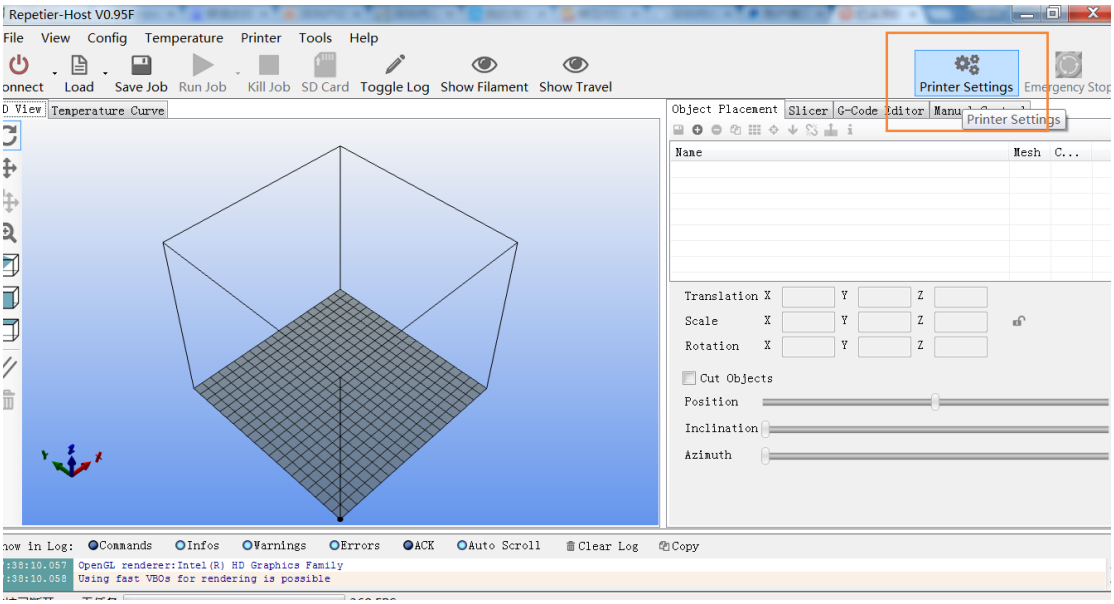
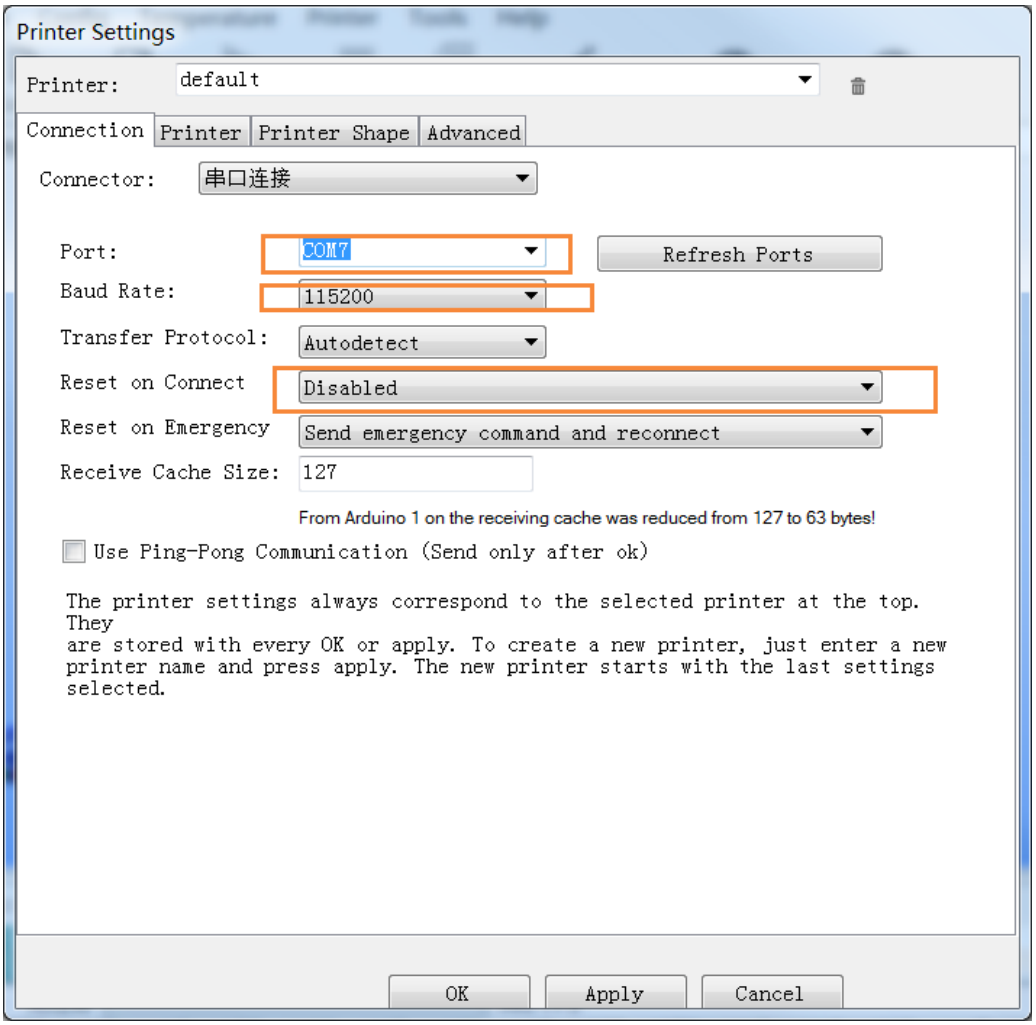
