

CALIBRAT.TXT

FIRMWARE: mpmd_marlin_1.1.x-119r14 [SM0001, PCfan, 10ALimit] (Oct 7 2020)

NOTE: @e-lambert, issue #43

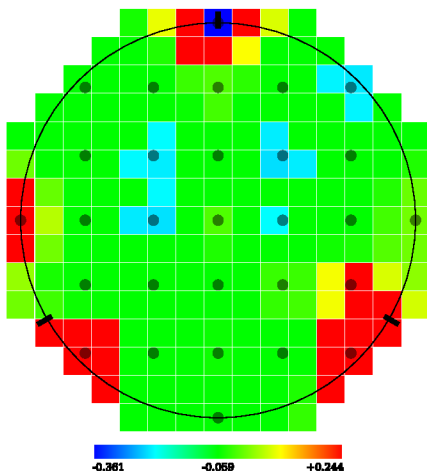
Machine Geometry/ Calibration

- M92 X114.29 Y114.29 Z114.29 E97.01
- M665 L120.80 R62.69 H133.02 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-0.44 Y0.00 Z-0.03
- M851 Z0.60

G33 auto calibration

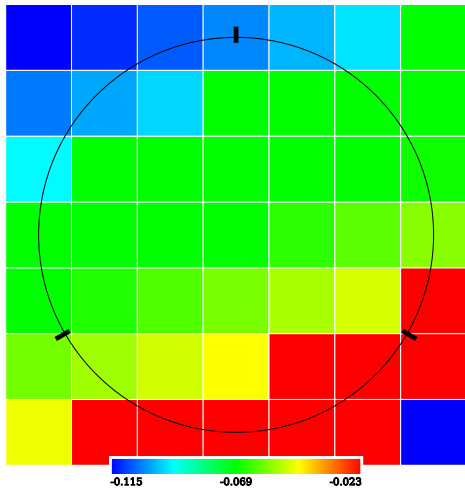
- Checking... AC
- .Height:133.02 Ex:-0.43 Ey:+0.00 Ez:-0.06 Radius:62.76
- . c:+0.01 x:-0.03 y:+0.05 z:+0.04
- . yz:-0.11 zx:-0.04 xy:-0.10
- Iteration : 1 std dev:0.063
- .Height:133.02 Ex:-0.44 Ey:+0.00 Ez:-0.03 Radius:62.69
- . c:-0.02 x:-0.01 y:+0.11 z:+0.06
- . yz:-0.06 zx:+0.00 xy:-0.07
- Iteration : 2 std dev:0.059
- .Height:133.03 Ex:-0.47 Ey:+0.00 Ez:-0.01 Radius:62.73
- . c:+0.00 x:+0.04 y:+0.11 z:+0.06
- . yz:-0.08 zx:+0.02 xy:-0.04
- Iteration : 3 std dev:0.060
- .Height:133.04 Ex:-0.45 Ey:+0.00 Ez:-0.01 Radius:62.75
- . c:+0.00 x:+0.03 y:+0.11 z:+0.09
- . yz:-0.05 zx:+0.05 xy:-0.05
- Calibration OK rolling back.
- .Height:133.02 Ex:-0.44 Ey:+0.00 Ez:-0.03 Radius:62.69

Probed Points



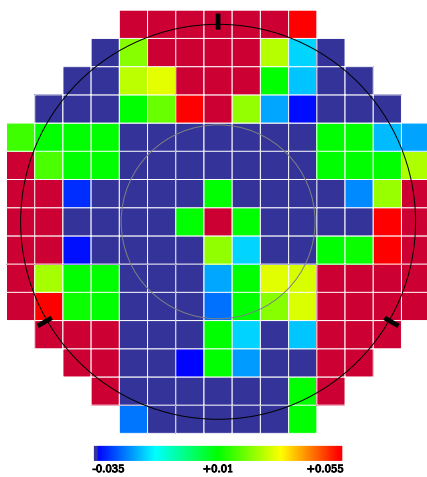
- Bed X: 0.000 Y: -55.000 Z: -0.128
- Bed X: 37.000 Y: -37.000 Z: 0.196
- Bed X: 18.000 Y: -37.000 Z: -0.090
- Bed X: 0.000 Y: -37.000 Z: -0.051
- Bed X: -18.000 Y: -37.000 Z: -0.151
- Bed X: -37.000 Y: -37.000 Z: 0.178
- Bed X: -37.000 Y: -18.000 Z: -0.059
- Bed X: -18.000 Y: -18.000 Z: -0.191
- Bed X: 0.000 Y: -18.000 Z: -0.079
- Bed X: 18.000 Y: -18.000 Z: -0.025
- Bed X: 37.000 Y: -18.000 Z: 0.098
- Bed X: 55.000 Y: 0.000 Z: 0.009
- Bed X: 37.000 Y: 0.000 Z: -0.098
- Bed X: 18.000 Y: 0.000 Z: -0.210
- Bed X: 0.000 Y: 0.000 Z: -0.012
- Bed X: -18.000 Y: 0.000 Z: -0.227
- Bed X: -37.000 Y: 0.000 Z: -0.133
- Bed X: -55.000 Y: 0.000 Z: 0.123
- Bed X: -37.000 Y: 18.000 Z: -0.081
- Bed X: -18.000 Y: 18.000 Z: -0.220
- Bed X: 0.000 Y: 18.000 Z: -0.176
- Bed X: 18.000 Y: 18.000 Z: -0.229
- Bed X: 37.000 Y: 18.000 Z: -0.063
- Bed X: 37.000 Y: 37.000 Z: -0.222
- Bed X: 18.000 Y: 37.000 Z: -0.101
- Bed X: 0.000 Y: 37.000 Z: -0.012
- Bed X: -18.000 Y: 37.000 Z: -0.066
- Bed X: -37.000 Y: 37.000 Z: -0.204
- Bed X: 0.000 Y: 55.000 Z: 0.244

