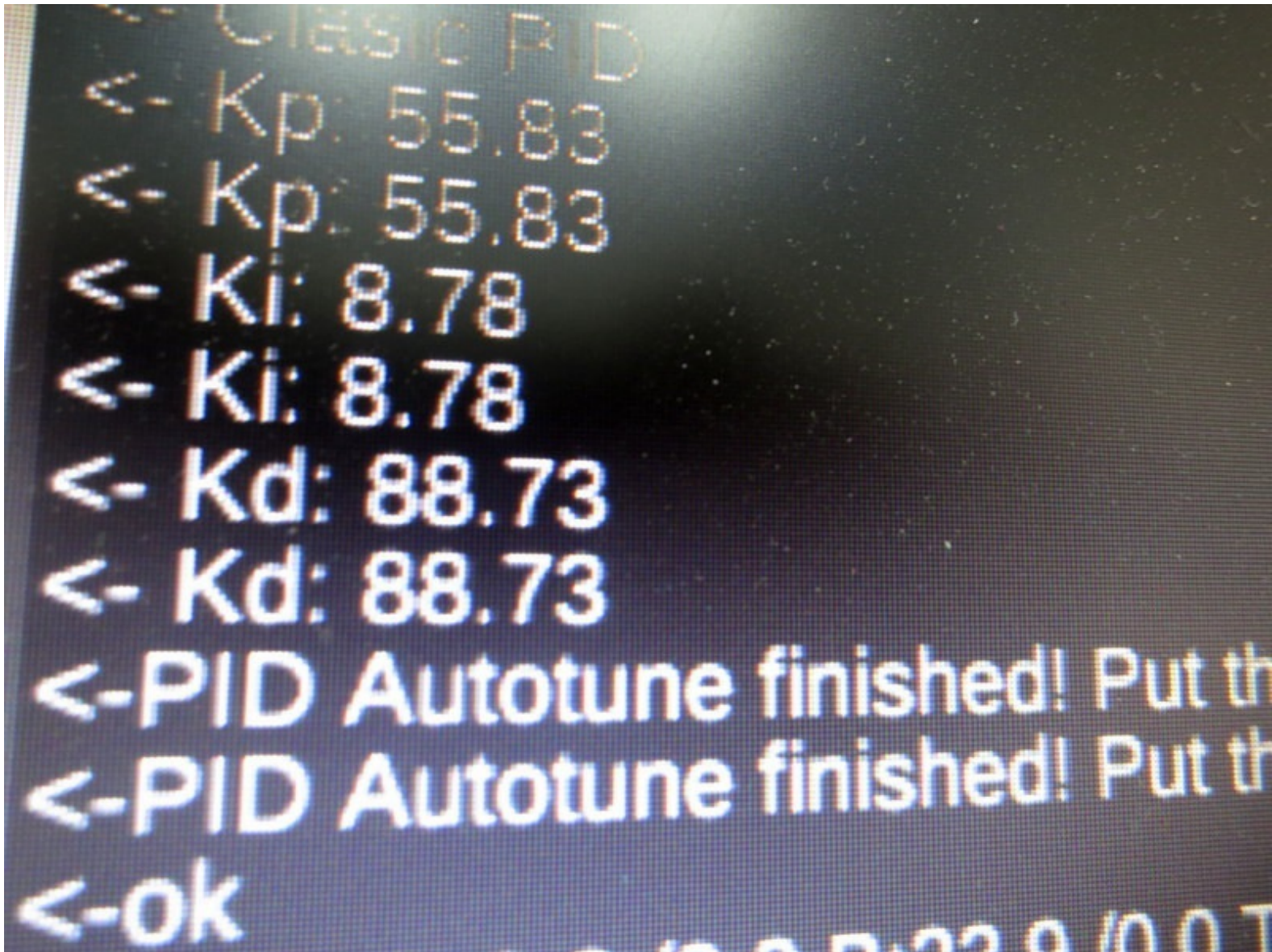


MatterHackers

PID Tuning

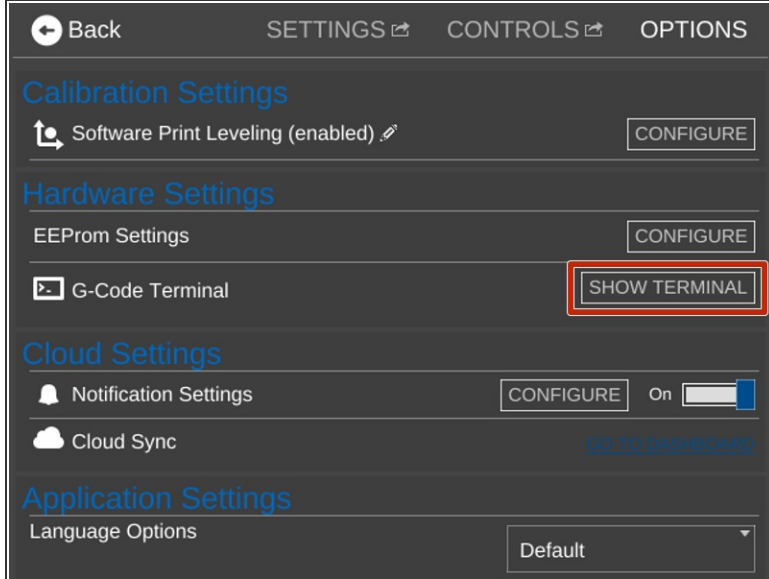
Written By: Tyler Anderson



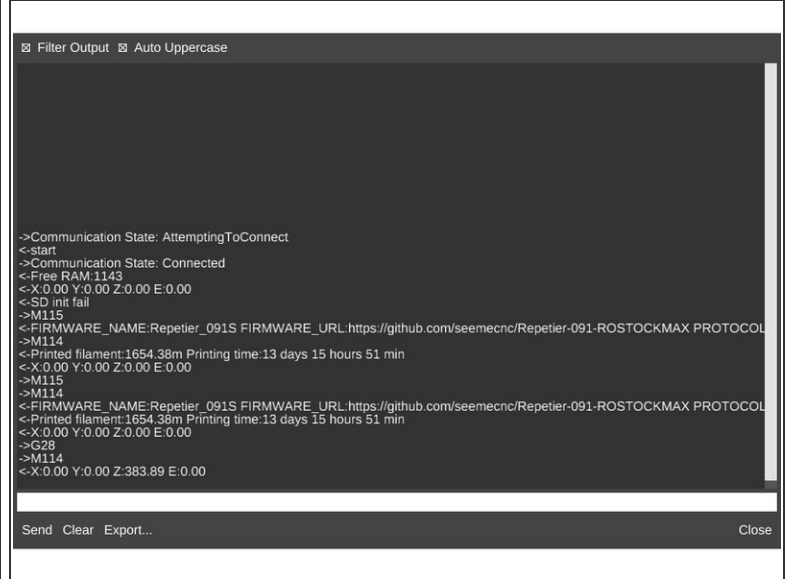
INTRODUCTION

PID ([Proportional Integral Derivative](#)) is the control algorithm the printers use for holding temperature. The parameters for this algorithm control how fast the printer reaches the set temperature and how well it holds that temperature once it gets there. Fortunately, the printer has an automatic way of tuning these values.

Step 1 — Open G-Code Terminal



The screenshot shows the MatterControl settings interface. At the top, there are navigation options: 'Back', 'SETTINGS', 'CONTROLS', and 'OPTIONS'. Below this, there are several settings sections: 'Calibration Settings' with 'Software Print Leveling (enabled)' and a 'CONFIGURE' button; 'Hardware Settings' with 'EEProm Settings' and a 'CONFIGURE' button, and 'G-Code Terminal' with a 'SHOW TERMINAL' button highlighted by a red rectangle; 'Cloud Settings' with 'Notification Settings' (CONFIGURE, On) and 'Cloud Sync' (GO TO DASHBOARD); and 'Application Settings' with 'Language Options' set to 'Default'.



