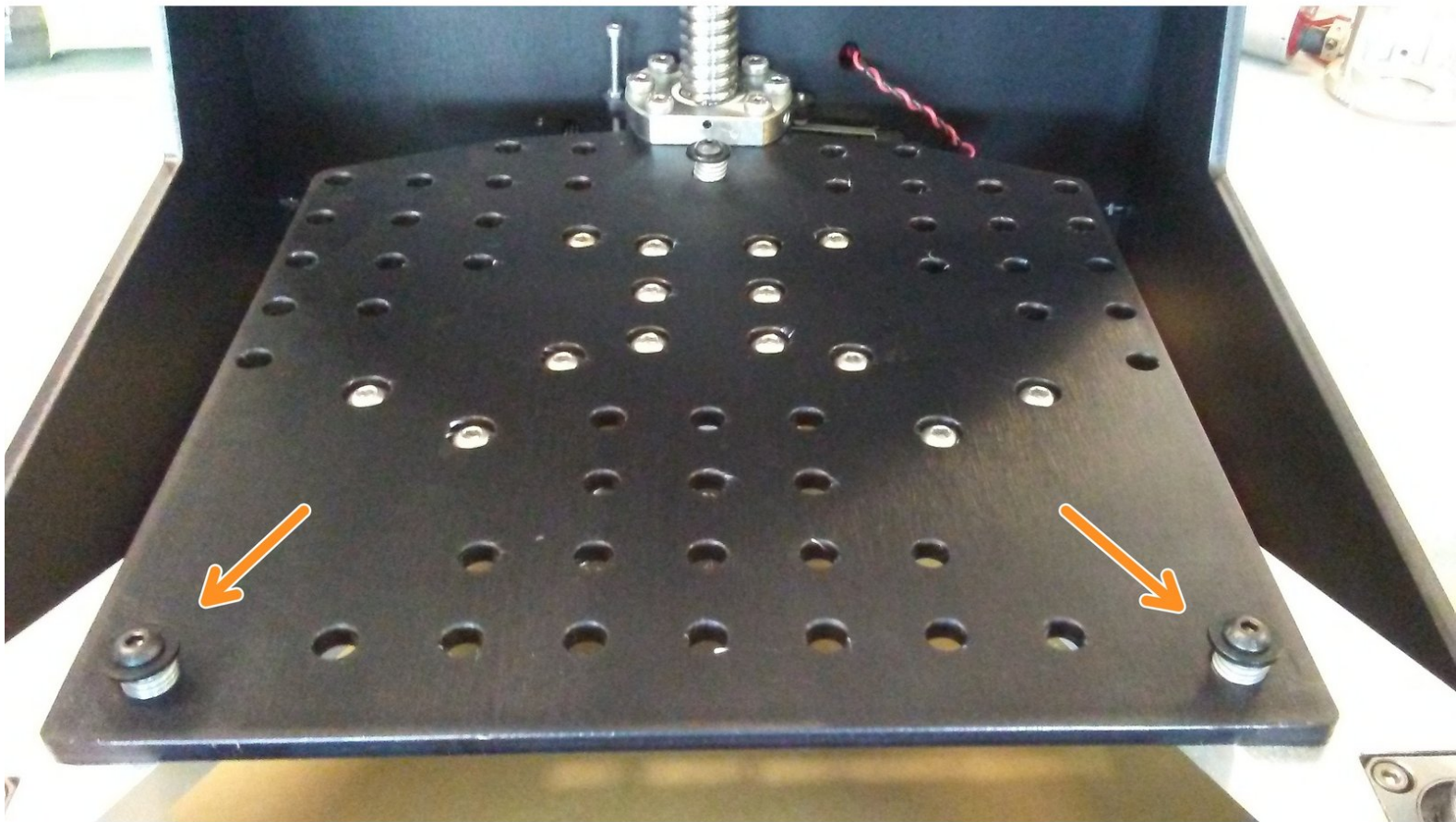




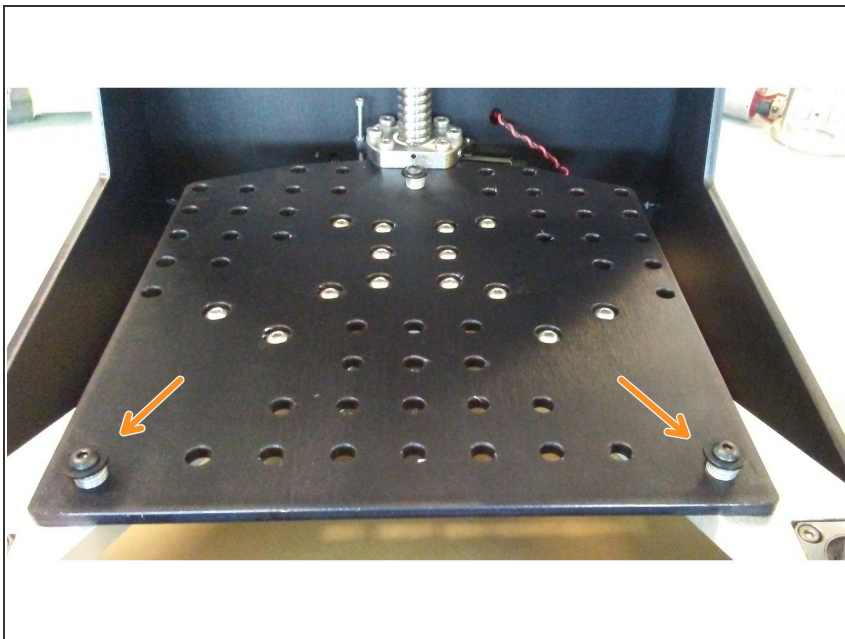
Leveling Guide

This guide will walk you through how