

# Debug and Print

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**thank you for your kind support to choose our product!**

**when you use the printer,meet some problems, pls contact us.**

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**Other email:rose@flsund3d.com**

**Technical Support skype 1:wangbo5111**

**Technical Support skype 2:oldjiawei Yin**

**whatsapp :008613183017642**

**1,If you are satisfied with Cube 3d printer kits,please leave a positive feedback to us,thank you so much for your kindness.**

**2,If you are not satisfied for any reason,please contact us before leaving a negative feedback(any negative review no longer be changed again),we will work together with you to help you solve any problem until you are satisfied.**

## Important Note

A,when use switch power supply,If your country AC voltage is 220V,pls choose 220V;if it's110V,pls choose 110V,there is one adjust button on the switch power supply.

B, when heating the nozzle or printing,for the fan which cooling heat sink,guarantee it working,if not,pls stop heating and printing.

C,the temperature is a important parameter, for PLA filament, the working temperature is 200°C-210°C, you could adjust it,and the temperature should not too high.too high temperature maybe lead to Nozzle clogging.

D,Before printing, please paste high temperature tape on the hot bed

E,If you have installed the touch screen ,pls choose PC or touch screen to make a Single control

F,If you need to upload marlin ,when you upload ,pls disconnect the touch screen with the motherboard

# 1 Connect and Software

## 1 Software Introduction

Need software as follows:

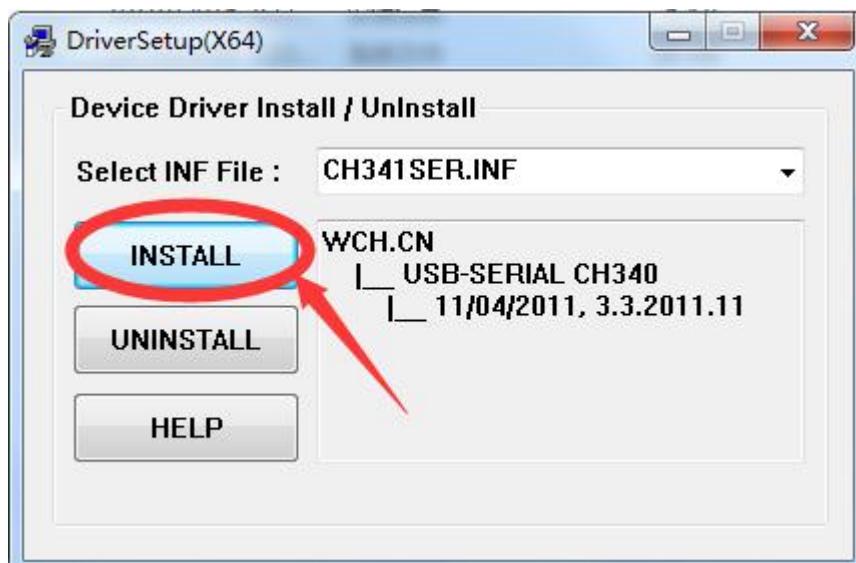
A:**arduino**,it's the firmware working environment.

B:**Marlin**,it's the firmware,it's program to run printer working,need flash firmware to motherboard.

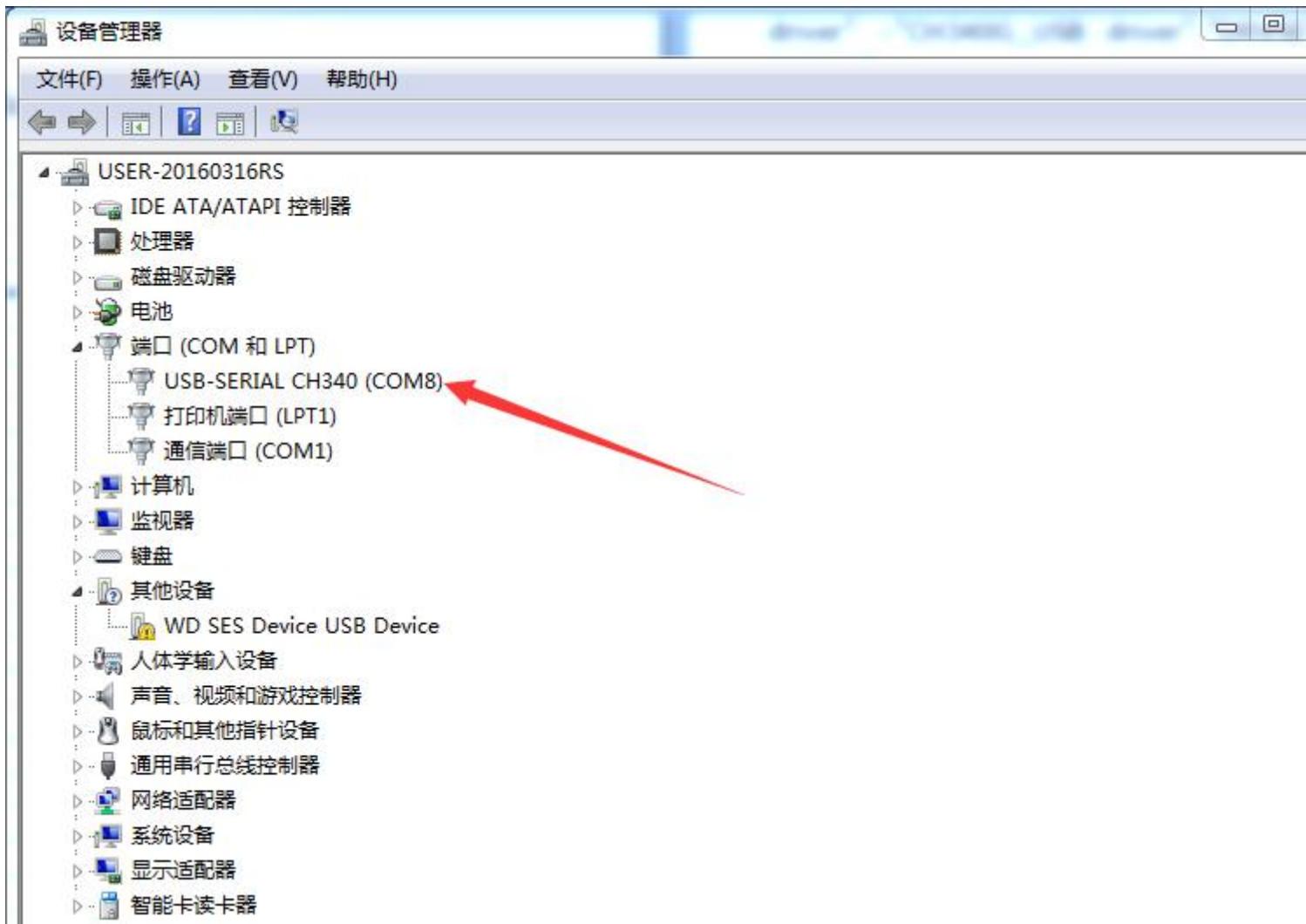
C:**RepetierHost**,it's also PC software,can control the printer,can slice the model, when printing,it's good to use.

## 2 Connect printer to PC

Install the driver. copy the file in the sd card to PC. open the file " CH340G\_USB toTTL driver"-“CH340G\_USB driver”-“DRVSETUP64”(64-bit system) or “SETUP”\*(64-bit system).



Check Device Manager, will find the hardware



If the PC can not find the hardware.pls check out the file “Solve streamline Version Windows 7,Can not install d river issue”.do as the file show.

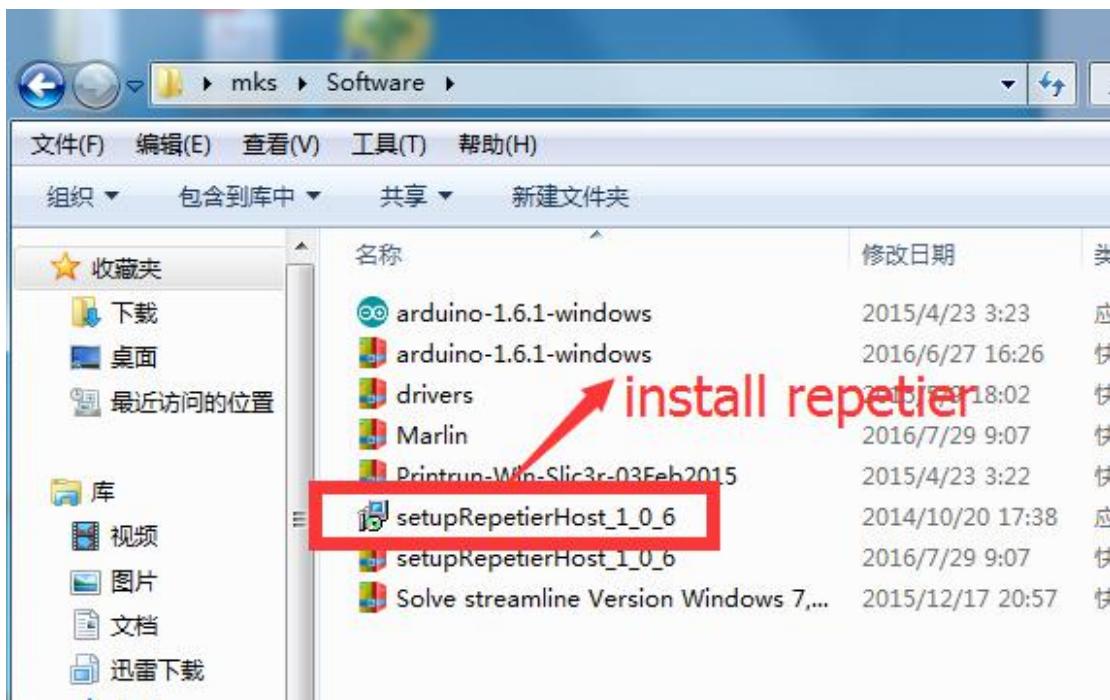
### 3 Repetier and control printer

#### 1 Software Installation

The repetier is software to control the printer,so need install it first.

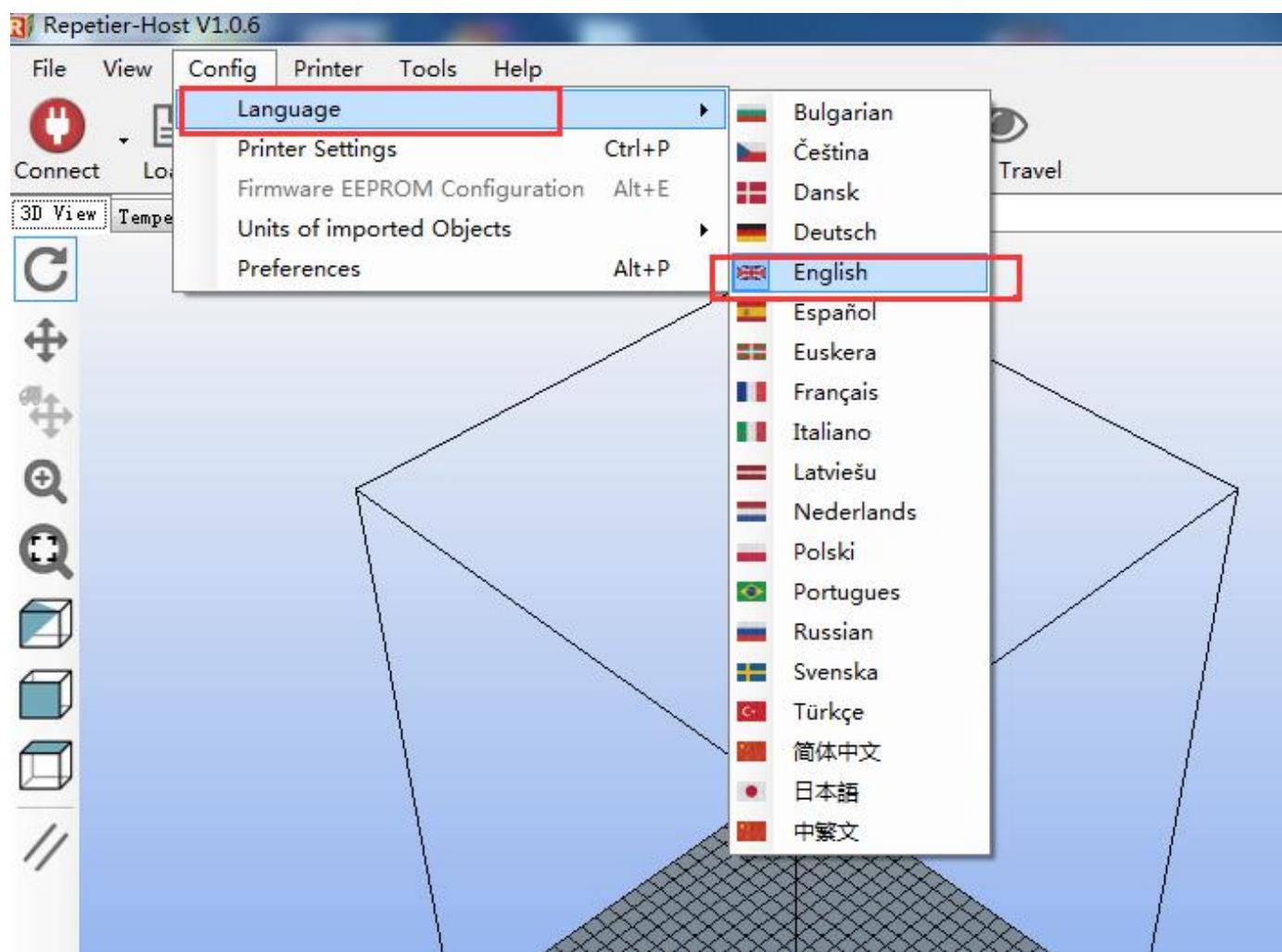
Install the “software,setupRepetierHost\_1\_0\_6”, the software could be download on the link:<http://www.repetier.com/download/>

About the more info about the Repetier, pls go the the link :  
<http://www.repetier.com/documentation/repetier-host/>

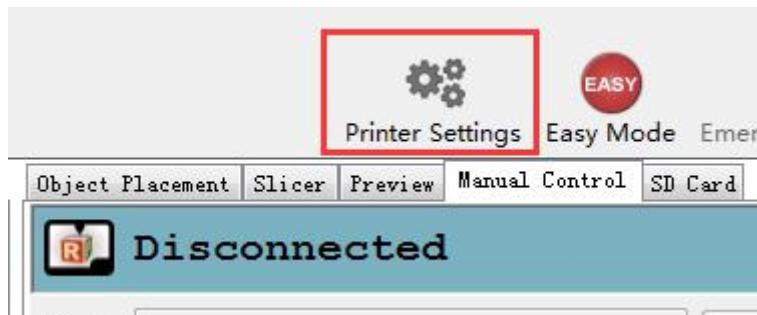


## 2 Language Settings

Set the language, Config-Language-choose the suit language.



### 3 Printer settings



Printer Settings

Printer: default

Connection Printer Extruder Printer Shape Advanced

Connector: Serial Connection

Port: COM11 (highlighted with a red box and arrow pointing to it)

Baud Rate: 250000

Transfer Protocol: Autodetect

Reset on Connect: DTR low->high->low

Reset on Emergency: Send emergency command and reconnect

Receive Cache Size: 127

Use Ping-Pong Communication (Send only after ok)

The printer settings always correspond to the selected printer at the top. They are stored with every OK or apply. To create a new printer, just enter a new printer name and press apply. The new printer starts with the last settings selected.

IN the printer shape,choose the Classic printer,the home X is 0,the home Y is 0,the home Z is 0.the setting as the follow pictue.

Printer Settings

Printer: default

Connection Printer Extruder Printer Shape Advanced

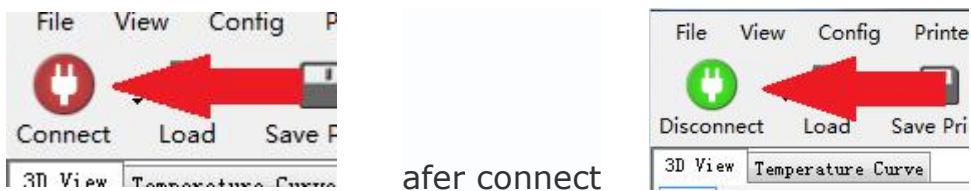
Printer Type: Classic Printer

Home X: 0 Home Y: 0 Home Z: 0

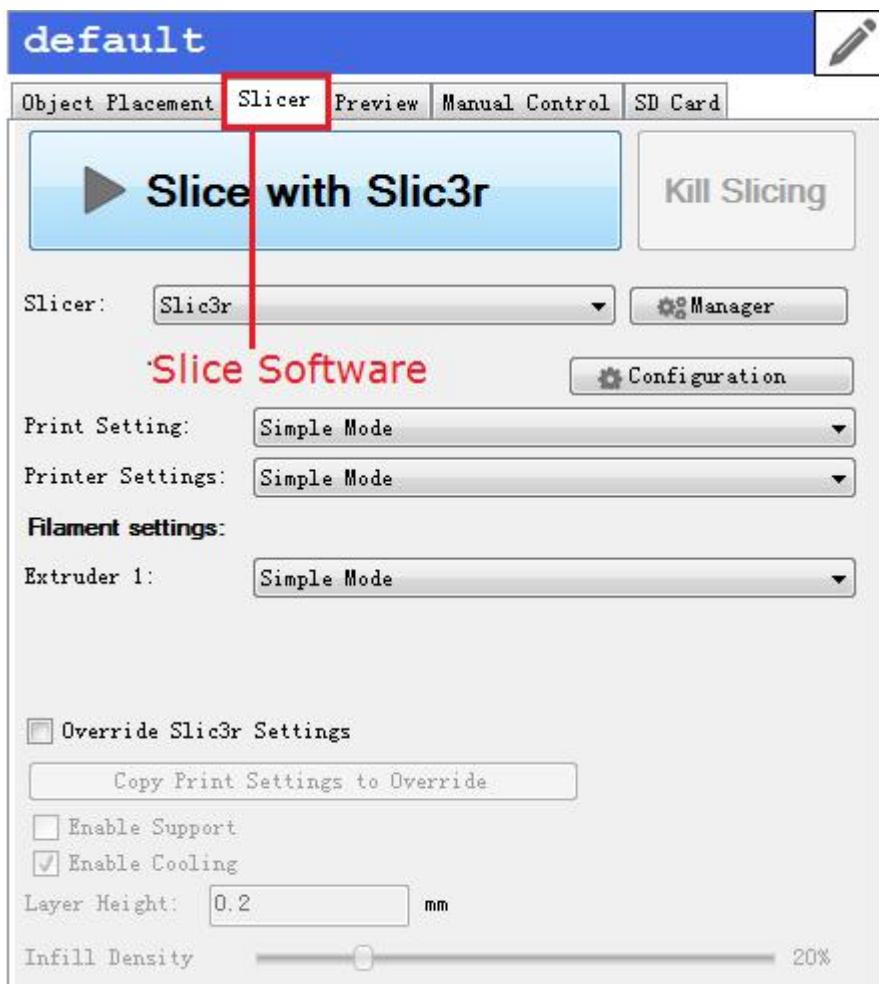
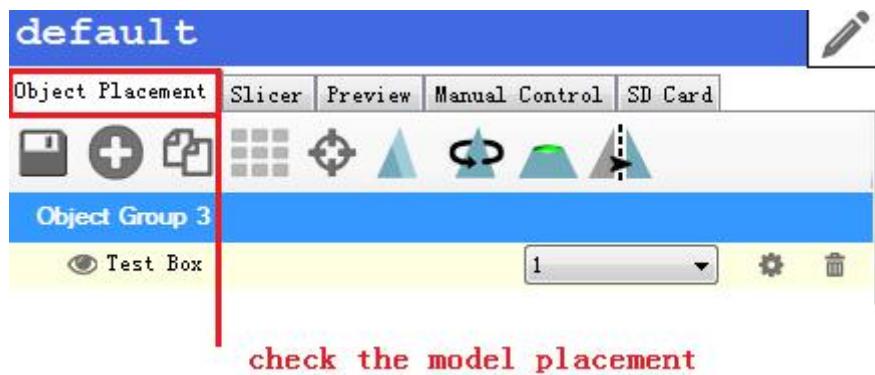
X Min: 0 X Max: 260 Bed Left: 0  
Y Min: 0 Y Max: 260 Bed Front: 0

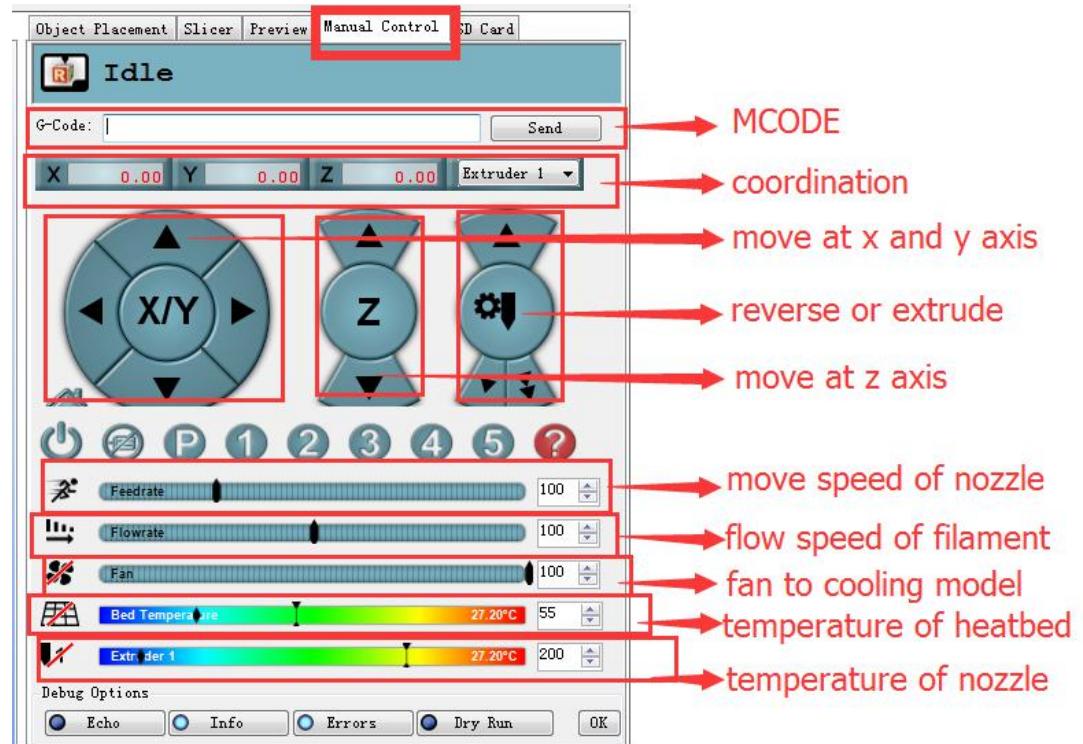
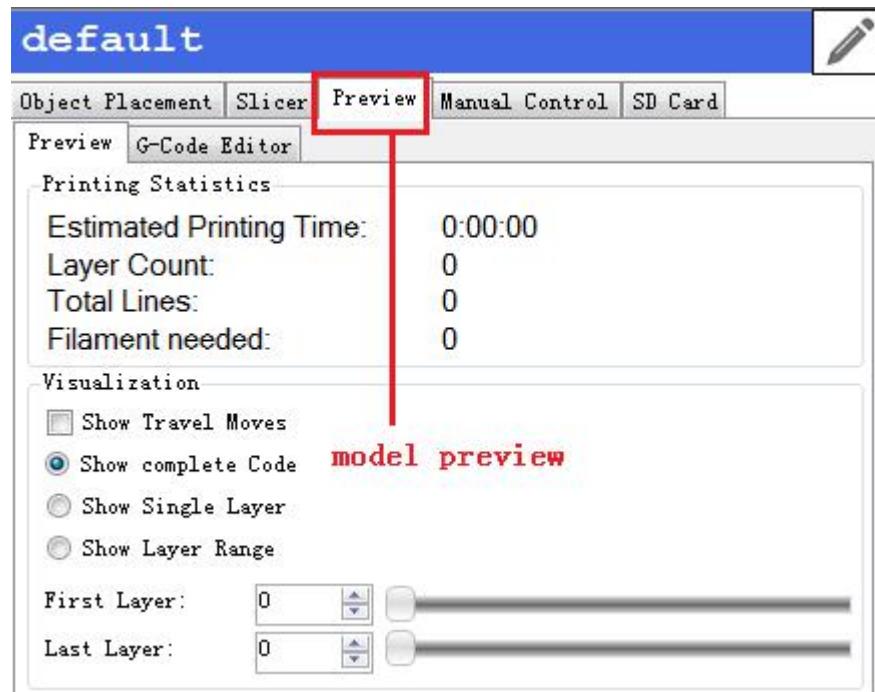
Print Area Width: 260 mm  
Print Area Depth: 260 mm  
Print Area Height: 350 mm

## 4 Connect the printer



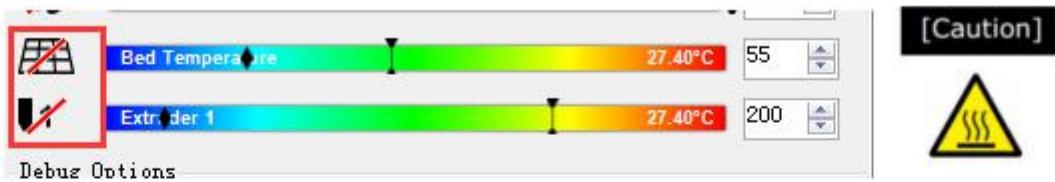
## 5 Panel Introduction





home function same to G28

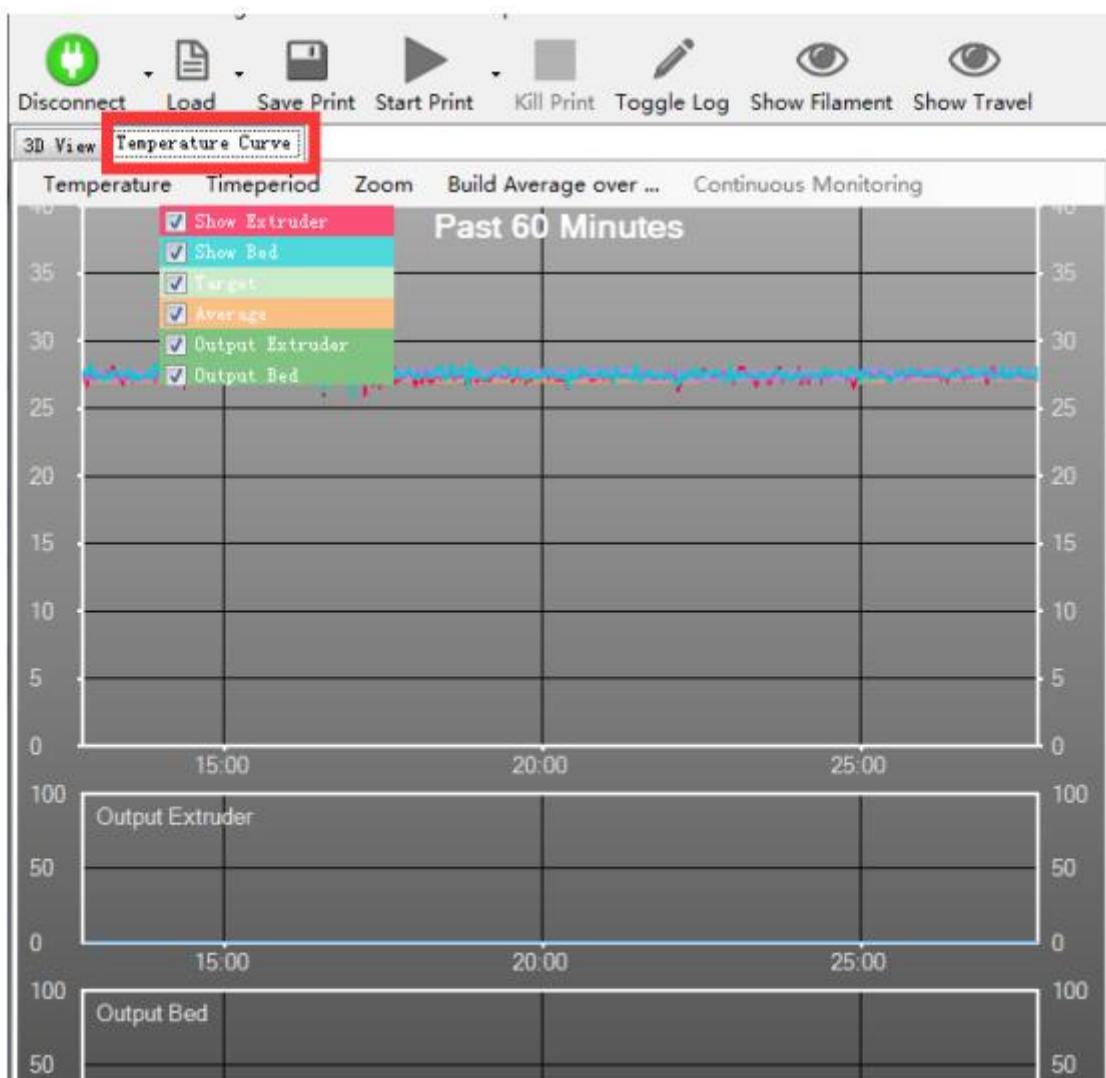
>> Preheat hotend and bed



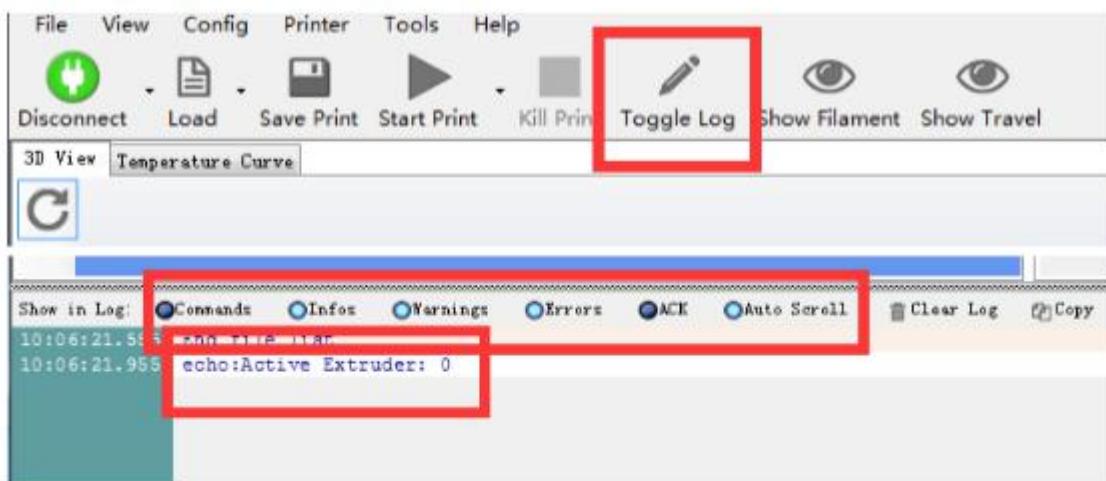
Check from there (bottom of repetier)



