



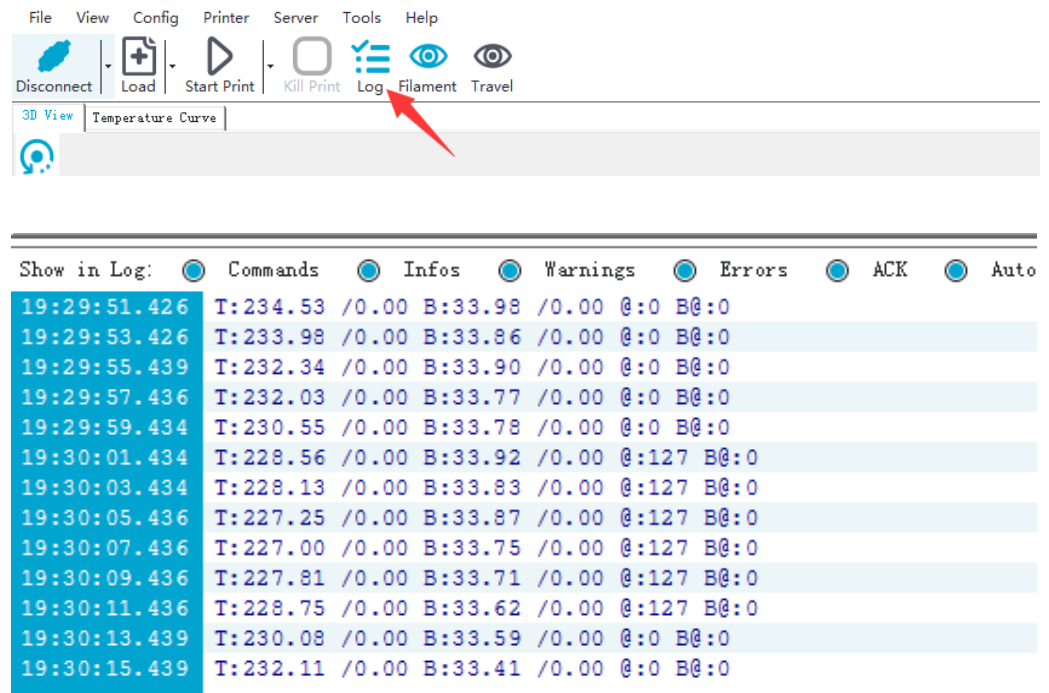
How to correct Nozzle temperature

Ver: 1.0

How to Correct Nozzle Temperature

If you find that nozzle temperature is not very stable, you adjusting the PID parameters of temperature control to improve it, steps are as following:

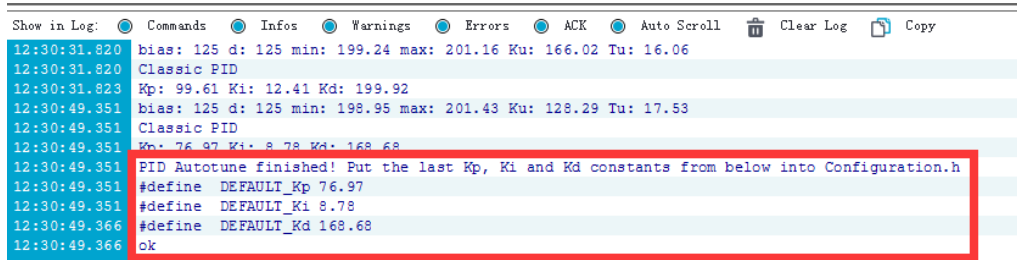
1. Connect 3d printer with your computer by Repetier-Host.
2. Send the following gcode command to the printer.
3. Open the log window and view the log data.



Note: For information on how to use Repetier-Host, please refer to the relevant files in the folder.

How to Correct Nozzle Temperature

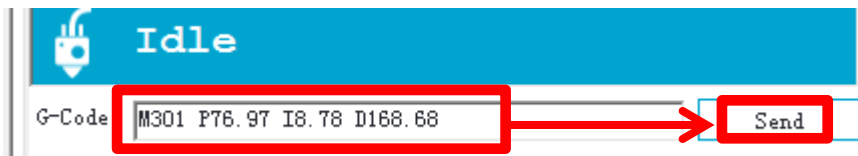
3. After adjustment is completed, the PID parameters will display in the LOG window, as below:



```
12:30:31.820 bias: 125 d: 125 min: 199.24 max: 201.16 Ku: 166.02 Tu: 16.06
12:30:31.820 Classic PID
12:30:31.823 Kp: 99.61 Ki: 12.41 Kd: 199.92
12:30:49.351 bias: 125 d: 125 min: 198.95 max: 201.43 Ku: 128.29 Tu: 17.53
12:30:49.351 Classic PID
12:30:49.351 Kp: 76.97 Ki: 8.78 Kd: 168.68
12:30:49.351 PID Autotune finished! Put the last Kp, Ki and Kd constants from below into Configuration.h
12:30:49.351 #define DEFAULT_Kp 76.97
12:30:49.351 #define DEFAULT_Ki 8.78
12:30:49.366 #define DEFAULT_Kd 168.68
12:30:49.366 ok
```

4. Send PID parameters to control board by M301 command.

M301 P76.97 I8.78 D168.68



5. Save it to the memory of control board by M500 command

M500