The screenshot shows the G-Code Terminal window. At the top, there are options for 'Filter Output' and 'Auto Uppercase'. The terminal displays the following output:

```
<-start
->Communication State: AttemptingToConnect
->Communication State: Connected
<-Free RAM:1143
<-X:0.00 Y:0.00 Z:0.00 E:0.00
<-SD_init fail
->M115
<-FIRMWARE_NAME:Repeter_091S FIRMWARE_URL:https://github.com/seemecnc/Repeter-091-ROSTOCKMAX_PROTOCOL
->M114
<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
<-X:0.00 Y:0.00 Z:0.00 E:0.00
->M115
->M114
<-FIRMWARE_NAME:Repeter_091S FIRMWARE_URL:https://github.com/seemecnc/Repeter-091-ROSTOCKMAX_PROTOCOL
<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
<-X:0.00 Y:0.00 Z:0.00 E:0.00
->G28
->M114
<-X:0.00 Y:0.00 Z:383.89 E:0.00
```

At the bottom of the terminal window, there are buttons for 'Send', 'Clear', 'Export...', and 'Close'.

- Open the [G-Code Terminal](#) in MatterControl.

Step 2 — Run Auto-tuning

```

Filter Output  Auto Uppercase

->Communication State: AttemptingToConnect
<-start
->Communication State: Connected
<-Free RAM:1143
<-X:0.00 Y:0.00 Z:0.00 E:0.00
<-SD init fail
->M115
<-FIRMWARE_NAME:Repetier_091S FIRMWARE_URL:https://github.com/seemecnc/Repetier-091-ROSTOCKMAX PROTOCOL
->M114
<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
<-X:0.00 Y:0.00 Z:0.00 E:0.00
->M115
->M114
<-FIRMWARE_NAME:Repetier_091S FIRMWARE_URL:https://github.com/seemecnc/Repetier-091-ROSTOCKMAX PROTOCOL
<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
<-X:0.00 Y:0.00 Z:0.00 E:0.00
->G28
->M114
<-X:0.00 Y:0.00 Z:383.89 E:0.00

M303 E0 S240 C8

Send Clear Export... Close

```

- The M303 command runs the PID tuning. It uses the following format:
 - M303 E<extruder>
S<temperature> G<cycles>
 - Example: M303 E0 S240 C3
- The E option is not required on single extruder machines. To tune the heated bed, use P1 (Repetier) or E-1 (Marlin, others). On multi-extruder machines, use the number of the extruder you want to tune (starting with 0).
- S is the temperature you want to run the tuning at. This should be close to the temperature you will use for printing.
- C is the number of cycles of tuning to run. We recommend 3.
- Once you run this command the autotuning process will start. The printer will cycle the temperature up and down over the course of several minutes.
- ⓘ You can turn off the Filter Output option in the console to watch the temperatures change.

Step 3 — Set PID Values

```

-<-start
->Communication State: Connected
-<-Free RAM:1143
-<-X:0.00 Y:0.00 Z:0.00 E:0.00
-<-SD init fail
->M115
-<-FIRMWARE_NAME:Repeter_091S FIRMWARE_URL:https://github.com/seemecnc/Repeter-091-ROSTOCKMAX_PROTOCOL
->M114
-<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
-<-X:0.00 Y:0.00 Z:0.00 E:0.00
->M115
->M114
-<-FIRMWARE_NAME:Repeter_091S FIRMWARE_URL:https://github.com/seemecnc/Repeter-091-ROSTOCKMAX_PROTOCOL
-<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
-<-X:0.00 Y:0.00 Z:0.00 E:0.00
->G28
->M114
-<-X:0.00 Y:0.00 Z:383.89 E:0.00
->M303 E0 S240 C8
-<-Info:PID Autotune start
-<- bias: 149 d: 105 min: 237.50 max: 241.54
-<- bias: 155 d: 99 min: 237.81 max: 241.92
-<- bias: 152 d: 102 min: 238.75 max: 241.54
-<- Ku: 48.57 Tu: 15.65
-<- Classic PID
-<- Kp: 27.94
-<- Ki: 3.57
-<- Kd: 54.68
-<- bias: 147 d: 107 min: 238.75 max: 241.54
-<- Ku: 48.86 Tu: 15.12
-<- Classic PID
-<- Kp: 29.31
-<- Ki: 3.88
-<- Kd: 55.41
-<- bias: 147 d: 107 min: 238.75 max: 241.54
-<- Ku: 48.86 Tu: 15.13
-<- Classic PID
-<- Kp: 29.31
-<- Ki: 3.88
-<- Kd: 55.42
-<-Info:PID Autotune finished ! Place the Kp, Ki and Kd constants in the Configuration.h or EEPROM
M301 P29.31 I3.88 D55.42