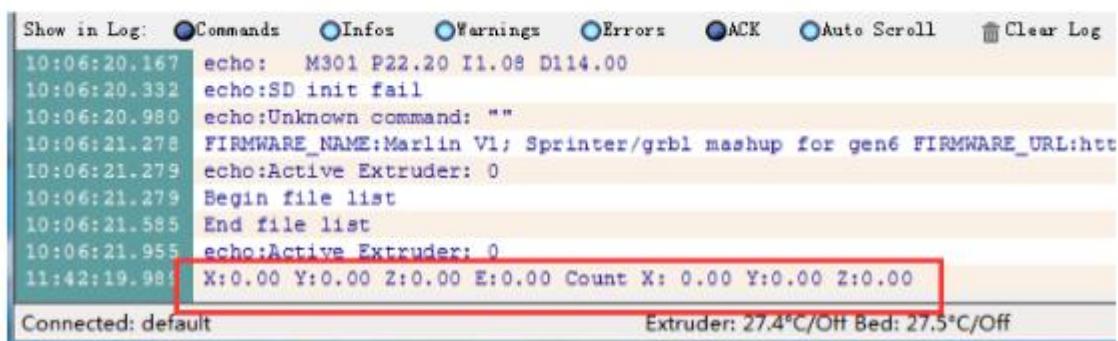
Temperature curve



>>Info of operation, Check at the bottom



>> Info of coordination ,send m114 then check at the bottom

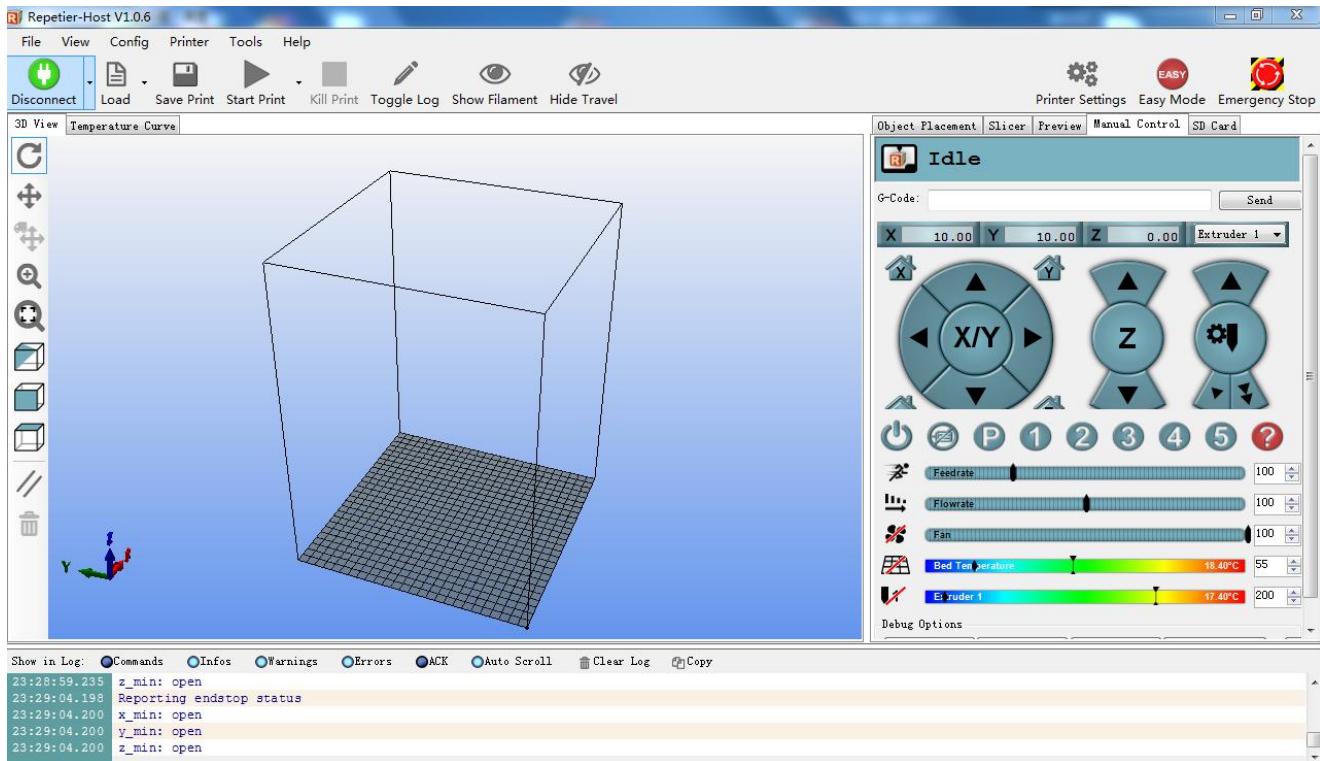


>>Info of limit switch, send m119 then check at the bottom

```
09:34:54.446 Reporting endstop status
09:34:54.448 x_min: open
09:34:54.448 y_min: open
09:34:54.448 z_min: open
09:34:54.448 z_max: closed
```

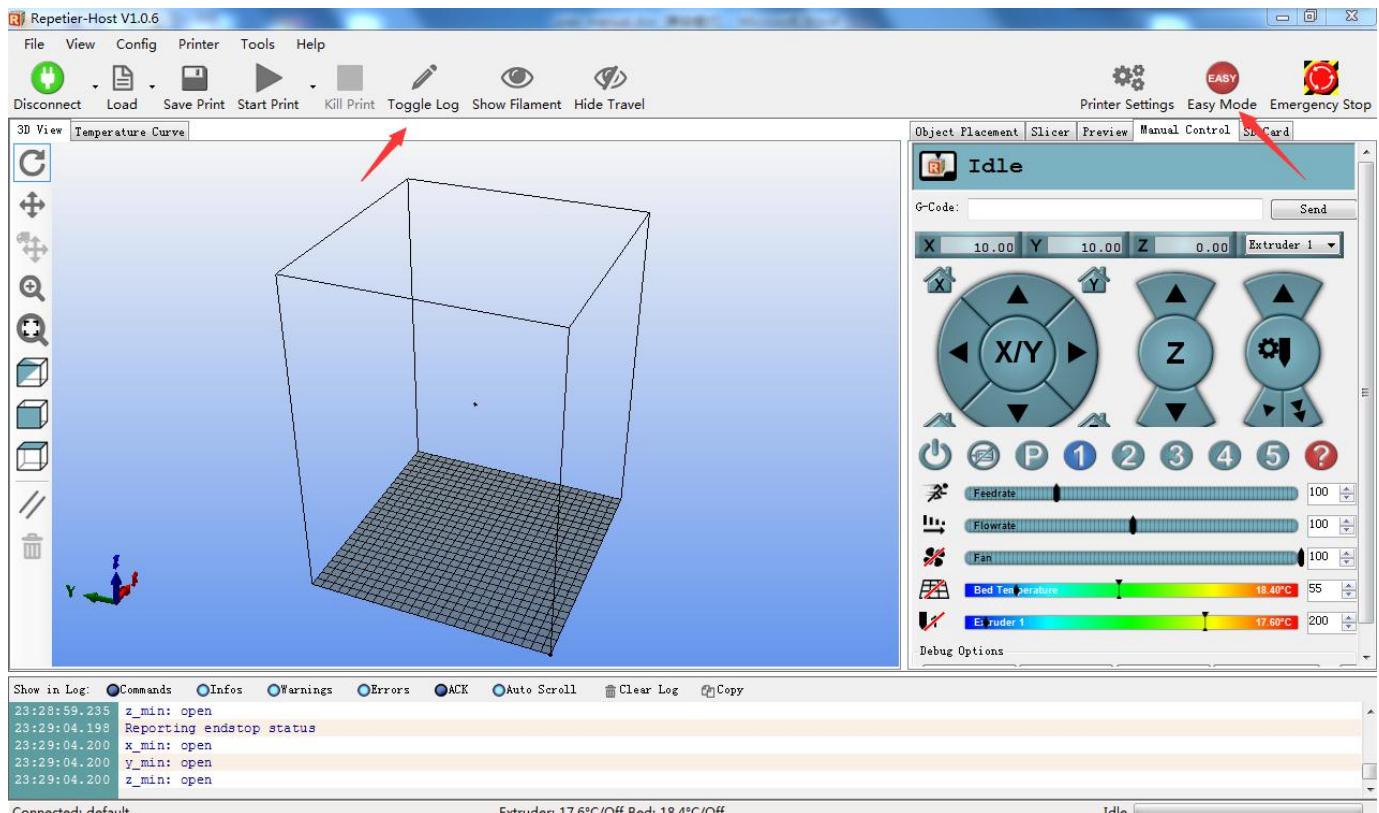
## 6 some important command

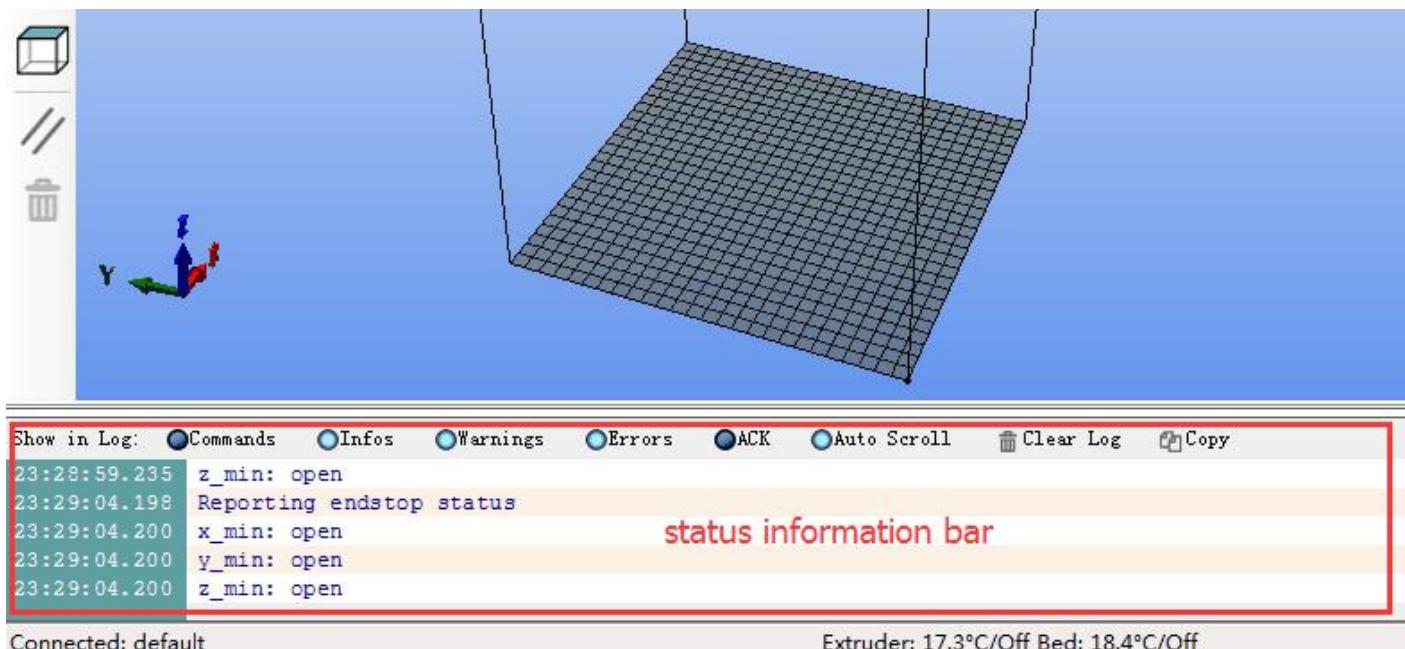
Controling the printer by repetier,after opening repetier,choose right port and click connect. The repetier interface is like this



open “command bar” where we can input command. **Click Easy Mode open command bar**, can input command in command bar.

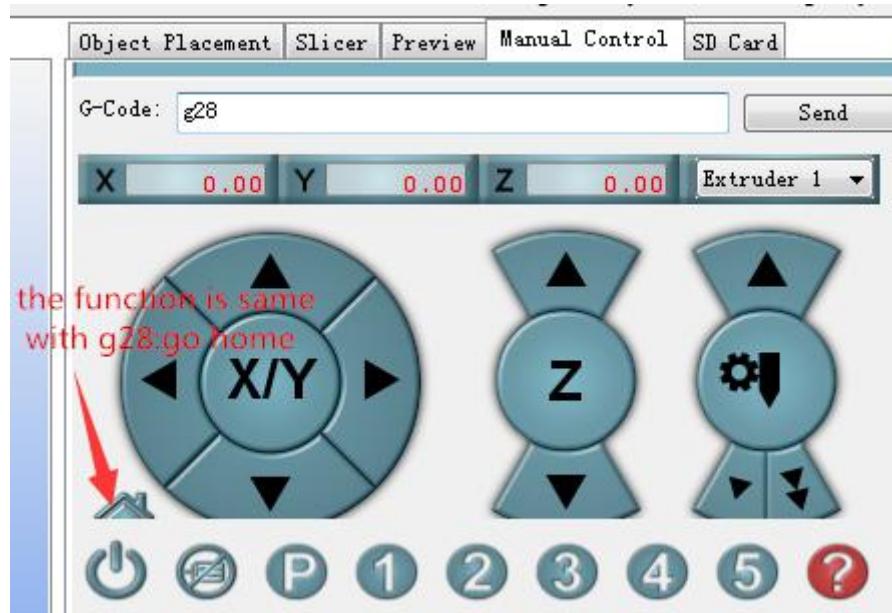
Then **click Toggle Log**, The information bar appears below the repetier interface. can read info about printer in information bar.





### (1) g28----all axis go home

In the repetier letters are case-insensitive, G28 also can be used.but in simplify3D,only can use capital letters .The other command is the same



Send g28,in delta 3D printer all axis rise and hit limit switch ,then stop at the highest position.



G28 is same to this icon

### (2) m114----check the current coordinates of the nozzle

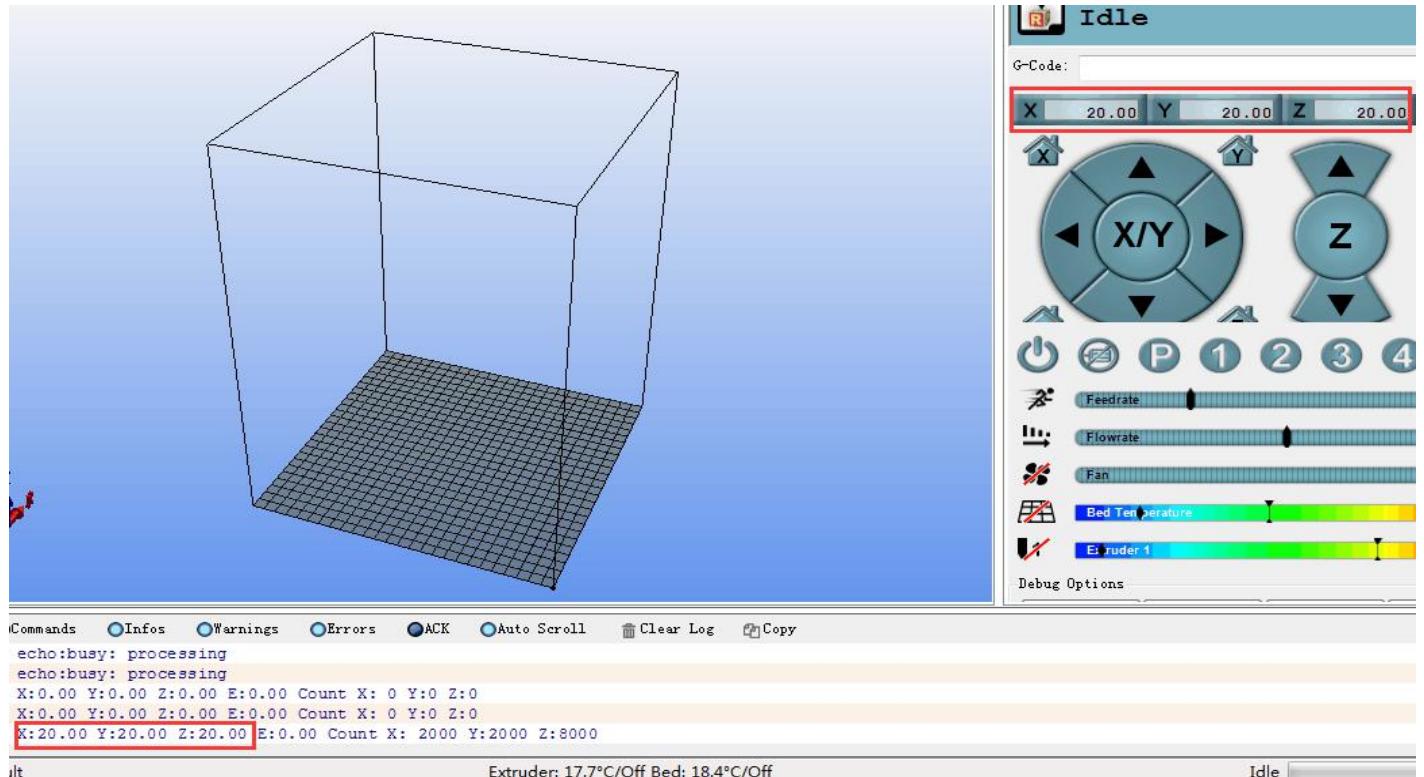
input m114 and send ,can see the current coordinates of the nozzle in information bar.

### (3) g1 x\_ y\_ z\_----move nozzle to targeted coordinate

For example ,input g1 x20 y20 z20,the nozzle will go to coordinate x y z(20 20 20)



After we send this command ,we can view coordinate of nozzle now.



It's ok to move only one or two axis

Eg:

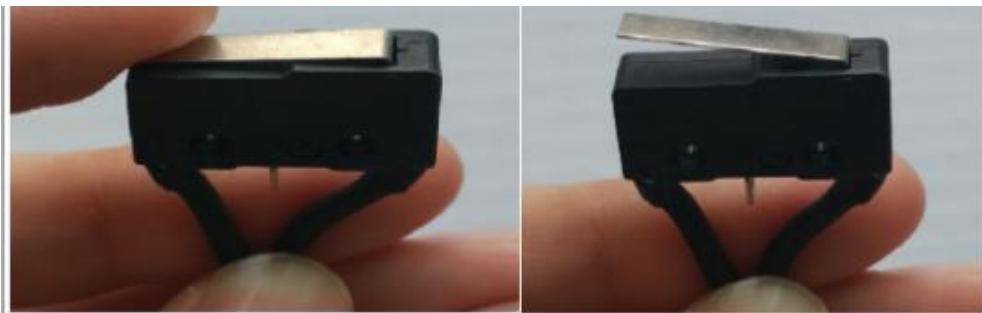
g1 z0—x and y keep previous coordinate,z coordinate arrive to x 0,this arrive the lowest bottom;  
g1 x20—y and z keep previous coordinate,x coordinate will arrive to x 20;

g1 x20 y10—z keeps previous coordinate,x coordinate arrive to x 20;y coordinate arrive to y 10;  
g1 y15 z30—x keeps previous coordinate,y coordinate arrive to y15; z coordinate arrive to y 30.

#### (4) M119----check the status of the switch.

The switch status is important directive,when meeting the motor moving problem,can check the switch status to search problem.

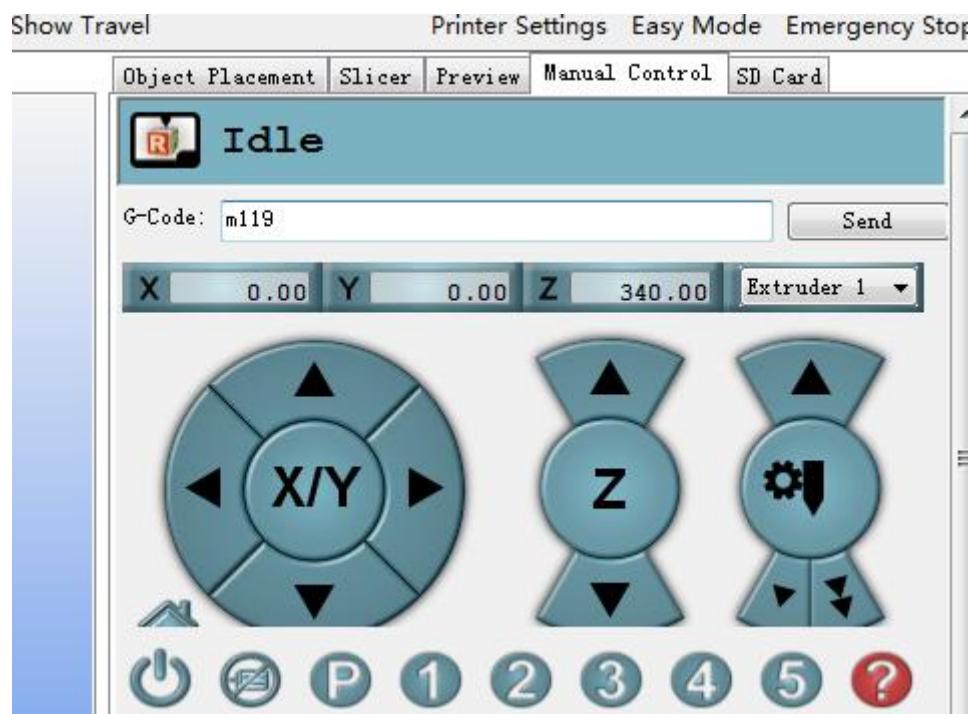
When hit the switch,it shows TRIGGERED;if not touch, it shows open.



**switch on**

**switch off**

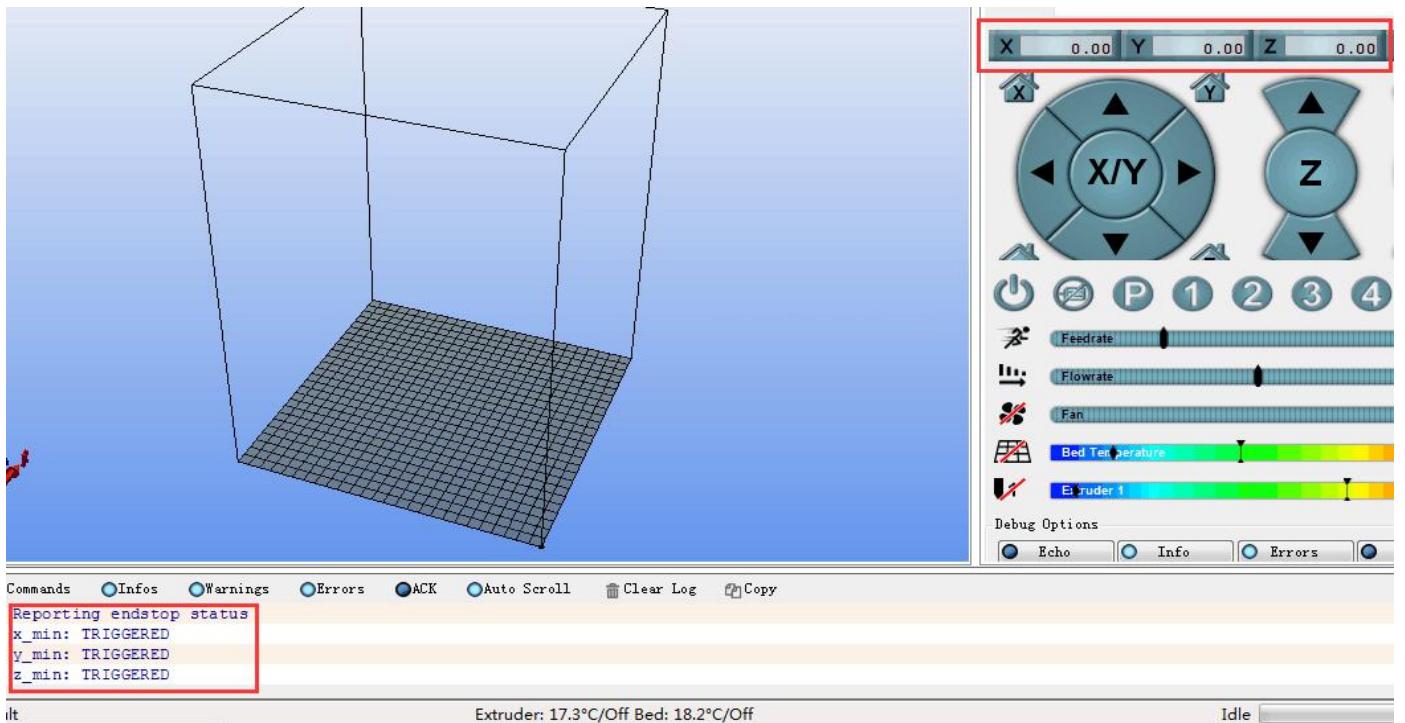
Commands	Infos	Warnings	Errors	Commands	Infos	Warnings	Errors
X:0.00 Y:0.00 Z:0.00 E:0.00 Count				z_min: open			
Reporting endstop status				Reporting endstop status			
x_min: TRIGGERED				x_min: open			
y_min: TRIGGERED				y_min: open			
z_min: open				z_min: open			



When send g28, the nozzle will go home, then send m119

It show:

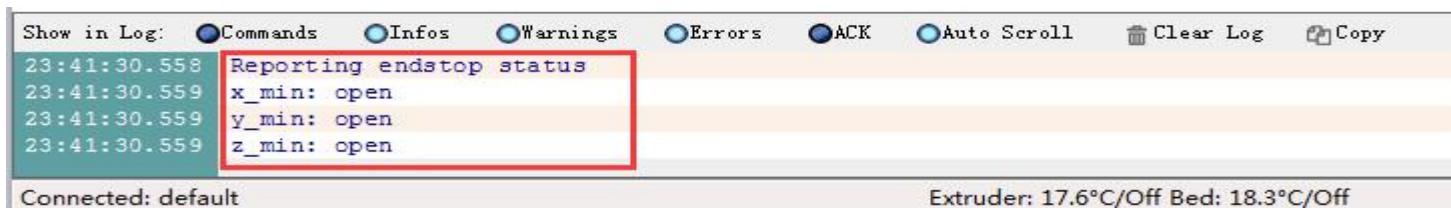
x\_min TRIGGERED  
 y\_min TRIGGERED  
 z\_min TRIGGERED.



If the nozzle is at the middle air, not hit any limit switch, all four switch show open.

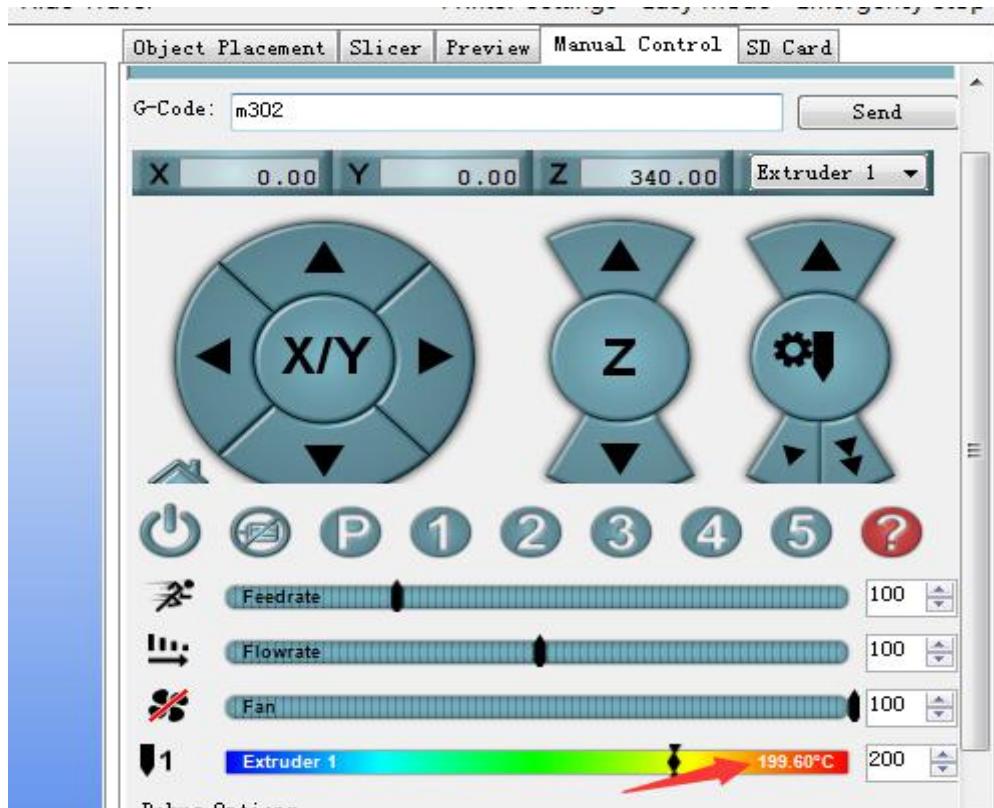
It show:

x\_min open  
y\_min open  
z\_min open

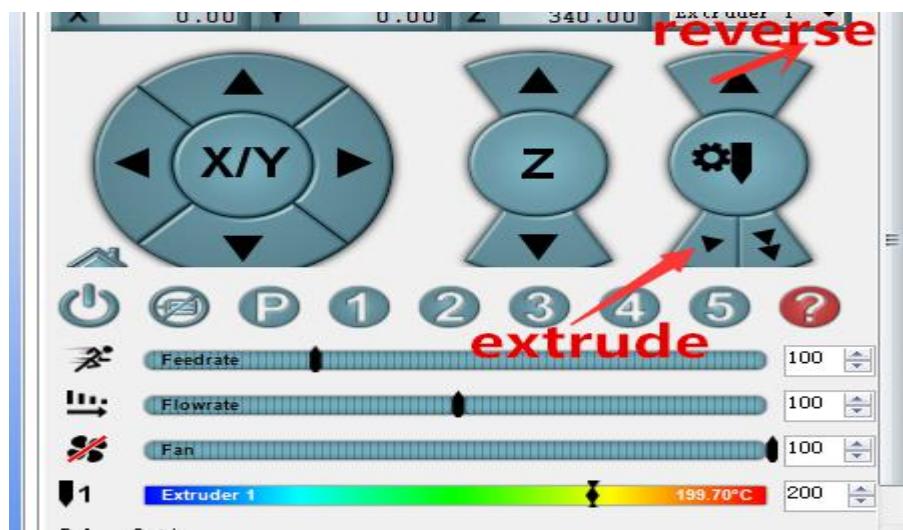


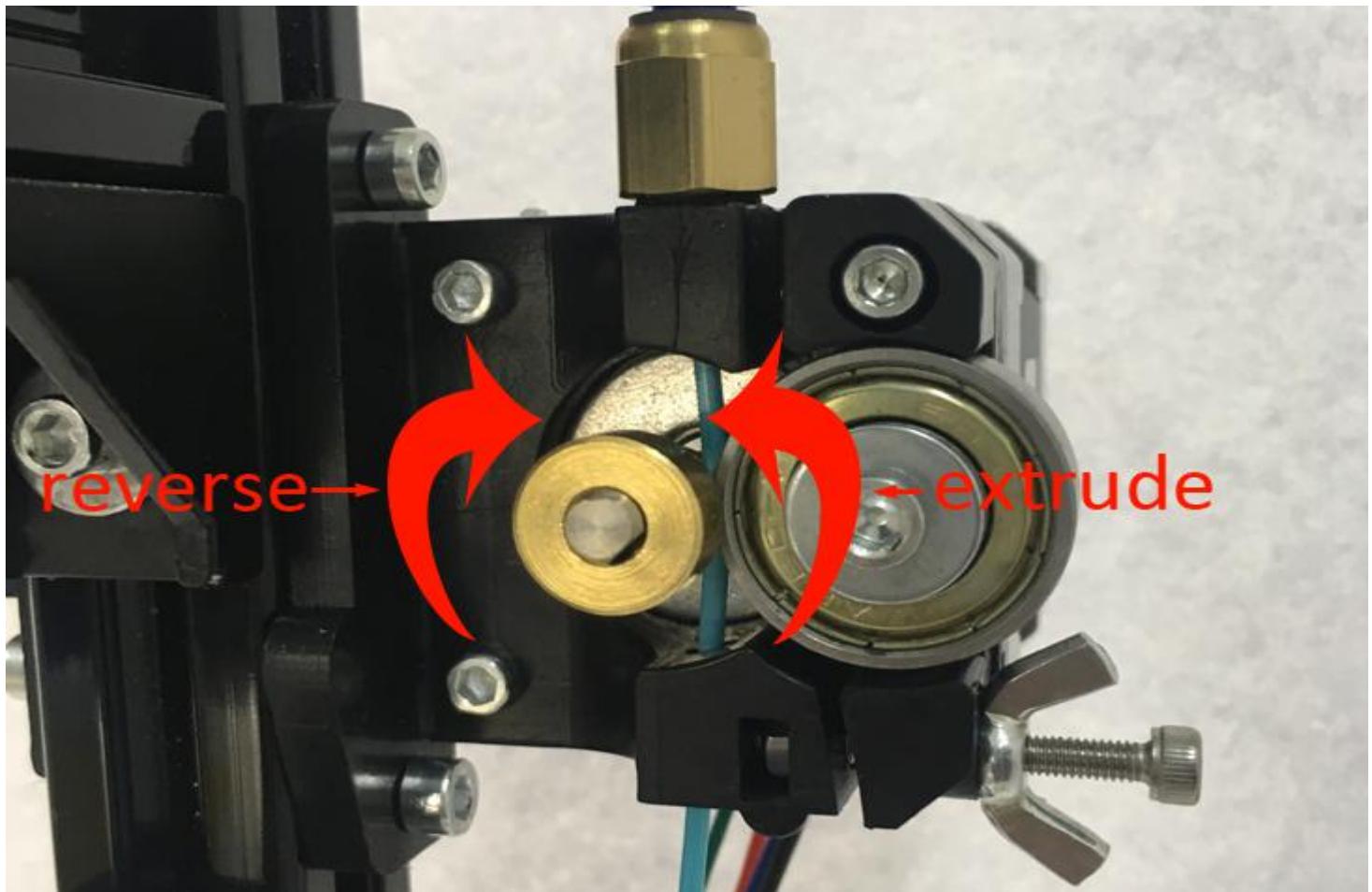
## (5) m302----manual control extruder motor

Before manual control extruder motor , need heat nozzle to targeted temperature and can melt filament. this step is to prevent the extruder run at cold status, then input 302.