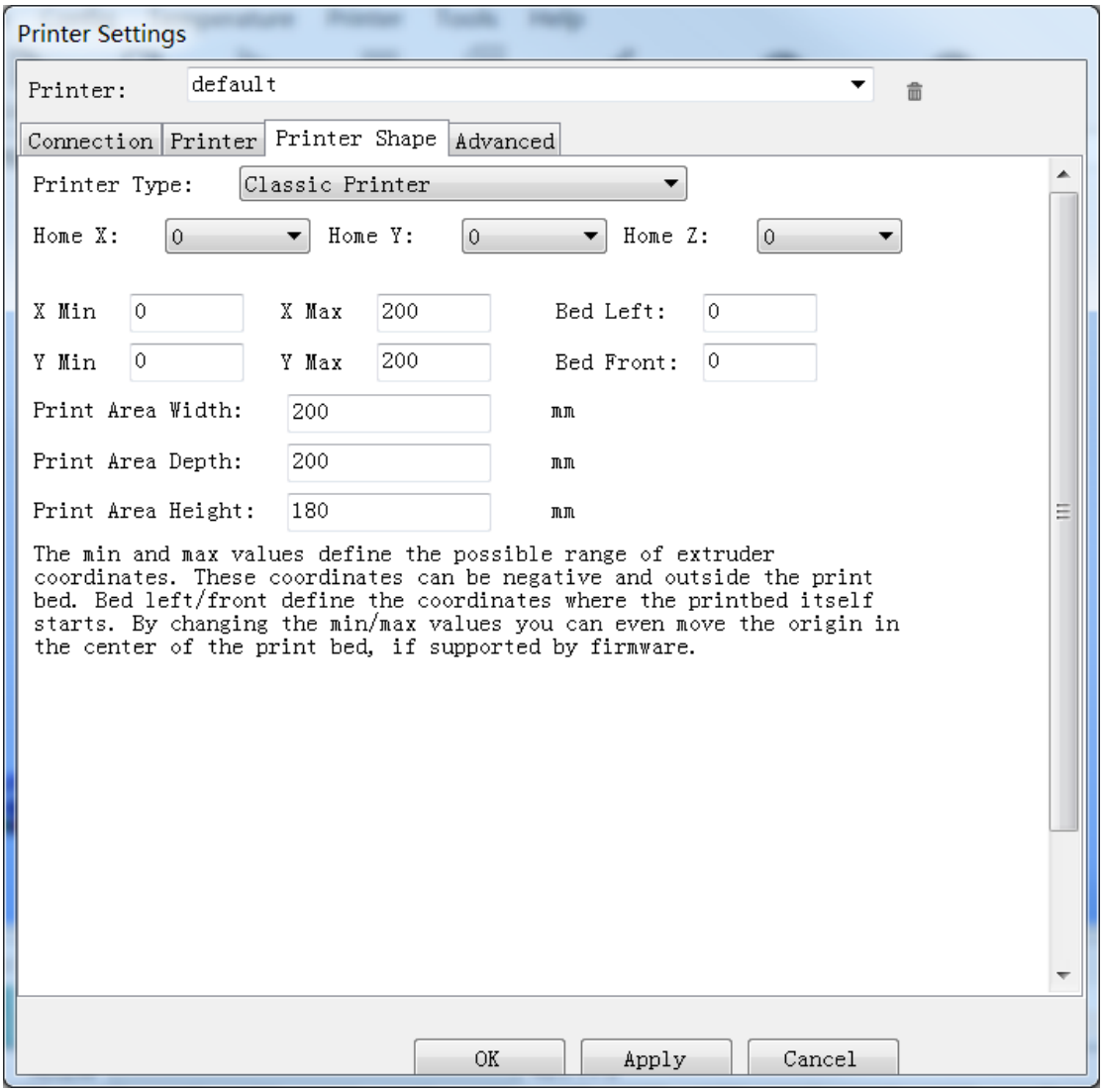
Click the printer settings as follow picture shows.

