Quick Start Guide

1. Plug printer in and switch it on. Your Graphical display should be lit up.

2. Make sure that your bed is reasonably levelled (the springs should all be compressed to 1cm). You also need to ensure your Inductive sensor is fixed tightly so that it sits +- 1mm higher than the tip of your nozzle. If this is not set correctly, your nozzle could crash into the bed.

3. Navigate to ***PREPARE / AUTOHOME*** on the LCD panel. All three axes should home and the auto-level probe should rest in the middle of the bed (Nozzle about 1cm away from the bed surface)

4. Make sure your SD card is inserted into the left of the LCD panel. Navigate to ***SD CARD / Maintenance Files / PID Tune*** and select "**Bed@80.gcode**" , this will perform a Bed PID tune. After this do a " **Hot End@250** " PID tune.

5. Next up is using the Unified Bed Levelling file, which is located in *SD* ***CARD / Maintenance Files / Bed Levelling / Bed Levelling ABS.*** Run this file to probe the bed surface and store UBL compensation. If you are not happy with the Bed level after this you may navigate to Unified Bed Levelling options using your Graphical LCD display, follow the prompts and finetune these probe points heights.

6. Navigate to ***PREPARE / PRE-HEAT PLA*** (or ABS depending on the filament you are using). Make sure that the Hotend and Bed heat up to temperature

7. Now it is time to test print - Navigate to *SD CARD* and select "**TestPrintPLA** or **TestPrintABS**".

   Your Bed and Hotend will now heat up to their respective temperatures and the print will start. Now is the important part – Get ready 'Babystep' your hotend for the perfect first layer.

   Once the print starts, double click the LCD rotary dial to enable 'baby stepping'. Here you can rotate the dial clockwise and anti-clockwise to lower or raise the Z axis (extruder). Tweak until you have a perfect first layer. Take note of this baby stepping number.

   To store this offset permanently, navigate to: ***Control / Motion / Z-offset*** , input the baby-stepping offset here and click. Go back to ***Control*** and click '**Store Settings**'

   Your first layer offset should now be set and you are ready for printing!