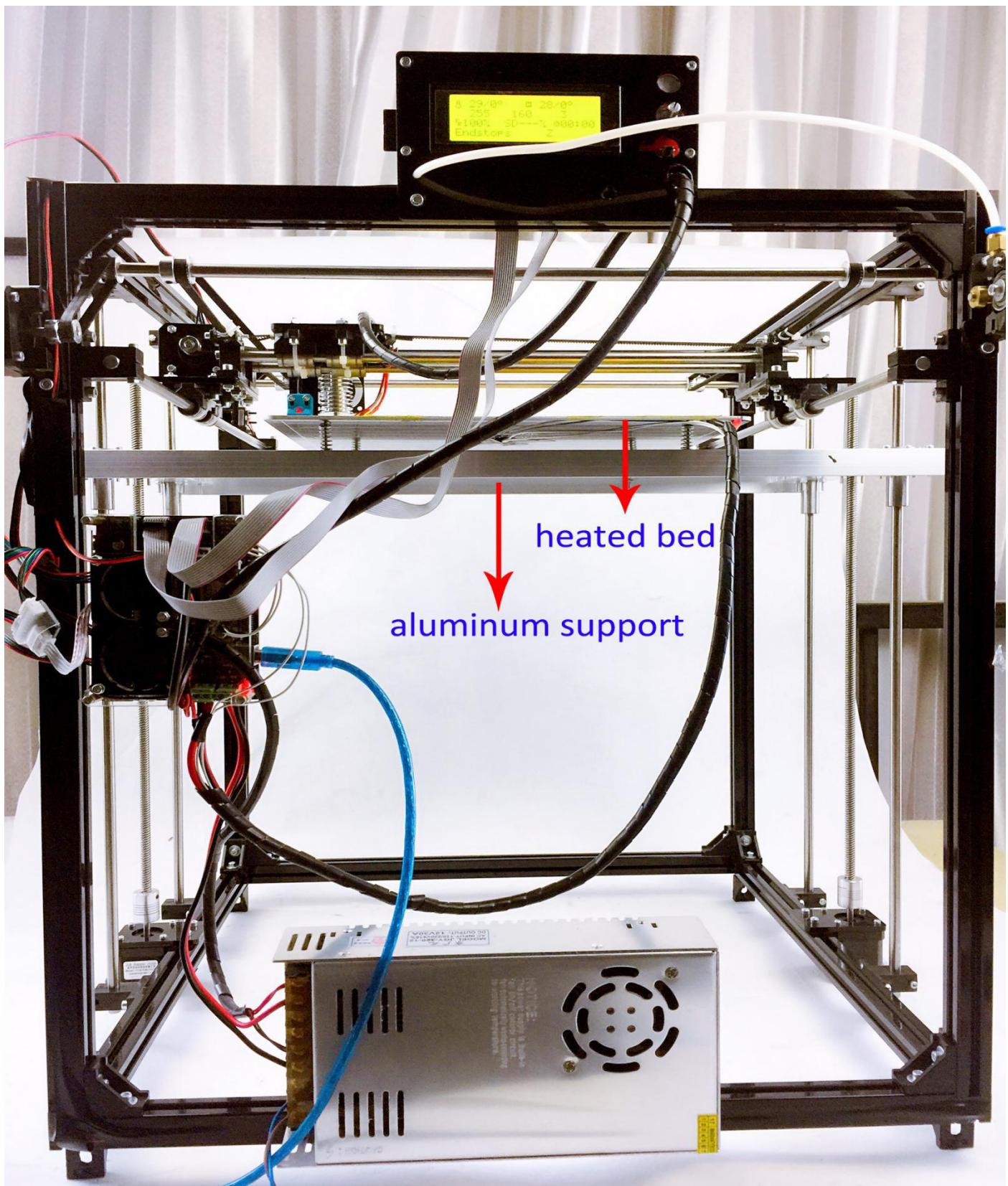
Important note: if use M302 code, must guarantee the nozzle temp reaach 175°C.  
If can not reach 175°C, the extruder can not run. !!!





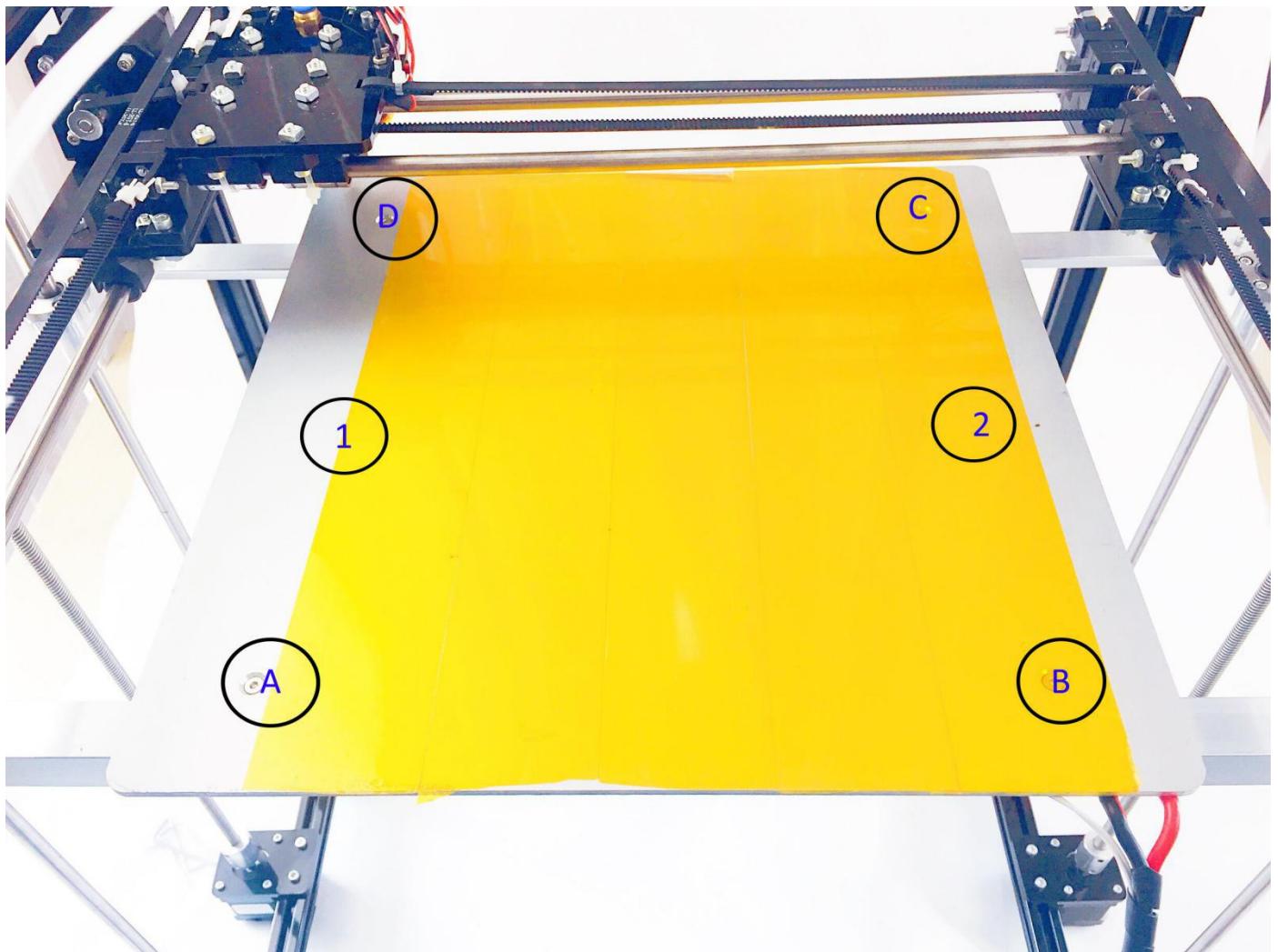
When heating the nozzle ,first input m302 and send ,and then click extrude,we can see extrude motor run ,and filament come out from nozzle(if you have installed filament)

## 2 preparation before leveling and automatic leveling



Before automatic leveling, the heated bed and the aluminum support should be leveling

We can through ① ② two points, adjust the aluminum pieces, through the ABCD four points, adjust the hot bed



First enter the G28 command, so that the machine is in the middle position.

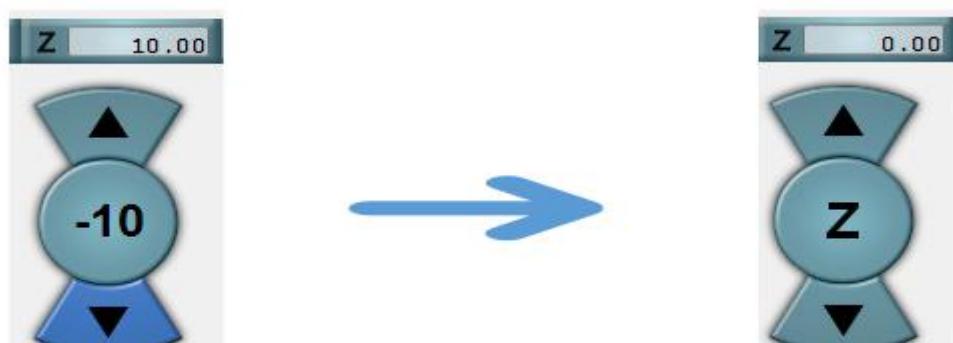
Second in the command bar enter: g1 z10 (The purpose of doing so is to prevent the scratches when the nozzle goes down to the next coordinate)



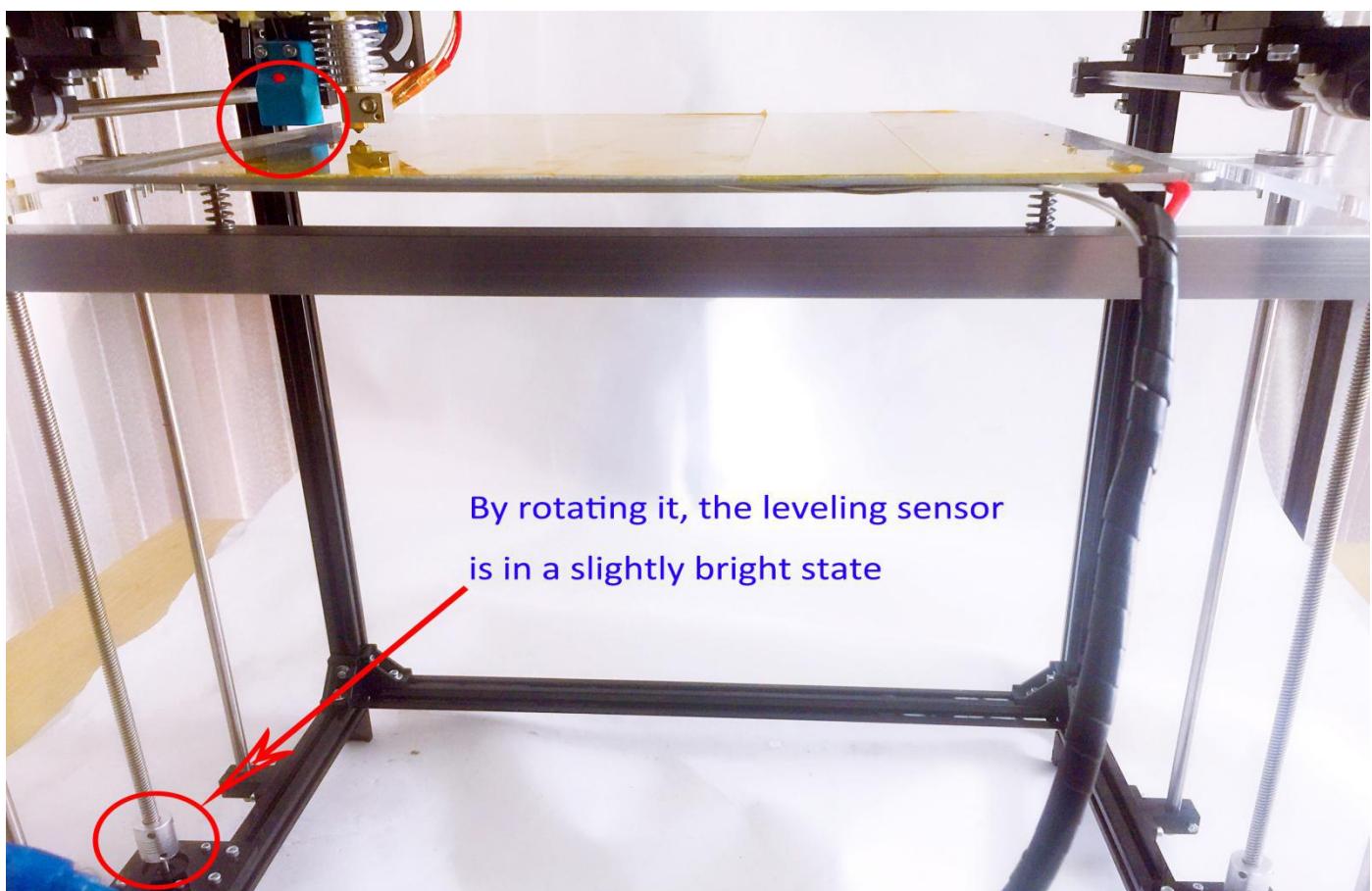
Then enter: g1 x255 y160 ,The nozzle will go to ① coordinate



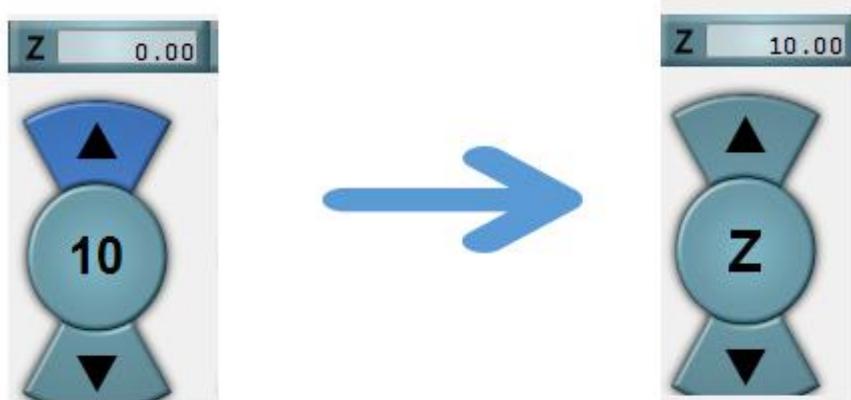
Then



Move the Z axis to zero



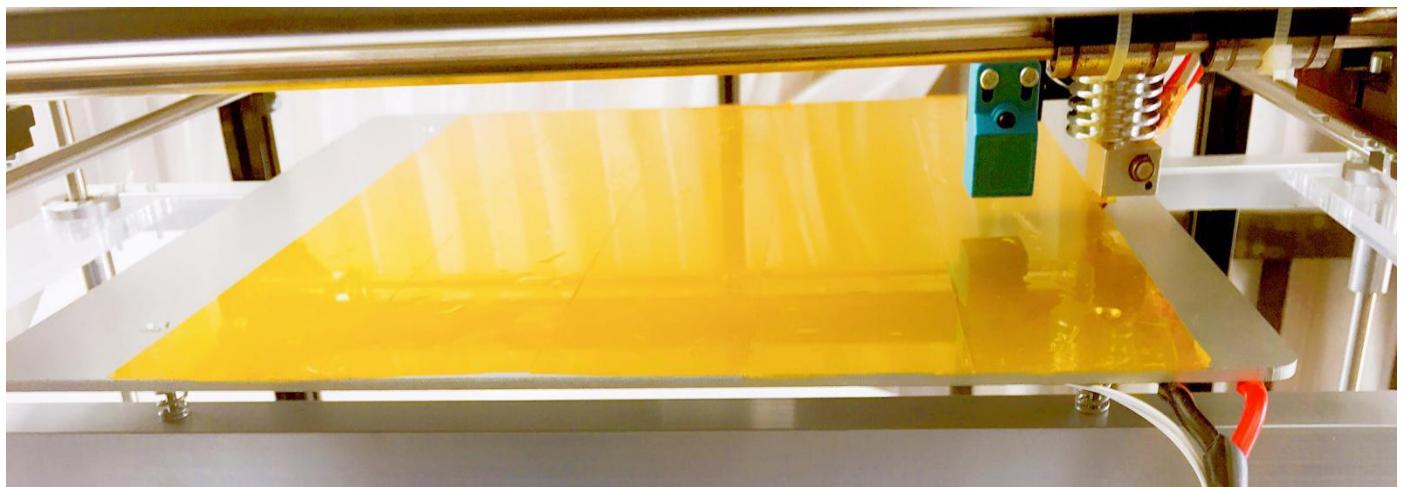
By rotating it, the leveling sensor  
is in a slightly bright state



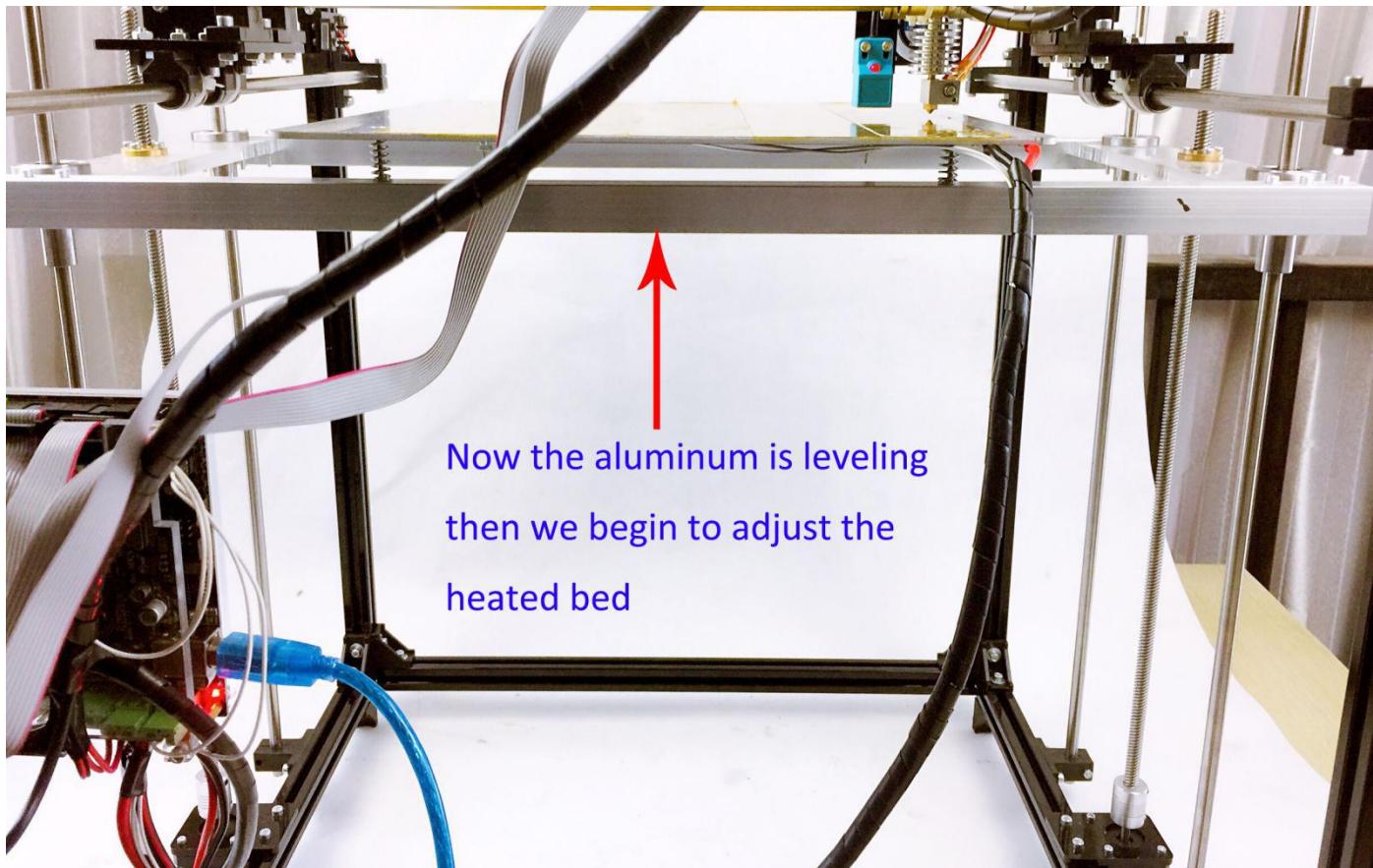
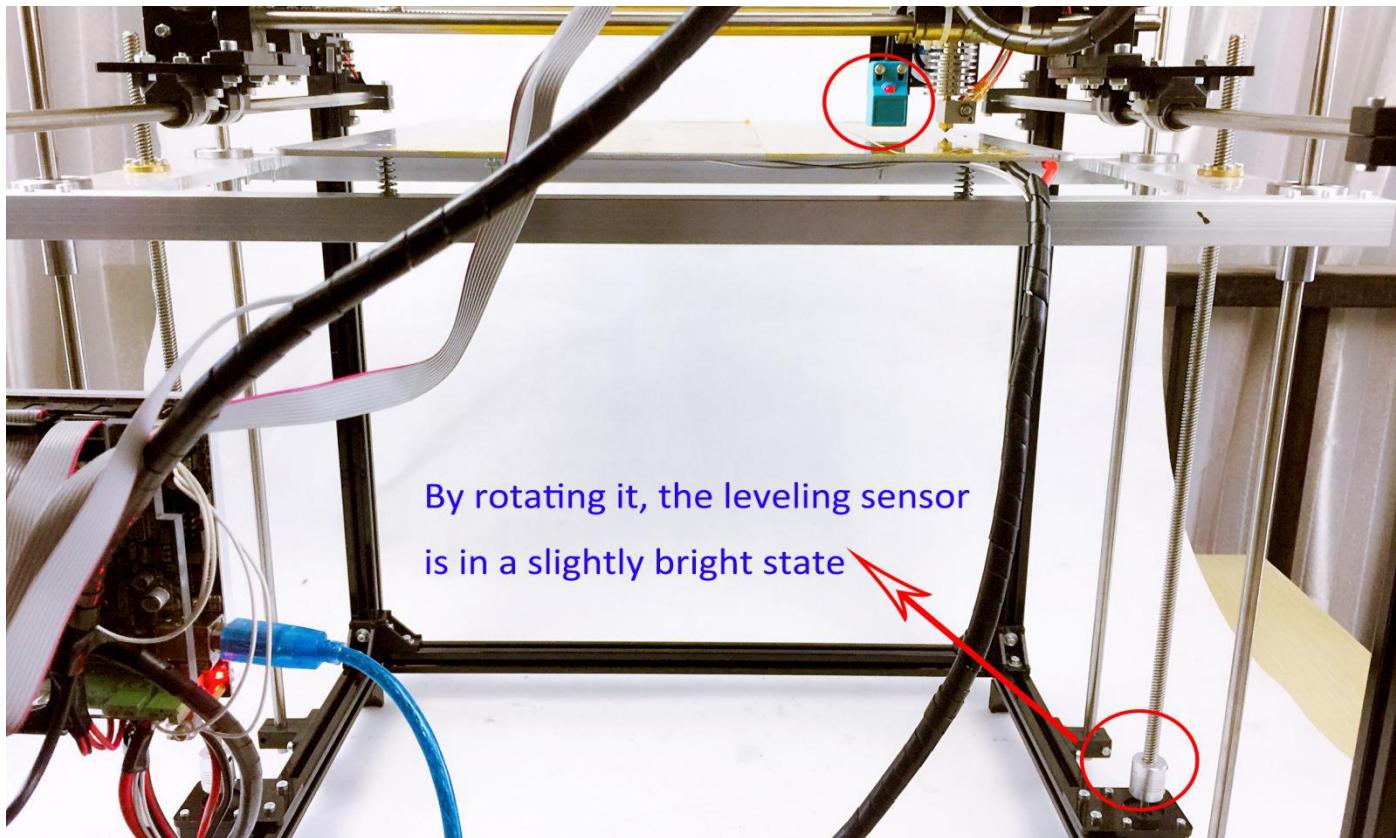
Move the Z axis to 10

(The purpose of doing so is to prevent the scratches when the nozzle goes down to the next coordinate)

Then enter: g1 x0 y160 ,The nozzle will go to ② coordinate



Move the Z axis to zero





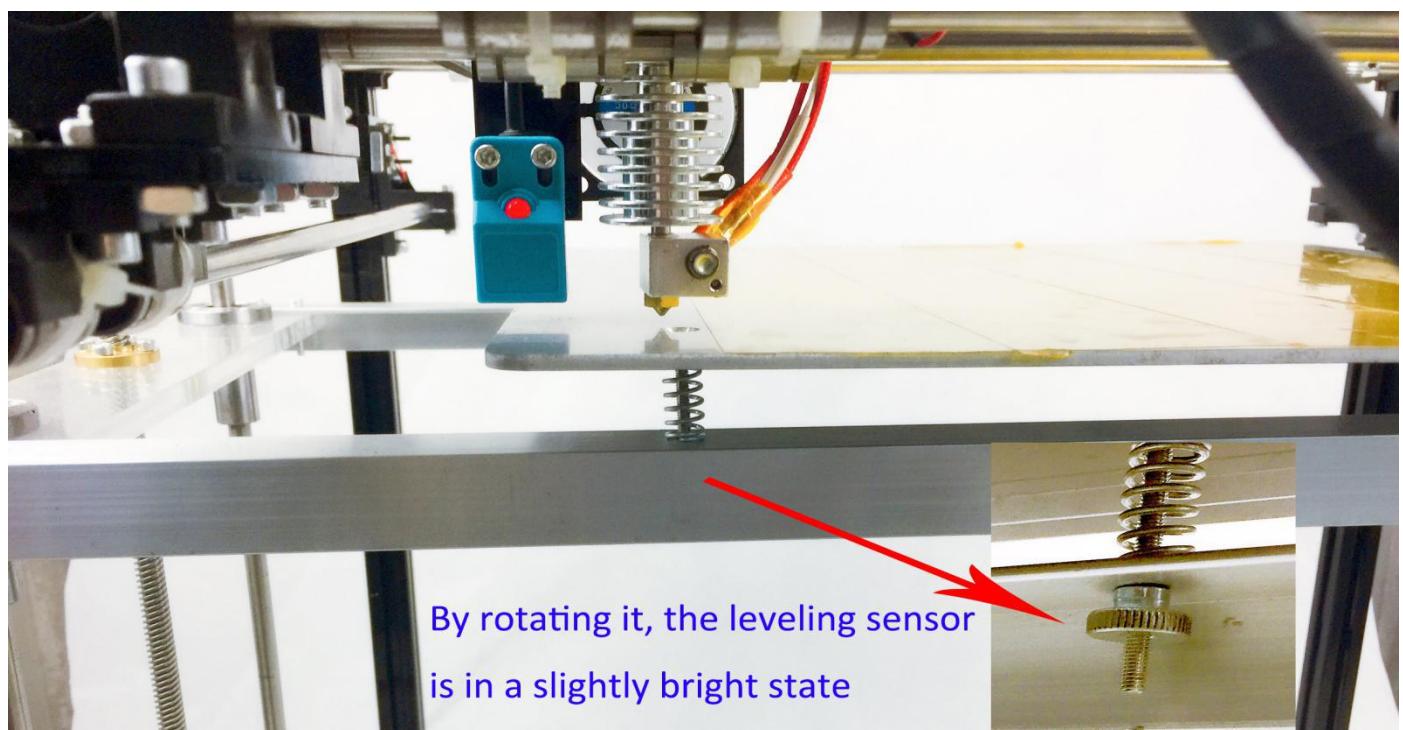
Move the Z axis to 10

(The purpose of doing so is to prevent the scratches  
when the nozzle goes down to the next coordinate)

Then enter: g1 x255 y260 ,The nozzle will go to A coordinate



Move the Z axis to zero





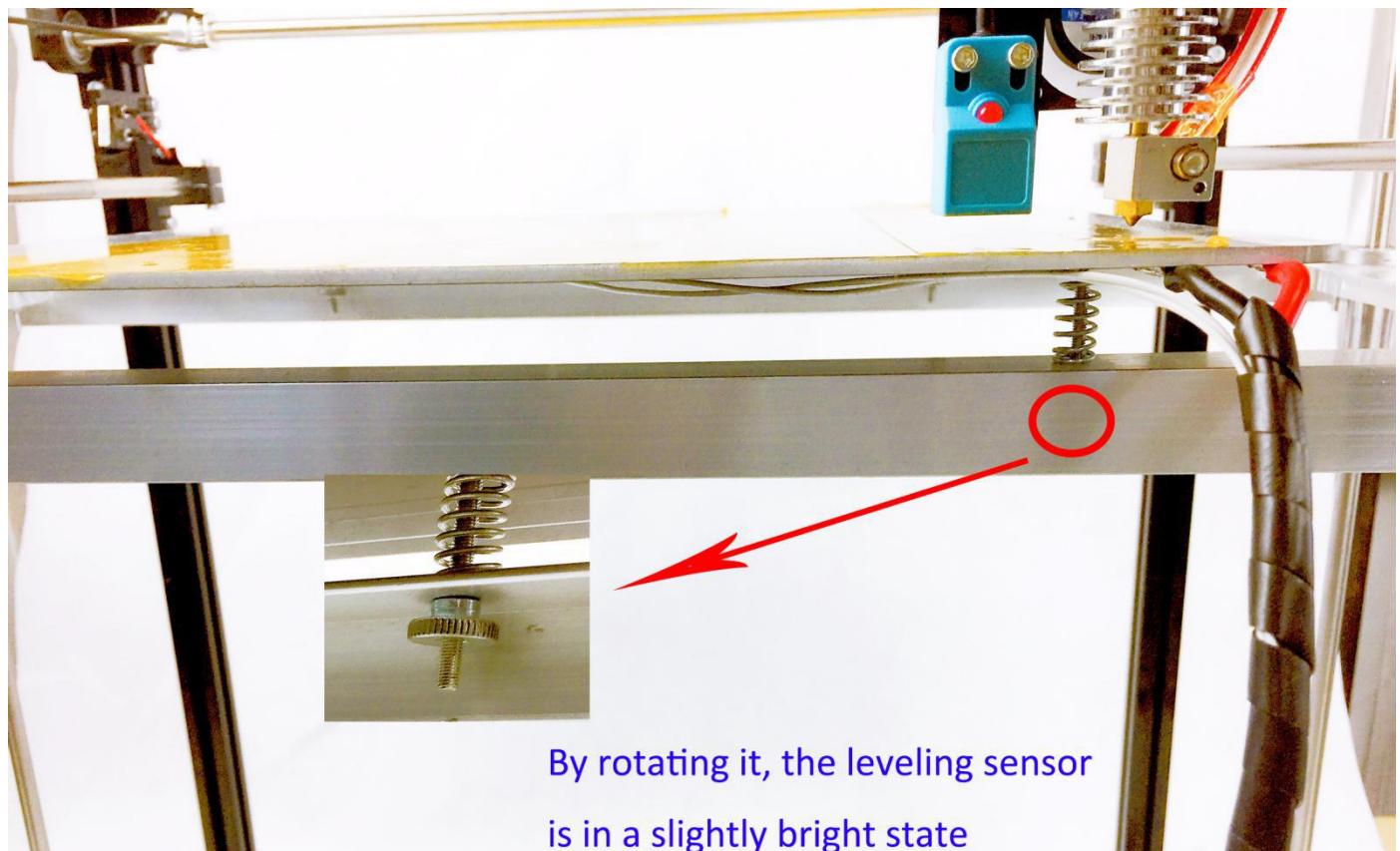
Move the Z axis to 10

(The purpose of doing so is to prevent the scratches  
when the nozzle goes down to the next coordinate)

Then enter: g1 x0 y260 ,The nozzle will go to B coordinate



Move the Z axis to zero



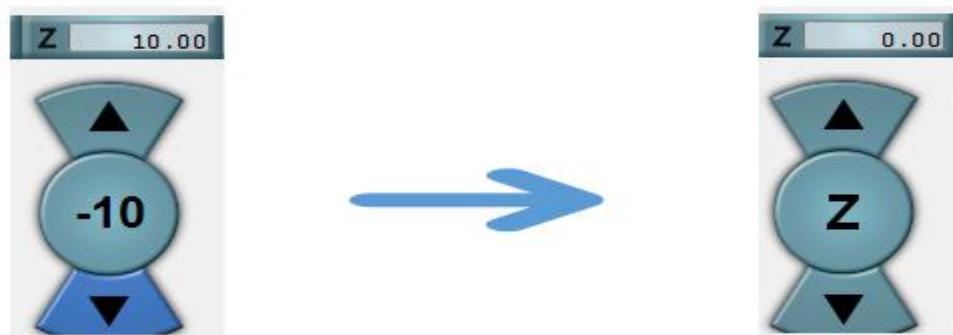
By rotating it, the leveling sensor  
is in a slightly bright state



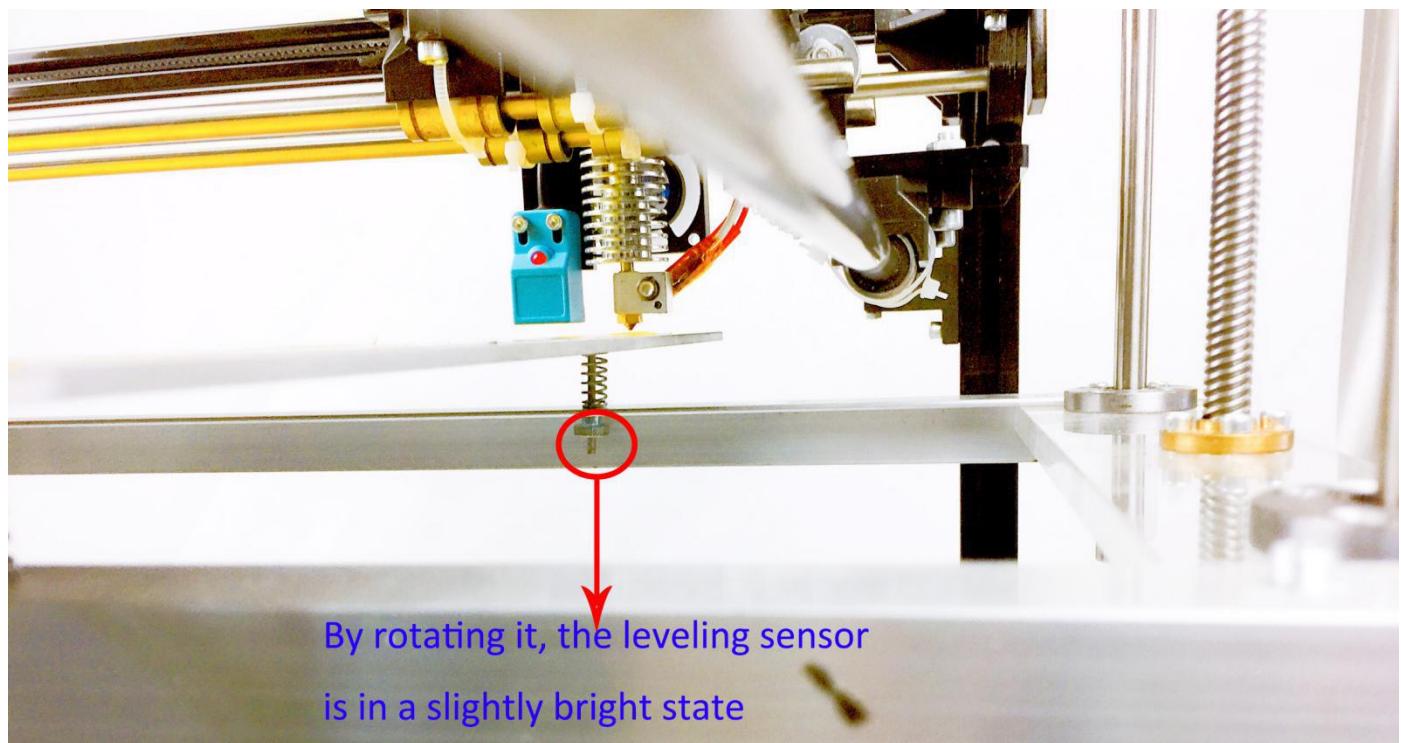
Move the Z axis to 10

(The purpose of doing so is to prevent the scratches when the nozzle goes down to the next coordinate)

