How to Level the hotbed

After assembling, you need to level the bed when firstly print

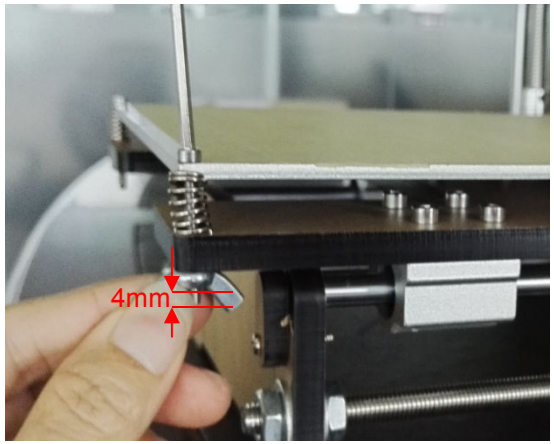
1. Rough Debugging to level hotbed

1.1 Adjust the screws at the 4 angle of the hotbed to make the screws 4mm out of the nut（Picture 1)；

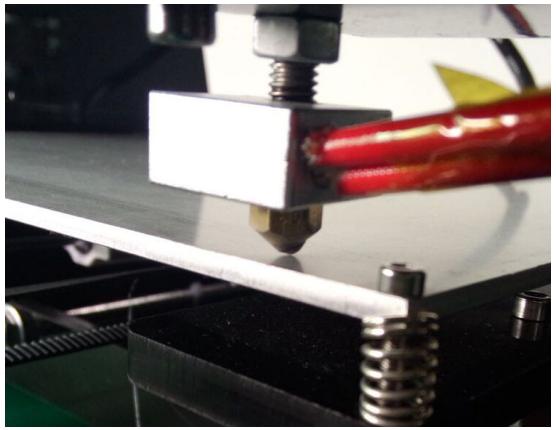
1.2 Move the nozzle as near as possible to the hotbed, and pull the extruder with hand to the upper everywhere of hotbed to check if the distance between the nozzle and 4 angle of hotbed is accordant.（Picture2）；

1.3 Hold the T couping at left& right bottom of Z axis with hand and rotate it to make the nozzle to 4mm above the hotbed （Picture 3、4）

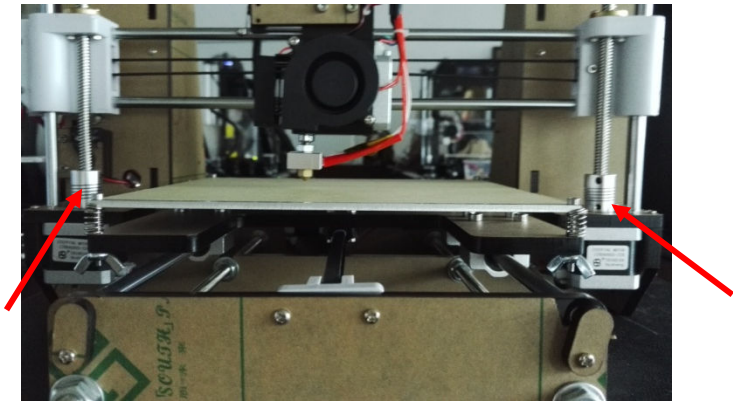
1.4 Move the Z axis limit switch to the proper position, to make that the Z axis stop once the bottom of left Z axis nut support meet the sphere of limit switch（Picture 5）