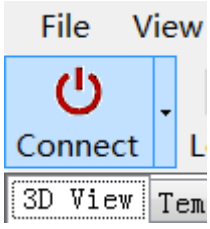


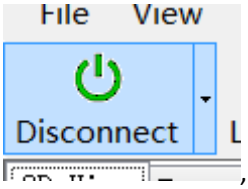
Then you'll see this new window, The parameters that be circled need to be changed. The port you need to choose your printer port, may you could refer to your driver installing.



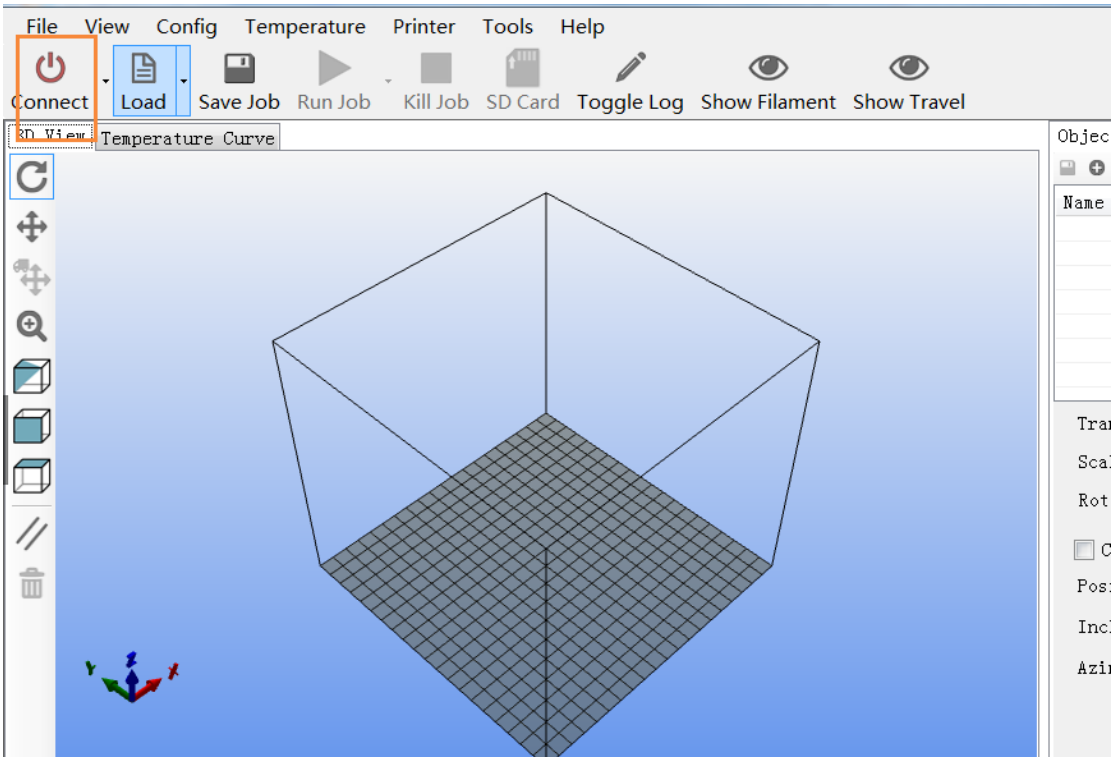
Let set up the printer shape parameter as shown below. Please do not forget to save your operation.

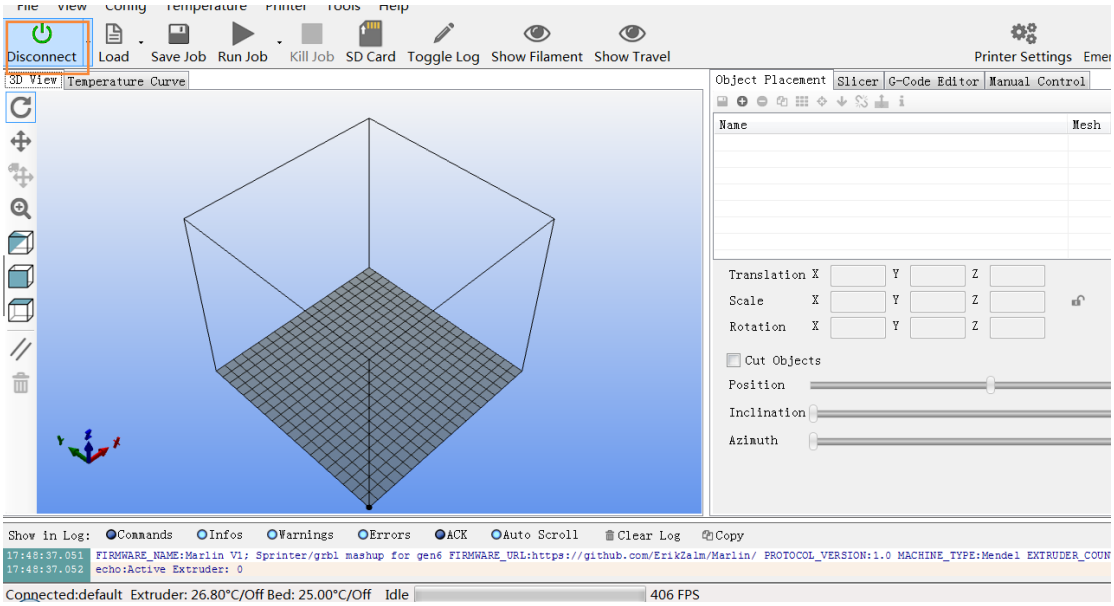


Click the “connect” 

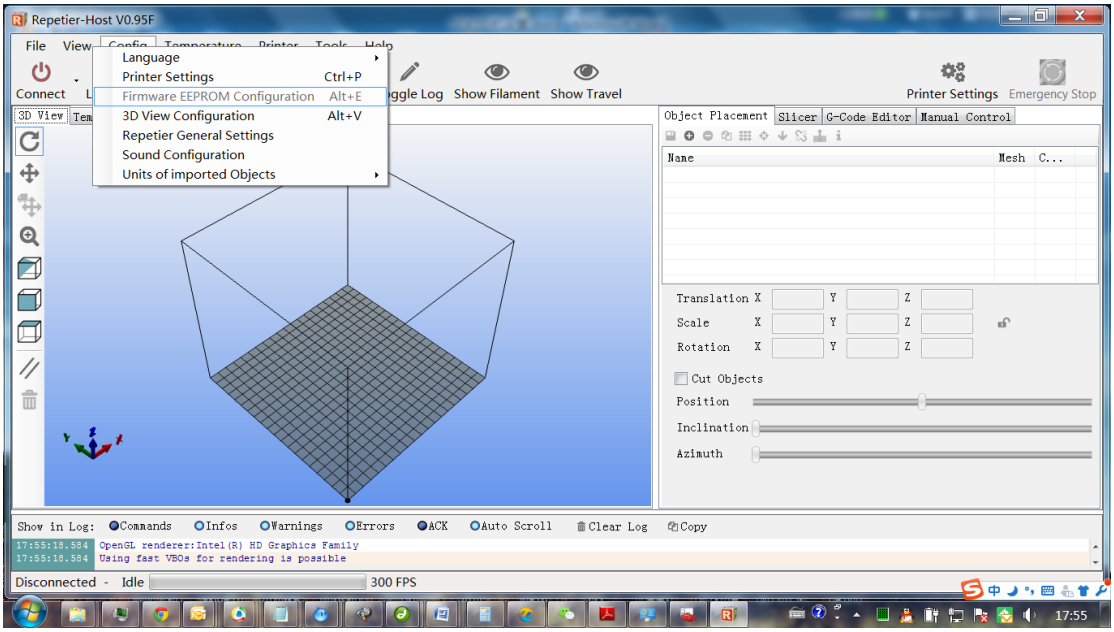
and wait for a while. When it change into green and shows “Disconnect” 