Then enter: g1 x0 y30 ,The nozzle will go to C coordinate



Move the Z axis to zero

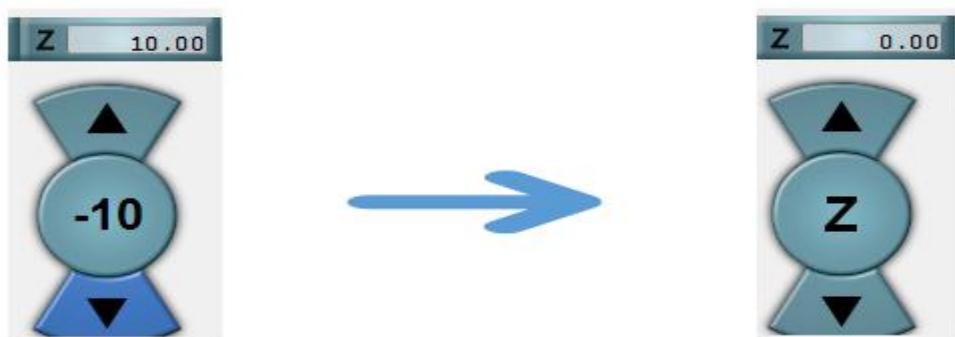




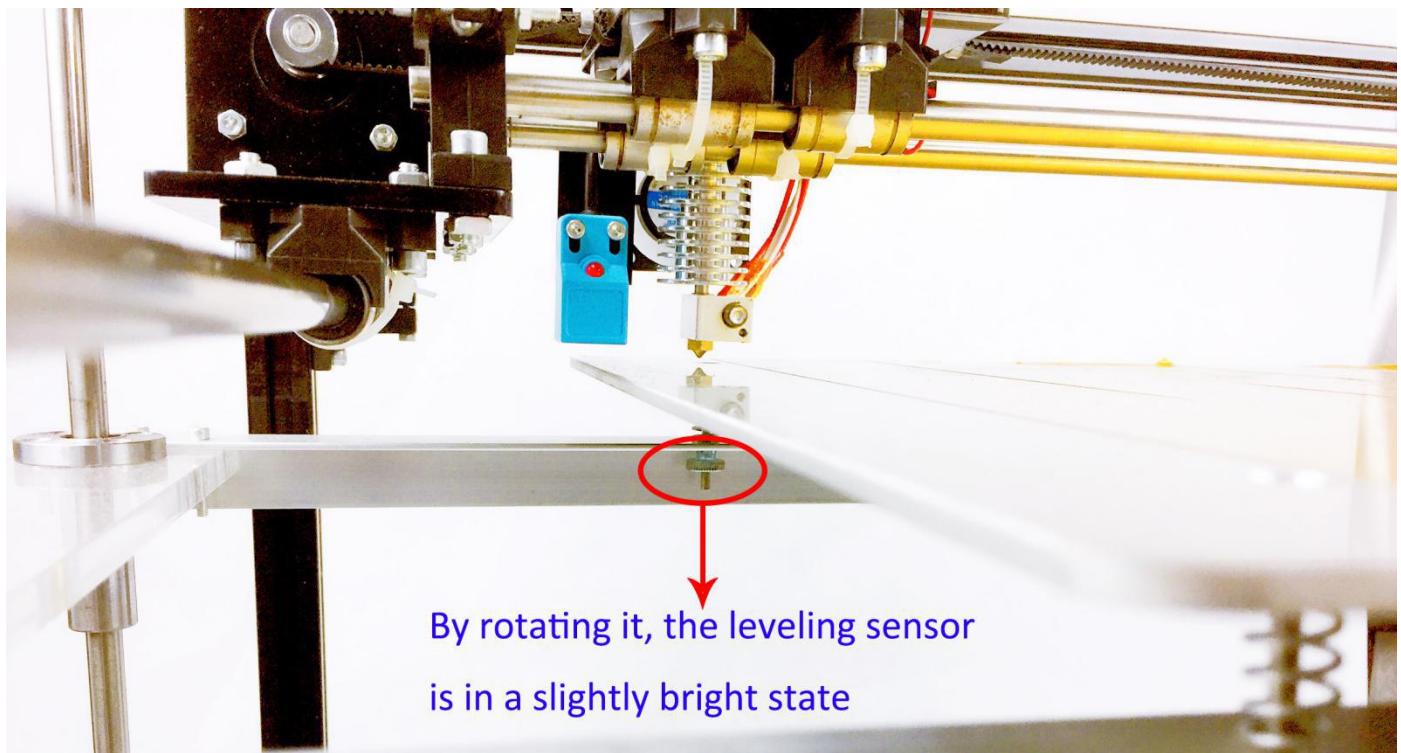
Move the Z axis to 10

(The purpose of doing so is to prevent the scratches when the nozzle goes down to the next coordinate)

Then enter: g1 x255 y30 ,The nozzle will go to D coordinate



Move the Z axis to zero



Repeat two to three times to ensure that the results are more accurate.

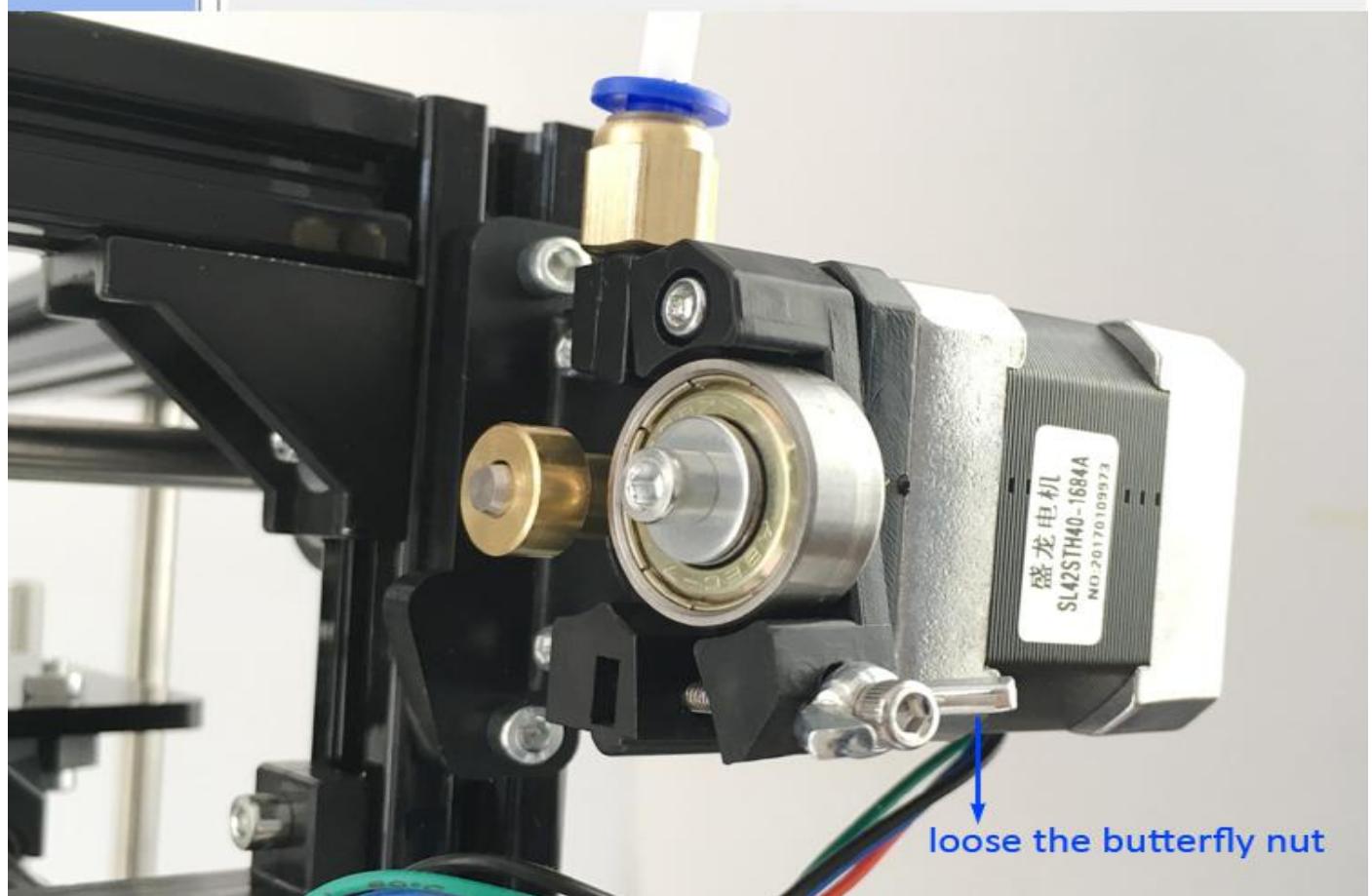
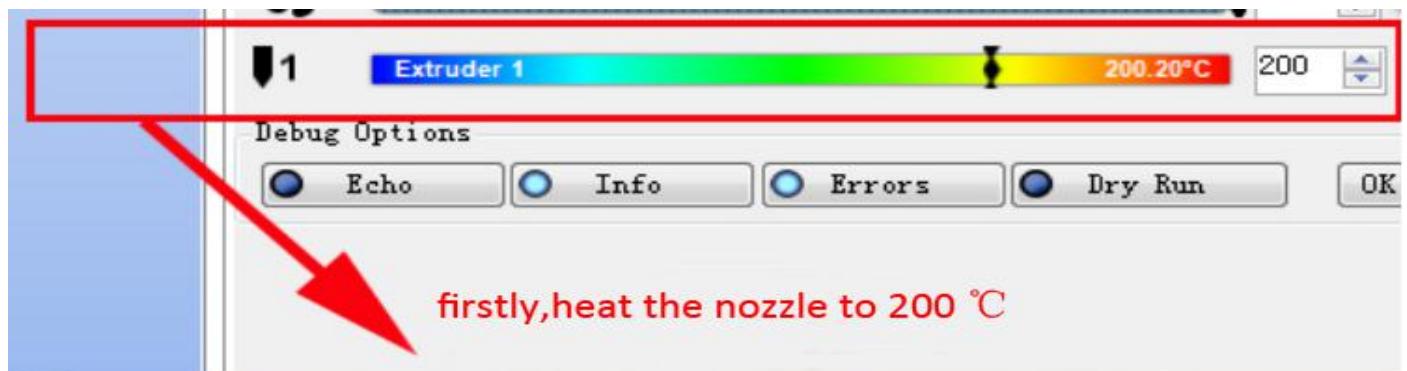
Now the heated bed is leveling ,preparation before leveling is complete,We can start the automatic leveling

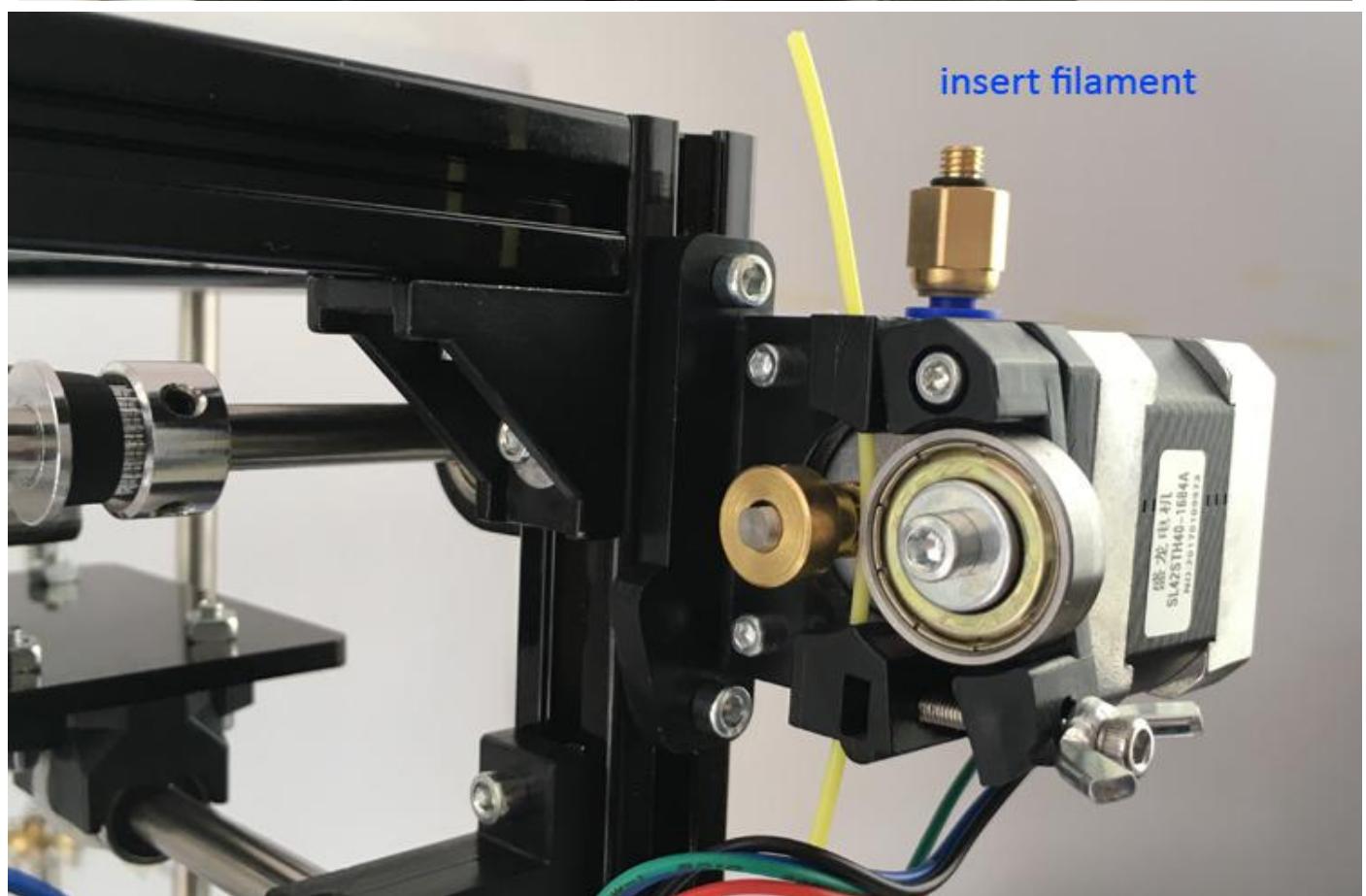
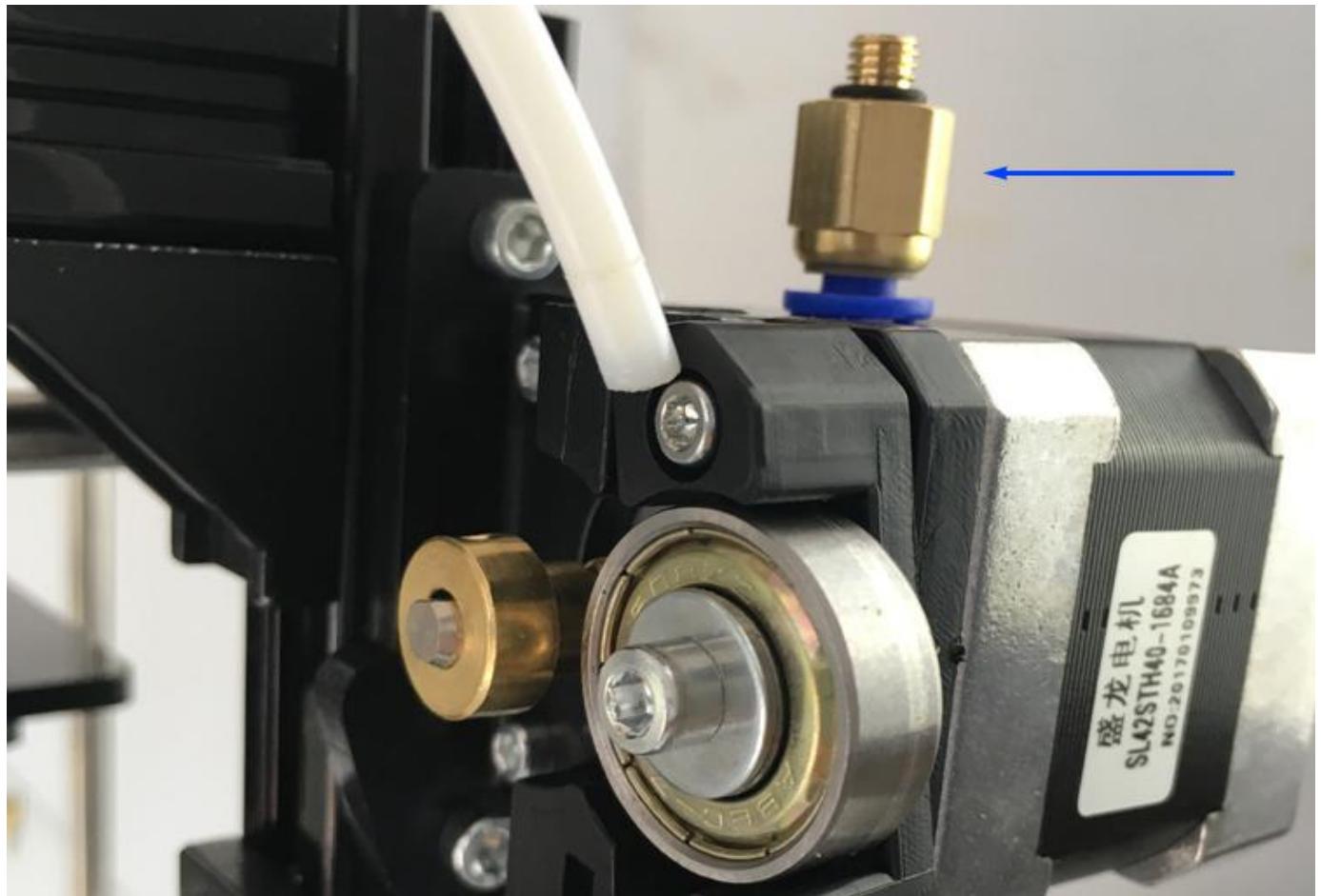
G29 is autolevel command,after you load model and slice it ,the regular succession is g28 go home,g29 autolevel ,then you can click start print

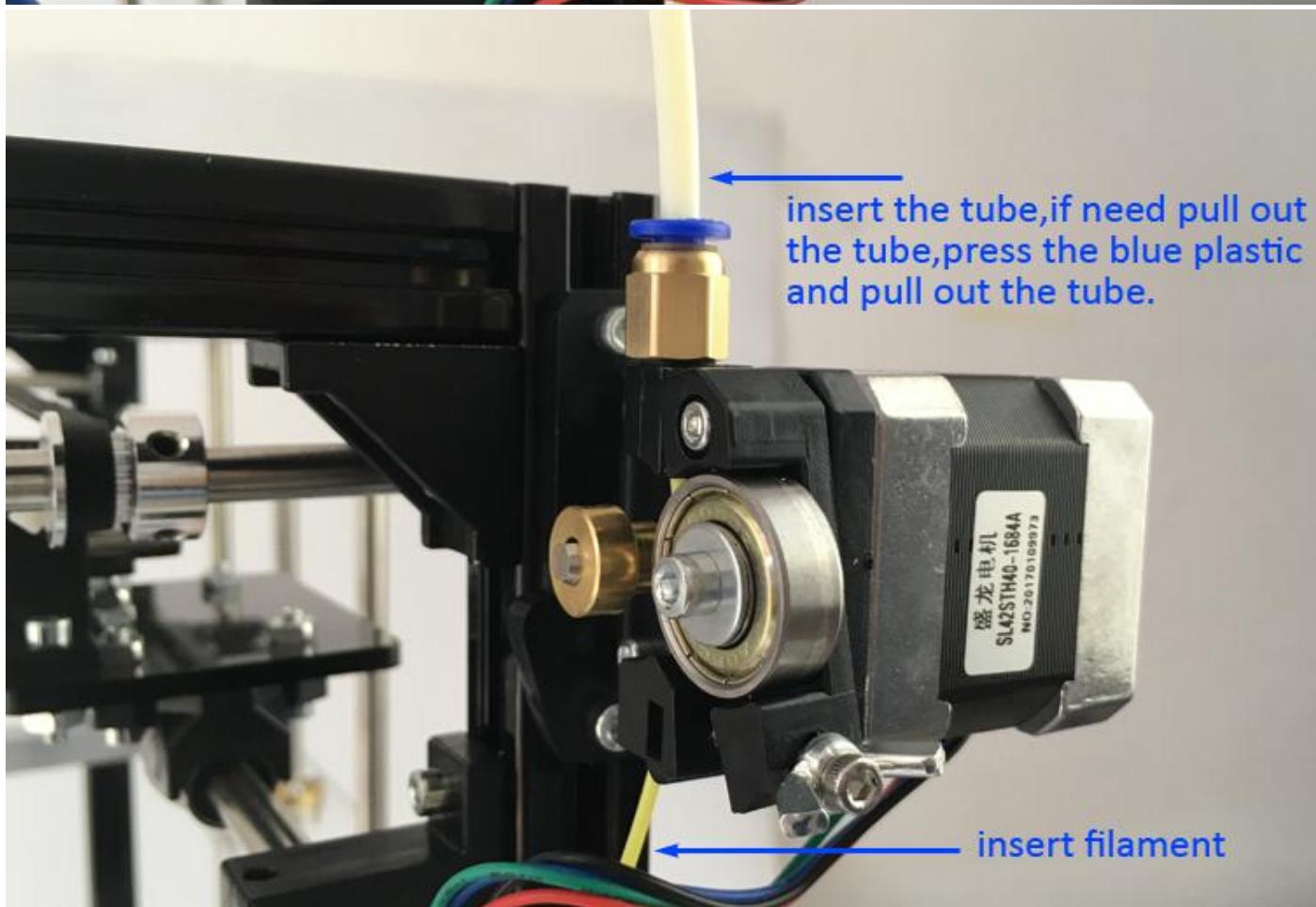
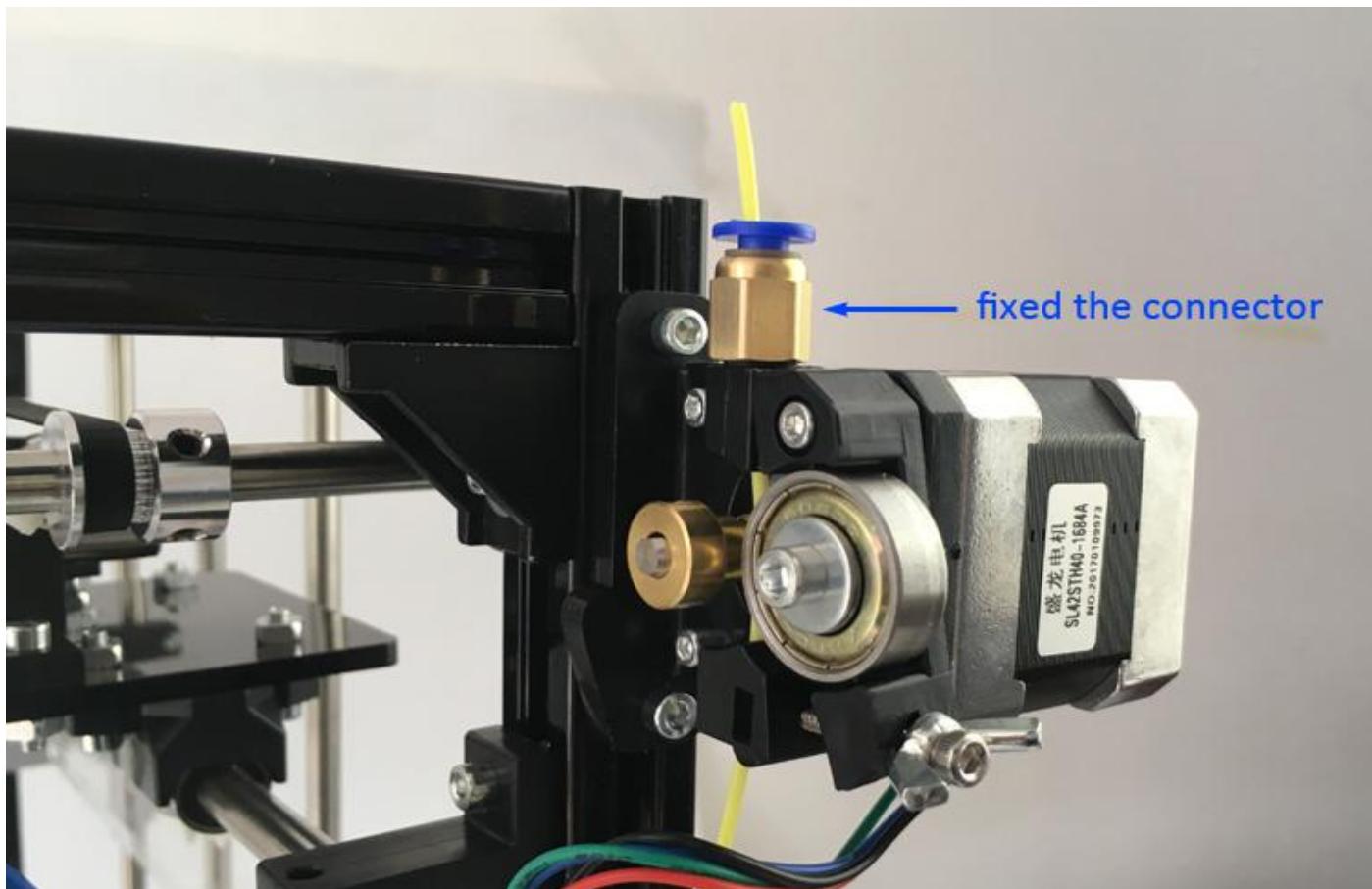
## 2,Start printing

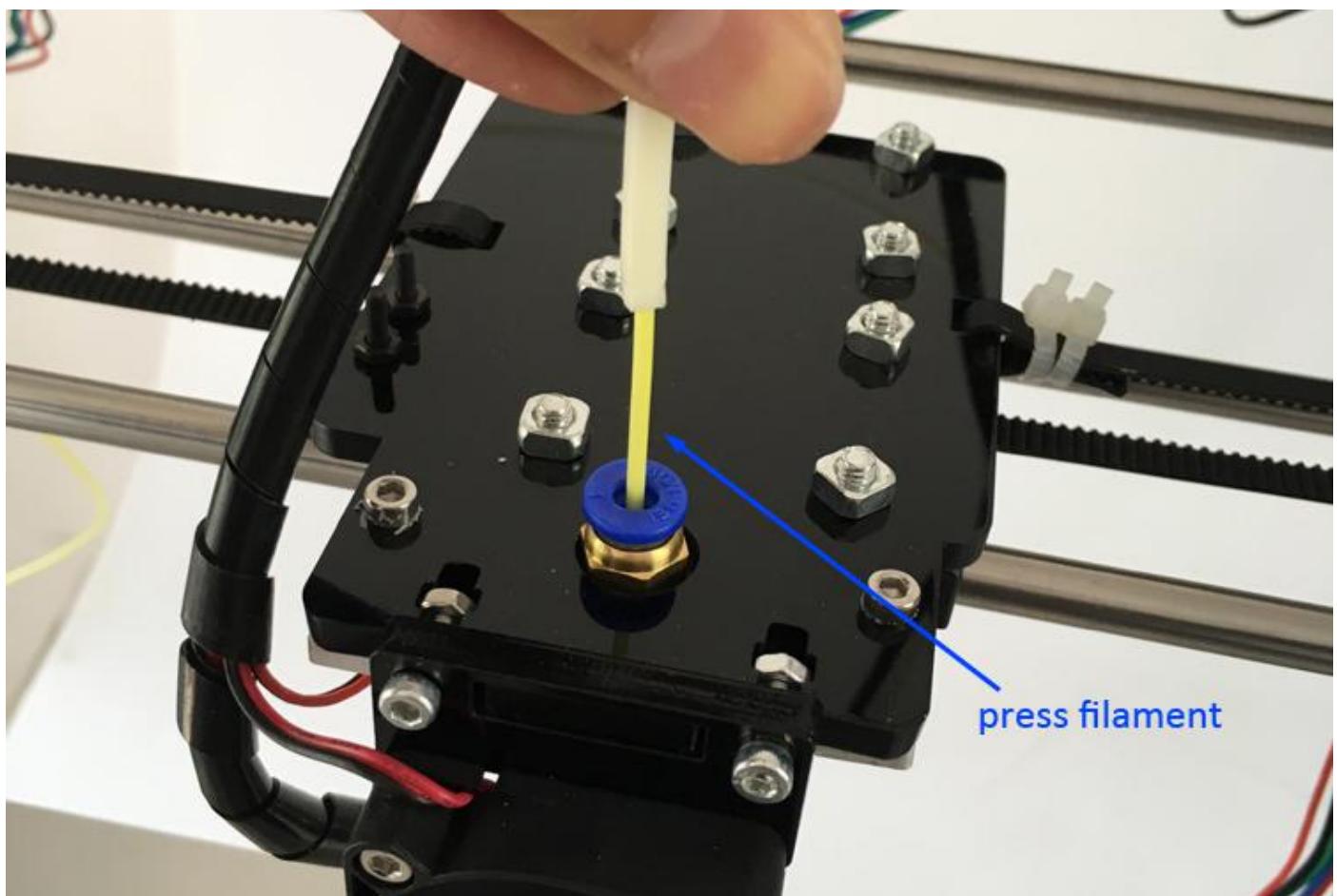
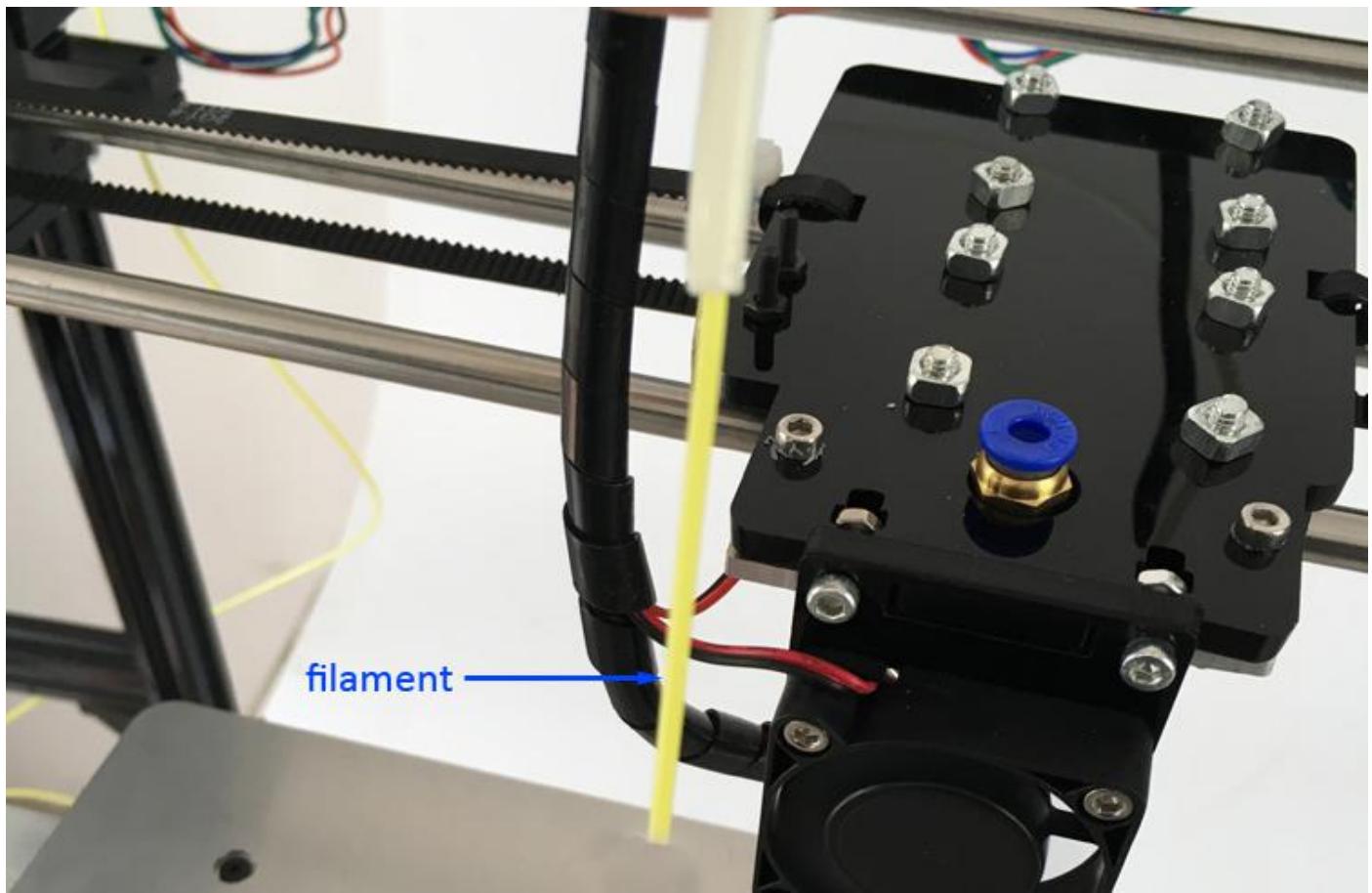
### 1 Feeder filament

