Click the printer settings as follow picture shows.

Repetier-Host V0.95F		
File View Config Temperature Printer Tools Help	n <b>gs</b> Eme	rgency Stor
D View Temperature Curve Object Placement Slicer G-Code Editor Manu - O	er Settin	15
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Position		
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Azinuth		
now in Log: @Commands Olnfos O¥arnings OErrors @ACK OAuto Scroll @Clear Log @Conv		
138:10.057 OpenGL renderer: Intel (R) HD Graphics Family		
Using last vous for rendering is possible		

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.

Printer Settings	
Printer: default 🔹 💼	
Connection Printer Printer Shape Advanced	
Connector: 串口连接     ▼	
Port: COM7 Refresh Ports	
Baud Rate:	
Transfer Protocol: Autodetect 💌	
Reset on Connect Disabled 🗸	
Reset on Emergency Send emergency command and reconnect -	
Receive Cache Size: 127	
From Arduino 1 on the receiving cache was reduced from 127 to 63 bytes!	
🔲 Use Ping-Pong Communication (Send only after ok)	
The printer settings always correspond to the selected printer at the top. They are stored with every OK or apply. To create a new printer, just enter a new printer name and press apply. The new printer starts with the last settings selected.	
OK Annly Cancel	

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





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

Repetier-Host	: V0.95F		CONTRACTOR OF CONTRACTOR	- Allern				_ 0 _ ×
File View	Config Tomporatura Drintor To Language Printer Settings C	Ctrl+P	۲	۲			\$\$°	Ó
Connect L	Firmware EEPROM Configuration	Alt+E ggle Log	Show Filament	Show Travel			Printer Settings	Emergency Stop
3D Viev Tem	3D View Configuration A	Alt+V			Object Placement	Slicer G-Code Edit	or Manual Contro	L
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Show in Log:	●Commands ●Infos ●Warnings	OErrors OACK	OAuto Scrol	1 m Clear Log	@ Copy			
17:55:18.584 Op	enGL renderer: Intel (R) HD Graphics Fa	amily						*
17:55:18.584 Us	ing fast VBOs for rendering is possib	ble						*
Disconnected -	Idle	300 FPS					<b>9</b> 🕈	J 🤊 📼 🐁 🕇 🗡
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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)

Marlin Firmware EEPROM Settings	Printer	1.00					
Steps per mm: X:	100.00	Υ:	100.00	] 2:	1600.00	E:	100.00
Maximum feedrates [mm/s]: X:	500.00	Υ:	500.00	Z:	2.00	E:	25.00
Maximum Acceleration [mm/s <sup>2</sup> X:	800	Υ:	800	Ζ:	100	E:	2000
Acceleration:	1000.00						
Retract Acceleration:	1000.00						
PID settings: P:	22.20	I:	1.08	D:	114.00		
Homing Offset: X:	0.00	Υ:	0.00	Ζ:	0.00		
Advanced Variables:							
Min feedrate [mm/s]	0.00		Maxin	ռատ Հ	K-Y jerk [mi	m/s]	20.00
Min travel feedrate [mm/s]	0.00		Maxin	ռատ 2	Z jerk [mm/:	s]	0.40
Minimum segment time [ms]	20000						
Reload Config Rest	ore factory	y se	ttings	Sav	re to EEPROM	1	Cancel

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.

Heat Extruder	Heat Printbed
Extruder 1 V 200° C / 200 文	Temp. 200°C/ 55 🚖
Speed [mm/min] 100 🚊	Fan
Extrude [mm]	Fan Output 50
Retract [mm]	0
Debug Options	

	Printbe	ed										
Ok, click the "		Heat Pr	rintbe	d	", if you	touch th	ne heat	ing pri	intbe	d an	d feel	the
rising of tem	perature	after a	little	while.	It shows	normal	work.	Next	we	can	click	the
Extruder												
Hea	at Extrud	er		to hea	t the extru	der until	over 1	50 deg	ree c	entig	rade.	

Show as below picture, it time to test the extruder.()

Speed [mm/min]	100 🚊	
Extrude [mm]	10 *	•
Retract [mm]	10 🔺	

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.

	Turn	Motor	Of
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:







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"



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

angle by the left toolbar.





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.

