

Apply fixes in order — enclosure first, then brim, then adhesion aids. Most warping problems are resolved by the first two steps.

Fix	Apply When	Priority	Notes
FIX HIERARCHY (APPLY IN ORDER) 5 items			
Raise bed temperature	Always — first action for any warping	CRITICAL	ABS: 100–110°C. Nylon: 80°C. PC: 110°C. ASA: 95°C.
Enclose the printer	All engineering materials (PA, PC, ASA, ABS)	CRITICAL	Maintains 40–60°C ambient. Most effective single fix.
Add a brim	Large flat parts or sharp corners	IMPORTANT	5–15mm wide. Remove with blade after print completes.
Apply adhesion aid	After enclosure and temp are correct	IMPORTANT	Choose aid by material — see table below.
Redesign the part	When all other measures still fail	NORMAL	Chamfer edges. Split into smaller sections.
BED ADHESION BY MATERIAL 6 items			
PLA	Textured PEI sheet	NORMAL	Releases cleanly when cool. Clean with IPA.
PETG	PEI + light glue stick	NORMAL	Prevents over-adhesion. Re-clean between prints.
ABS	Hairspray or Magigoo on glass	IMPORTANT	Apply thin coat. Heat bed before printing.
ASA	Textured PEI	IMPORTANT	Light glue optional for large prints.
Nylon (PA12/PA6)	PEI + glue stick	CRITICAL	Glue acts as release agent. Re-apply every 2–3 prints.
PC	PEI + glue stick	CRITICAL	PC bonds very aggressively to bare PEI without glue.