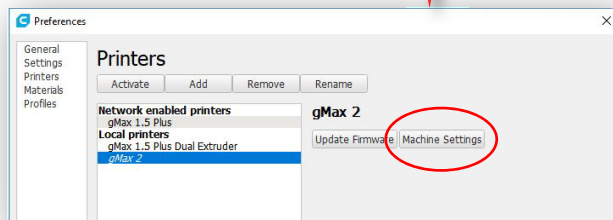
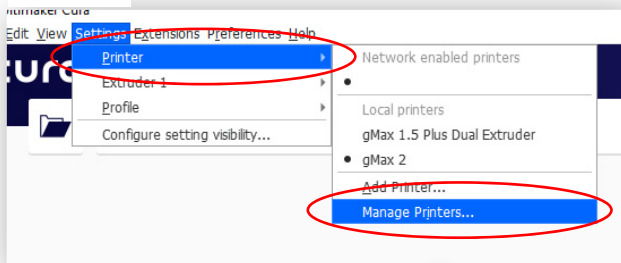
## Warning

- The heated bed can reach very high temperatures. Never touch the bed when it is hot.
- Let the heated bed cool prior to removing finished prints.
- Ensure bed clips are secure prior to every print.

# Slicer Setting Changes

If you are using your existing slicing settings, make sure to turn on the heated bed or add a temperature controller depending on the slicing software you are using. Make sure to add the proper end gcode to turn off the heated bed

## Cura 3.6 - 4.1.x



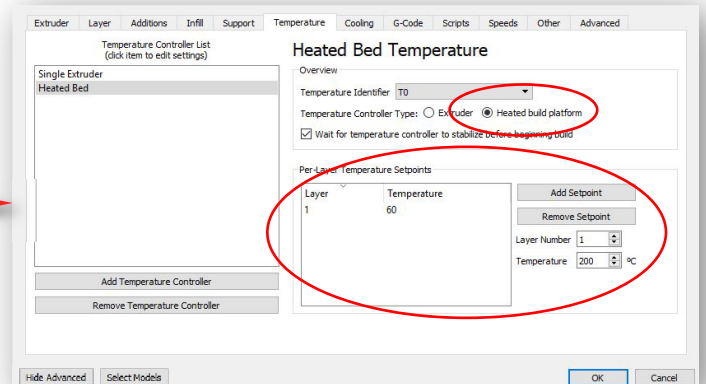
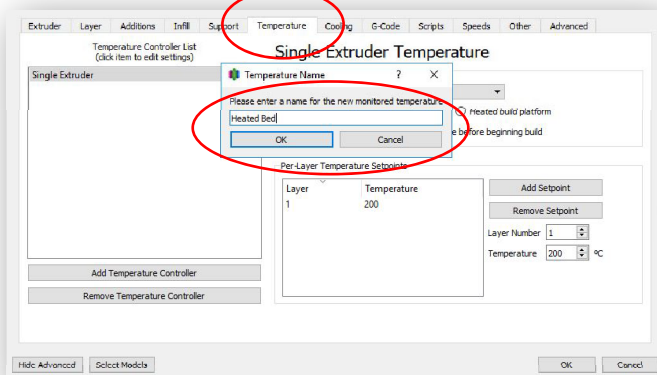
Make sure to turn on the heated bed under

**"Settings > Printer > Manage Printers... > Machine Settings"**

and add the proper end gcode to turn off the heated bed

**M140 S0 ; Turn off heated bed**

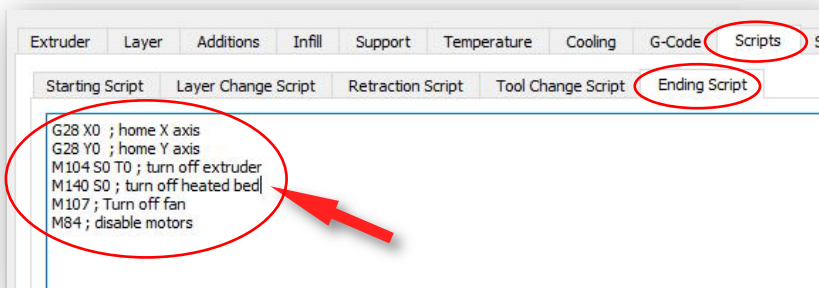
## Simplify3D 4.x



Add the heated bed temperature controller under

**"Temperature > Add Temperature Controller"**

and also add the proper end gcode to turn off the heated bed in the **"Scripts > Ending Scripts"** tab



**M140 S0 ; turn off heated bed**