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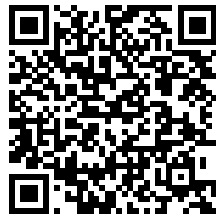
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How to replace the FEP film (SL1S)



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STEP 1 Introduction



i This guide will take you through the replacement of the **FEP film** on the **Original Prusa SL1S resin tank**.

◆ All necessary parts are available in our shop
shop.prusa3d.com

i Note that you have to be logged in to have access to the spare parts section.

⚠ **Before you start, make sure there is no resin in the resin tank. Clean the tank.**

STEP 2 Video tutorial

◆ You can follow this online guide, or watch the video tutorial. Both methods are the same.

STEP 3 Tools necessary for this guide



◆ **For the following steps, please prepare:**

- ◆ TX9 Torx key (1x)
- ◆ Piece of cloth or paper towels *for cleaning the resin tank*
- ◆ Spatula (1x) *recommended for removing resin residue*
- ◆ Knife with a sharp tip (1x)
- ◆ Nitrile gloves *are recommended while handling with the FEP film*

ⓘ At least **two pairs of gloves are recommended**. Use one to remove the origin film and the other pair to install a new film.

STEP 4 Removing the FEP film



- Using the TX9 Torx key release all 22 screws from the bottom side of the resin tank.

⚠ Do not throw away the screws, you will need them later on.

- Push the FEP film from the inside out of the resin tank using your fingers.

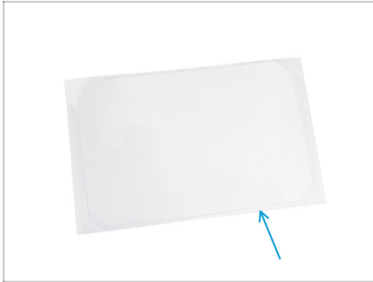
i Use nitrile gloves to avoid contact with resin residues.

STEP 5 Cleaning the tank



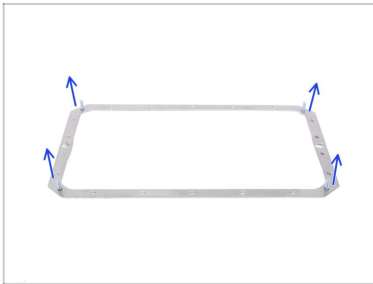
- Using a spatula, **carefully** scrape all the resin leftovers off the edges on the tank. **The edges must be perfectly clean. Otherwise, the tank will leak!**
- Clean the tank with Isopropyl Alcohol and a towel.
- Clean the metal frame.

STEP 6 New FEP film: parts preparation



- ◆ **For the following steps, please prepare:**
- ◆ New FEP film (1x)

STEP 7 Preparing the resin tank frame



- ◆ Take the resin tank frame (orientation doesn't matter) and push through four 2.5x8rt Torx screws in the corners.

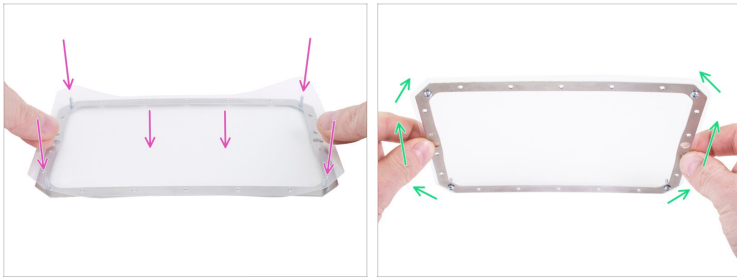
STEP 8 Preparing the FEP film



⚠ WARNING: the following procedure is crucial. Make sure you read the instructions first! The new FEP film consists of three layers. The outer layers are just a protection film for the middle layer, which is the actual FEP film.