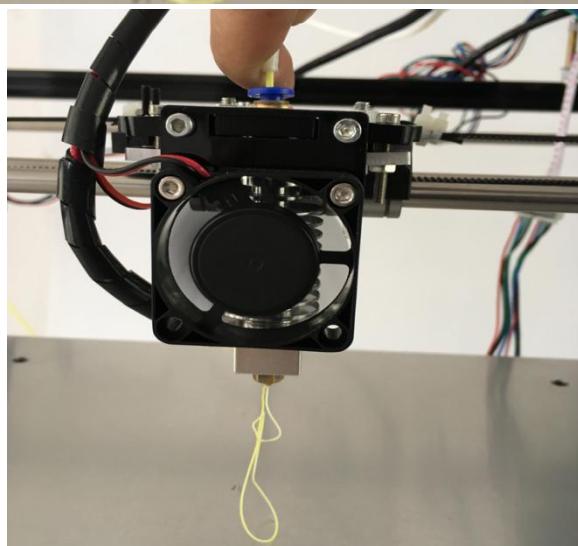
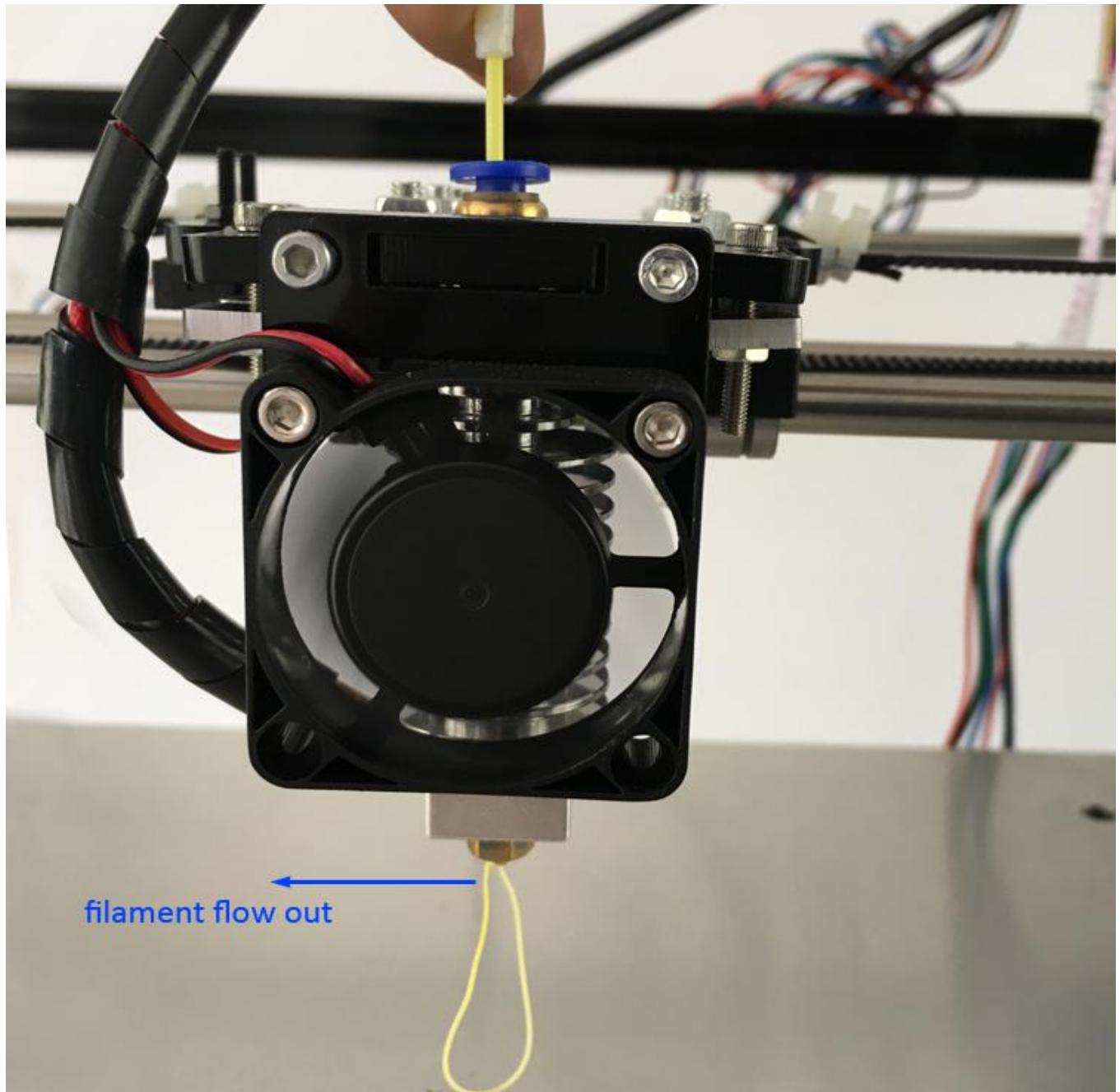
Before printing,connect USB and power supply,then feeder filament.

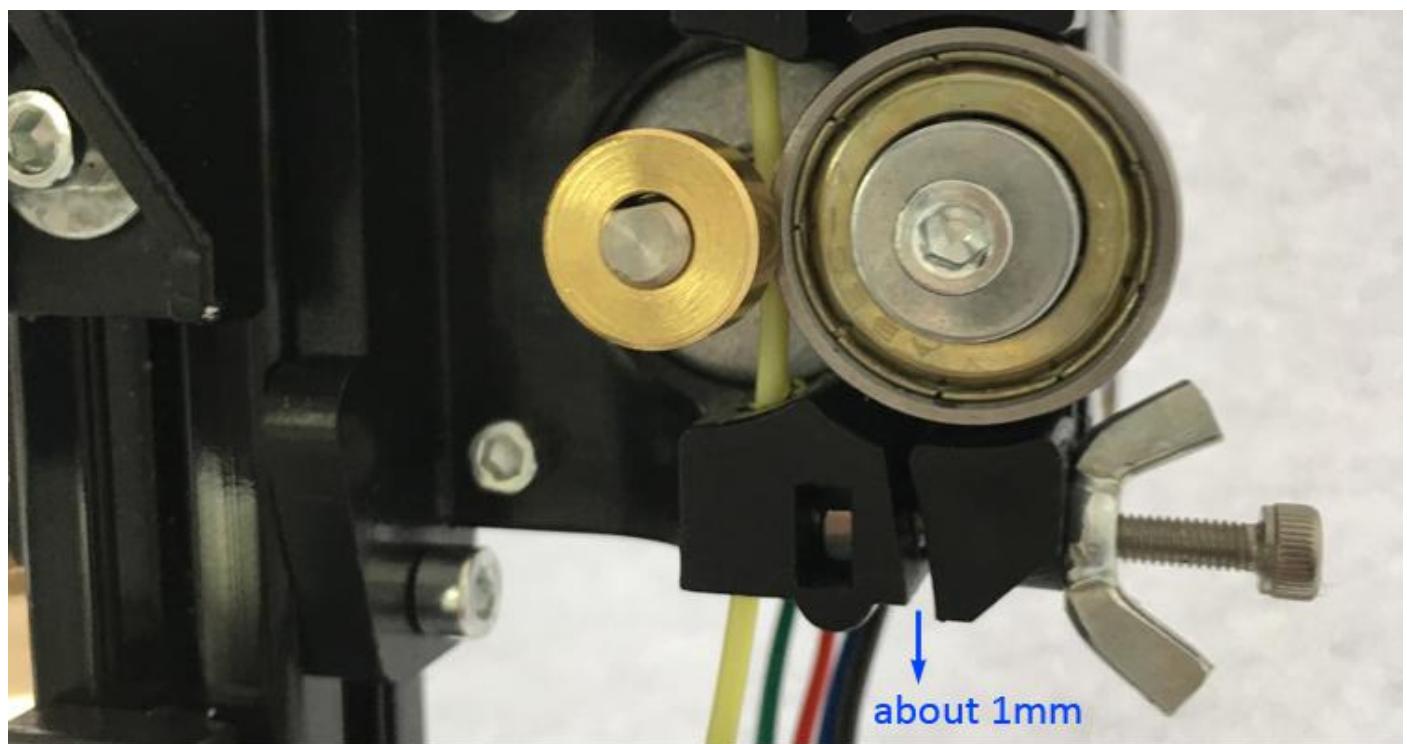
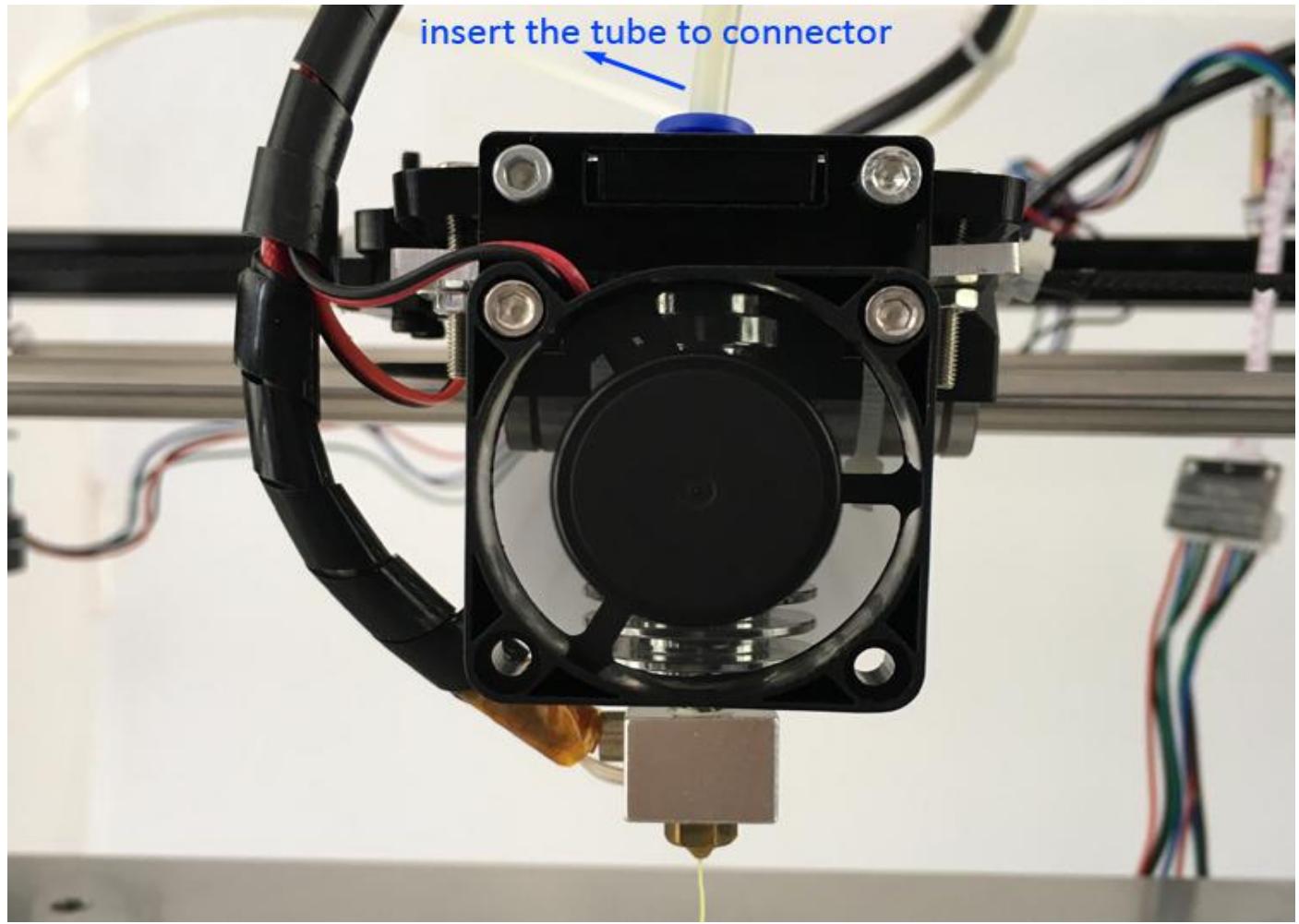








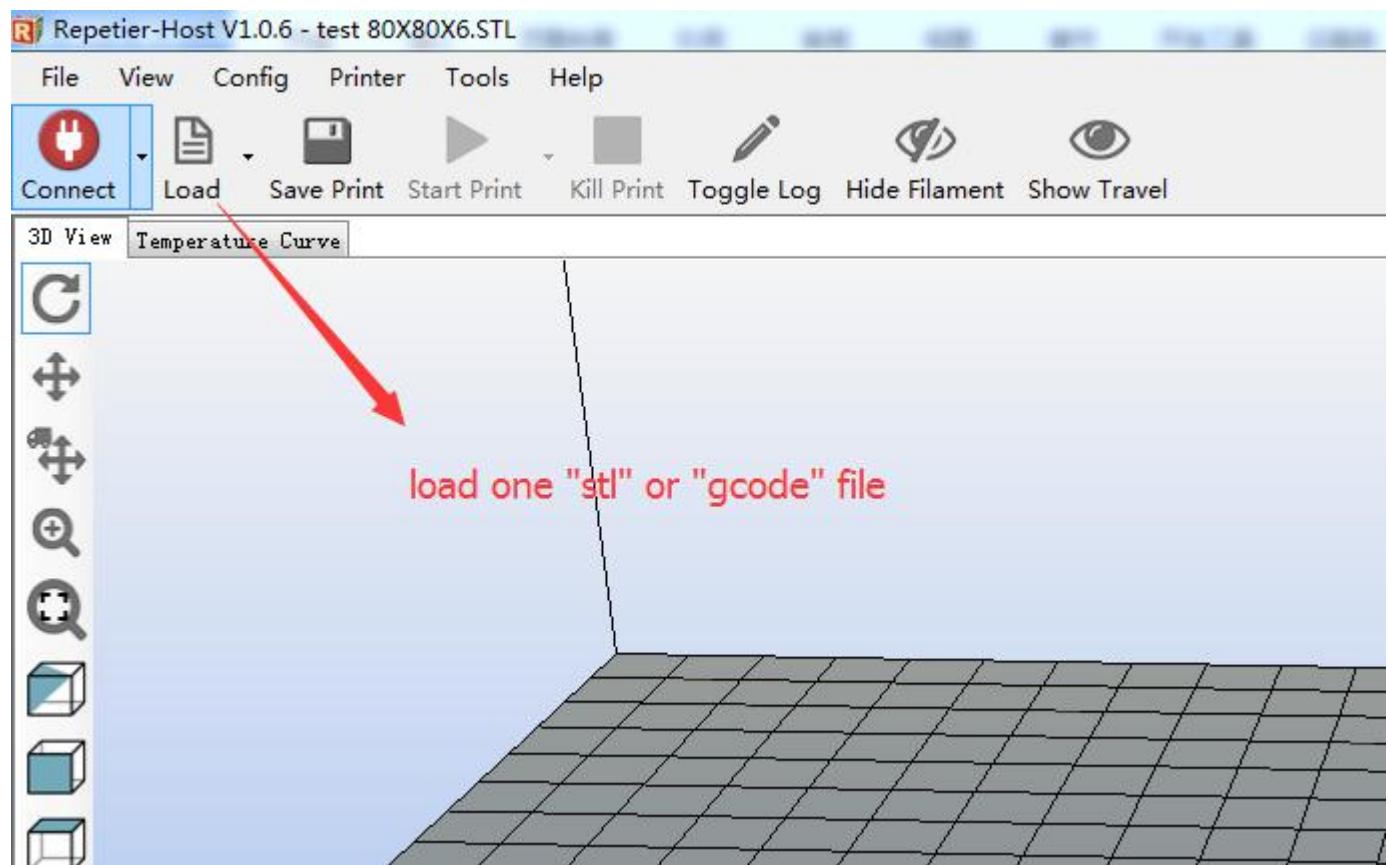




tight the butterfly nut, the butterfly can not tight too much, the gap is about 1 mm. if tight too much, will stop the filament.

## 2 Slice

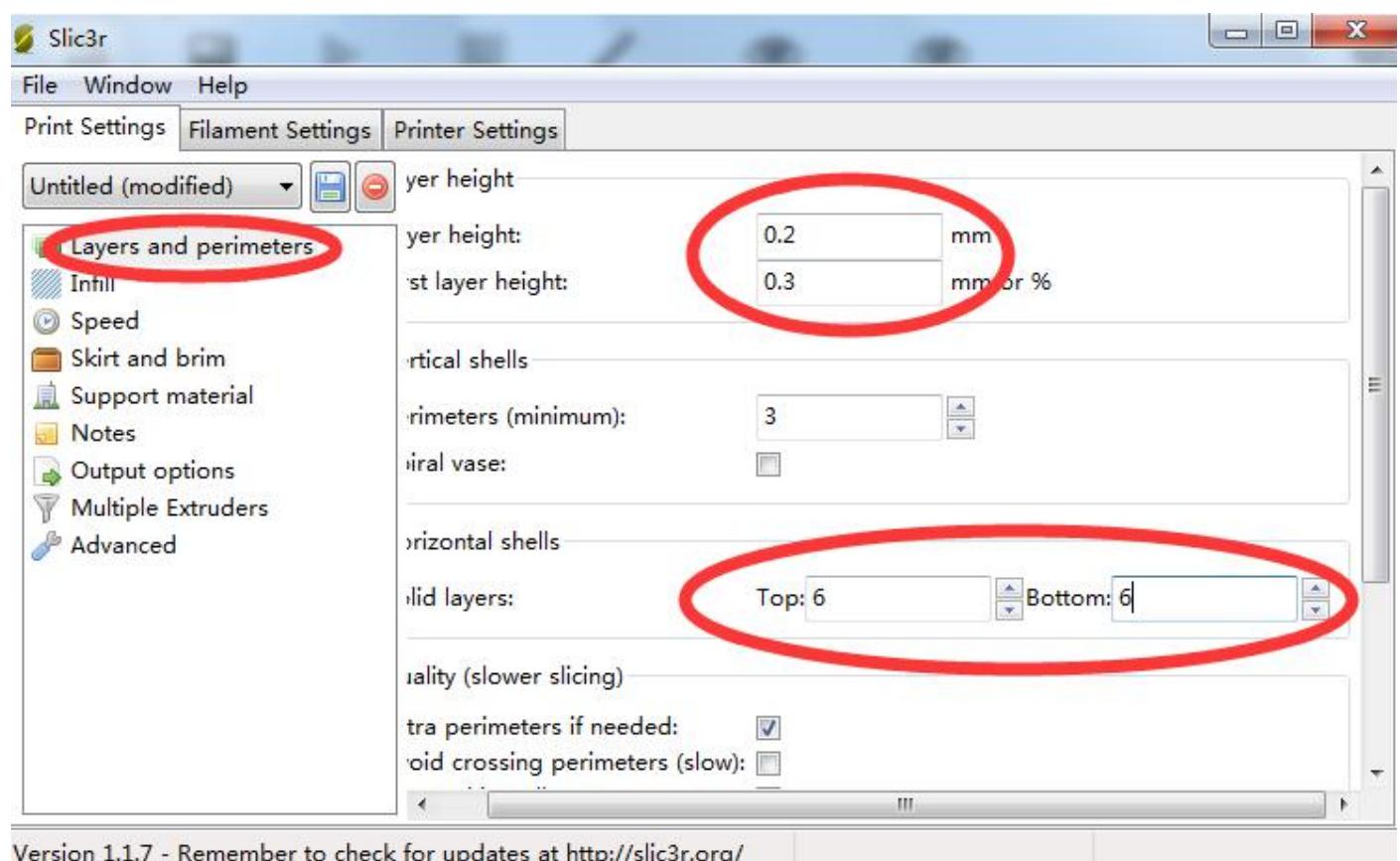
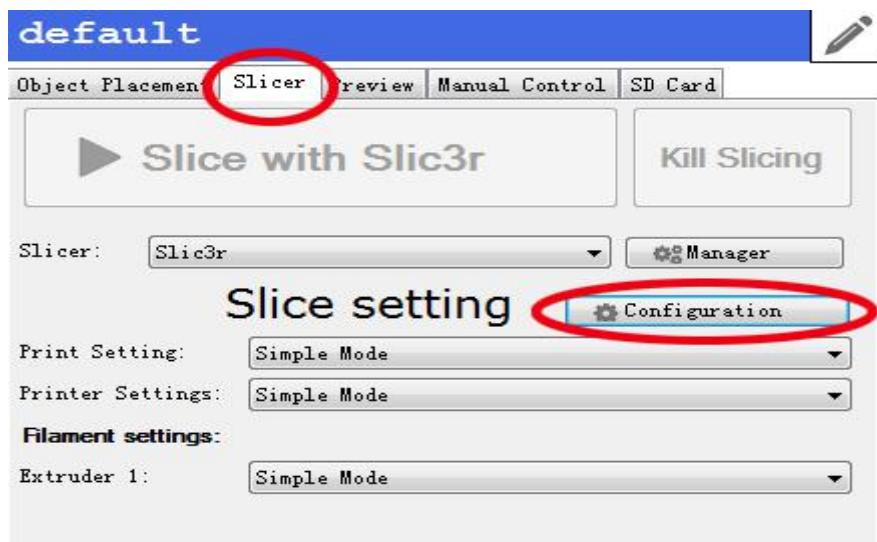
The 3d printer only can identify g-code files, so need slice first, transfer the stl file to g-code file.



bot.gcode	2017/3/24 11:24	GCODE 文件	1,324 KB
bot.stl	2017/3/24 11:24	证书信任列表	764 KB
cov.gcode	2017/3/24 11:24	GCODE 文件	527 KB
cov.stl	2017/3/24 11:24	证书信任列表	317 KB
D20.gcode	2017/3/24 11:24	GCODE 文件	182 KB
D20.stl	2017/3/24 11:24	证书信任列表	529 KB
m10-8c.gcode	2017/3/24 11:24	GCODE 文件	1,045 KB
m10-8c.stl	2017/3/24 11:24	证书信任列表	529 KB
m10-20.gcode	2017/3/24 11:24	GCODE 文件	2,405 KB
m10-20.stl	2017/3/24 11:24	证书信任列表	978 KB

choose the file you will print

### 3 slice setting



Version 1.1.7 - Remember to check for updates at <http://slic3r.org/>

File Window Help

Print Settings Filament Settings Printer Settings

My Settings (modified ▾)



Layers and perimeters

Infill

Speed

Skirt and brim

Support material

Notes

Output options

Multiple Extruders

Advanced

### Infill

Fill density:

20 %

Fill pattern:

rectilinear

Top/bottom fill pattern:

rectilinear

### Reducing printing time

Combine infill every:

1 layers

Only infill where needed:



### Advanced

Solid infill every:

0 layers

Fill angle:

45 °

Solid infill threshold area:

70 mm<sup>2</sup>

Only retract when crossing  
perimeters:



Infill before perimeters:



File Window Help

Print Settings Filament Settings Printer Settings

My Settings (modified ▾)



Filament

Cooling

PLA filament

### Filament

Diameter:

1.75

mm

Extrusion multiplier:

1

### Temperature (°C)

Extruder:

First layer: 210

Other layers: 205

Bed:

First layer: 0

Other layers: 0

Print Settings Filament Settings Printer Settings

My Settings (modified)

Filament Cooling

Enable

Keep fan always on:

Enable auto cooling:

If estimated layer time is below ~30s, fan will run at 100% and print speed will be reduced so that no less than 30s are spent on that layer (however, speed will never be reduced below 10mm/s).  
If estimated layer time is greater, but still below ~60s, fan will run at a proportionally decreasing speed between 100% and 80%.  
During the other layers, fan will always run at 80% except for the first layer.

this fan is turbo fan, can be controled by repetier

Fan settings

Fan speed: Min: 80 Max: 100

Bridges fan speed: 100 %

Disable fan for the first: 1 layers

Cooling thresholds

Enable fan if layer print time is below: 60 approximate seconds

Slow down if layer print time is below: 30 approximate seconds

Min print speed: 10 mm/s

File Window Help

Print Settings Filament Settings Printer Settings

My Settings

General Custom G-code Extruder 1

Size

Nozzle diameter: 0.4 mm

Position (for multi-extruder printers)

Extruder offset: x: 0 y: 0 mm

Retraction

Length: 5 mm (zero to disable)

Lift Z: 0 mm

Speed: 30 mm/s

Extra length on restart: 0 mm

Minimum travel after retraction: 2 mm

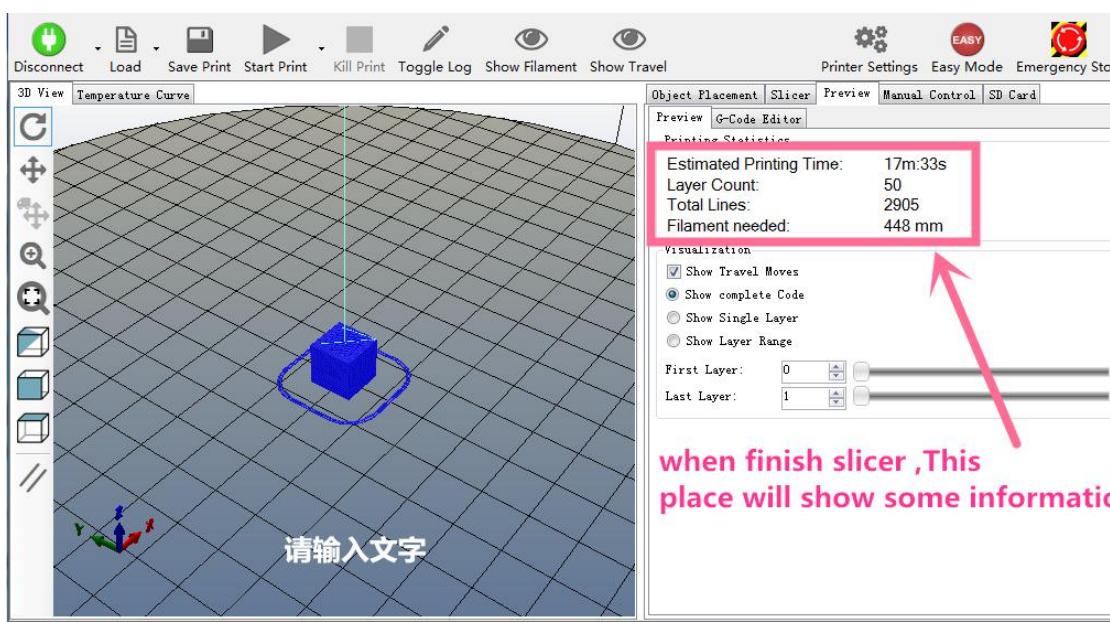
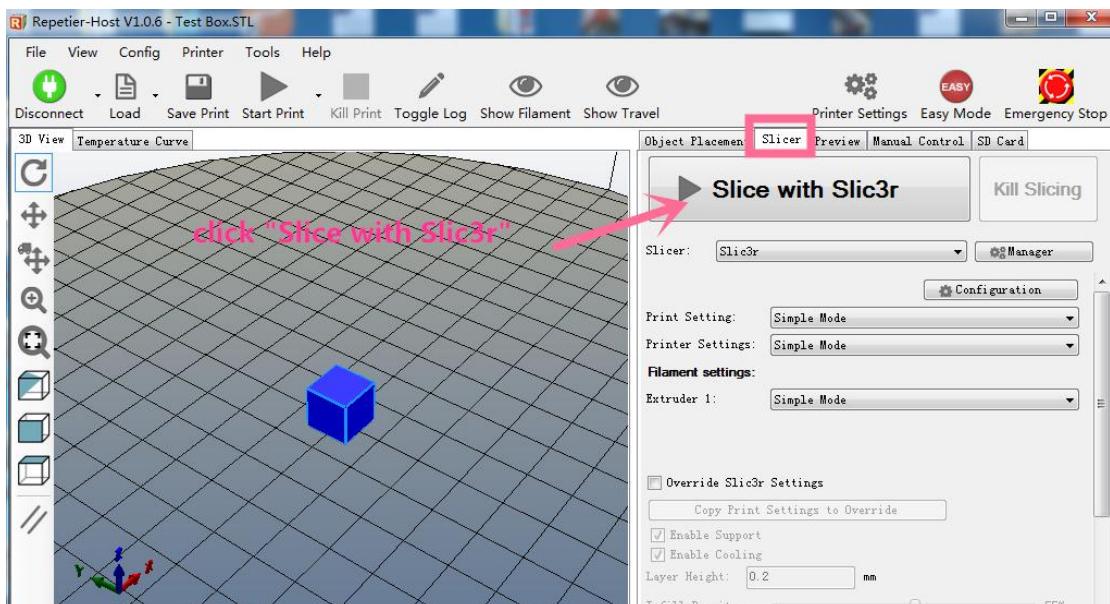
Retract on layer change:

Wipe while retracting:

Retraction when tool is disabled (advanced settings for multi-extruder setups)

Length: 10 mm (zero to disable)

Extra length on restart: 0 mm

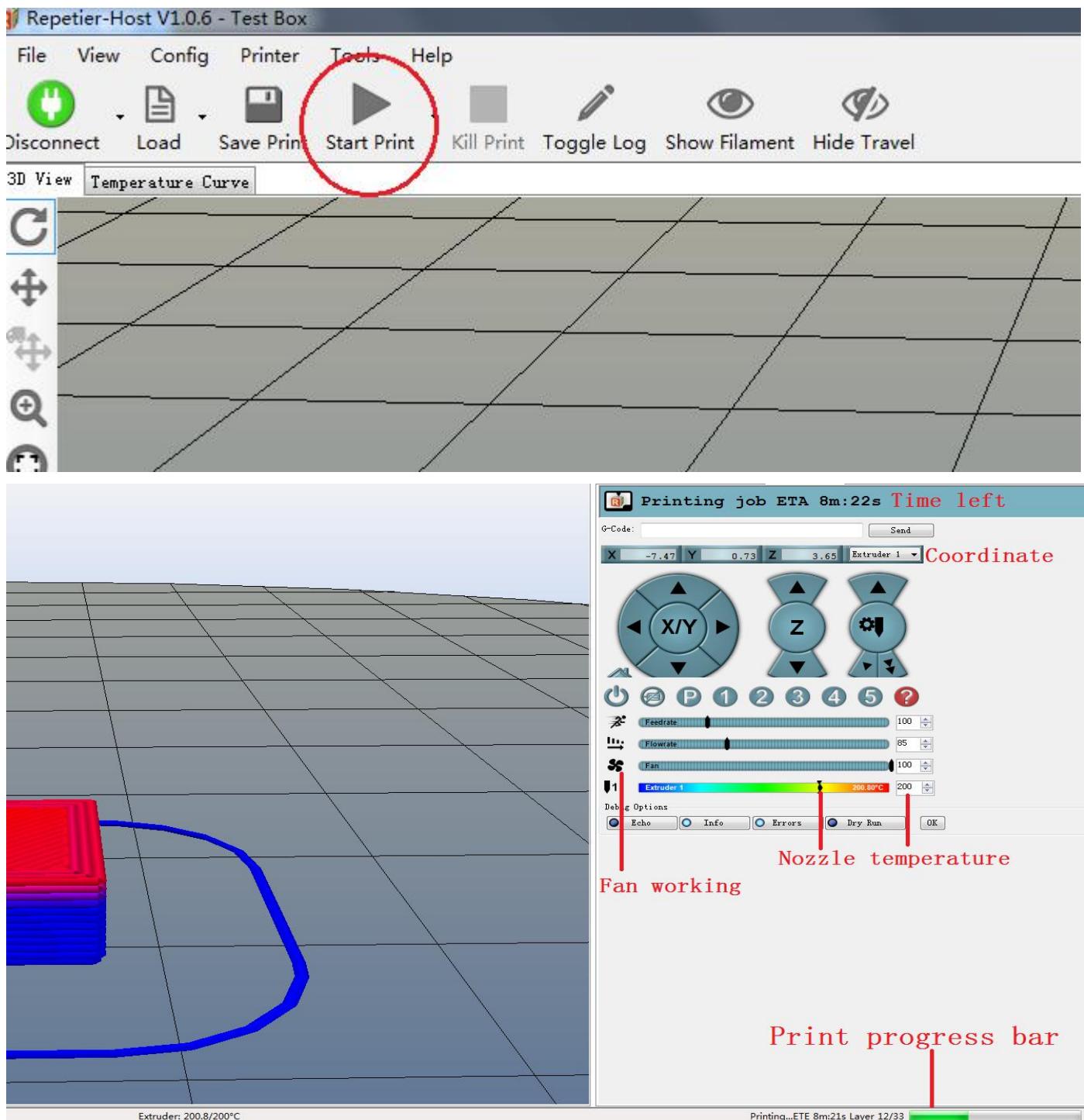


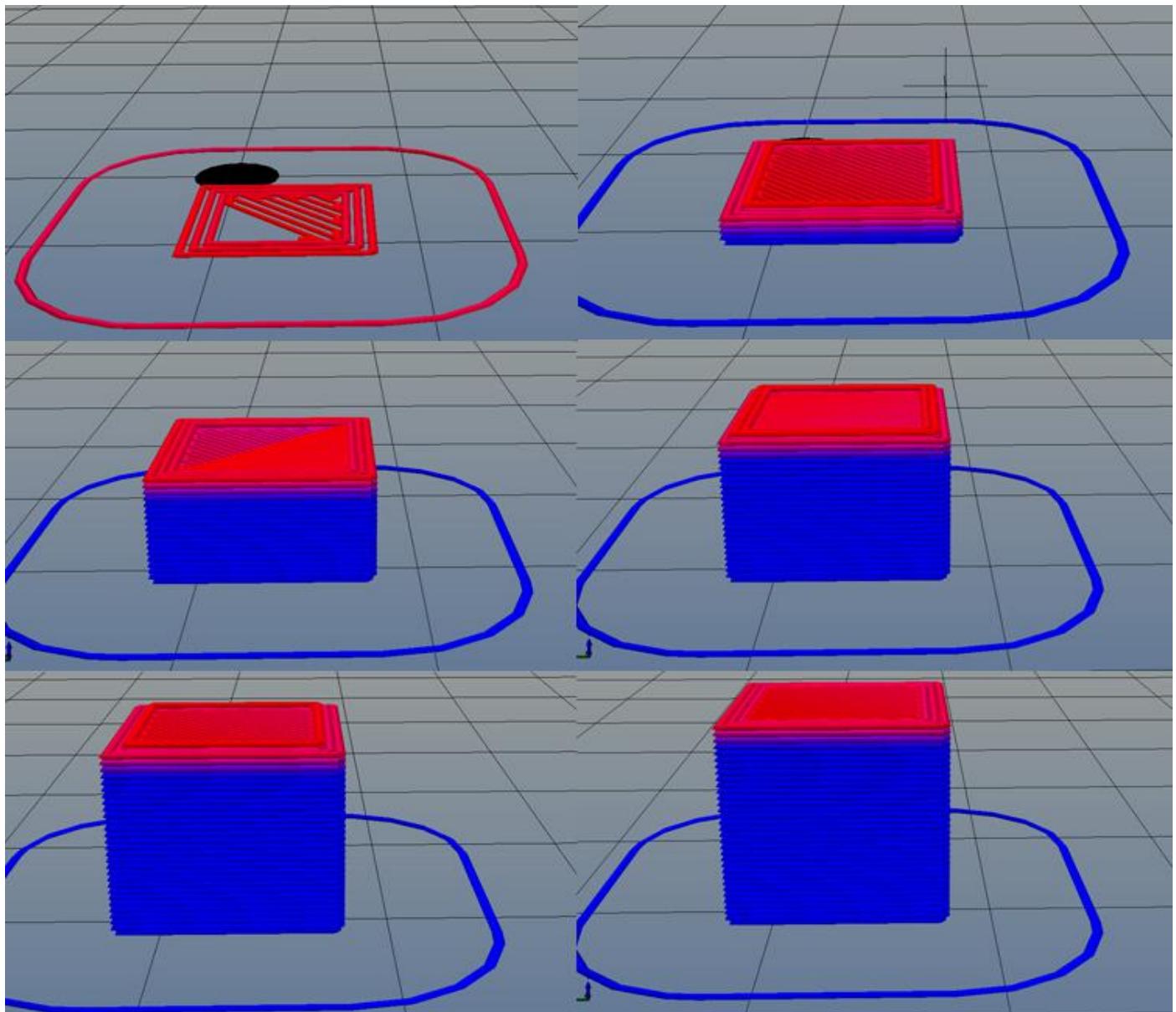
The above pictures only show some key parameters setting when slice, about more info about the slic3d software, pls go to the link as follow.

