* To disable redundant "Not SD printing" commands:
  + M27 S0
* Launch a Nozzle PID in a terminal:
  + M303 E0 S220 C8
  + Retrieve the values Kp, Ki and Kd then:
  + M301 P**Kp** I**Ki** D**Kd**
  + Then M500 to save.
* Launch a Bed PID in a terminal:
  + M303 E-1 S90 C8
  + Retrieve the values Kp, Ki and Kd then:
  + M304 P**Kp** I**Ki** D**Kd**
  + Then M500 to save.
* Launch an extruder calibration in a terminal:
  + Heat your hotend to its usual operating temperature :
  + M109 S**xxx** where xxx is temperature
  + Make a pencil mark at 120mm on the filament from the hole on the top of the printer (where we insert the filament)
  + M83 to switch to relative mode.
  + G1 E100 F100 for extruding 100mm.
  + Wait until the end of the extrusion and measure if there is still 20mm of the line on the filament until the filament inlet otherwise apply this calculation:
    - To obtain extrusion length: 120 - (value measured between the line and the filament inlet)
    - To obtain number of steps to have extruded 100mm: (value of E-steps/mm) x 100. Default E-Steps value is 415.
    - To obtain the new E-steps/mm: (number of steps to have extruded 100mm) / (extrusion length)
  + M92 E**(new E-steps/mm)**
  + Then M500 to save.
* Launch a Delta Calibration a wait until end of process :
  + **Make sure to connect bed level probe before to start the following command**.
  + G33
  + Then M500 to save.
* Start auto-leveling from the TFT screen menu and adjust Z-Offset. Don't forget to save.
* Perform a full format of your SD card (not a quick format) to avoid problems afterwards.
* If you want more precision or solve dimension problems, follow the instructions in this Excel file: [Delta Calibration Calculator.zip](https://github.com/Guilouz/Marlin-SuperRacer-MKS-Nano-V3/files/8146727/Delta.Calibration.Calculator.zip)

Link for a terminal: [Printrun (ex Pronterface)](https://github.com/kliment/Printrun/releases)