

## CALIBRAT.TXT

FIRMWARE: mpmd\_marlin\_1.1.x-119r12 [SM0001, ACfan, 5Alimit] (Jul 29 2020)

NOTE: A sample calibration report; actual data from a CALIBRAT.TXT file. Notice that the bed level mesh has been curve-fit to a plane as part of the setup process of the AUTO\_CALIBRATE.gcode command. The calibration result does not seem to be all that great; lousy really.

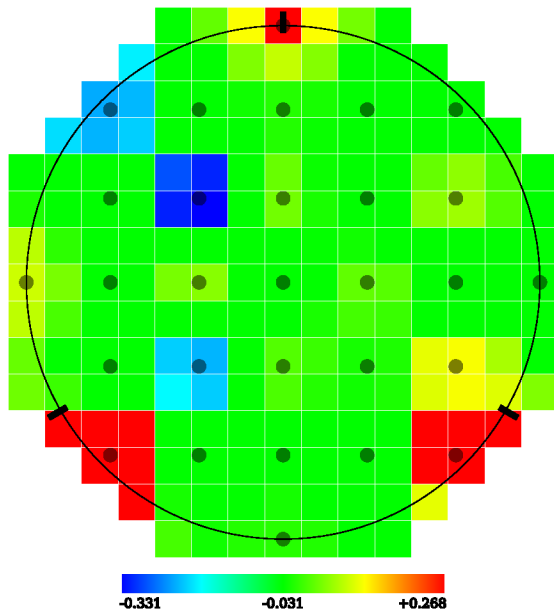
### ▼ Machine Geometry/ Calibration

- M92 X114.29 Y114.29 Z114.29 E97.01
- M665 L120.80 R62.88 H125.09 S200.00 V50.00 X0.00 Y0.00 Z0.00
- M665 A0.00 B0.00 C0.00 D0.00 E0.00 F0.00
- M666 X-0.15 Y0.00 Z-0.23
- M851 Z0.60

### ▼ G33 auto calibration

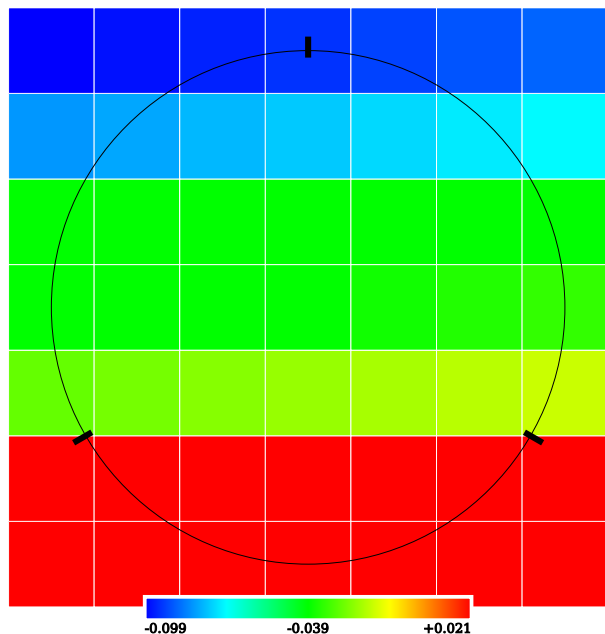
- Checking... AC
- .Height:125.09 Ex:-0.15 Ey:+0.00 Ez:-0.23 Radius:62.88
- . c:+0.01 x:+0.07 y:+0.02 z:+0.07
- . yz:-0.06 zx:-0.06 xy:+0.01
- Iteration : 01 std dev:0.050
- .Height:125.08 Ex:-0.11 Ey:+0.00 Ez:-0.24 Radius:62.86
- . c:-0.01 x:+0.03 y:+0.02 z:+0.06
- . yz:-0.05 zx:-0.09 xy:-0.04
- Calibration OK rolling back.
- .Height:125.09 Ex:-0.15 Ey:+0.00 Ez:-0.23 Radius:62.88

