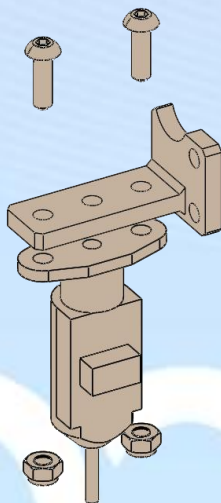


Neptune2&2D&2S Automatic leveling tutorial

一、First :print the“Auto_Leveling_bracket.STL”.



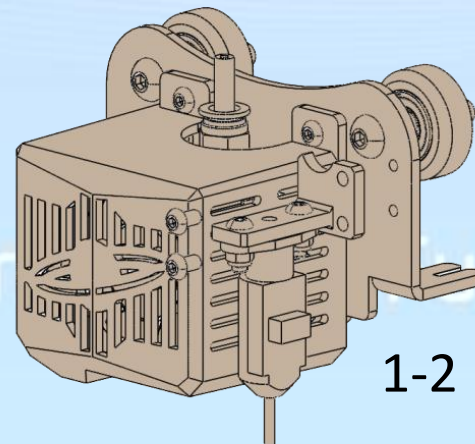
二、Auto_Leveling Installation instruction.



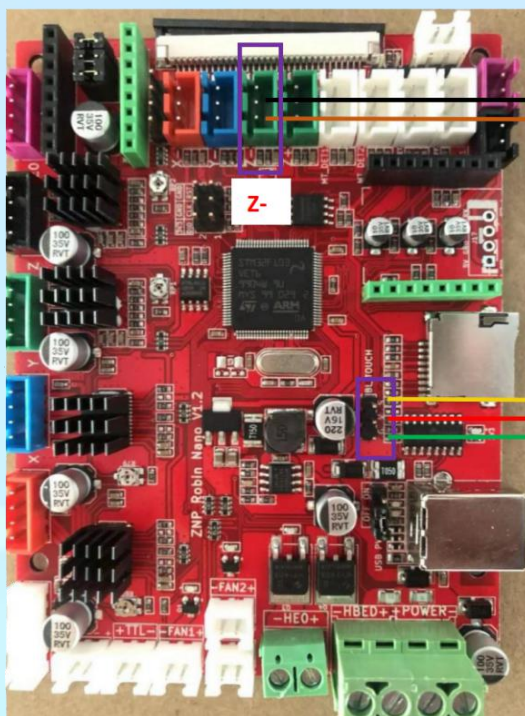
1-1

1. Fix the Auto_Leveling part on the bracket using screw M3*10 and M3 screw nut. (You can refer to the picture 1-1.)
2. Fix the well-assembled Auto_Leveling on the right of the hotend. Like the Picture 1-2.
3. Following the picture 1-3 to connect all cables.

(Note: After you install the Auto_Leveling, it's necessary to disassemble the Z axis end-stop sensor.)



1-2



1-3

三、Adjust the machine configuration

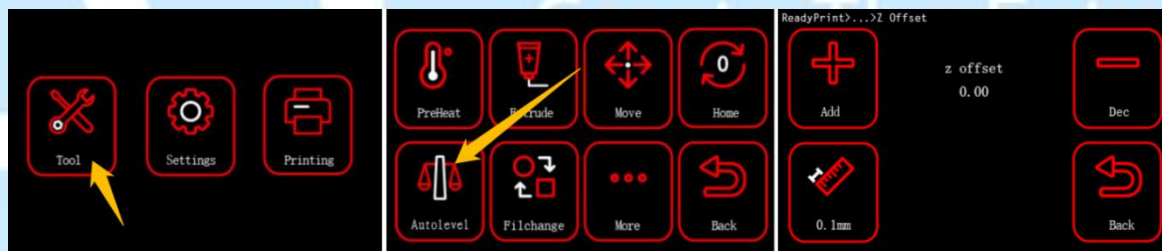
1. Select the firmware of your machine referring to the "Neptune2&2D&2S Firmware Update Notes", then move the configuration file "elegoo.txt" to TF card.
2. Open the configuration file "elegoo.txt", search for the following content and modify the following values.