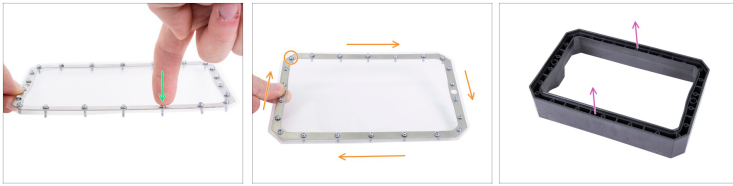
- Separate all layers slightly apart to recognize them:
 - Semi-thick outer layer (protection)
 - Thick inner layer (FEP film)
 - Thin outer layer (protection)
- Remove both protection layers so end up with the middle layer only. Also, check you have removed all the remains.

STEP 9 Preparing the resin tank frame



- ◆ Carefully place the FEP film on the frame and on the screws, use them to stretch and align the film.
- ◆ Carefully rotate the frame upside down.
- ⓘ We recommend using nitrile gloves while handling the FEP film to avoid fingerprints on the film.

STEP 10 Inserting the torx screws



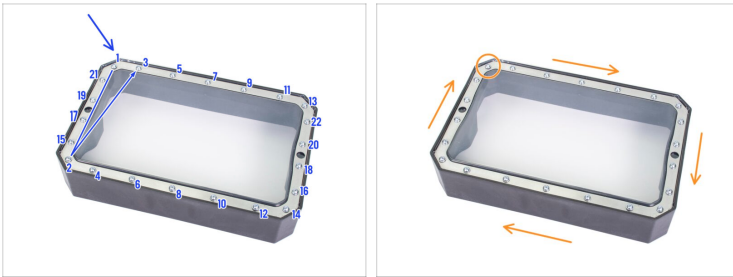
- ◆ Check the holes in the frame and in the film are aligned.
- ⚠ **DON'T PUNCH** through new holes for the Torx screws!
- ◆ Start inserting the remaining screws. **Don't push hard**, or you might bend the frame.
- ⓘ If it's difficult to insert the screw, screw it in by your hand.
- ◆ Check you have used twenty-two M2.5x8rt Torx screws.
- ◆ Prepare the resin tank, place it on a flat surface with the bottom facing up.

STEP 11 Assembling the resin tank



- ◆ Place the frame with the film and screws onto the tank and start attaching the 2.5x8 screws with the Torx key. Follow the indicated direction, go one by one.
- ⓘ There are no threads inside the holes in the resin tank. The screw will cut them there during tightening. So lightly push the wrench towards the screw while tightening.
- ⚠ Tighten them a few turns to just start the thread and set the position. **Do not tighten the screws fully yet!!**
- ⚠ **BE CAREFUL.** If the Torx key slips, you might damage the FEP film!

STEP 12 Assembling the resin tank



- ◆ Tighten all the screws following the sequence indicated by the numbers in the picture. Start with the one labeled 1 in the corner and work your way around the tank in the zig-zag pattern.
- ⓘ The **zig-zag** tightening sequence is important to follow to make sure the FEP foil is stretched evenly and the tank won't leak resin.
- ◆ Finally, fully tighten all the screws. This time, proceed clockwise.
- ⚠ **Make sure that all the screws are fully tightened! Leaking resin may fatally damage your printer.**

STEP 13 Assembling the resin tank



- ◆ Take any knife with a sharp tip (not included in the package).
- ◆ Carefully punch two holes in the FEP film, as indicated in the picture.
- ◆ Punch each hole in two directions to create a cross.
- ⚠ **Don't use a knife with a blunt tip or you might accidentally overstretch the FEP film.**
- ⓘ Pro tip: Turn the tank upside down to its "normal position" and fill it with tap water to its max level. Watch the tank and ensure no water is leaking.

STEP 14 It's done



- ◆ **Congratulation**, you have just successfully replaced the FEP film on your resin tank. Fill it with resin and let's print.
- ◆ A few tips in conclusion:
 - ① Do not use isopropyl alcohol on the FEP film.
 - ① Re-calibrate the printer after installing the resin tank with the new FEP film.
- ◆ Visit the menu **Settings > Calibration**