▼ Probed Points



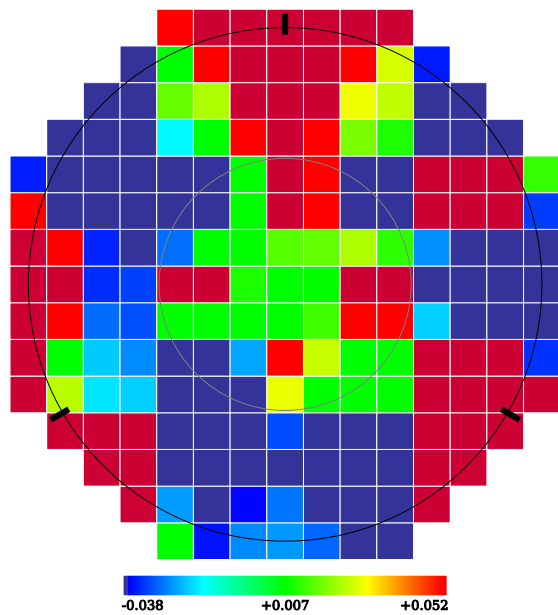
- Bed X: 0.000 Y: -55.000 Z: -0.008
- Bed X: 37.000 Y: -37.000 Z: 0.175
- Bed X: 18.000 Y: -37.000 Z: -0.168
- Bed X: 0.000 Y: -37.000 Z: -0.038
- Bed X: -18.000 Y: -37.000 Z: -0.075
- Bed X: -37.000 Y: -37.000 Z: 0.265
- Bed X: -37.000 Y: -18.000 Z: -0.047
- Bed X: -18.000 Y: -18.000 Z: -0.225
- Bed X: 0.000 Y: -18.000 Z: 0.018
- Bed X: 18.000 Y: -18.000 Z: -0.018
- Bed X: 37.000 Y: -18.000 Z: 0.116
- Bed X: 55.000 Y: 0.000 Z: -0.153
- Bed X: 37.000 Y: 0.000 Z: -0.138
- Bed X: 18.000 Y: 0.000 Z: 0.026
- Bed X: 0.000 Y: 0.000 Z: -0.049
- Bed X: -18.000 Y: 0.000 Z: 0.049
- Bed X: -37.000 Y: 0.000 Z: -0.076
- Bed X: -55.000 Y: 0.000 Z: 0.089
- Bed X: -37.000 Y: 18.000 Z: -0.124
- Bed X: -18.000 Y: 18.000 Z: -0.332
- Bed X: 0.000 Y: 18.000 Z: 0.036
- Bed X: 18.000 Y: 18.000 Z: -0.142
- Bed X: 37.000 Y: 18.000 Z: 0.063
- Bed X: 37.000 Y: 37.000 Z: -0.143
- Bed X: 18.000 Y: 37.000 Z: -0.047
- Bed X: 0.000 Y: 37.000 Z: -0.010
- Bed X: -18.000 Y: 37.000 Z: -0.056
- Bed X: -37.000 Y: 37.000 Z: -0.230
- Bed X: 0.000 Y: 55.000 Z: 0.127

