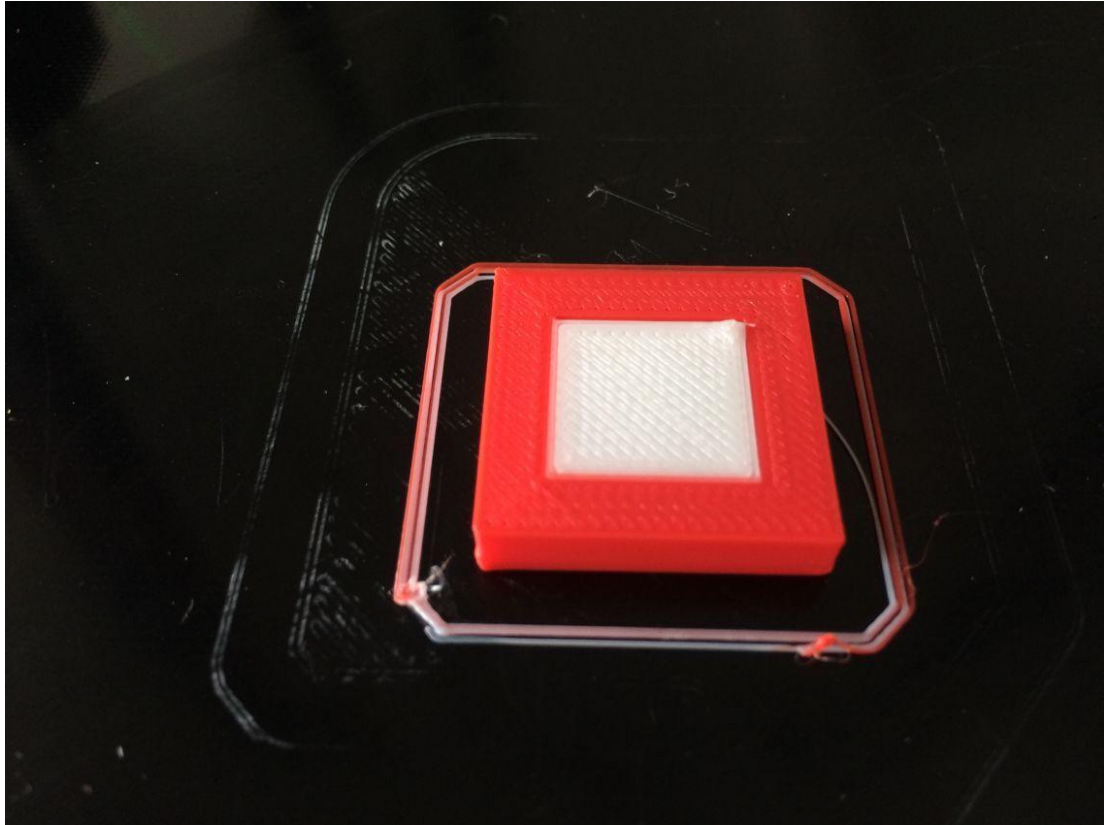
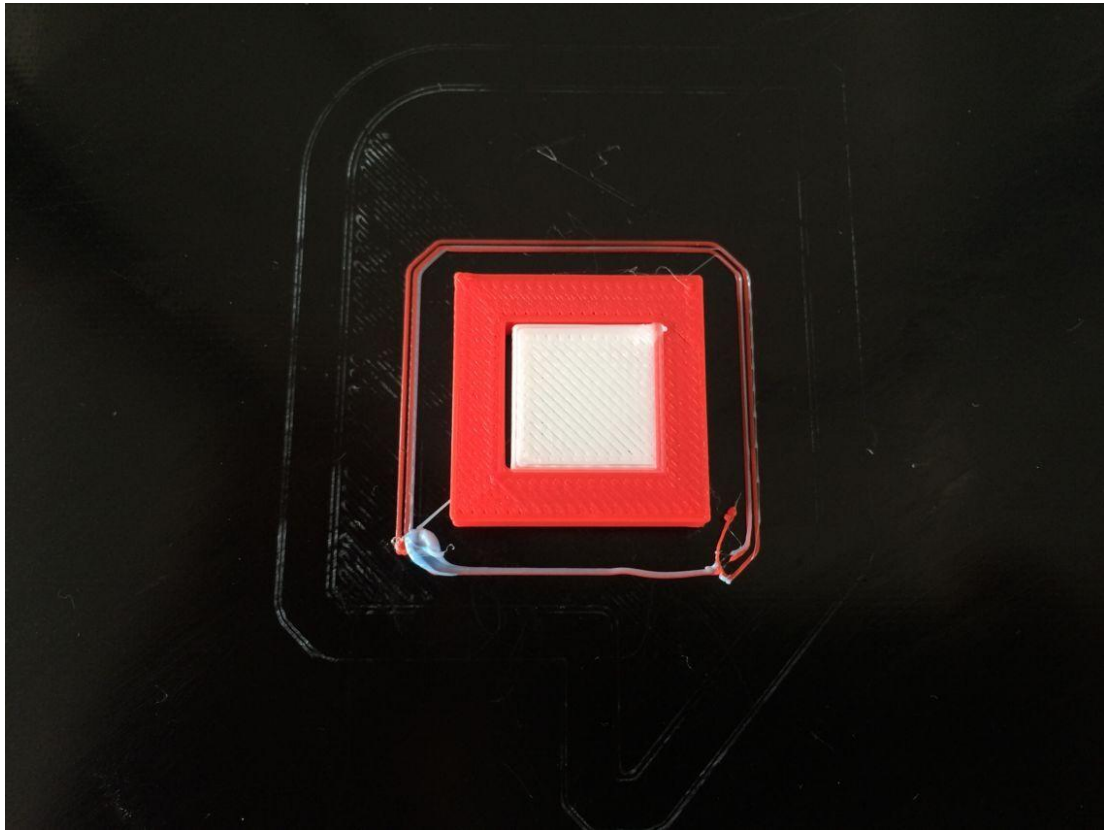