<http://manual.slic3r.org/intro/overview>

## 4 printing

Complete sliced,could start printing,click the “Start print”,will print the model, the panel display printing progress.





If when print ,the distance between nozzle and bed is big (filament can't stick at bed),you can reduce the offset ,E.g:change -1.4 to -1.5,-1.8,-2.0.

If when print ,the distance between nozzle and bed is too small(nozzle hit bed),you can add the offset in marlin ,eg:change -1.4 to -1.2,-1.0,-0.8.

```
// L (+) P R <-- probe (20,20)
// E | I
// F | (-) II (+) G <-- nozzle (10,10)
// T | H
// | (-) I
// | |
// 0-- FRONT ++
// (0,0)

#define X_PROBE_OFFSET_FROM_EXTRUDER 15 // X offset: -left +right [of the n
#define Y_PROBE_OFFSET_FROM_EXTRUDER -11 // Y offset: -front +behind [the no
#define Z_PROBE_OFFSET_FROM_EXTRUDER -1.4 // Z offset: -below +above [the

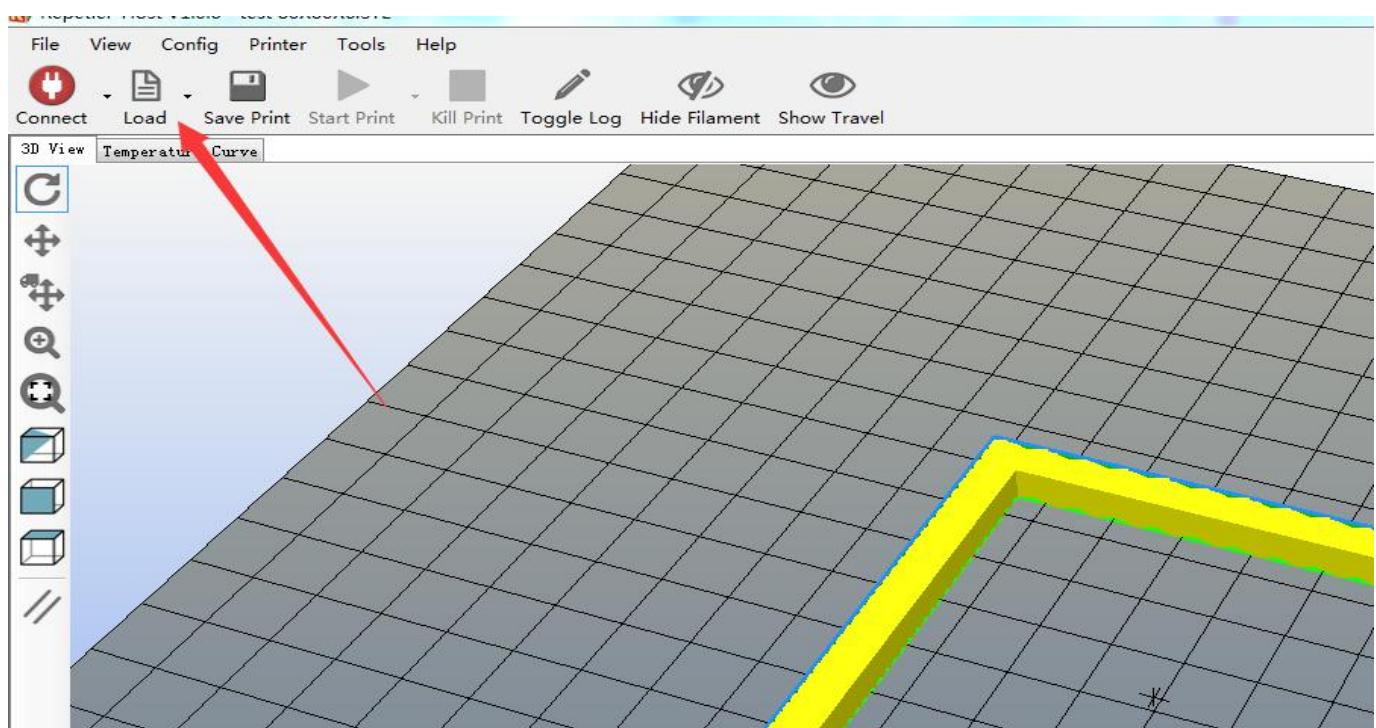
// X and Y axis travel speed (mm/m) between probes
#define XY_PROBE_SPEED 8000
// Speed for the first approach when double-probing (with PROBE_DOUBLE_TOUCH)
#define Z_PROBE_SPEED_FAST HOMING_FEEDRATE_Z

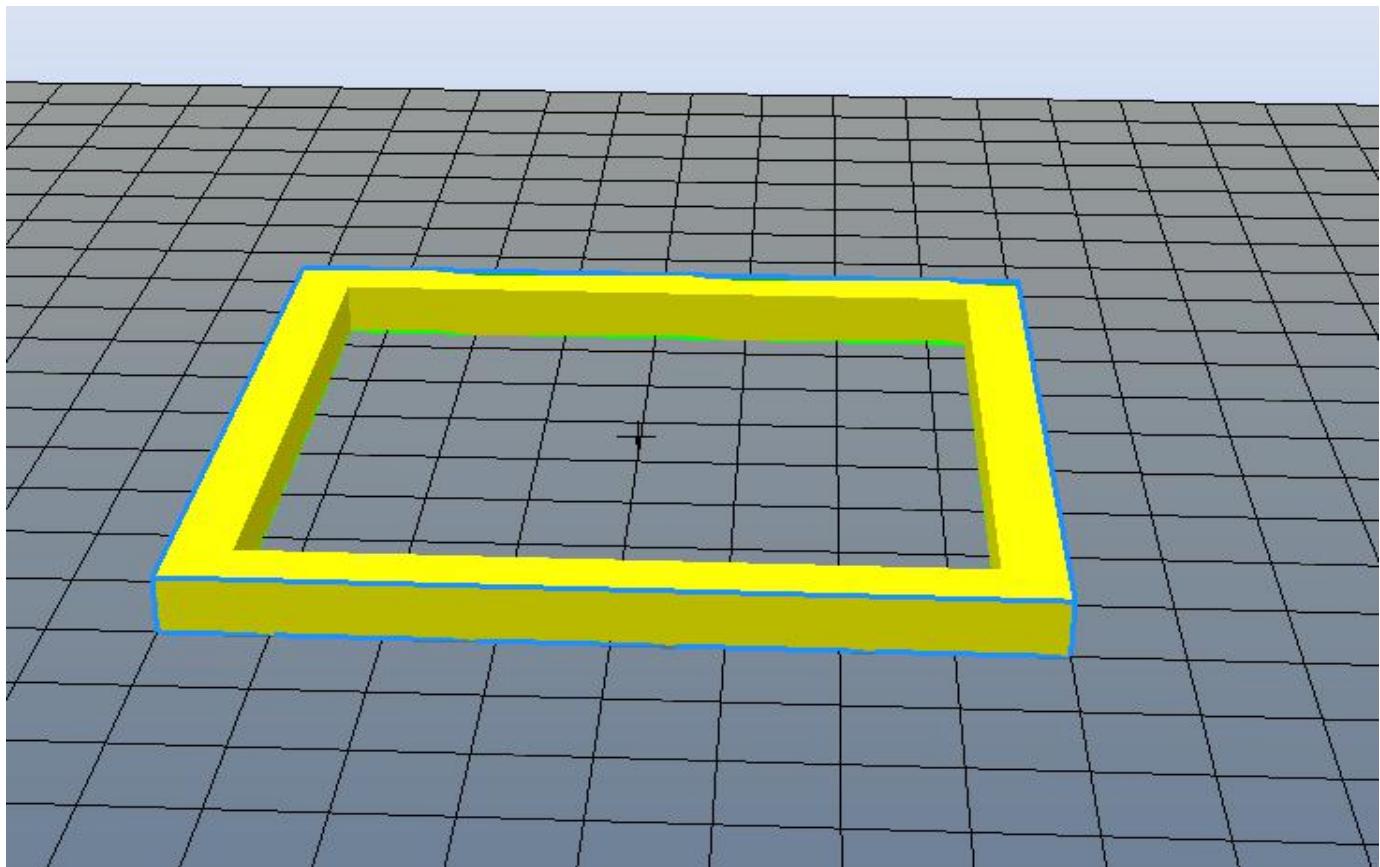
```

The value is at configuration.h ,481line.

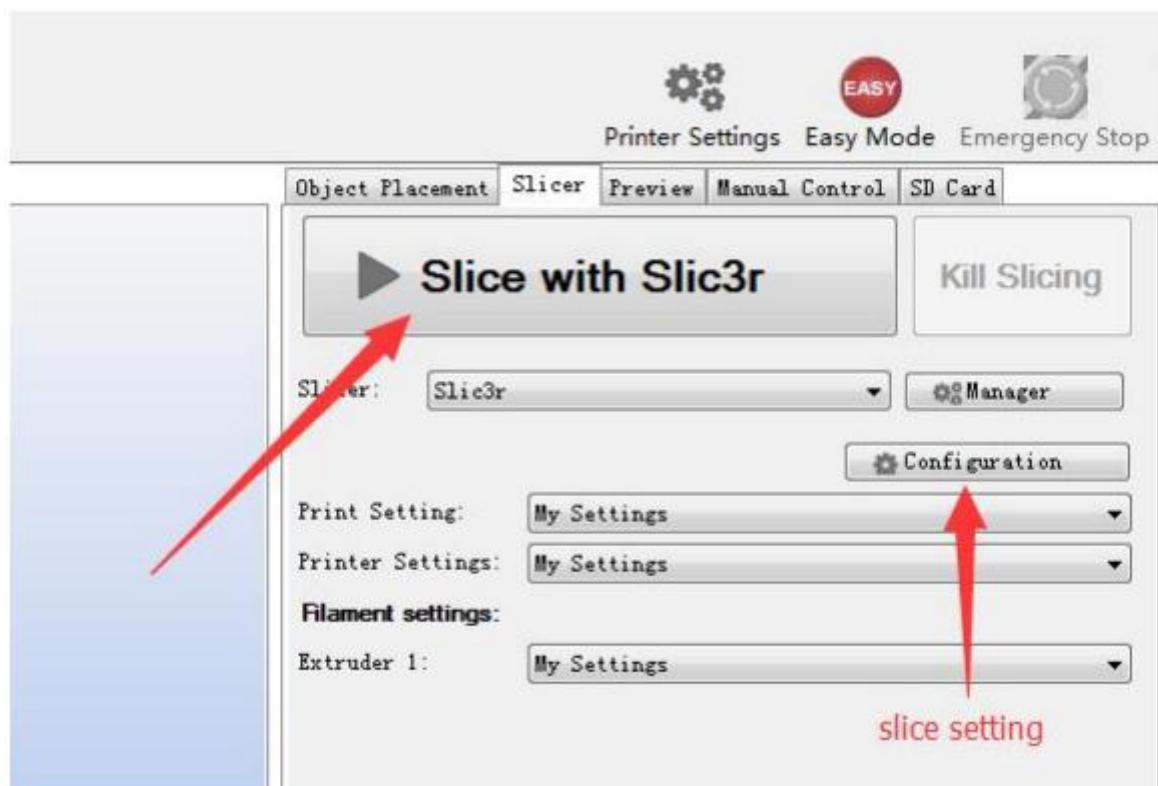
### 3 Offline printing

#### 1 load the model





2 slice





Printer Settings Easy Mode Emergency Stop

Object Placement Slicer Preview Manual Control SD Card

Preview G-Code Editor

Printing Statistics

Estimated Printing Time: 49m:5s  
Layer Count: 23  
Total Lines: 12895  
Filament needed: 3736 mm

Visualization

- Show Travel Moves  
 Show complete Code  
 Show Single Layer  
 Show Layer Range

First Layer:

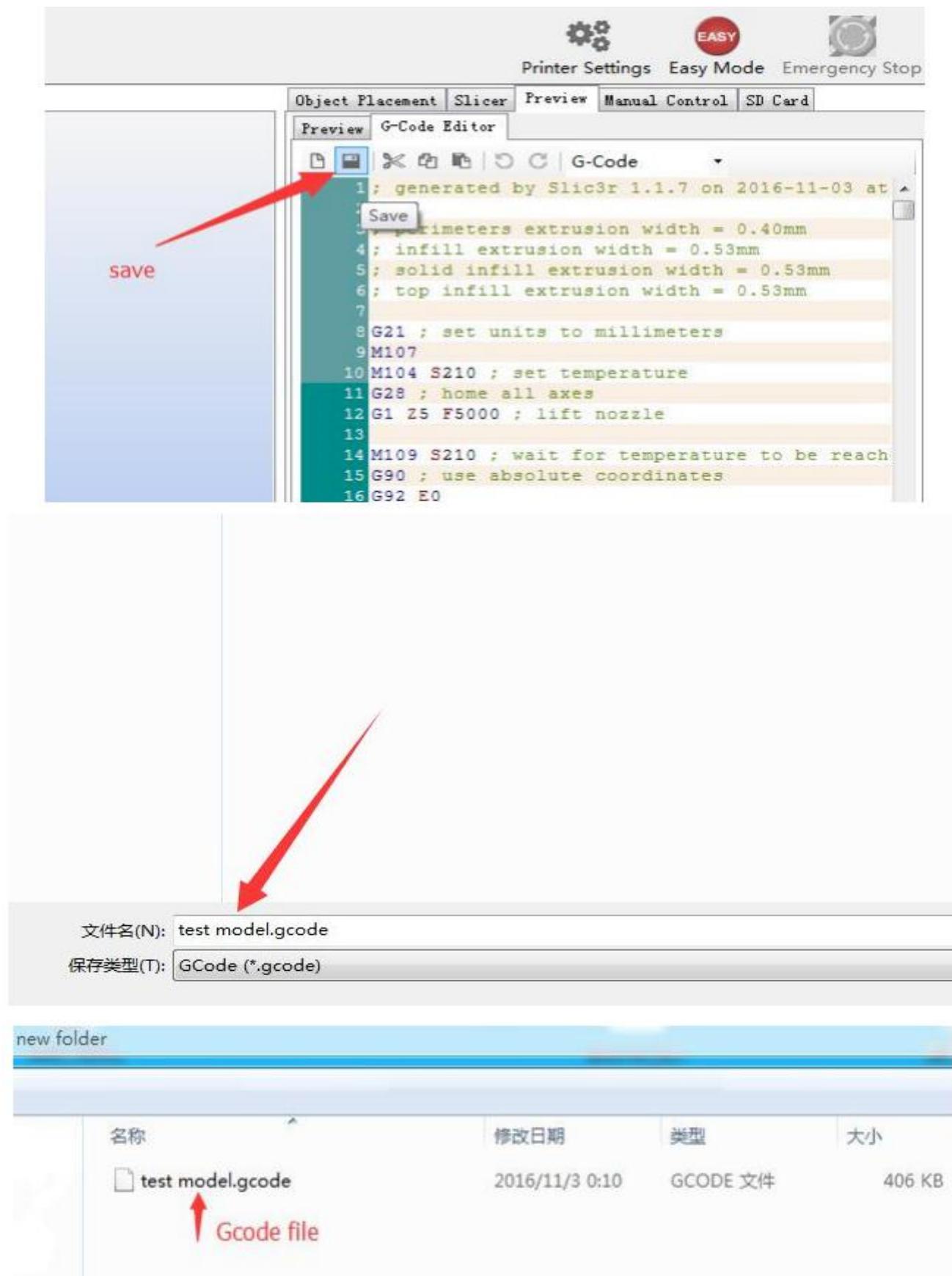
0

Last Layer:

1

after slicing

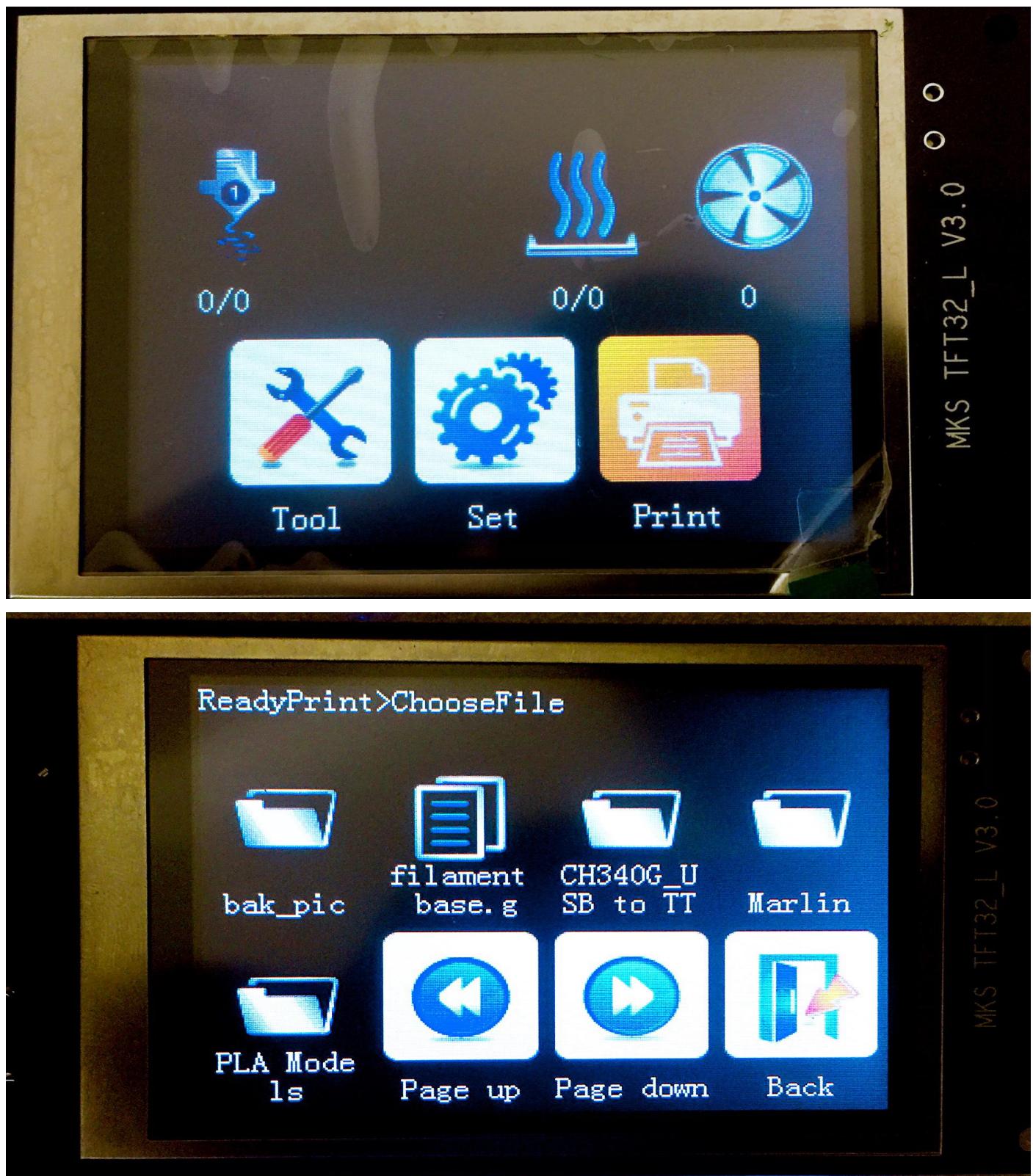
### 3 Export Gcode file



## 4 Copy

Copy the Gcode file to SD card and insert the SD card into LCD

## 5 Printing



## 4 Marlin

# Sometimes we will encounter some problems that need to be changed and uploaded marlin

## 1 Arduino

The marlin is the printer program which run the printer,it's also named firmware.

Arduino is an working environment for firmware, only installing the arduino on PC,then can open marlin and flash program to board, if you are not familiar with the software,pls don't change any parameters,thank you.

autolevel Marlin-1.1.2 -cube printer ...	2017/8/19 星期...	文件夹
Marlin-1.1.2 -cube printer marlin	2017/8/19 星期...	文件夹
arduino-1.8.1-macosx	2017/2/3 星期五 ...	压缩(zipped)文件... 151,733 KB
arduino-1.8.1-windows	2017/2/3 星期五 ...	应用程序 91,528 KB
autolevel Marlin-1.1.2 -cube printer ...	2017/7/15 星期...	压缩(zipped)文件... 2,024 KB
Marlin-1.1.2 -cube printer marlin	2017/7/15 星期...	压缩(zipped)文件... 2,024 KB
setupRepetierHost_1_0_6	2017/7/15 星期...	应用程序 22,018 KB

## 2 Marlin

### 1 Open marlin

open marlin, if it's compressed file,must unzip it.

find the icon green color,this format is "ino", click and open it in arduino.

autolevel Marlin-1.1.2 -cube printer ...	2017/8/19 星期...	文件夹
Marlin-1.1.2 -cube printer marlin	2017/8/19 星期...	文件夹
arduino-1.8.1-macosx	2017/2/3 星期五 ...	压缩(zipped)文件... 151,733 KB
arduino-1.8.1-windows	2017/2/3 星期五 ...	应用程序 91,528 KB
autolevel Marlin-1.1.2 -cube printer ...	2017/7/15 星期...	压缩(zipped)文件... 2,024 KB
Marlin-1.1.2 -cube printer marlin	2017/7/15 星期...	压缩(zipped)文件... 2,024 KB
setupRepetierHost_1_0_6	2017/7/15 星期...	应用程序 22,018 KB

least_squares_fit.cpp	2017/5/31 星期...	CPP 文件	3 KB
least_squares_fit.h	2017/5/31 星期...	H 文件	3 KB
M100_Free_Mem_Chk.cpp	2017/5/31 星期...	CPP 文件	12 KB
macros.h	2017/5/31 星期...	H 文件	7 KB
Makefile	2017/5/31 星期...	文件	16 KB
Marlin.h	2017/5/31 星期...	H 文件	16 KB
Marlin	2017/5/31 星期...	Arduino file	2 KB
Marlin_main.cpp	2017/5/31 星期...	CPP 文件	402 KB
MarlinConfig.h	2017/5/31 星期...	H 文件	2 KB
MarlinSerial.cpp	2017/5/31 星期...	CPP 文件	14 KB
MarlinSerial.h	2017/5/31 星期...	H 文件	7 KB

## 2 settings

Firmware could only be upload succeed when the settings like the above

Go to tools > board >arduino mega 2560

Go to tools > port, select the COM port

Go to tools > programmers > USBtinyISP



## 3 Upload Firmware

Click the 上传 (Upload) button to upload the Marlin Firmware Sketch to MKS Gen\_LV1.0 Controller Board. Once upload successful, message “Done”.

**pls disconnect repetier when flash firmware !!!**



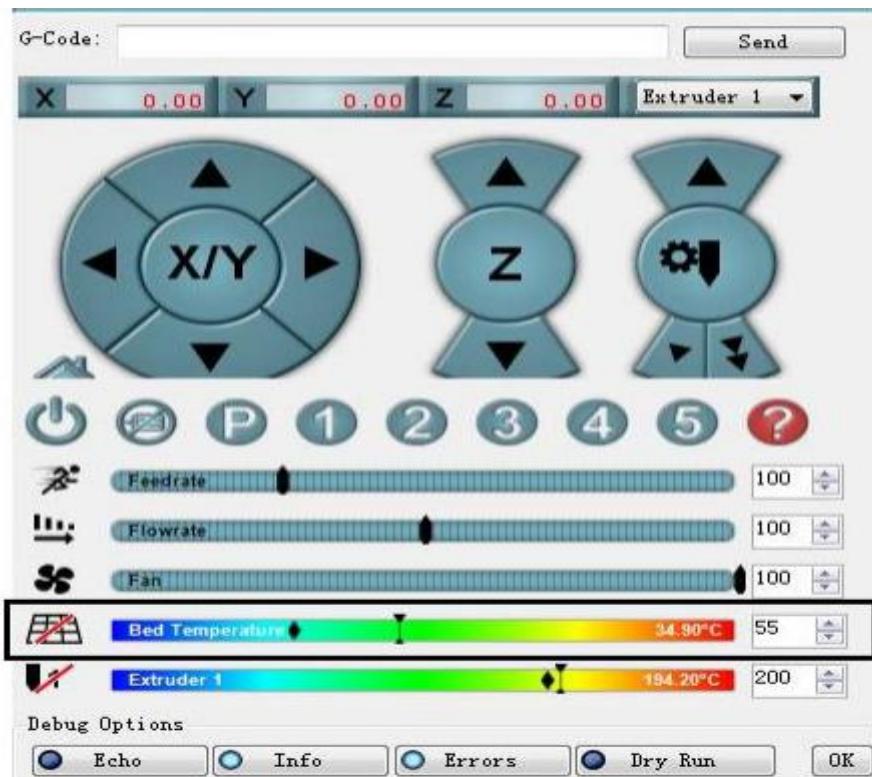
## 5 Heated bed

if use PLA filament,no need open heated bed.

If use ABS filament,need open heated bed, set the heated bed temp 85-100°C

Must connect heat bed line to board heated bed sensor to board.

If use repetier to control the printer, can see heated bed choose,can set heated bed temp.



# 6 Problem and advice

## 1. The computer can not install arduino and other software

this situation often occur in the windows10, you can download Arduino1.6.1 online, pay attention to the correct version.

## 2. The computer cann't installed the drive

first enter the device manager to find the port item, double-click the unknown device port (unplug the motherboard, the port disappears, connect the motherboard, the port appears, the port is the printer port), click the 'update driver' button, then click find the driver software the computer ', and then in the' Browse 'to find your driver address, the next step, that's ok.

If you connect the motherboard and computer, in the device manager port, nothing did appear, there may be a problem with the motherboard, please contact us

## 3.marlin upload failed

Marlin toolbar configuration may be wrong, the board (2560), processor (2560), port (2560), programmer (USBtinyISP) need to select the right

Repetier connection is not disconnected

Arduino don't be installed on right location ,don't be installed in C drive

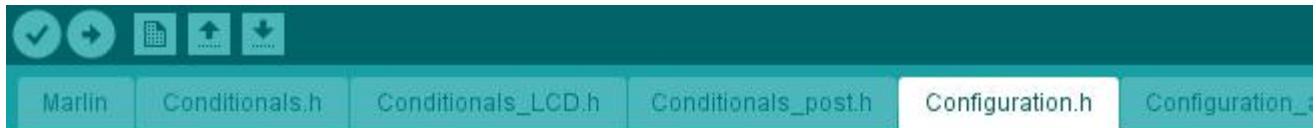
arduino version wrong, the correct version is 1.6.1

## 4.repetier interface nozzle temperature is 0, the display shows "MINTEMP"

Nozzle temperature sensor / white line in the motherboard slot inside the loose, another direction to tighten

may be the nozzle temperature line / white line is broken, measured with a multimeter, the resistance is 100K, you can also insert the hot bed temperature Sensor into the nozzle temperature sensor slot to check.