▼ Bed Level Mesh



- G29 W I0 J0 Z0.00989 ; X-55.00 Y-55.00
- G29 W I1 J0 Z0.01182 ; X-37.00 Y-55.00
- G29 W I2 J0 Z0.01385 ; X-18.00 Y-55.00
- G29 W I3 J0 Z0.01578 ; X0.00 Y-55.00
- G29 W I4 J0 Z0.01771 ; X18.00 Y-55.00
- G29 W I5 J0 Z0.01975 ; X37.00 Y-55.00
- G29 W I6 J0 Z0.02168 ; X55.00 Y-55.00
- G29 W I0 J1 Z-0.00784 ; X-55.00 Y-37.00
- G29 W I1 J1 Z-0.00591 ; X-37.00 Y-37.00
- G29 W I2 J1 Z-0.00387 ; X-18.00 Y-37.00
- G29 W I3 J1 Z-0.00194 ; X0.00 Y-37.00
- G29 W I4 J1 Z-0.00001 ; X18.00 Y-37.00
- G29 W I5 J1 Z0.00203 ; X37.00 Y-37.00
- G29 W I6 J1 Z0.00396 ; X55.00 Y-37.00
- G29 W I0 J2 Z-0.02654 ; X-55.00 Y-18.00
- G29 W I1 J2 Z-0.02461 ; X-37.00 Y-18.00
- G29 W I2 J2 Z-0.02258 ; X-18.00 Y-18.00
- G29 W I3 J2 Z-0.02065 ; X0.00 Y-18.00
- G29 W I4 J2 Z-0.01872 ; X18.00 Y-18.00
- G29 W I5 J2 Z-0.01668 ; X37.00 Y-18.00
- G29 W I6 J2 Z-0.01475 ; X55.00 Y-18.00
- G29 W I0 J3 Z-0.04427 ; X-55.00 Y0.00
- G29 W I1 J3 Z-0.04234 ; X-37.00 Y0.00
- G29 W I2 J3 Z-0.04030 ; X-18.00 Y0.00
- G29 W I3 J3 Z-0.03837 ; X0.00 Y0.00
- G29 W I4 J3 Z-0.03644 ; X18.00 Y0.00
- G29 W I5 J3 Z-0.03440 ; X37.00 Y0.00
- G29 W I6 J3 Z-0.03247 ; X55.00 Y0.00
- G29 W I0 J4 Z-0.06199 ; X-55.00 Y18.00
- G29 W I1 J4 Z-0.06006 ; X-37.00 Y18.00
- G29 W I2 J4 Z-0.05802 ; X-18.00 Y18.00
- G29 W I3 J4 Z-0.05609 ; X0.00 Y18.00
- G29 W I4 J4 Z-0.05416 ; X18.00 Y18.00
- G29 W I5 J4 Z-0.05213 ; X37.00 Y18.00
- G29 W I6 J4 Z-0.05020 ; X55.00 Y18.00
- G29 W I0 J5 Z-0.08069 ; X-55.00 Y37.00
- G29 W I1 J5 Z-0.07877 ; X-37.00 Y37.00
- G29 W I2 J5 Z-0.07673 ; X-18.00 Y37.00
- G29 W I3 J5 Z-0.07480 ; X0.00 Y37.00
- G29 W I4 J5 Z-0.07287 ; X18.00 Y37.00
- G29 W I5 J5 Z-0.07083 ; X37.00 Y37.00
- G29 W I6 J5 Z-0.06890 ; X55.00 Y37.00
- G29 W I0 J6 Z-0.09842 ; X-55.00 Y55.00
- G29 W I1 J6 Z-0.09649 ; X-37.00 Y55.00
- G29 W I2 J6 Z-0.09445 ; X-18.00 Y55.00
- G29 W I3 J6 Z-0.09252 ; X0.00 Y55.00
- G29 W I4 J6 Z-0.09059 ; X18.00 Y55.00
- G29 W I5 J6 Z-0.08856 ; X37.00 Y55.00
- G29 W I6 J6 Z-0.08663 ; X55.00 Y55.00

▼ Results/ Statistics



• R-55 SAMPLE

sample radius: 55mm (149 samples)

min/ avg/ max: -0.275/ -0.007/ 0.26mm

std.deviation: 0.094mm (3 $\sigma$ : 0.284mm)

-0.284 +0.284



rating: **POOR** (based on a  $\pm 0.045$ mm limit)

• R-27 SAMPLE

sample radius: 27mm (37 samples)

min/ avg/ max: -0.275/ 0.002/ 0.091mm

std.deviation: 0.069mm (3 $\sigma$ : 0.208mm)

-0.208 +0.208



rating: **POOR** (based on a  $\pm 0.045$ mm limit)