, printer connection is OK!

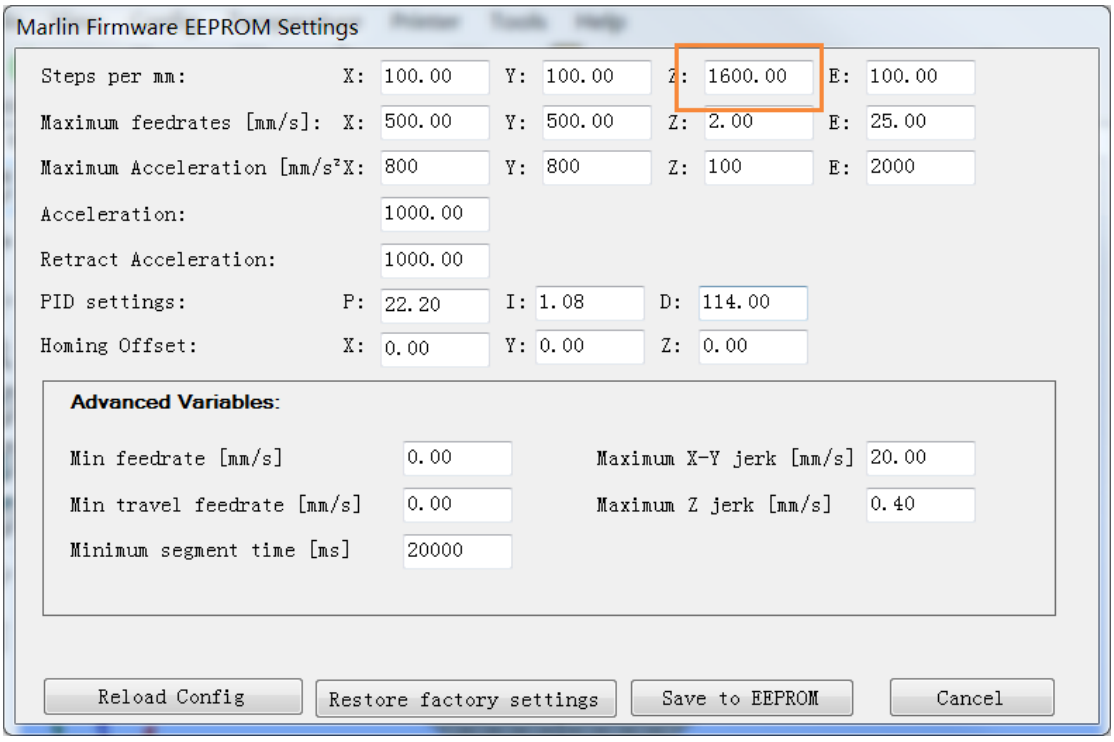




Now we should start the Firmware EEPROM settings. Click the “config” option at the toolbar. You could see it in the drop-down list.



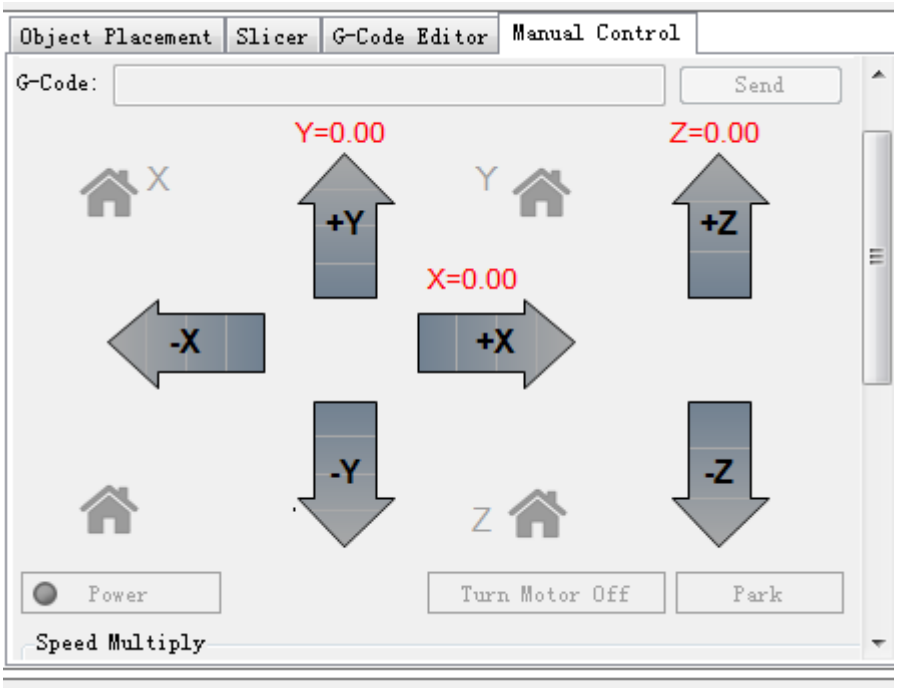
Please compare the parameters with below picture, it will ensure machine's steady running.(pay attention to the STEPS PER MM about z axis. It should be changed into 1600)