## 5 if the motor steering is wrong(For example ,control it rises, it drops)



```
// @section extruder

#define DISABLE_E false // For all extruders
#define DISABLE_INACTIVE_EXTRUDER true // Keep only the active extruder enabled.

// @section machine

// Invert the stepper direction. Change (or reverse the motor connector) if an axis goes the wrong way.
#define INVERT_X_DIR false
#define INVERT_Y_DIR true
#define INVERT_Z_DIR true
// Enable this option for Toshiba stepper drivers
//#define CONFIG_STEPPERS_TOSHIBA

// @section extruder

// For direct drive extruder v9 set to true, for geared extruder set to false.
#define INVERT_E0_DIR false
#define INVERT_E1_DIR false
#define INVERT_E2_DIR false
#define INVERT_E3_DIR false
#define INVERT_E4_DIR false
```

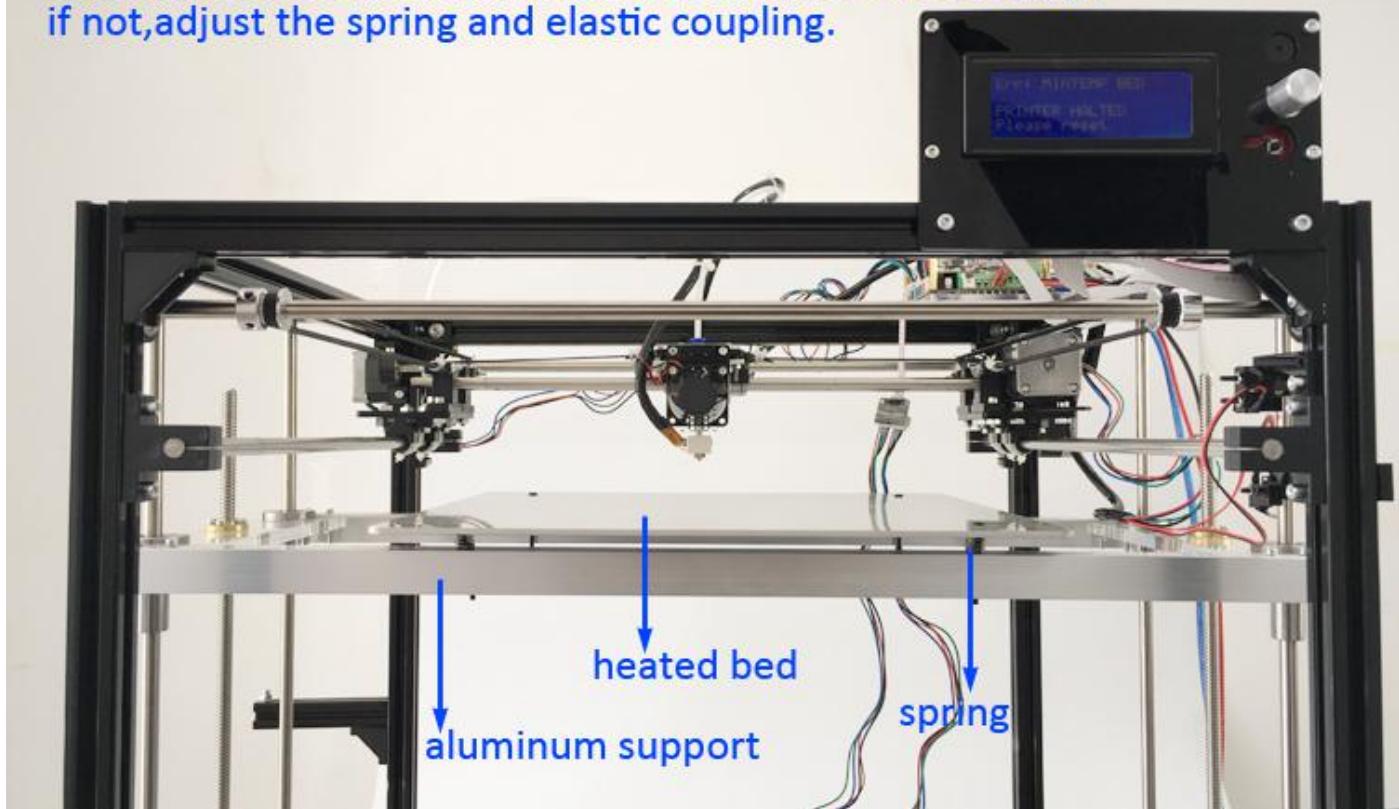
This is the standard motor steering setting, here you can change the motor steering according to your need

**7 if your auto-level senor is bad or not working ,you can use the manual leveling**

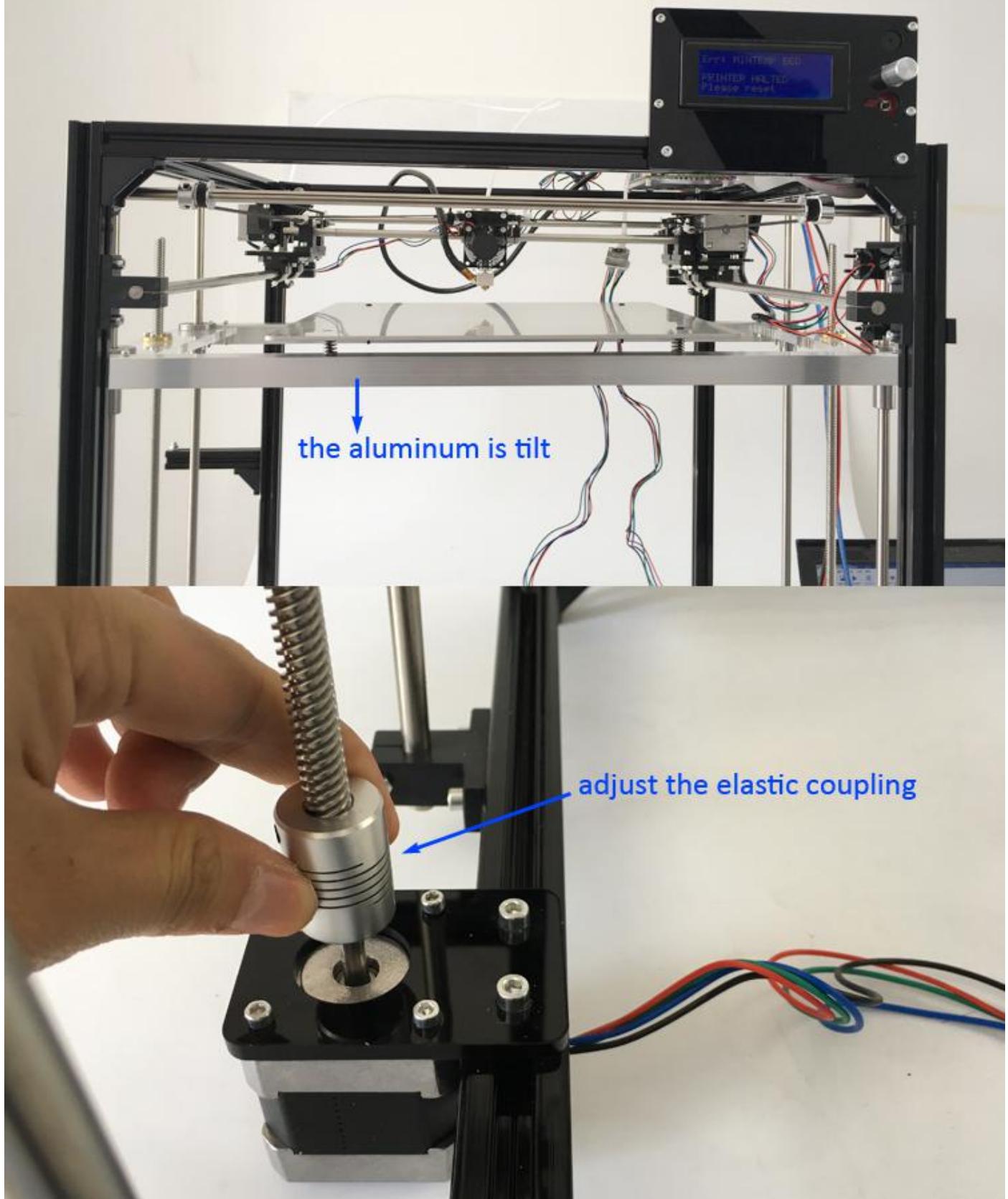
**First you should installed the Z limit switch instead of the Auto-level senor(refer to the the Assembly instructions from page 129 to page131)**

## 1,make leveling

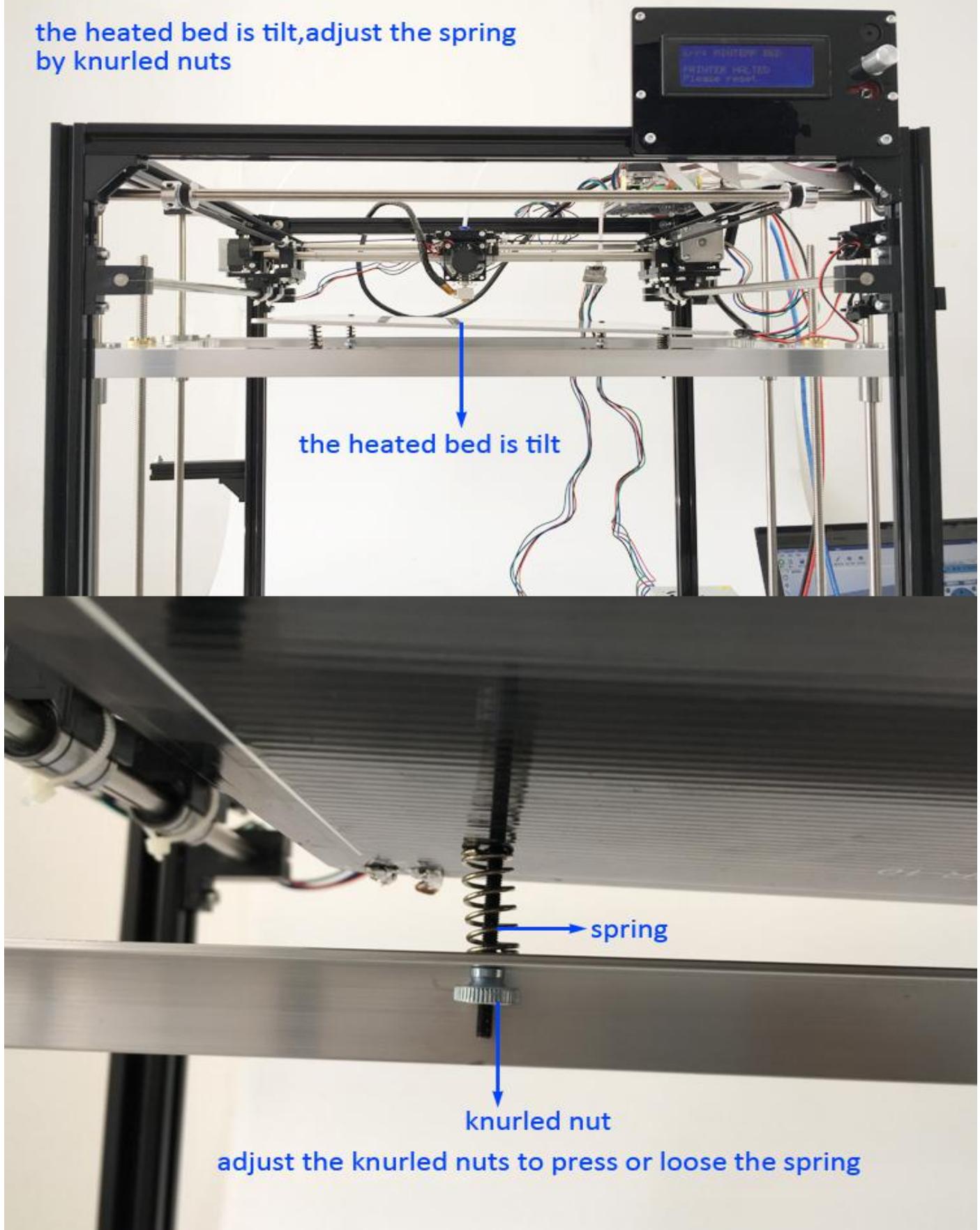
the heated bed and aluminum support should be leveling.  
if not,adjust the spring and elastic coupling.



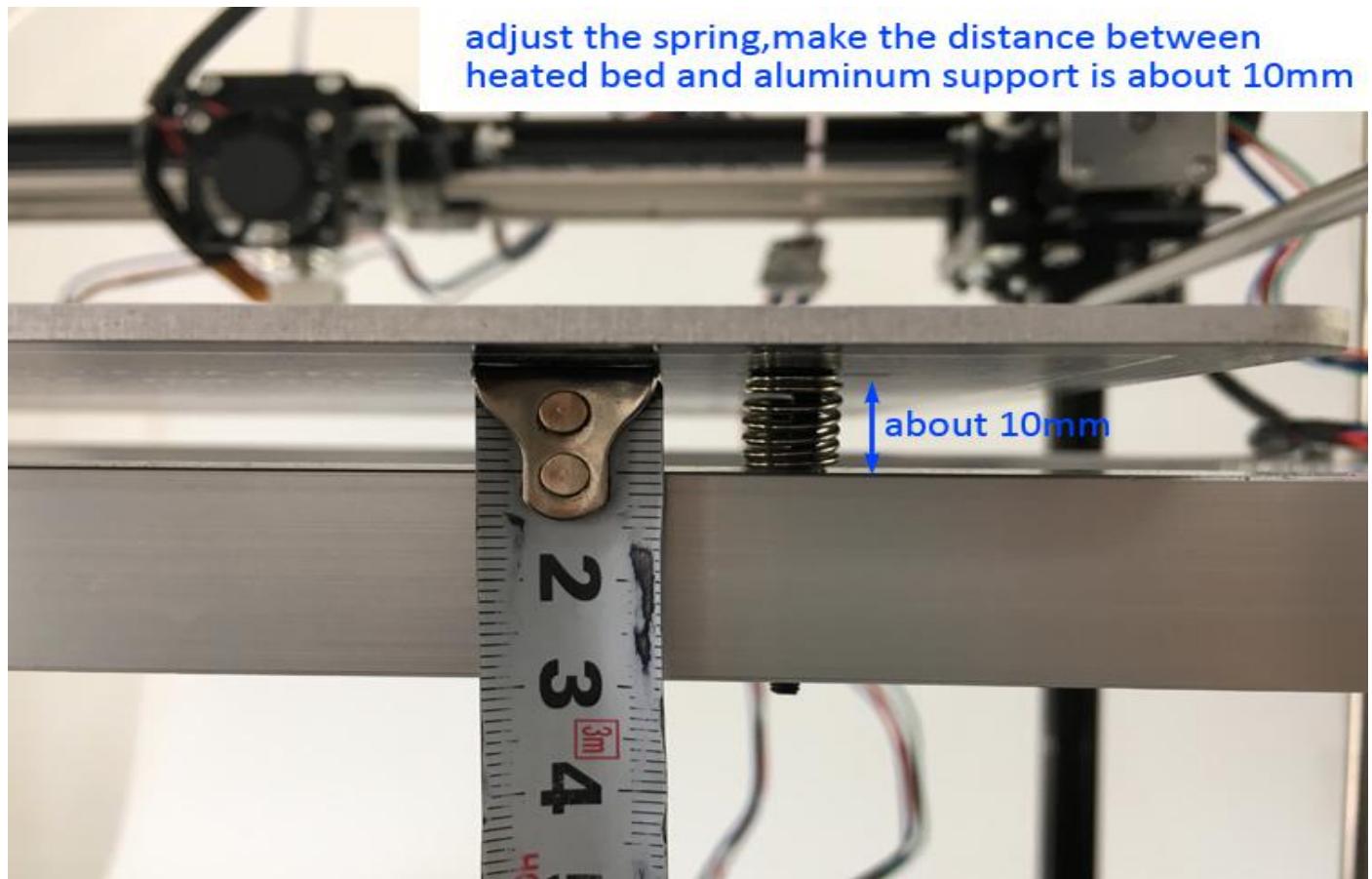
if the aluminum is tilt,adjust the elastic coupling



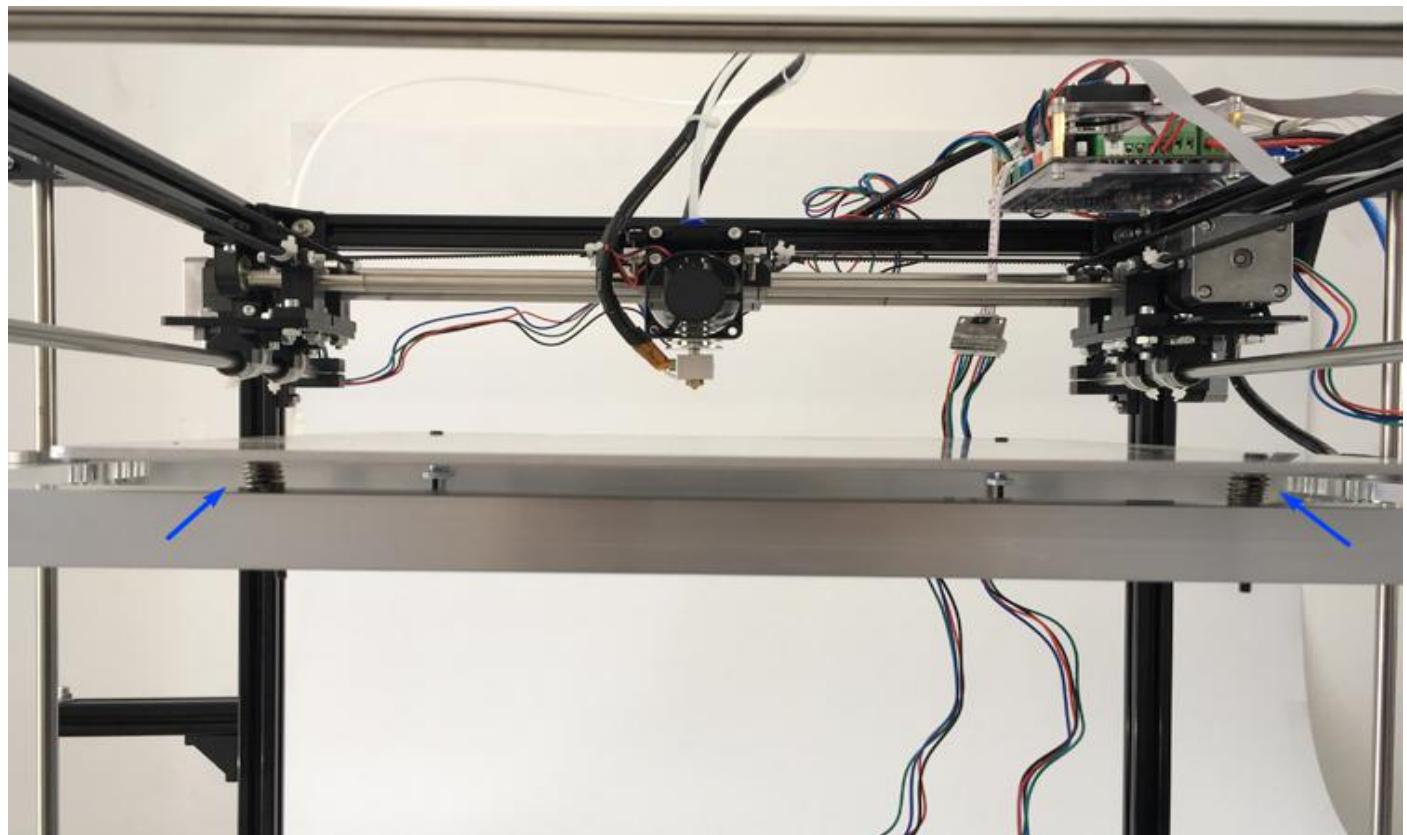
the heated bed is tilt,adjust the spring by knurled nuts

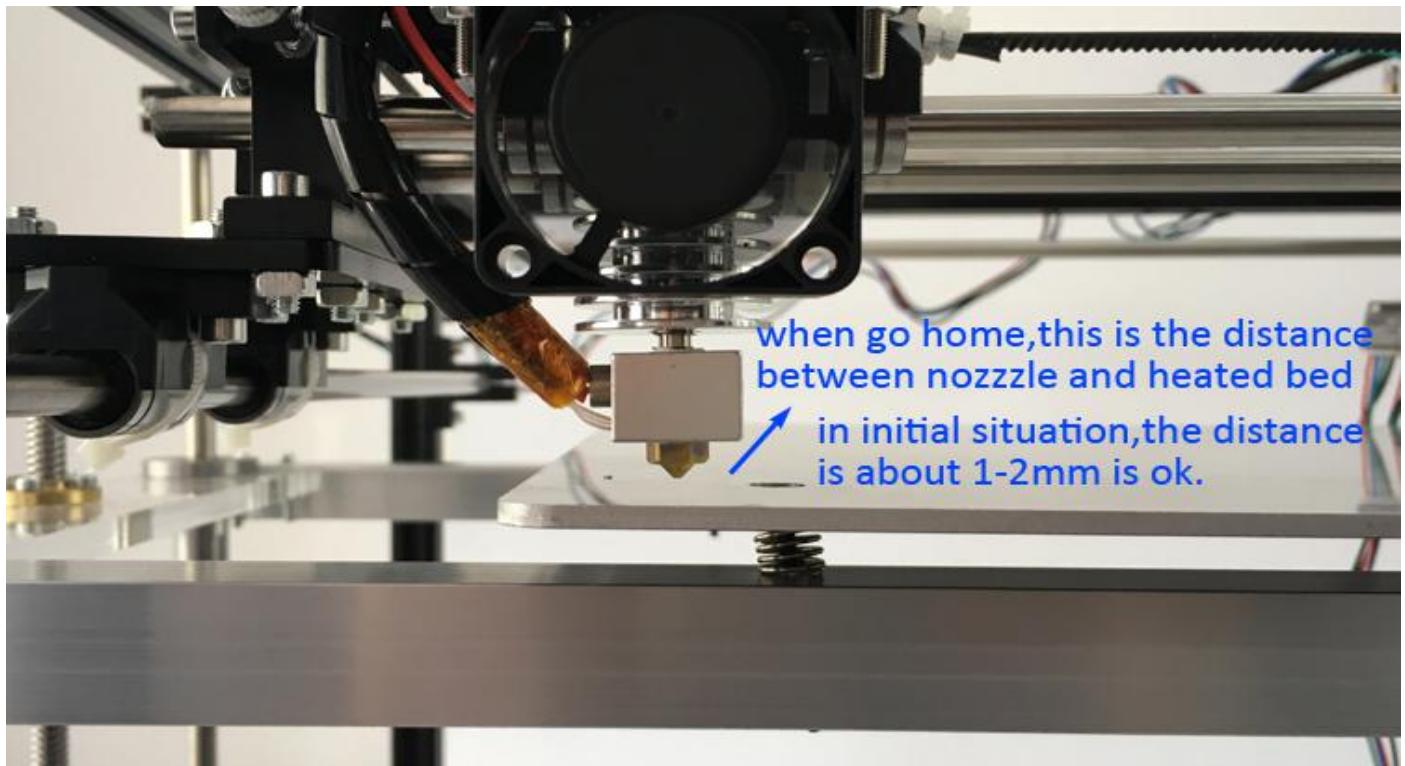


adjust the spring, make the distance between heated bed and aluminum support is about 10mm

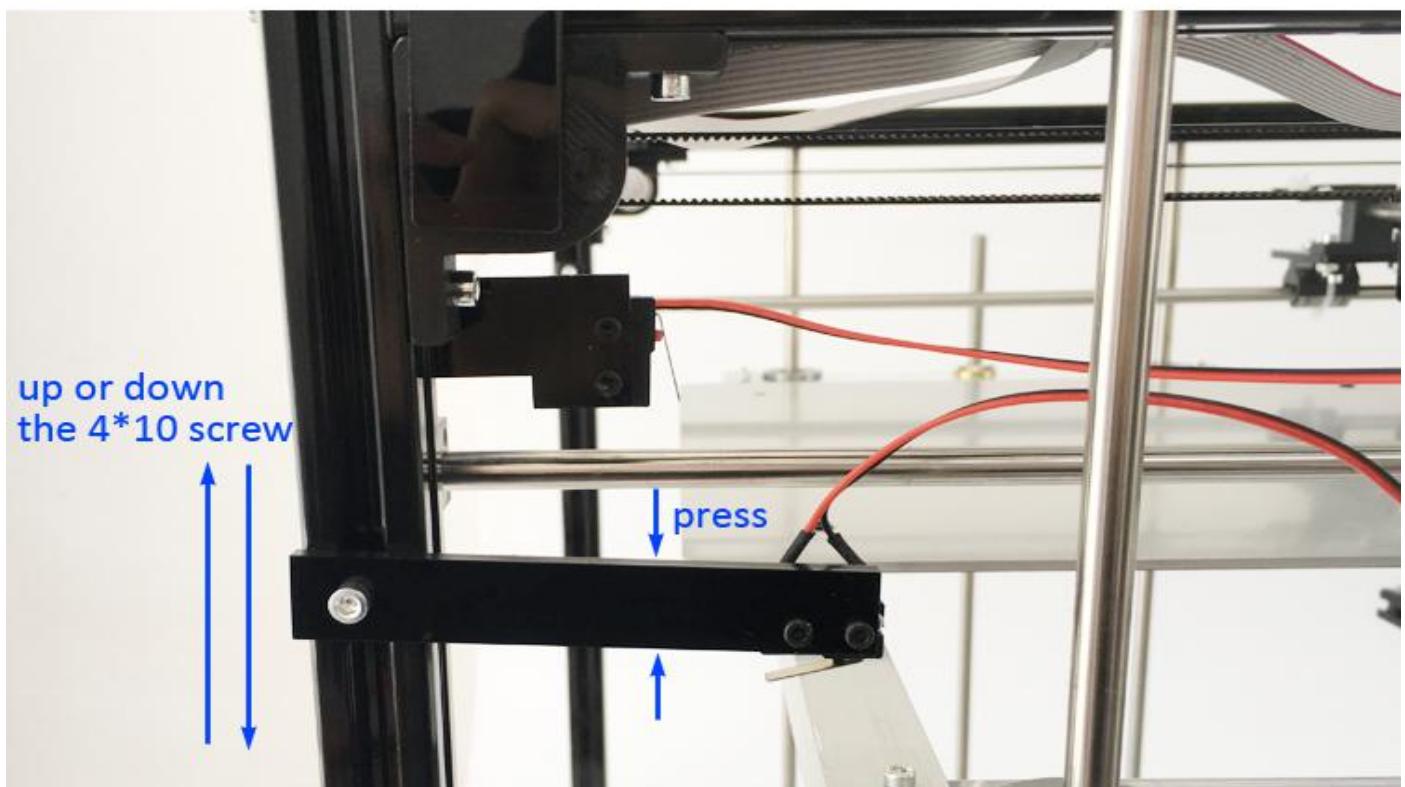


The reason for this is to prepare the spring for later manual leveling



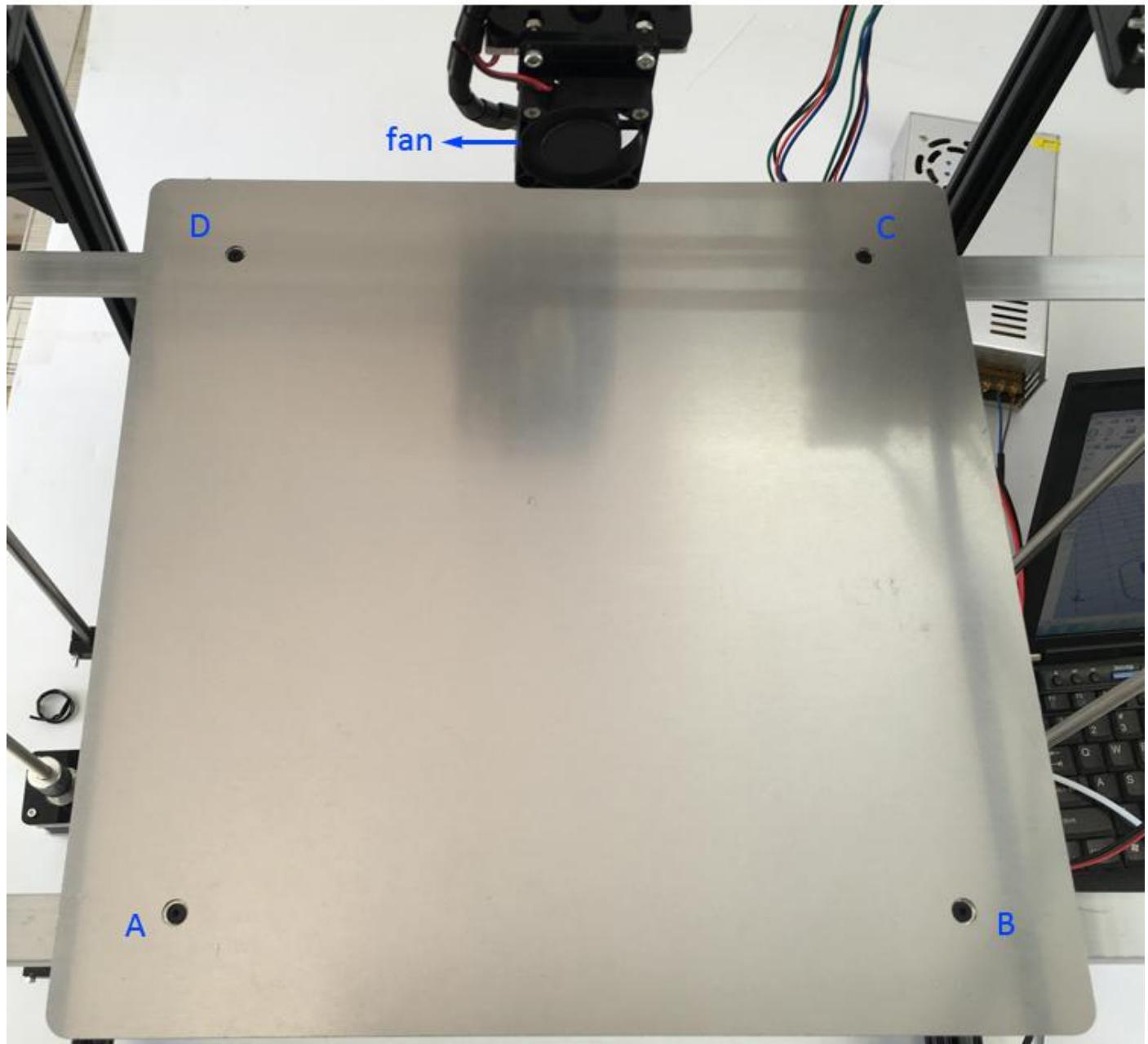


- 1, the distance between nozzle and heated bed depend on Z switch location, this location can be adjusted.
- 2, up or down the M4\*10 screw, can large range adjust the switch.  
press up or down can small range adjust the switch.
- 3, once confirmed location, the M4\*10 screw must firmly fixed.



## 2. Four-point leveling

definity 4 ponits as the picture, A B C D.  
the A B C D is near the M3\*35 screw.have no absolute position.



