CALIBRATING THE PRINT PLATE AND NOZZLE HEIGHT

To print successfully, the Print plate should be set to start at a distance of 0.2mm from the nozzle (0.4mm Nozzle). As each printer is slightly different, this distance needs to be calibrated before starting to print.

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INTRODUCTION

The distance varies as per the size of the Nozzle. For eg.

- 0.7mm nozzle – distance 0.35mm – Business card can be used (measuring distance).
- 0.4mm nozzle – distance 0.2mm – Folding a piece of paper (measuring distance).
- 0.2mm nozzle – distance 0.1mm – a piece of paper can be used (measuring distance).

To figure out the correct nozzle distance, please follow these steps:
Step 1 — CALIBRATING THE PRINT PLATE AND NOZZLE HEIGHT

1. Fix the Print plate on to the screws provided. Ensure that x-end idler assembly and x-end motor assembly is in same height. You can measure the both ends using Height gauge or L angle. If they are not in same height, you can rotate the z-axis threaded rod to bring it to the same level.

Step 2

1. Check the distance between the nozzle and Print plate by folding a piece of paper in two (Which will make it about 0.2mm thick – for 0.4mm Nozzle) and use that as a spacer to gauge the distance between the nozzle and Print plate.
**Step 3**

- Bring X, Y and Z axis to Home position then move Y-axis enough so that nozzle is on print plate. Check distance between nozzle and print plate and adjust if necessary. (distance of 0.2mm).
- Move Z-axis 10mm height and bring it to the left hand side far corner (1) of Print plate and click Z-axis home position.

**Step 4**

- Now check the distance between the nozzle and the platform (distance of 0.2mm).
Step 5

- Move Z-axis 10mm height and bring to right side far corner (2) of print plate by clicking X-axis +10 and click Z-axis home position. Now check the distance between the nozzle and the platform using folded piece of paper.

Step 6

- Move Z-axis 10mm height and bring to right side far corner (3) of print plate by clicking Y-axis +10 and click Z-axis home position. Now check the distance between the nozzle and the platform using folded piece of paper.
Step 7

- If the folded piece of paper is not moving or if there is too much of gap, you can adjust the Print plate screws with the help of screw driver until you get the correct distance (0.2mm). Re-check the distance between the nozzle and the platform using folded piece of paper.

Step 8

- Move Z-axis 10mm height and bring to left side far corner (4) of print plate by clicking X-axis -10 and click Z-axis home position. Now check the distance between the nozzle and the platform using folded piece of paper. Ensure that you have checked all four corners of the print plate. To avoid crash the platform into the nozzle.