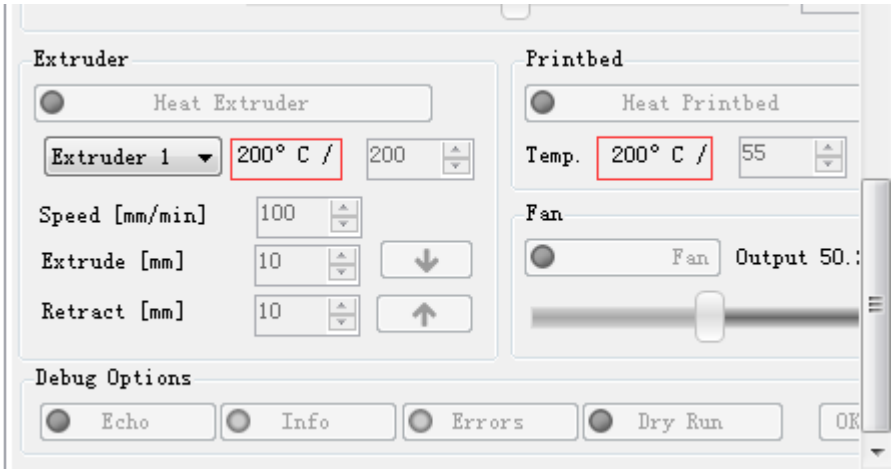
At last, remember to click the "Save to EEPROM".

OK! Preparatory work has been completed. It's time to test the printer. You could find the "manual control" option at the right side of software interface. Test the "+Y""-Y""+X""-X""+Z""-Z" to make sure it can work well. Please tidy the wire up and be not keep out the limit switch. Click the  in the bottom left. Then X,Y,Z will automatic zero resetting and knock into the

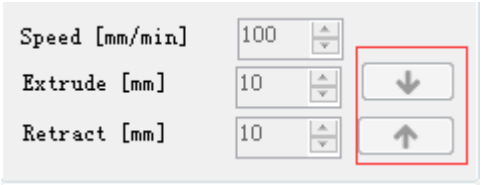
limit switch.



Pull the dexter scroll bar down, have a test with heating printbed and extruder. It can display the room temperature when we run the printer. If show as “0”, you should pay attention to the sensor. May be there are some wrongs happen to it.

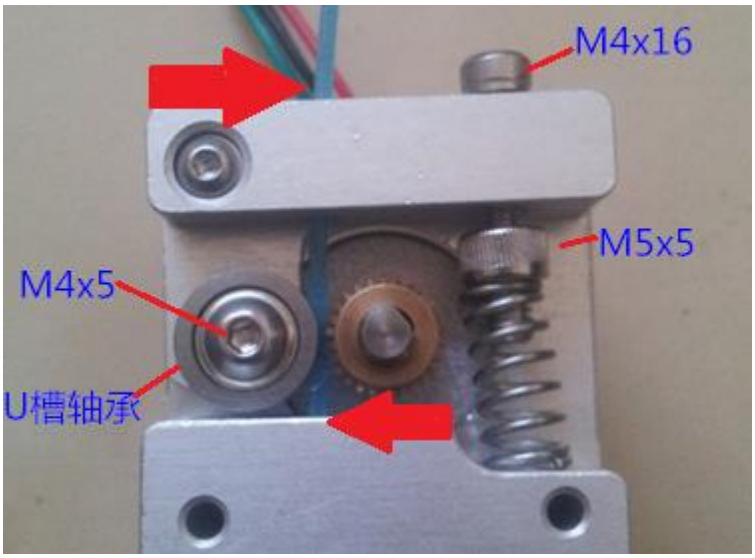


Ok, click the “  ”, if you touch the heating printbed and feel the rising of temperature after a little while. It shows normal work. Next we can click the  to heat the extruder until over 150 degree centigrade. Show as below picture, it time to test the extruder.()

Click the “up and down arrow”, 

you could hear that rotation of the extruder. Wait for a while until the temperature reach to 200 and install the printing-supplies to have a test.

There is a Print figure internal structure, the blue one is printing-supplies line, it plug into the holes that up red arrow pointed. Then use the bearing to pressure on the gear. Then through the hole as down red arrow pointed.(please keep on pressing the M4x16). This operation should to be done at the 200 degree centigrade. It shows work well If you touch the printing-supplies and feel very soft when you plug into the printing-supplies. Else it was get stuck at the down red arrow pointed as below picture shows.

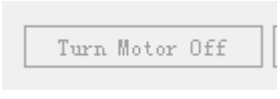


When these step done. Then click the up and down arrow again. The down arrow is “material extrusion”. and up arrow is ”retraction”.