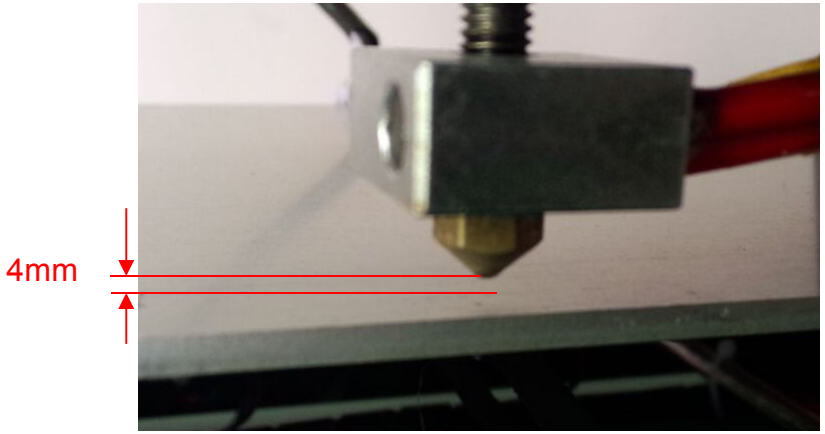
Picture 1



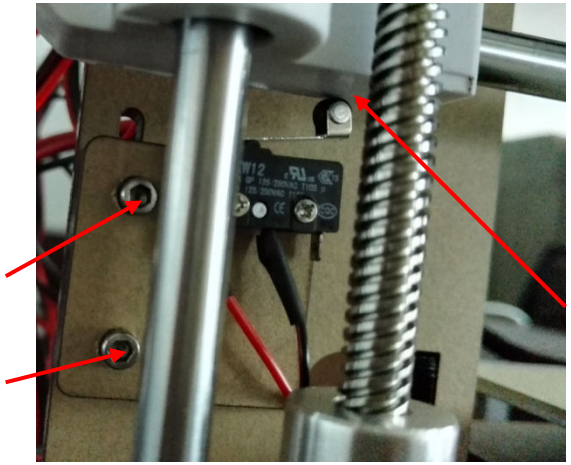
Picture 2



Picture 3



Picture 4



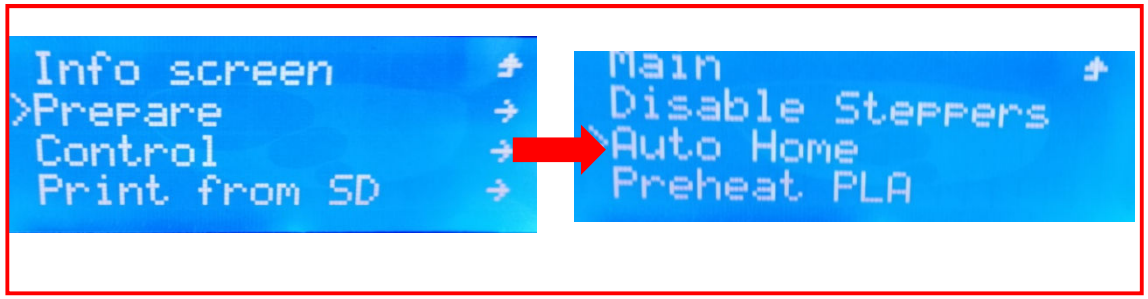
Picture 5

2. Accurate Debugging

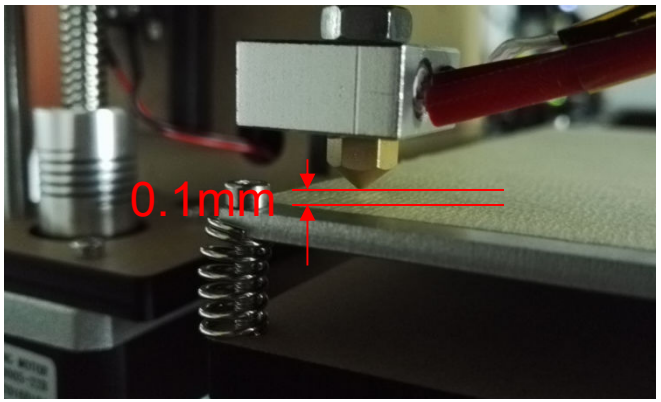
2.1 Auto home and make the XYZ axis back to origin（Picture 6）;

2.2 Screw the screws at 4 angle of hotbed to make the nozzle above 1mm to the hotbed (Picture 7)

（PS: After Auto home, please click “Disable Steppers” or turn off the power, otherwise, you will can’t move the XYZ axis by hand）



Picture 6

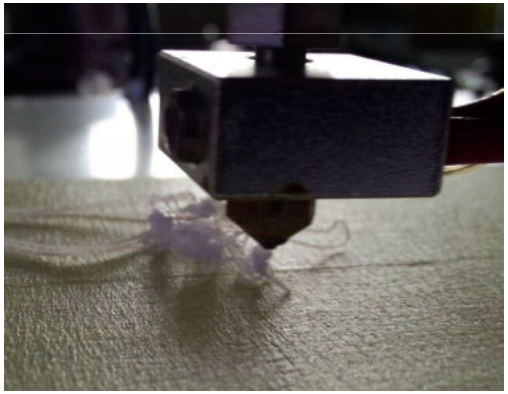


Picture 7

3. Fine Debugging When printing

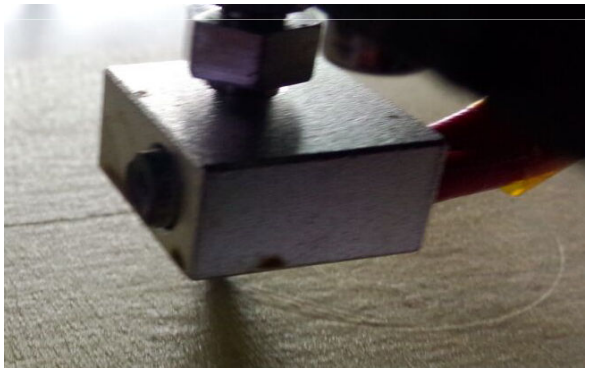
3.1 Please check the printing status of first layer when you first printing by your printer. If you need, you can screw the screws at 4 angle of hotbed to the best position(as shown on picture 10)

The different printing effect depends on the different distance between nozzle and hotbed：



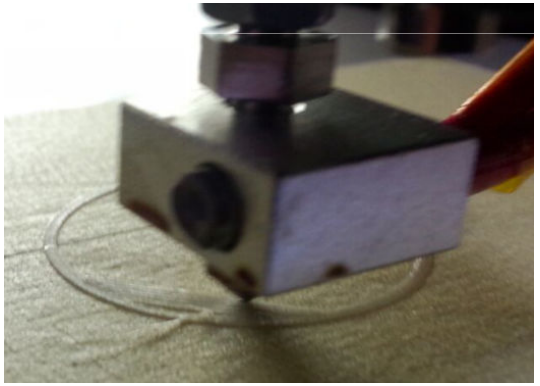
Picture 8

The distance between nozzle and hotbed is too high



Picture 9

The nozzle is too close to hotbed



Picture 10

The distance between nozzle and hotbed is proper