to level your BoXZY Leveling Platform

Written By: BoXZY

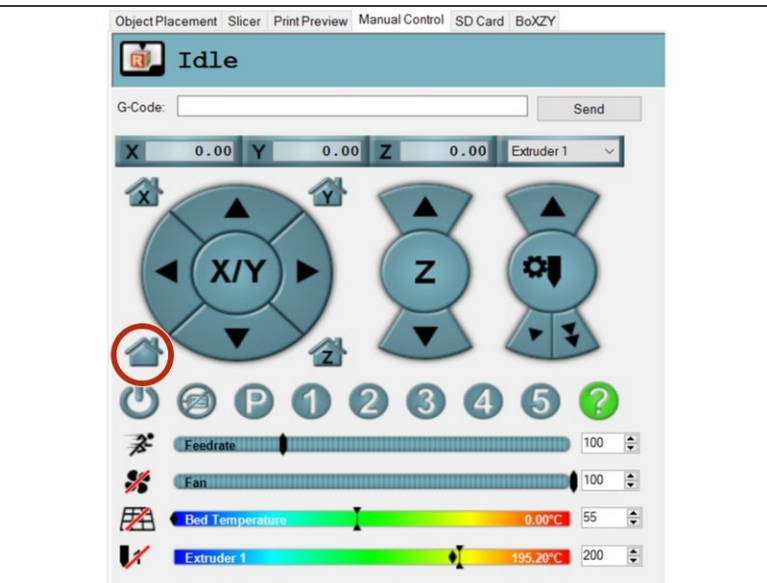
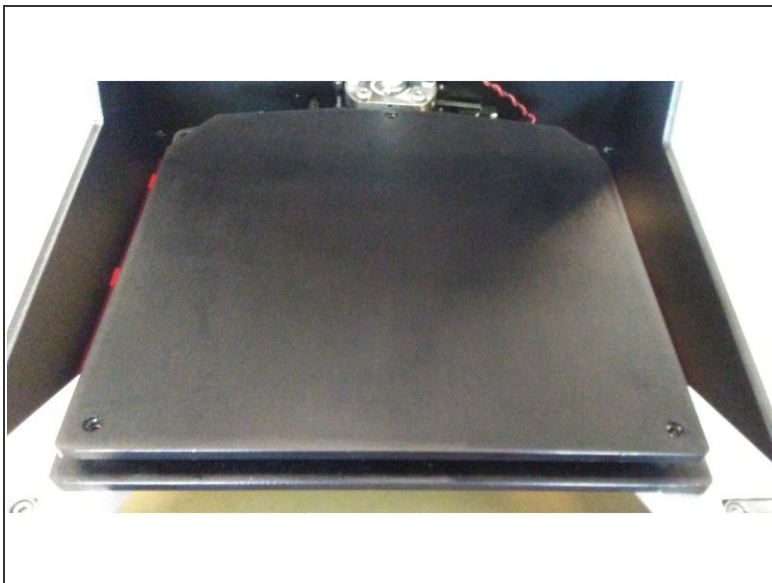