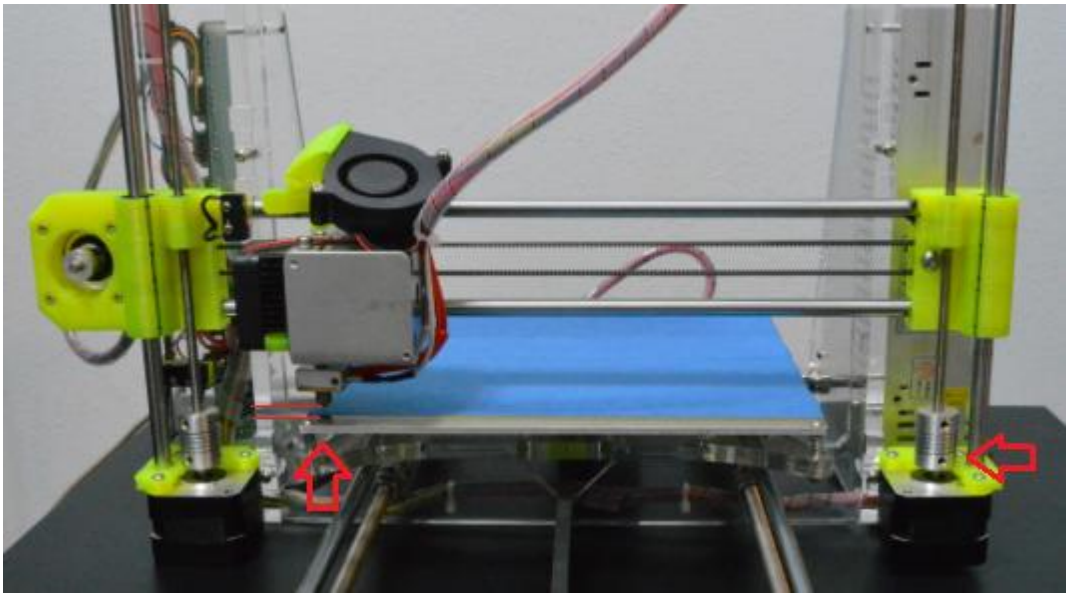
Now we need to adjust the balance of printer, you’d better to paste on the tape in advance. In order to avoid influence printing quality.

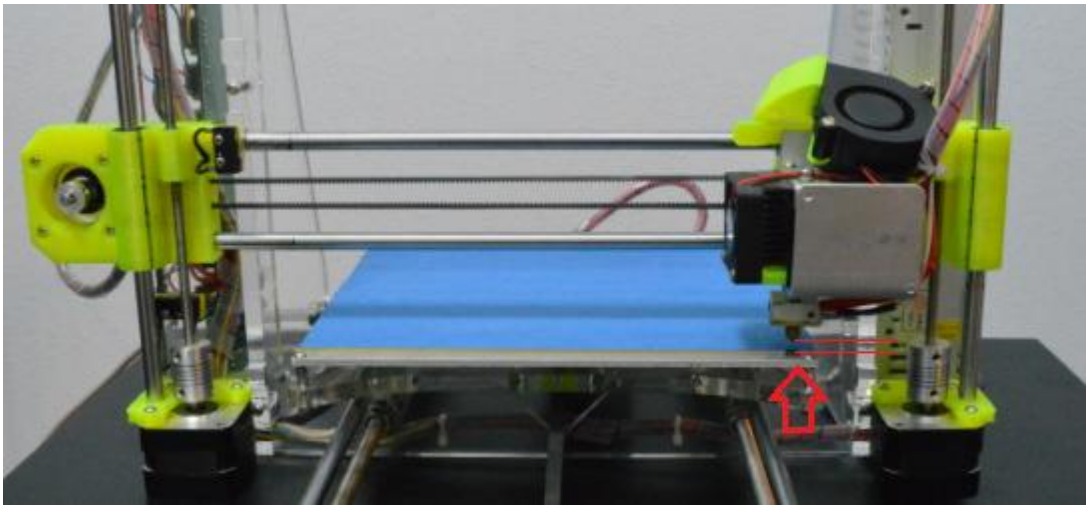
1:measure the height of four screws by eye, and keep them in level.

2:let the z axis fall by software controlling as below picture shows.

Click the 

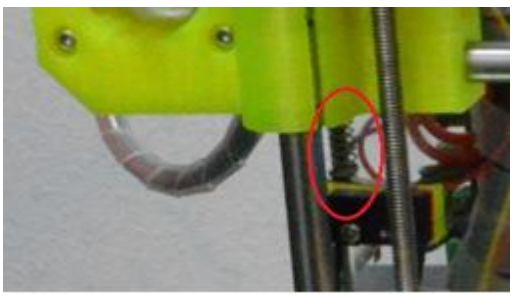
button when the nozzle and board at a distance of 1-2mm. after that twist the motor of right side by hand and adjust the level of the horizontal axis. It will achieve a result that whatever the print head at right or left. The distance of print head and board keep the same. as below pictures show:





