T-Rex 3.0 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 15 minutes around, but you only need to execute it once before first printing.

1. Set Z Offset

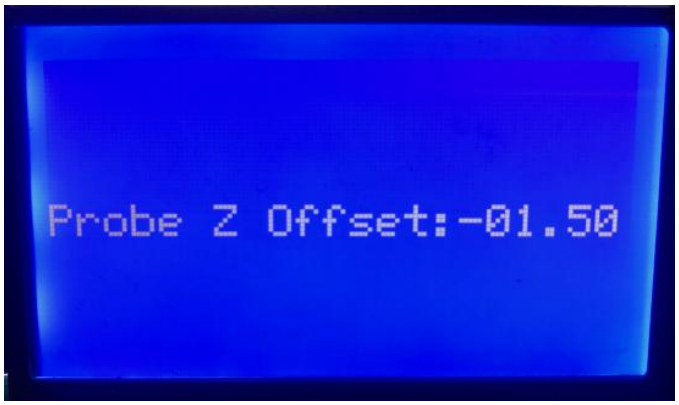
Choose “Motion” -> “Auto home”

Then choose “Motion” -> “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 can pass through ONLY one paper.

Then you can see the current Z axis coordinate, remember this value as Z1.

Then choose “Configuration” -> “Advanced Settings” -> “Probe Z Offset”, remember this value as Z2.

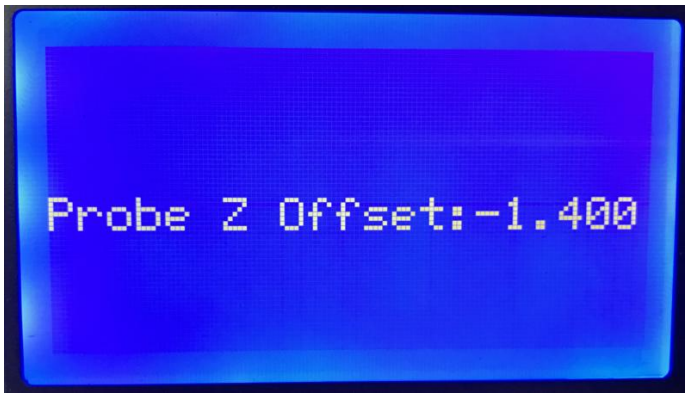


Finally calculate new Z offset by below formula:

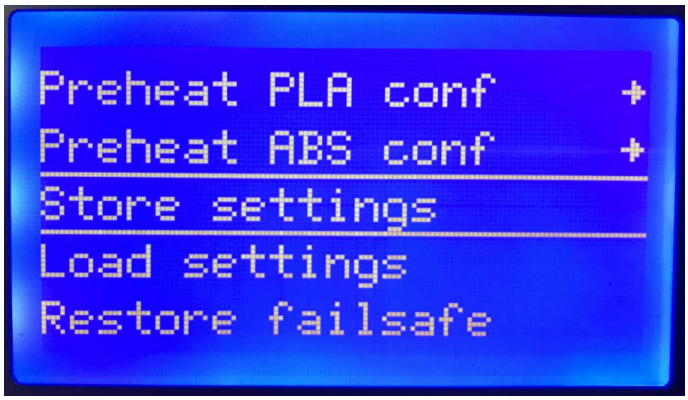
Z offset = Z1+Z2

So here Z offset should be -1.5+0.1=-1.4

Then update the Z offset as the value you calculated by above formula.



And save the new Z offset by choose “Configuration” -> “Store settings”.

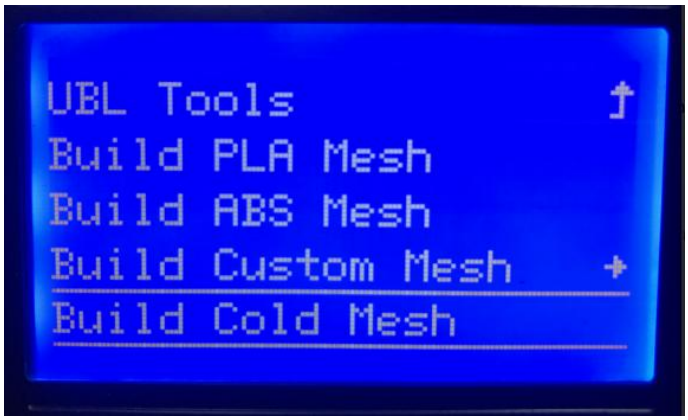


If it’s saved successfully, you’ll hear a beep sound.

then choose “Motion” -> “Auto home” again to keep safe distance between nozzle and bed.

2. Unified Bed Leveling

Choose "Motion" -> "Unified Bed Leveling" -> "UBL Tools" -> "Build Mesh" -> "Build Cold Mesh", then it'll execute unified bed leveling automatically.



The whole process takes 15 minutes around, then there will be a beep sound to indicate leveling finished.

Finally, save the UBL data into EEPROM by choose "Configuration" -> "Store settings".