▼ Bed Level Mesh



- G29 W 10 J0 Z-0.04669 ; X-55.00 Y-55.00
- G29 W 11 J0 Z-0.04267 ; X-37.00 Y-55.00
- G29 W 12 J0 Z-0.03842 ; X-18.00 Y-55.00
- G29 W 13 J0 Z-0.03440 ; X0.00 Y-55.00
- G29 W 14 J0 Z-0.03038 ; X18.00 Y-55.00
- G29 W 15 J0 Z-0.02613 ; X37.00 Y-55.00
- G29 W 16 J0 Z-0.02211 ; X55.00 Y-55.00
- G29 W 10 J1 Z-0.05776 ; X-55.00 Y-37.00
- G29 W 11 J1 Z-0.05374 ; X-37.00 Y-37.00
- G29 W 12 J1 Z-0.04950 ; X-18.00 Y-37.00
- G29 W 13 J1 Z-0.04547 ; X0.00 Y-37.00
- G29 W 14 J1 Z-0.04145 ; X18.00 Y-37.00
- G29 W 15 J1 Z-0.03721 ; X37.00 Y-37.00
- G29 W 16 J1 Z-0.03318 ; X55.00 Y-37.00
- G29 W 10 J2 Z-0.06945 ; X-55.00 Y-18.00
- G29 W 11 J2 Z-0.06543 ; X-37.00 Y-18.00
- G29 W 12 J2 Z-0.06118 ; X-18.00 Y-18.00
- G29 W 13 J2 Z-0.05716 ; X0.00 Y-18.00
- G29 W 14 J2 Z-0.05314 ; X18.00 Y-18.00
- G29 W 15 J2 Z-0.04889 ; X37.00 Y-18.00
- G29 W 16 J2 Z-0.04487 ; X55.00 Y-18.00
- G29 W 10 J3 Z-0.08052 ; X-55.00 Y0.00
- G29 W 11 J3 Z-0.07650 ; X-37.00 Y0.00
- G29 W 12 J3 Z-0.07225 ; X-18.00 Y0.00
- G29 W 13 J3 Z-0.06823 ; X0.00 Y0.00
- G29 W 14 J3 Z-0.06421 ; X18.00 Y0.00
- G29 W 15 J3 Z-0.05996 ; X37.00 Y0.00
- G29 W 16 J3 Z-0.05594 ; X55.00 Y0.00
- G29 W 10 J4 Z-0.09159 ; X-55.00 Y18.00
- G29 W 11 J4 Z-0.08757 ; X-37.00 Y18.00
- G29 W 12 J4 Z-0.08333 ; X-18.00 Y18.00
- G29 W 13 J4 Z-0.07930 ; X0.00 Y18.00
- G29 W 14 J4 Z-0.07528 ; X18.00 Y18.00
- G29 W 15 J4 Z-0.07104 ; X37.00 Y18.00
- G29 W 16 J4 Z-0.06701 ; X55.00 Y18.00
- G29 W 10 J5 Z-0.10328 ; X-55.00 Y37.00
- G29 W 11 J5 Z-0.09926 ; X-37.00 Y37.00
- G29 W 12 J5 Z-0.09501 ; X-18.00 Y37.00
- G29 W 13 J5 Z-0.09099 ; X0.00 Y37.00
- G29 W 14 J5 Z-0.08697 ; X18.00 Y37.00
- G29 W 15 J5 Z-0.08272 ; X37.00 Y37.00
- G29 W 16 J5 Z-0.07870 ; X55.00 Y37.00
- G29 W 10 J6 Z-0.11435 ; X-55.00 Y55.00
- G29 W 11 J6 Z-0.11033 ; X-37.00 Y55.00
- G29 W 12 J6 Z-0.10608 ; X-18.00 Y55.00
- G29 W 13 J6 Z-0.10206 ; X0.00 Y55.00
- G29 W 14 J6 Z-0.09804 ; X18.00 Y55.00
- G29 W 15 J6 Z-0.09379 ; X37.00 Y55.00
- G29 W 16 J6 Z-0.08977 ; X55.00 Y55.00

▼ Results/ Statistics



• R-55 SAMPLE

sample radius: 55mm (149 samples)
 min/ avg/ max: -0.156/ -0.012/ 0.346mm
 std.deviation: 0.096mm (3σ: 0.289mm)
 -0.289 +0.289

rating: **POOR** (based on a ±0.045mm limit)

• R-27 SAMPLE

sample radius: 27mm (37 samples)
 min/ avg/ max: -0.156/ -0.074/ 0.056mm
 std.deviation: 0.059mm (3σ: 0.178mm)
 -0.178 +0.178

rating: **POOR** (based on a ±0.045mm limit)