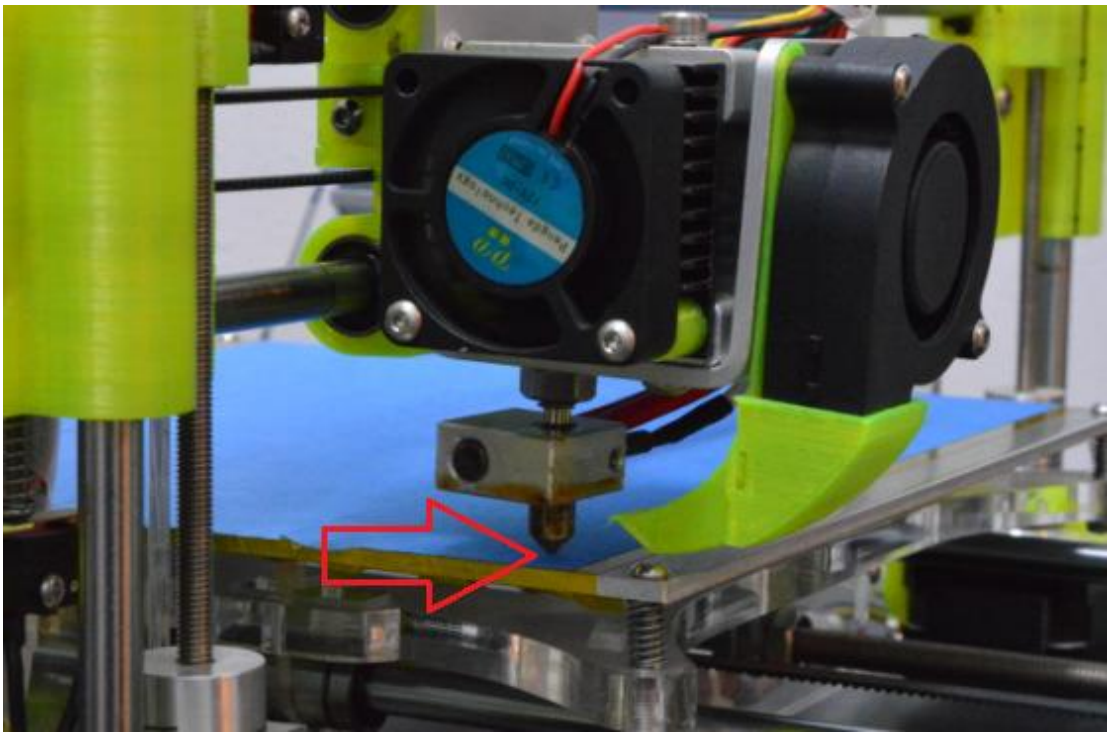
Click the 

and the z axis will decline until touch the limit switch.

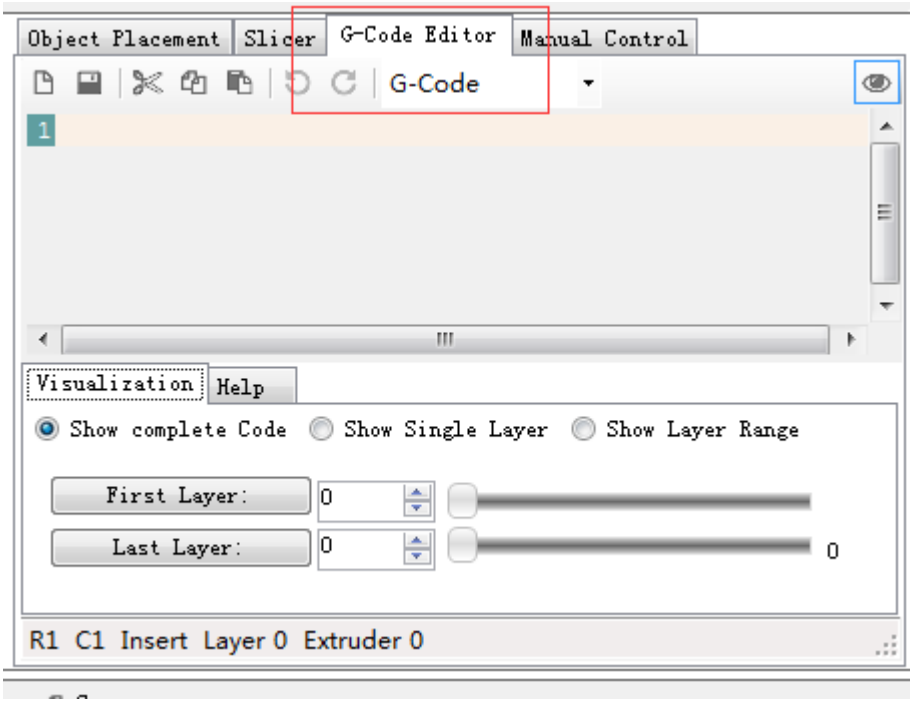


At the same time you should observe that if the nozzle touch the plate just right or not. Be not leave crack and press down the spring.

Please adjust the screw in picture above If not show as same as below picture. The aim to change the reset height of Z axis. Repeated to make it looks more good as below picture show.

