T-Rex 2+ adopts latest Unified Bed Leveling, much more precise than ordinary mesh leveling. It probes 225 points on print bed, collect the data and store them in EEPROM. The whole process takes 20 minutes around, but you only need to execute it once before first printing.

1. Set Z Offset

Choose “Prepare” -> “Auto home”

Now you can see the Z axis coordinate, please remember that value as Z1.

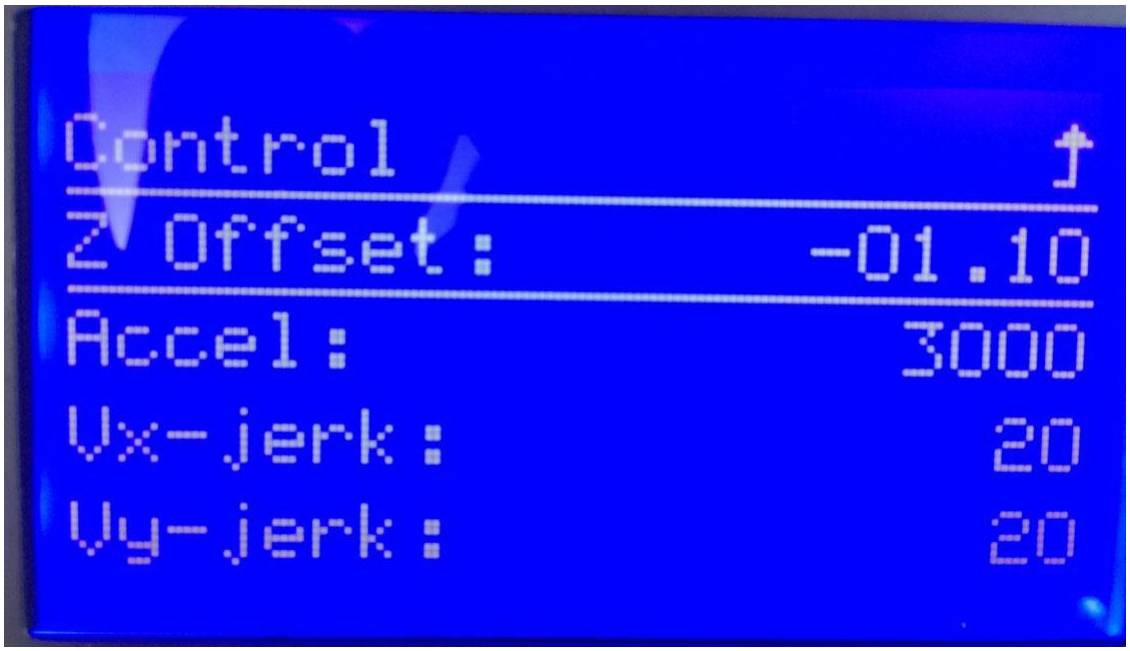
Then choose “Prepare” -> “Move axis” -> “Move Z” -> “Move 0.1mm”.

Put an A4 paper between nozzle and bed, rotate knob anticlockwise to move down Z axis until it only can pass through one paper.

Then you can see the current Z axis coordinate, remember that value as Z2.

Finally calculate the Z offset by below formula:
Z offset = -(Z1-5-Z2) 5 is a safety value for Z axis lift up
So here Z offset should be -(6.2-5-0.1)=-1.1

Then choose “Control” -> “Motion” -> “Z Offset”, set the Z offset as the value you calculated by above formula.



And save the Z offset by choose “Control” -> “Store memory”.

If it’s saved successfully, you’ll hear a beep sound. After restart printer, the Z offset will be still the one you set.

Then choose “Move axis” -> “Move Z” -> “Move 1mm”, and lift up Z axis 5mm around by rotate knob clockwise.

2. Unified Bed Leveling

Insert SD card to electrical box.

Choose “UBL” file from SD card, then it’ll execute unified bed leveling automatically.
The whole process takes 20 minutes around, then there will be a beep sound to indicate leveling finished, and one more beep sound to indicate data saved successfully.

Finally, save the UBL data into EEPROM by choose “Control” -> “Store memory”.

Now you can start to print formally. Congratulations!