```

Description	Value
Extr.1 acceleration [mm/s ²]	2500
Extr.1 heat manager [0-3]	1
Extr.1 PID drive max	205
Extr.1 PID drive min	60
Extr.1 PID P-gain/dead-time	29.31
Extr.1 PID I-gain	3.88
Extr.1 PID D-gain	55.42
Extr.1 PID max value [0-255]	255
Extr.1 X-offset [steps]	0
Extr.1 Y-offset [steps]	0
Extr.1 temp. stabilize time [s]	3
Extr.1 temp. for retraction when heating [C]	150
Extr.1 distance to retract when heating [mm]	0
Extr.1 extruder cooler speed [0-255]	255
Save To EEPROM	Cancel



Each firmware has different requirements for saving PID values. Consult your firmware's documentation to determine the correct method.

- As the tuning runs, the printer will calculate values for Kp, Ki, and Kd. When it is done, take the last three values provided and set these using the M301 command. For this example:
 - M301 P29.31 I3.88 D55.42
- In the case of multiple extruders, these settings will be applied to all of them.
- For the bed, use M304 instead.



You can also save the values through the [EEPROM settings](#) in MatterControl.

Step 4 — Save settings to EEPROM

```
->Communication State: Connected
<-Free RAM:1143
<-X:0.00 Y:0.00 Z:0.00 E:0.00
<-SD init fail
->M115
<-FIRMWARE_NAME:Repeticier_091S FIRMWARE_URL:https://github.com/seemecnc/Repeticier-091-ROSTOCKMAX_PROTOCOL
->M114
<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
<-X:0.00 Y:0.00 Z:0.00 E:0.00
->M115
->M114
<-FIRMWARE_NAME:Repeticier_091S FIRMWARE_URL:https://github.com/seemecnc/Repeticier-091-ROSTOCKMAX_PROTOCOL
<-Printed filament:1654.38m Printing time:13 days 15 hours 51 min
<-X:0.00 Y:0.00 Z:0.00 E:0.00
->G28
->M114
<-X:0.00 Y:0.00 Z:383.89 E:0.00
->M303 E0 S240 C8
<-Info:PID Autotune start
<- bias: 149 d: 105 min: 237.50 max: 241.54
<- bias: 155 d: 99 min: 237.81 max: 241.92
<- bias: 152 d: 102 min: 238.75 max: 241.54
<- Ku: 46.57 Tu: 15.65
<- Classic PID
<- Kp: 27.94
<- Ki: 3.57
<- Kd: 54.68
<- bias: 147 d: 107 min: 238.75 max: 241.54
<- Ku: 48.86 Tu: 15.12
<- Classic PID
<- Kp: 29.31
<- Ki: 3.88
<- Kd: 55.41
<- bias: 147 d: 107 min: 238.75 max: 241.54
<- Ku: 48.86 Tu: 15.13
<- Classic PID
<- Kp: 29.31
<- Ki: 3.88
<- Kd: 55.42
<-Info:PID Autotune finished ! Place the Kp, Ki and Kd constants in the Configuration.h or EEPROM
->M301 P29.31 I3.88 D55.42
M500
```

- When you are done, make everything permanent with M500.

This document was last generated on 2017-06-27 09:16:24 AM.