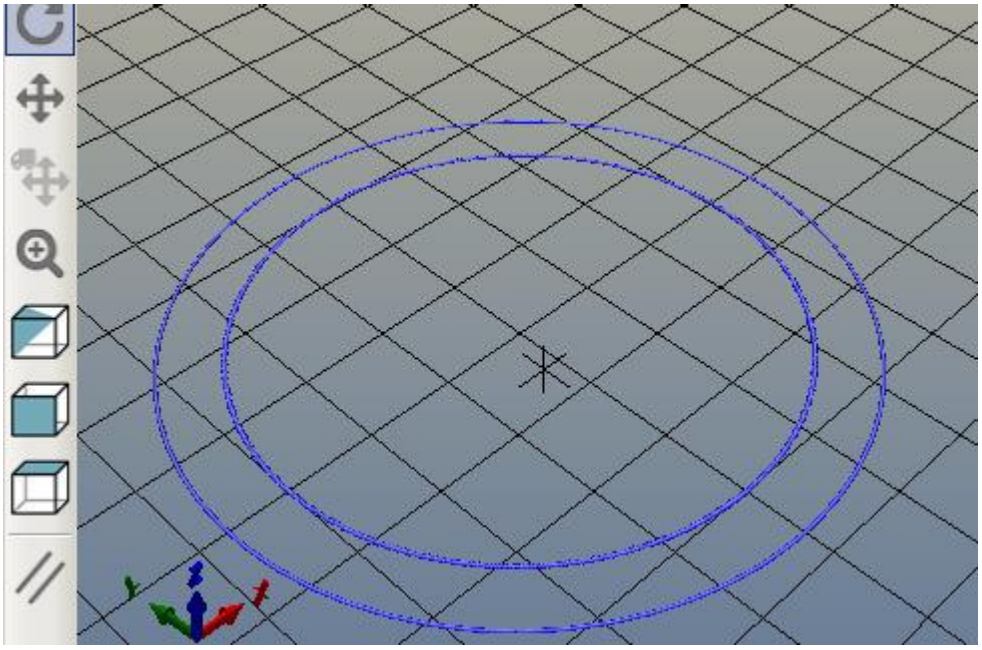


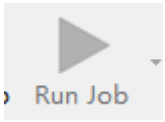
3:debugging in the actual printing. found the leveling test at documentation(.gcode) and load it at repetier. Then choose the ”G-Code Editor”



, now you can preview the trajectory of printer as below picture shows, you could adjust the view

angle by the left toolbar.



Click the 

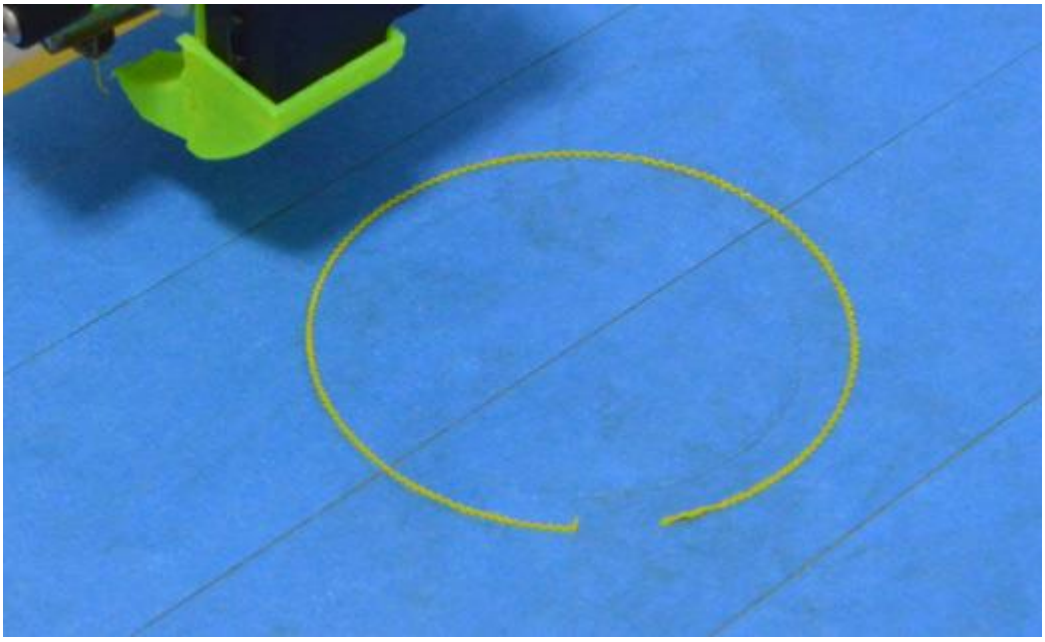
on the toolbar to start printing

First, heating the baseboard, when it meet our temperature requirement, the printer will back to initial point and then heating the extrusion head until it meet temperature requirement too. Ok. The machine start to printing:

If there are some problem as below situations:

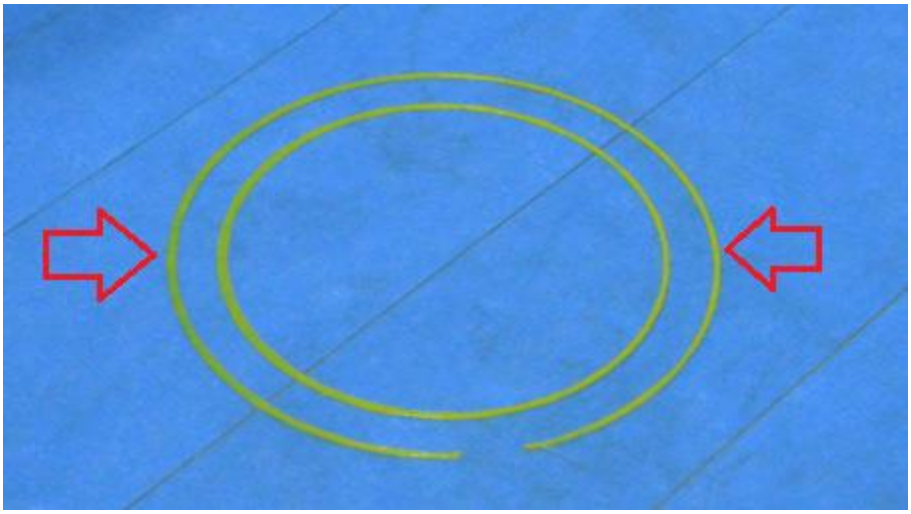
1:in the wave shape

cause: the printer head is too high, the nozzle could not touch the plate after Z axis reset. You need to adjust the height of nozzle.



2:line width of the left and right are not consistent.

Cause: the plate is out of level, you need to adjust the screw of plate which one is at the direction of right arrow. for example, you could unscrew the screw to rose the right side of plate if appear below(small amplitude adjustment and half-turn is enough.)



Through several adjustments to achieve below effect.(the line is flattened)

Debugging is done up to now.