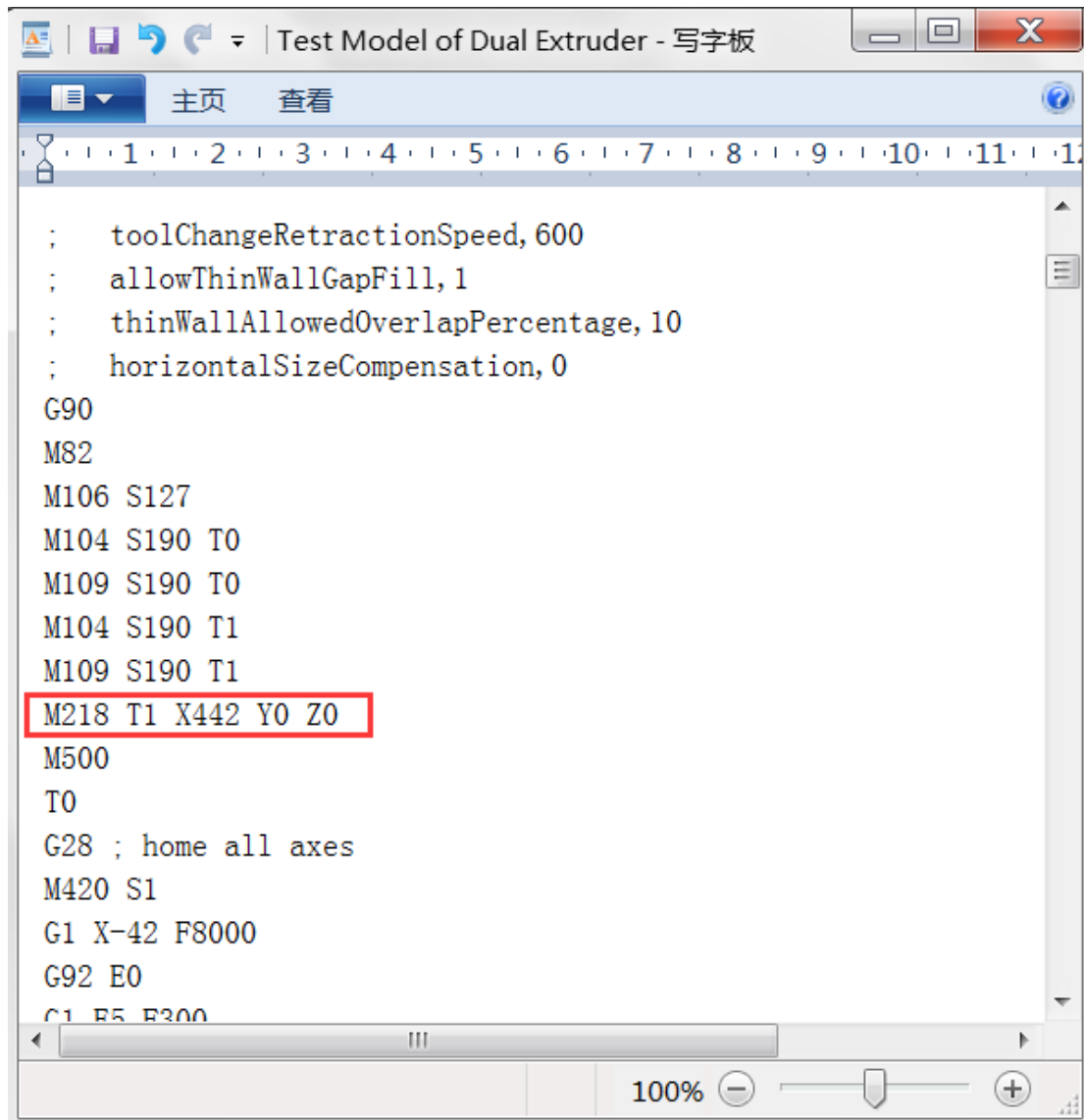
Please choose “test model of dual extruder” in SD card for printing, the best result should be as below: the white square is right in the middle of red square.