Step 1 — The Leveling Bolts



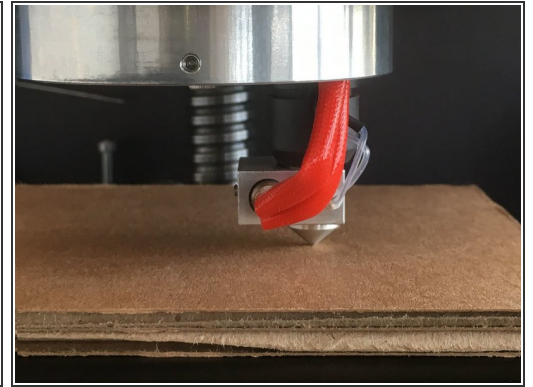
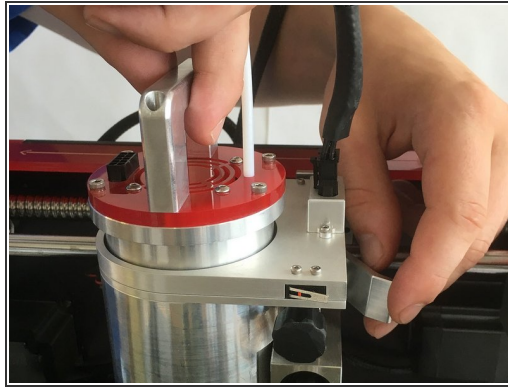
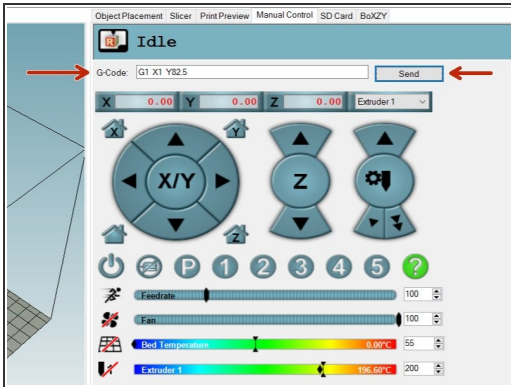
- ① Before you begin the leveling procedure remove anything you have inside of BoXZY. Raw Material, Attachments or Clamps should be placed aside for this guide
- **Remove** the *Leveling Platform* from the inside of BoXZY
 - Use an **Allen Wrench** to tighten the **2 front Leveling Bolts** on the BoXZY Build Platform, indicated by the *orange arrows*
 - Turn the Bolts 2 (two) full rotations in the direction that will compress the springs
- ① **Do Not** adjust the back Leveling Bolt. You only need to adjust the front two to level the platform

Step 2 — Pre-Leveling Setup



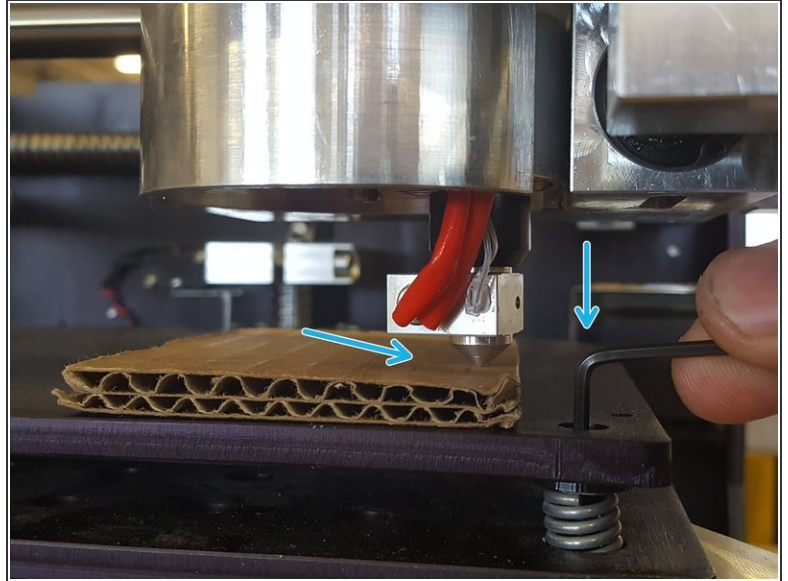
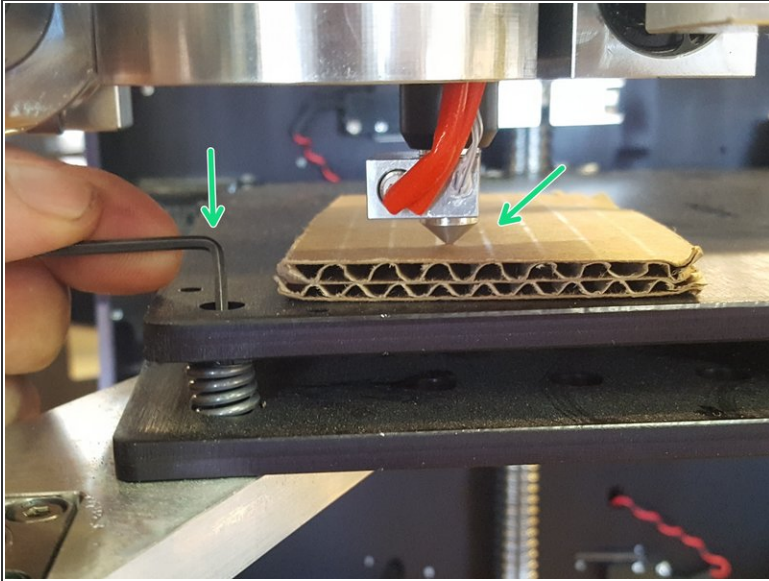
- Place the **Leveling Platform** on the *Leveling Pegs* on the Build Platform
 - Align the Magnets on the Leveling Platform with the Leveling Bolts
- **Connect** your *Computer* to BoXZY
 - In the **Manual Control** tab select the *Home All* button, indicated in the *second image*
 - ☑ Make sure there is nothing except the Leveling Platform inside BoXZY