Here we perform manual leveling with specific coordinates

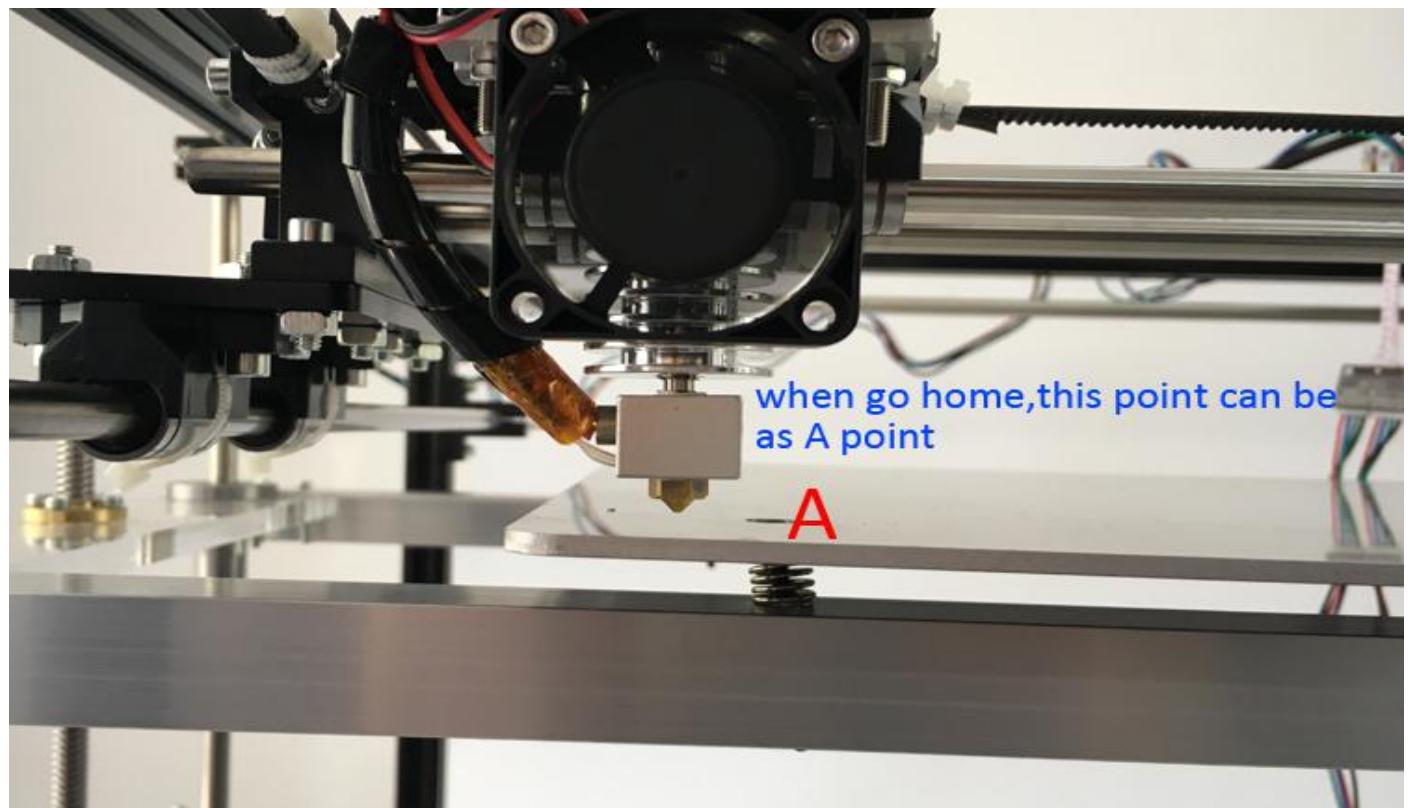
When go home(G28),the point can be as A point

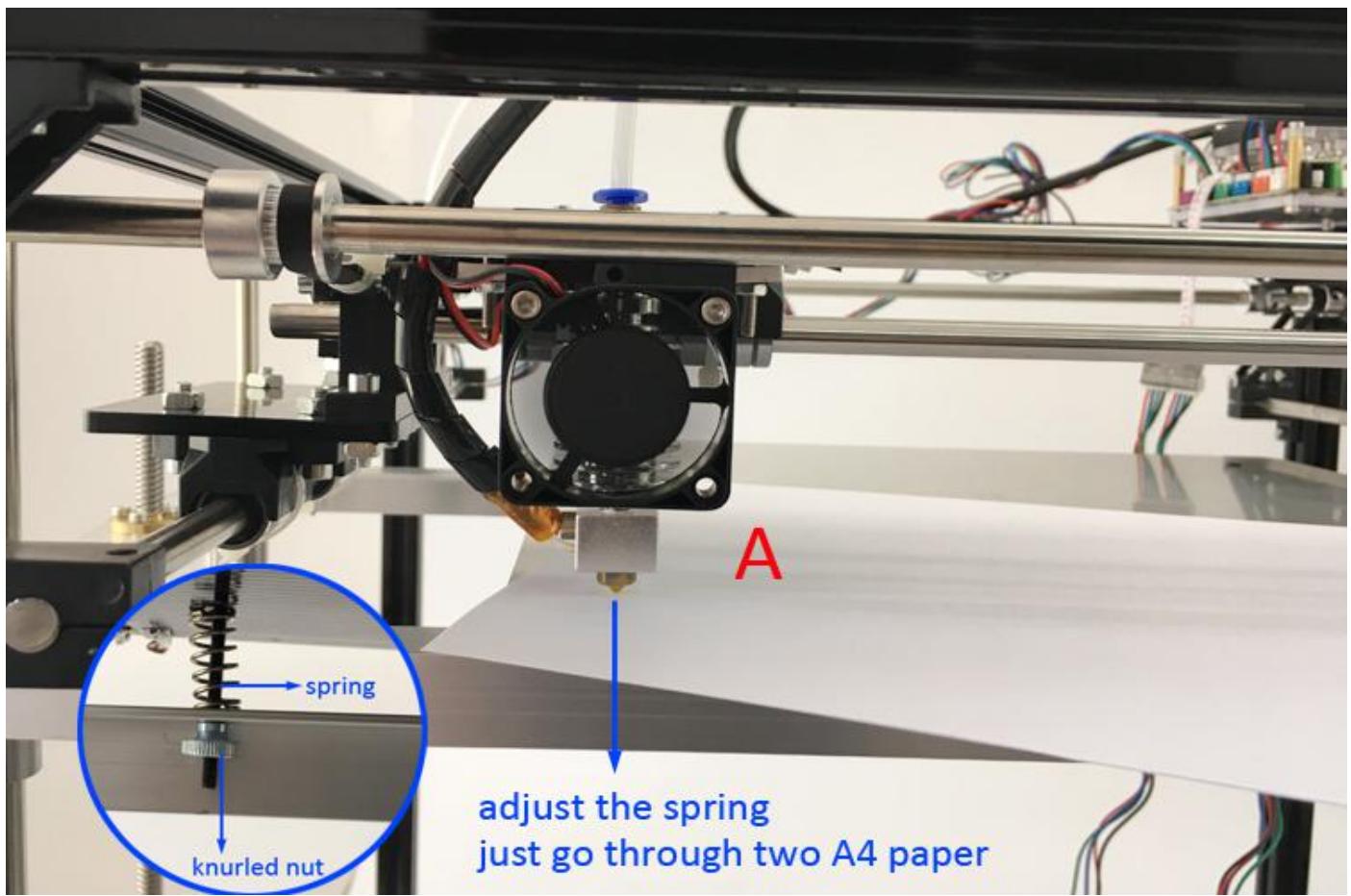
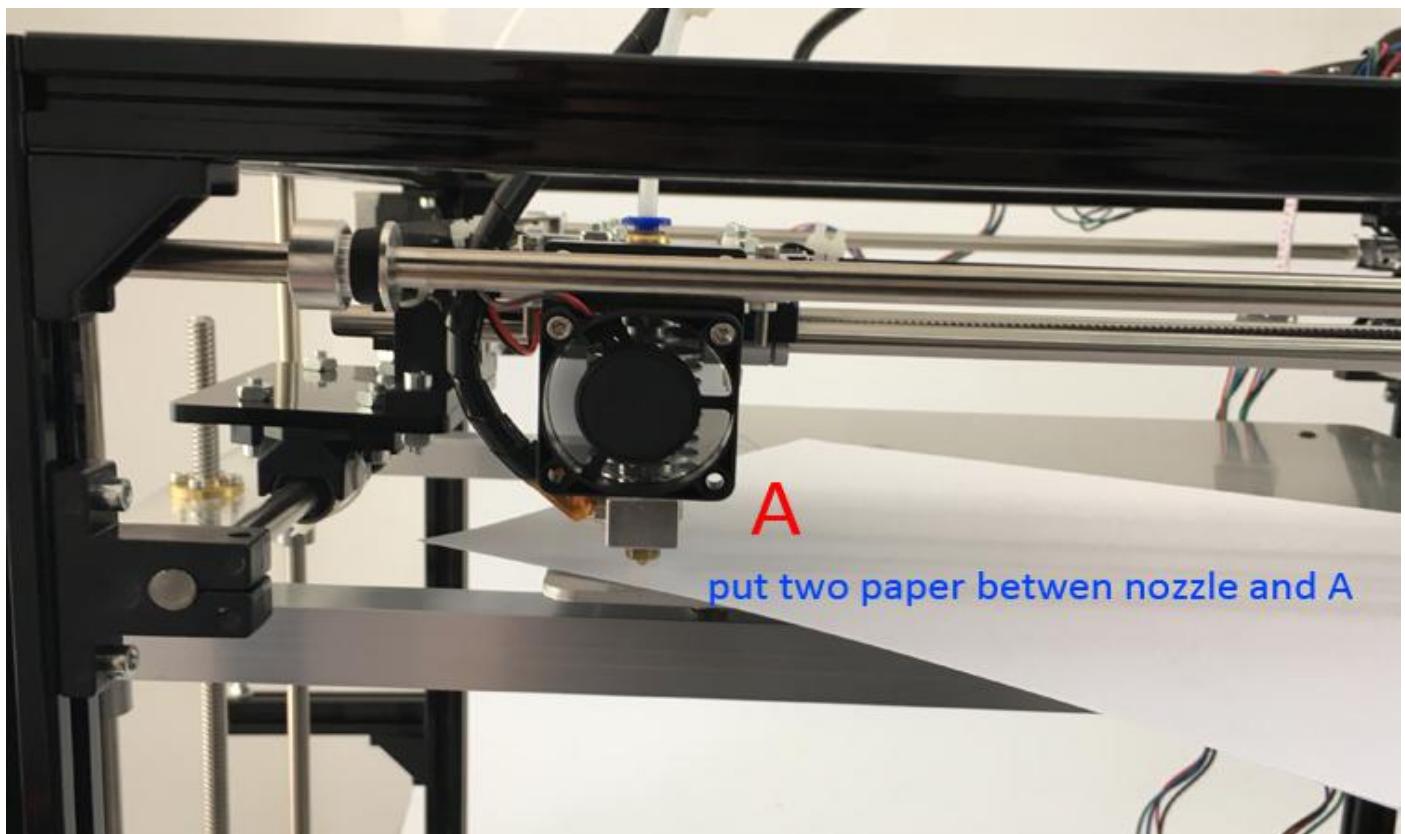
B(G1 X260 Y20) C(G1 X240 Y240) D(G1 X0 Y260)

prepare two A4 paper  
the distance between nozzle and heated bed can  
go through two A4 paper



**Enter G28 in the command bar**

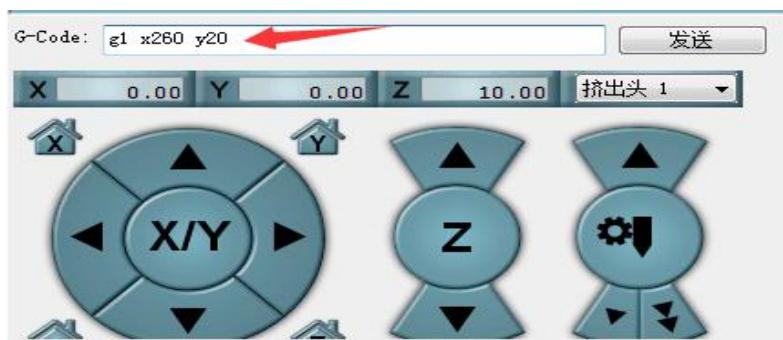




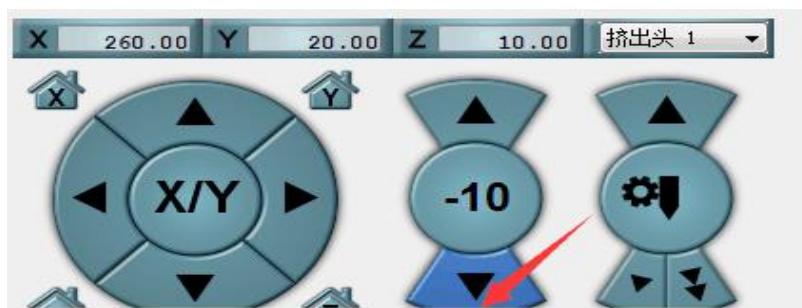
Then



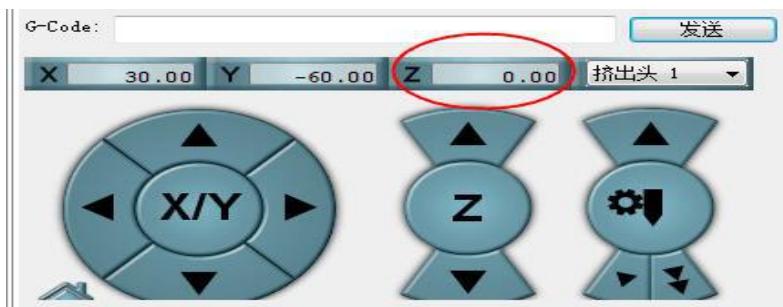
Increase z by 10 and move the nozzle to B(The reason for the rise Z is to prevent the collision platform during the movement of the nozzle to B)

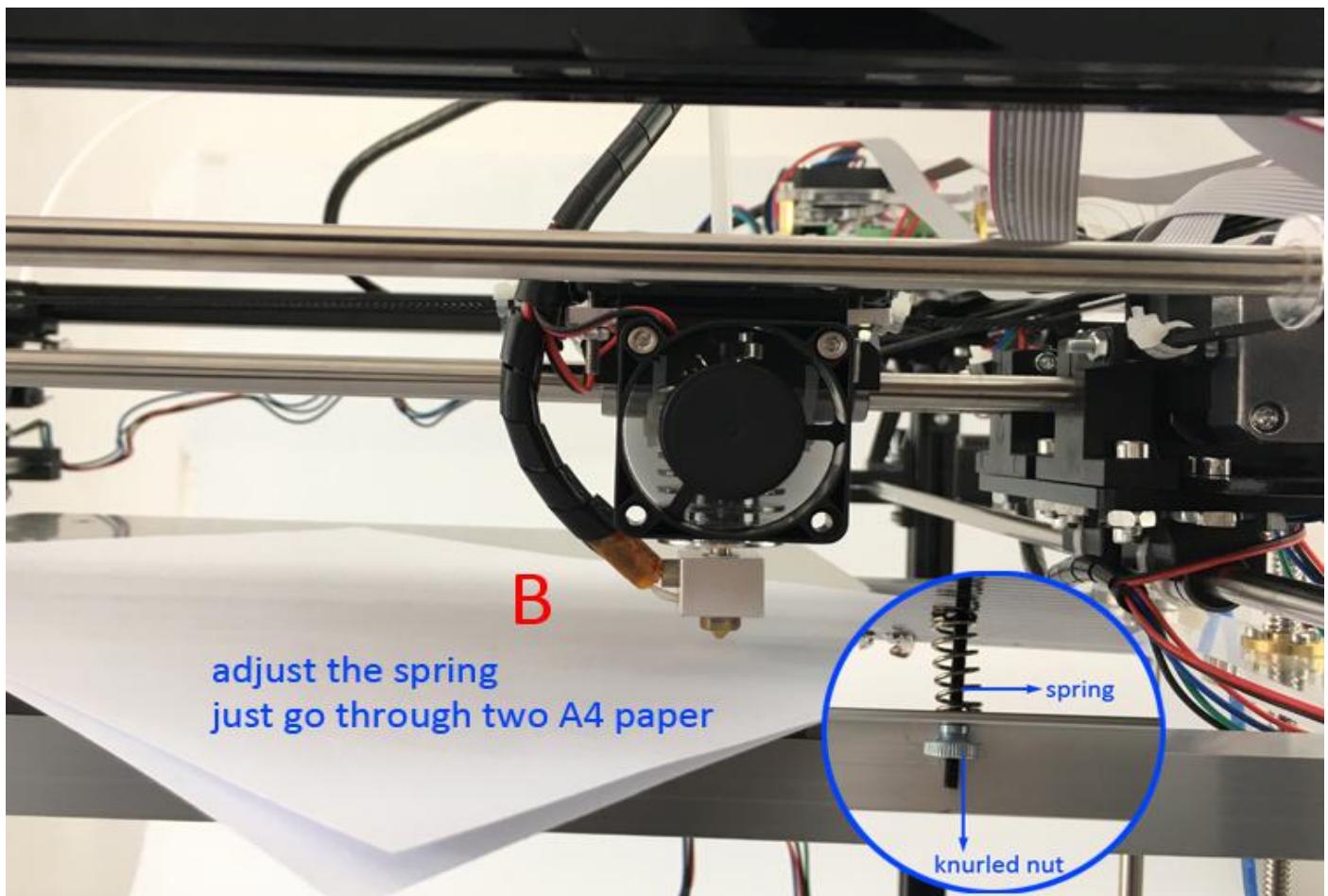
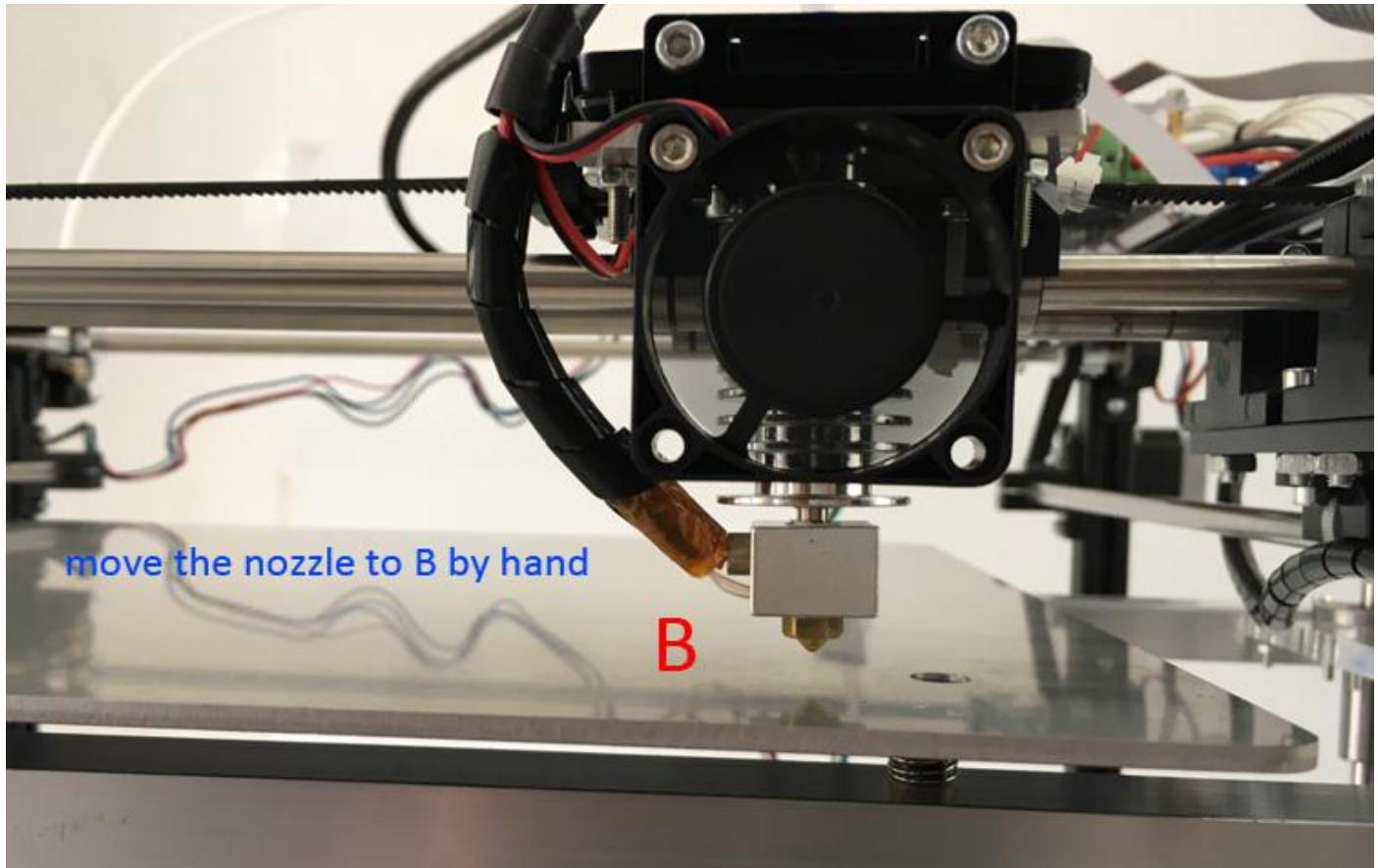


In the Command field, enter the coordinates of point B(G1 X260 Y20) and click Send

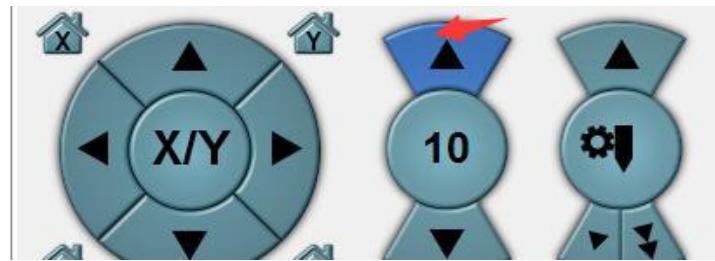


Reduce Z by 10, and then manually adjust the point B

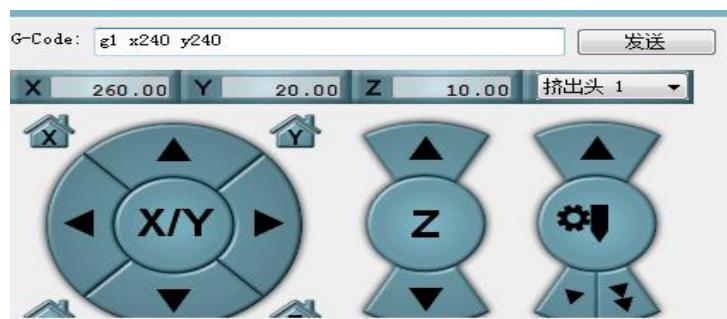




Then



Increase z by 10 and move the nozzle to C(The reason for the rise Z is to prevent the collision platform during the movement of the nozzle to C)

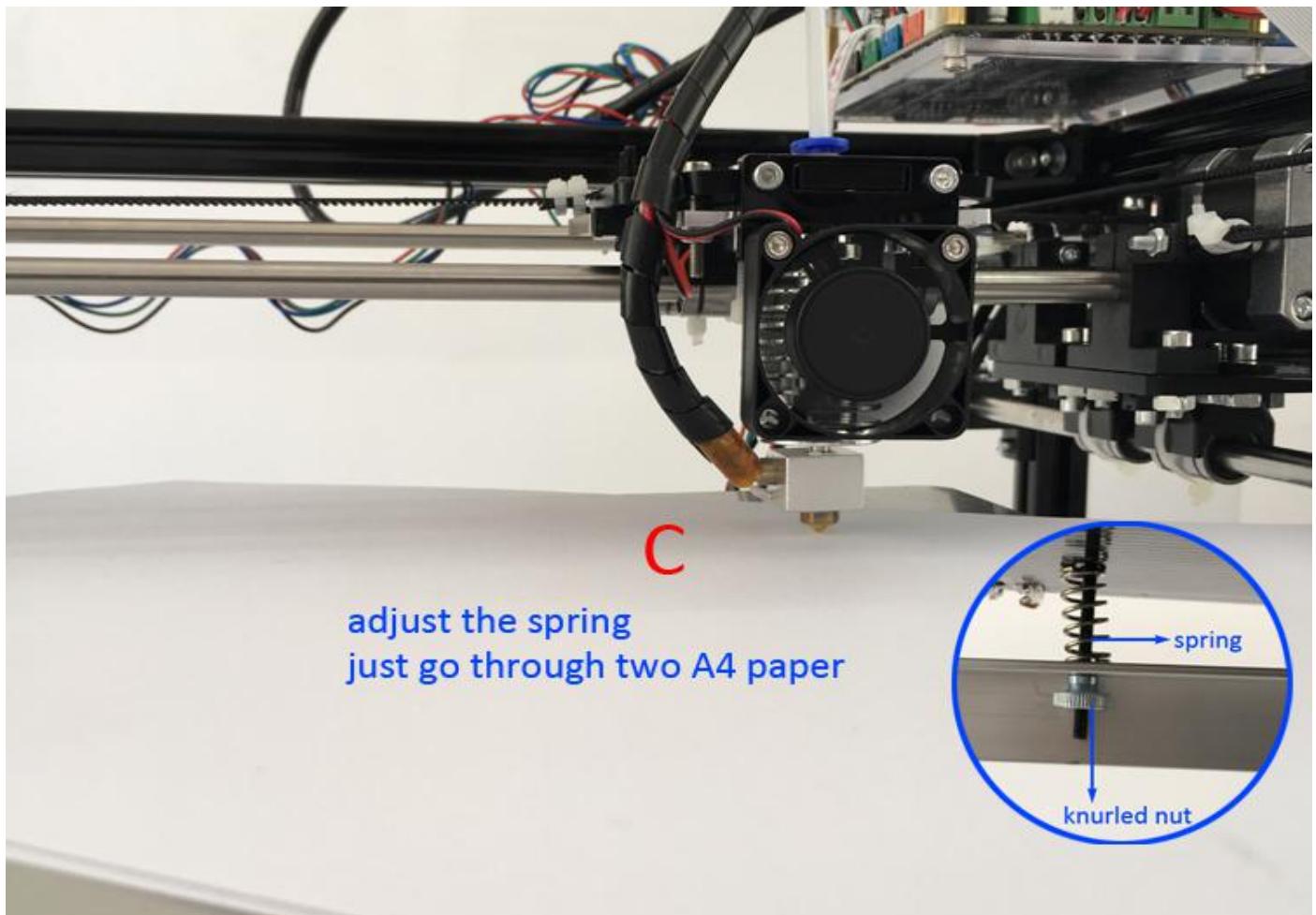
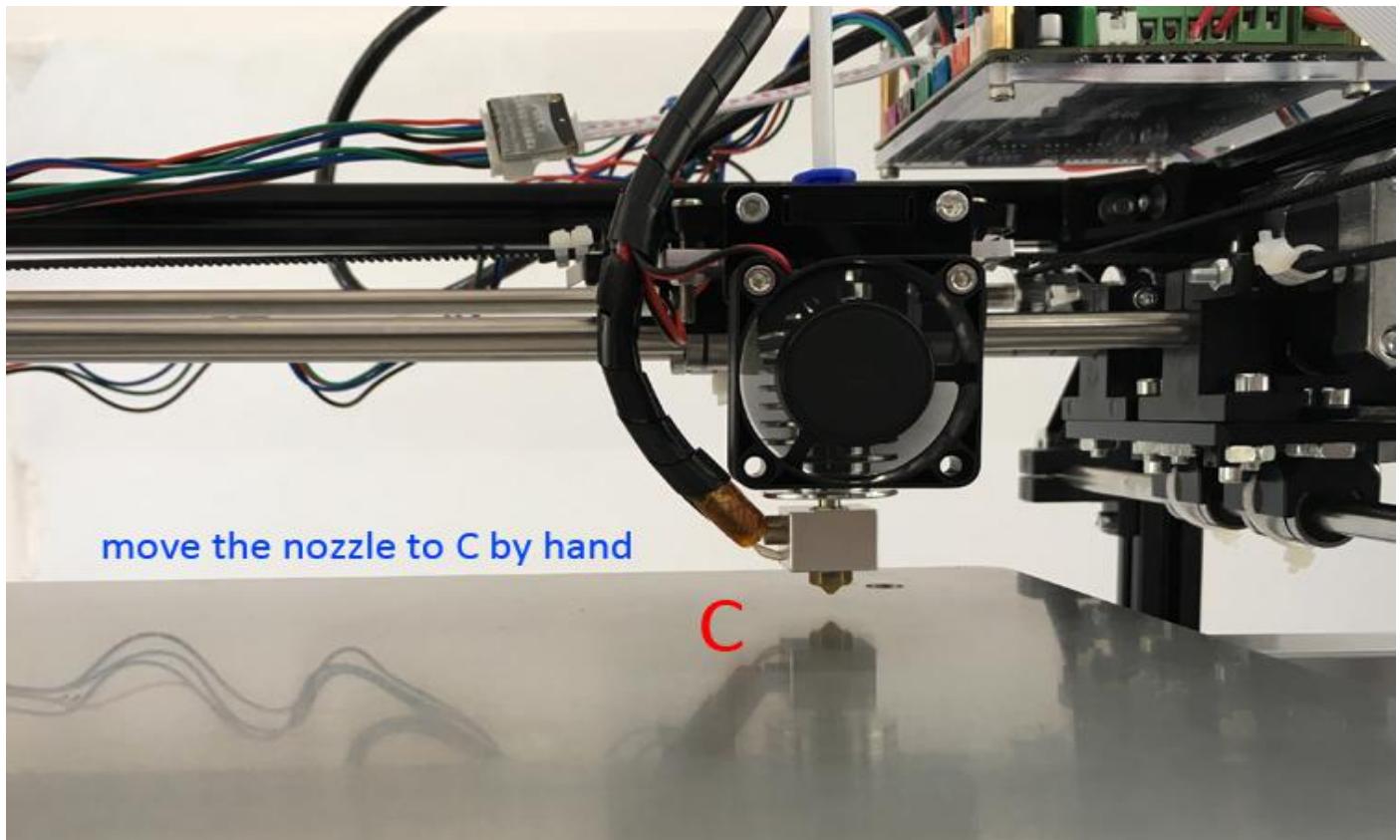


In the Command field, enter the coordinates of point C(G1 X240 Y240) and click Send



Reduce Z by 10, and then manually adjust the point C





Then



Increase z by 10 and move the nozzle to D(The reason for the rise Z is to prevent the collision platform during the movement of the nozzle to D)

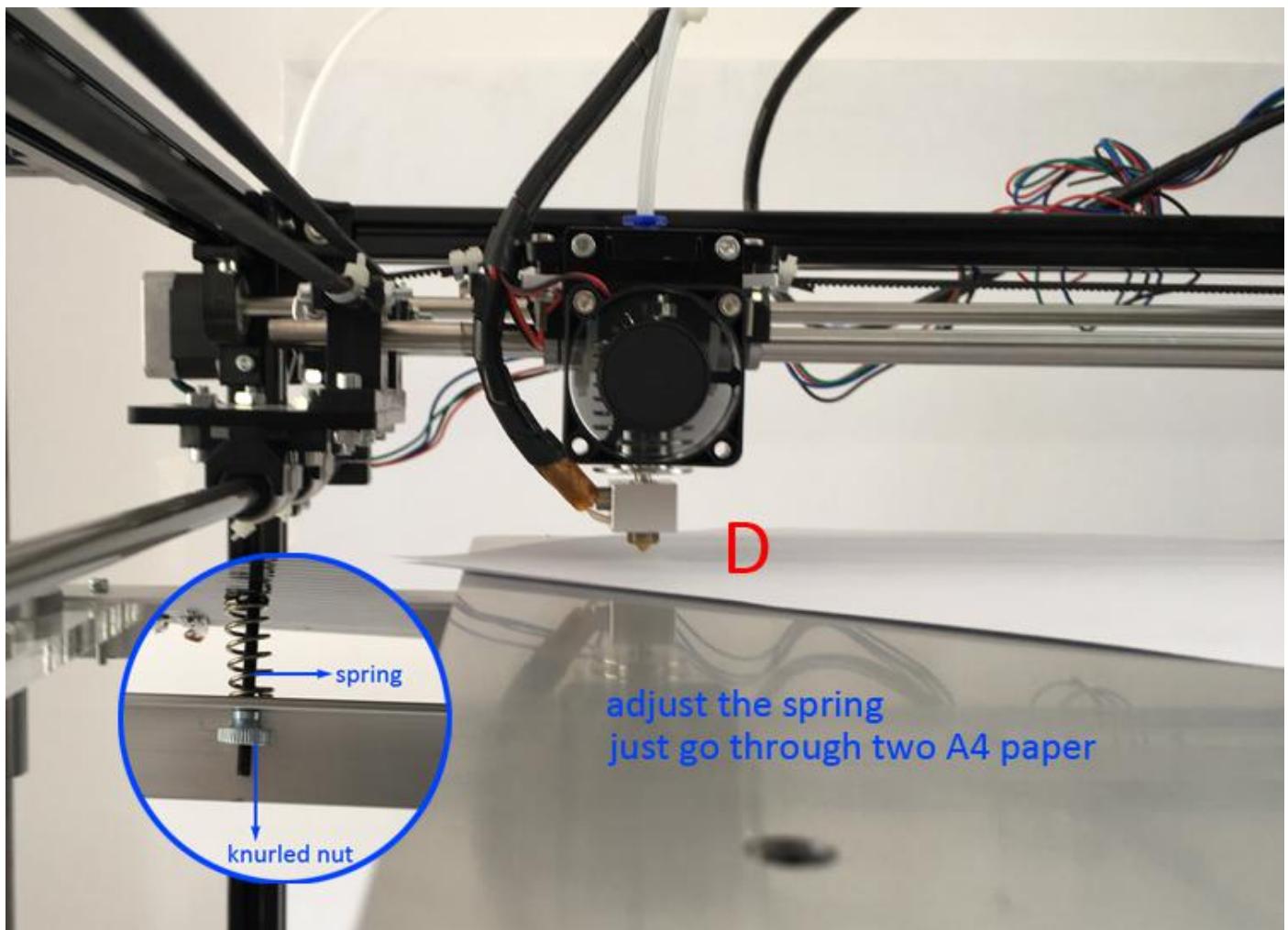
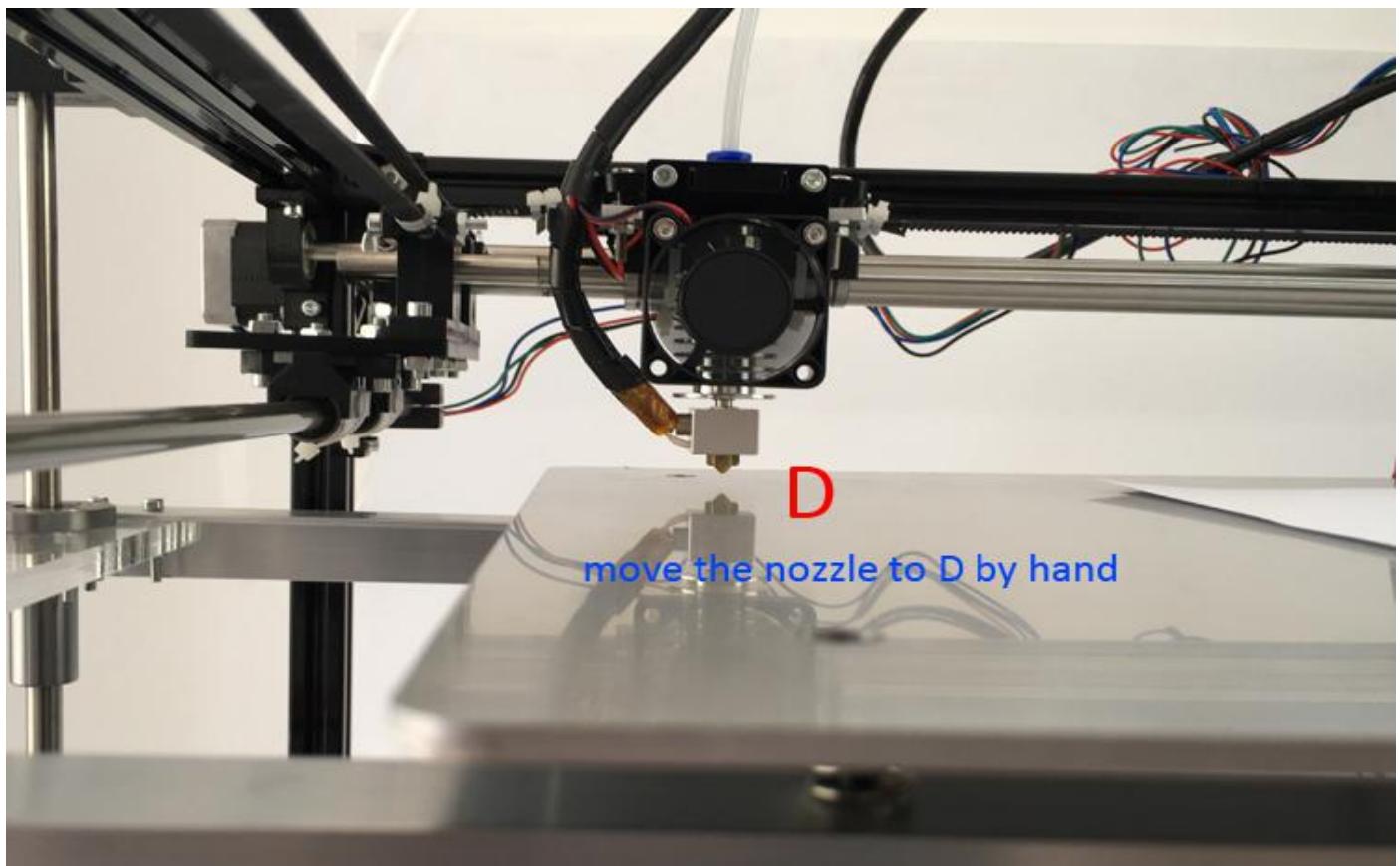


In the Command field, enter the coordinates of point D(G1 X0 Y260) and click Send



Reduce Z by 10, and then manually adjust the point D





after one time doing A B C D leveling,do again,from A to B to C to D.  
total 8 point,double A B C D.then go home.