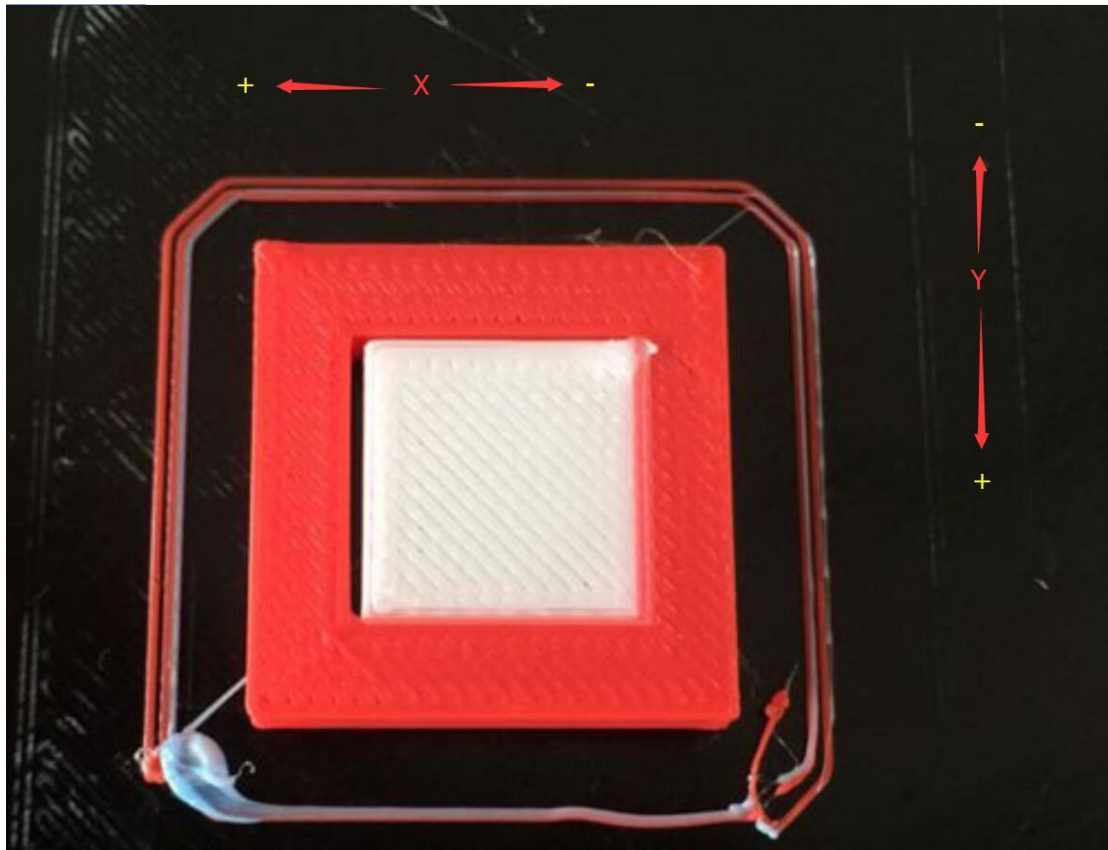
But if your printing result is as below, you need to adjust the XYZ offset of right extruder.