- | | | |
|---|-----------------------|-----|
| ① | >cfg_leveling_mode | 0→1 |
| ② | >BED_LEVELING_METHOD | 0→3 |
| ③ | >Z_SAFE_HOMING | 0→1 |
| ④ | >Z_MIN_PROBE_PIN_MODE | 0→1 |

3. Save the document after the modification, insert the TF card into the printer then reboot the machine.

四、How to use the auto_leveling

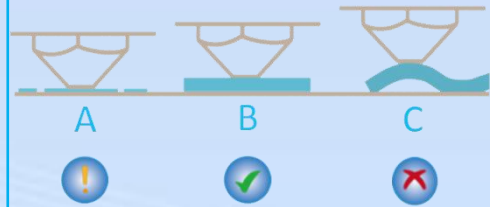
When using automatic leveling, the optimum distance between the nozzle and the heatbed is 0.2mm-0.3mm. When leveling, you need to prepare a half-folded A4 paper to assist in leveling.



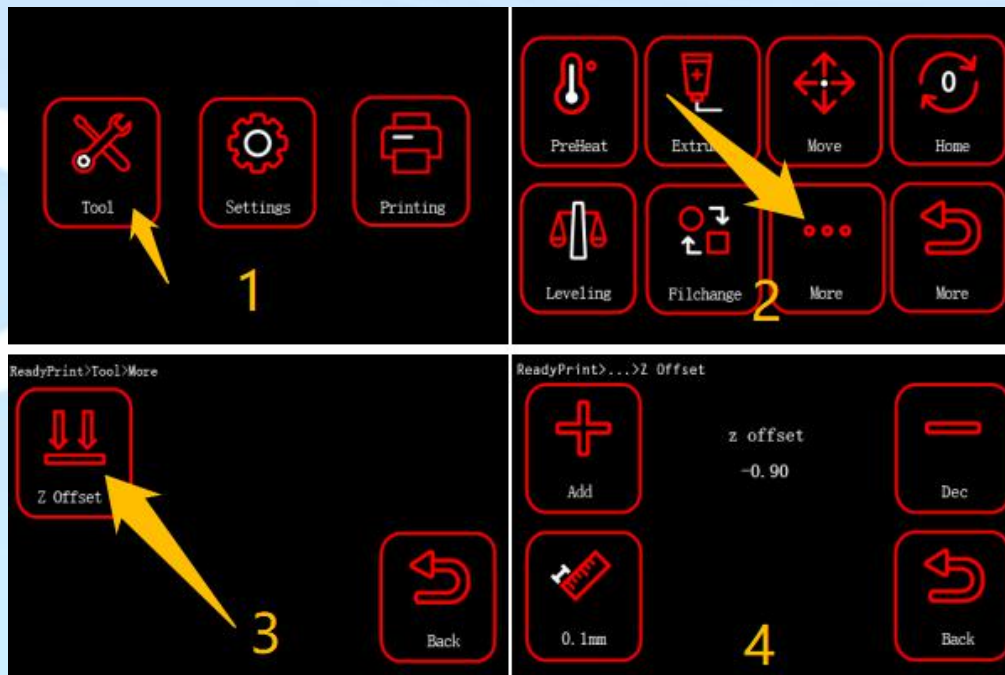
1. First make sure that all the cables are connected, then turn on the printer.
2. Click **【Tool】** in the home page, enter the tool interface and select the **【Autolevel】** icon, the sensor will select 16 coordinate points on the heatbed to test the height value.
3. After all the points are measured, the sensor returns to the middle of heatbed and then put a piece of A4 paper between the nozzle and the heatbed. Adjust the height of the nozzle on the **【Z-Offset】** interface (Click **Z-**, the nozzle will drop, on the contrary, the nozzle rises).
4. Adjust the height several times until the nozzle just touches the A4 paper and the paper can move smoothly.
5. Click **【Back】**, and then select the model to start print.

Tip:

When you print the test model, please observe the printing status of the first layer. If the first layer looks like A and C, which indicate that the Z height is not well compensated, and the Z axis compensation value needs to be reset. If the layer looks like B, it proves that you have set the proper Z axis height, which is the optimum distance between the nozzle and the plate.



If the status "A "or "C " appears, you can regulate the "z_offset" again following the below steps . There is no need to clicking 【Autolevel】 again . All you need to do is to click 【Back】 to save the "z_offset" after you complete the adjustment process . (The "z_offset" will only work after the auto-leveling is turned on).



Notice:

After you use the automatic leveling and reset the Z offset, there is no need to add G29 command to the beginning of the G-code file. Because the manual grid leveling will be automatically written into the **EEPROM** of the motherboard. You can simply use ELEGOO_Cura software for normal slicing.