
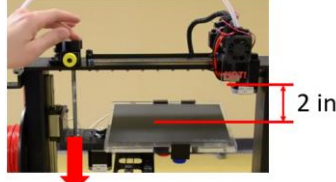

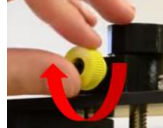

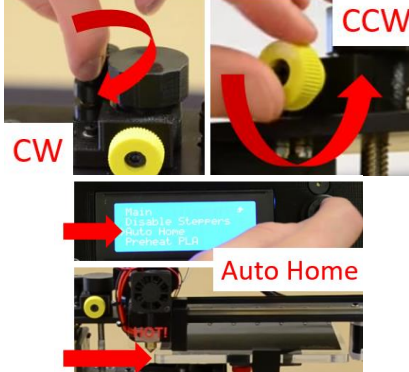

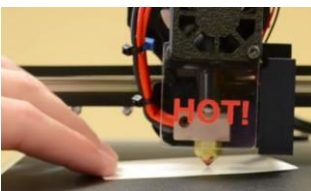


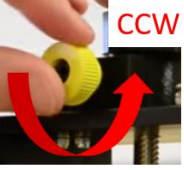
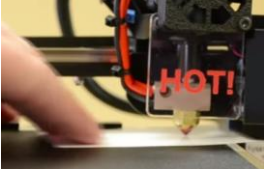


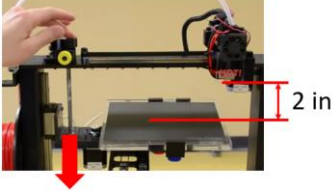


# Z Axis Calibration

STEP #01	Check and make sure that the yellow Z Axis lock is disengaged by turning it counterclockwise and that the Z Axis can move freely up and down.		Loosen the yellow screw
STEP #02	Lower the print board so that it is several inches below the hot end.		Lower the board by 2 in
STEP #03	On the LCD display press the selection wheel to enter the menu, then select and click Prepare, then select and click Auto Home. The motors will all go to their home positions.		LCD Display > Prepare > Auto Home
STEP #04	Lock the yellow Z Axis lock by turning it clockwise.		Lock the yellow screw
STEP #05	On the LCD display press the select wheel to enter the menu then select and click Prepare, then select and click Disable Steppers. This will release the motors so they can move freely.		LCD Display > Prepare > Disable Steppers
IF THE HOT END WON'T GO OVER THE PRINT BOARD:			
STEP #06	Lower the black Z Axis limit screw by turning it clockwise, unlock the yellow Z Axis lock by turning it counterclockwise, and perform the auto home function again.		<p>If Hot End won't go over the print board:</p> <ul style="list-style-type: none"> <li>• Lower black Z limit screw</li> <li>• Unlock yellow screw</li> <li>• Auto Home</li> </ul>
STEP #07	Lock the yellow Z Axis lock by turning it clockwise and perform the disable steppers function again.		<ul style="list-style-type: none"> <li>• Lock the yellow screw</li> <li>• Disable steppers</li> </ul>
STEP #08	Move the hot end over the center of the print board and check the gap between hot end and the print board with a standard business card. You should just barely feel a slight resistance when sliding the business card between hot end and the print board but make sure the hot end is not actually touching the print board.		<ul style="list-style-type: none"> <li>• Move hot end to the center</li> <li>• Check the clearance with the card</li> </ul>

# Z Axis Calibration

IF THE HOT END IS TOO FAR AWAY FROM THE PRINT BOARD:			
STEP # 09	If the hot end is too far away from the print board then turn the black Z Axis limit screw counterclockwise half of a turn.	 CCW - 180°	If Hot End too far: <ul style="list-style-type: none"> <li>Turn Black Z Axis screw CCW by 180°</li> </ul>
IF THE HOT END IS TOO CLOSE TO THE PRINT BOARD:			
STEP # 10	If the hot end is too close to the print board then turn the black Z Axis limit screw clockwise half of a turn.	 CW - 180°	If Hot End too far: Turn Black Z Axis screw CW by 180°
AFTER ANY ADJUSTMENT TO THE BLACK Z AXIS LIMIT SCREW			
STEP # 11	After any adjustment to the black Z Axis limit screw unlock the Yellow Z Axis lock by turning it counterclockwise and restart the Z Axis calibration process until the gap is properly adjusted.	 CCW	Loosen the yellow screw & Repeat the process if needed
AFTER THE GAP IS GOOD			
STEP # 12	Once the gap is properly adjusted at the center of the print board, position the hot end at each of the four corners of the print board and check the gap at those locations.		Check clearance in all 4 corners of the print board
AFTER THE GAP IS NOT GOOD			
STEP # 13	If the gap is unacceptable please refer to the video "Print Board Leveling" to properly adjust the flatness of your print board.		Watch other video and adjust the flatness of the print board
ONCE THE GAP IS PROPERLY ADJUSTED IN THE CENTER AND THE FOUR CORNERS OF THE PRINT BOARD			
STEP # 14	Once the gap is properly adjusted in the center and the four corners of the print board double check your work by unlocking the yellow Z Axis lock by turning it counterclockwise and performing the Z Axis calibration process again.	 CCW	Loosen the yellow screw
STEP # 15	When you are satisfied, unlock the yellow Z Axis lock by turning it counterclockwise and lower the print board a few inches. Now it is safe to print.		Lower the board by 2 in