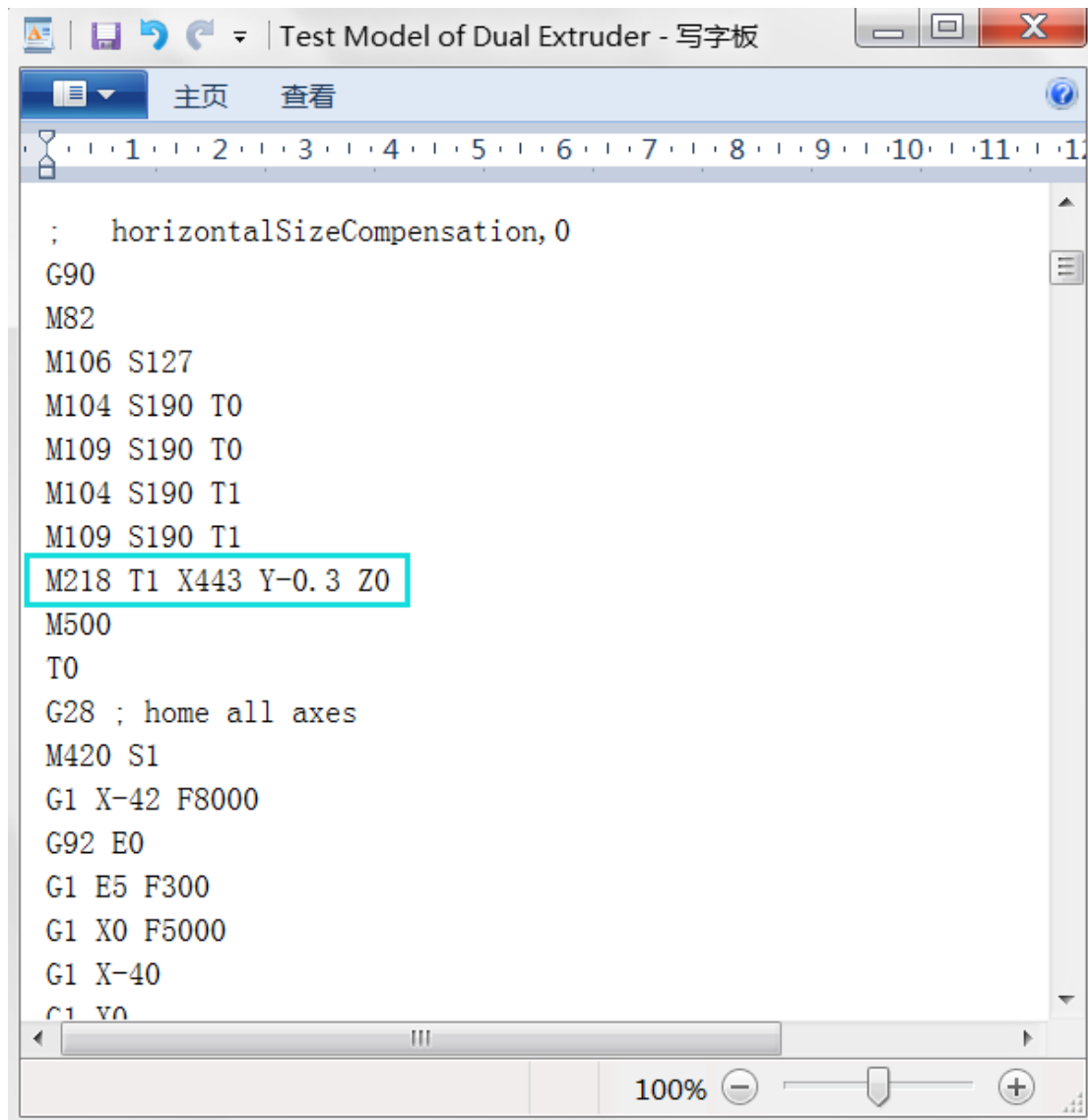
Please take out SD card from electrical box, and insert it into computer by card reader, then open “test model of dual extruder”, find the code marked in red.



Then measure the offset of test model by ruler, here X should be +1mm, Y should be -0.3mm.



Revise the value as below, then save the file for printing again.



```
; horizontalSizeCompensation, 0
G90
M82
M106 S127
M104 S190 T0
M109 S190 T0
M104 S190 T1
M109 S190 T1
M218 T1 X443 Y-0.3 Z0
M500
T0
G28 ; home all axes
M420 S1
G1 X-42 F8000
G92 E0
G1 E5 F300
G1 X0 F5000
G1 X-40
G1 Y0
```

As to Z offset of right extruder, if right extruder is higher 0.2mm than left extruder when printing first layer, please revise the Z offset of right extruder as 0.2, if right extruder is lower 0.2mm than left extruder when printing first layer, please revise the Z offset of right extruder as -0.2.

Note: you need to **store memory** by screen after calibrate dual extruder well.