Step 3 — Leveling: Part I



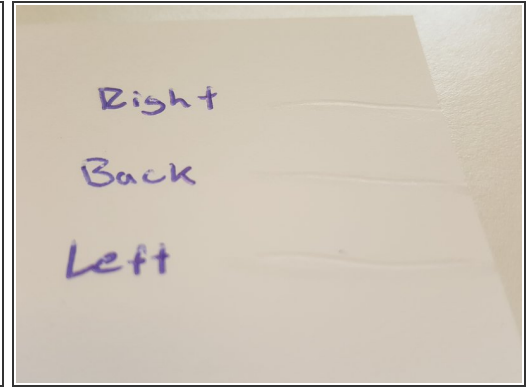
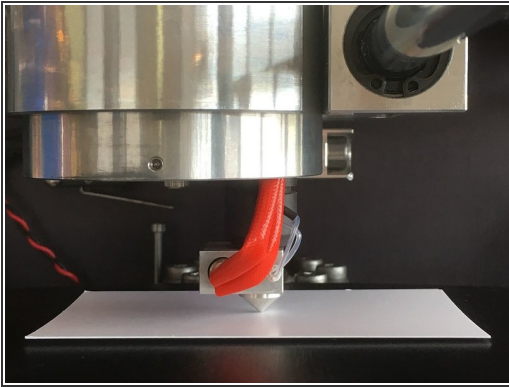
- In your Gcode Sender line type the following and select **Send**
- **G1 X1 Y82.5**
- **Insert** your **3D Printing Attachment** into the *Attachment Mount*, as seen in the *second image*
 - **Gently place** the nozzle of the 3D Printing Attachment on a thick piece of cardboard, this is shown in the *third image*
 - **Lock** the **Attachment Mount**
 - **Slide** the *cardboard* out from under the 3D Printing Attachment

Step 4 — Leveling: Part II



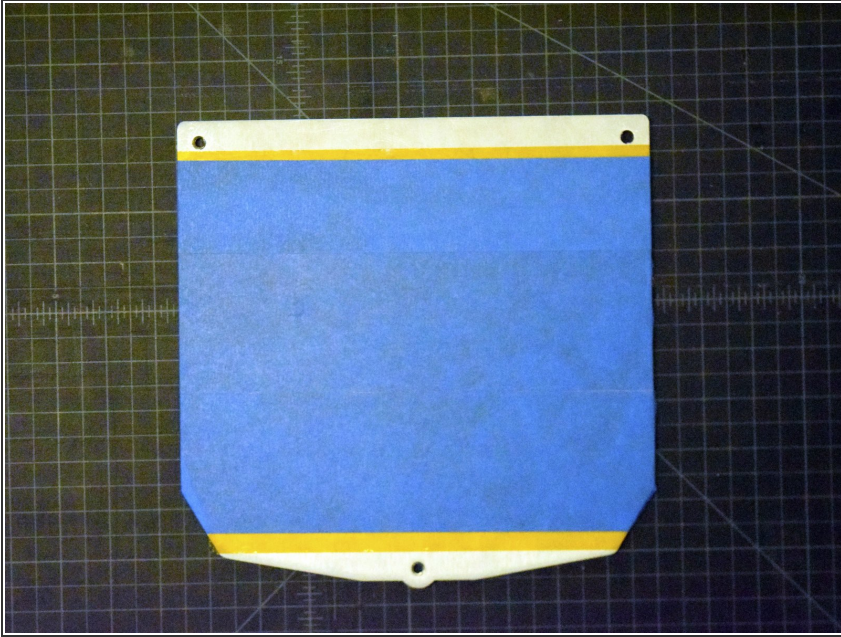
- In your Gcode Sender line type the following and select **Send**
 - **G1 X165 Y1**
 - **Slide** the *cardboard* underneath the *Nozzle*
 - Use an **Allen Wrench** to turn the *Leveling Bolt* to raise the platform until the cardboard touches the 3D Printing Nozzle
- In your Gcode Sender line type the following and select **Send**
 - **G1 X1 Y165**
 - **Slide** the *cardboard* underneath the *Nozzle*
 - Use an **Allen Wrench** to turn the *Leveling Bolt* to raise the platform until the cardboard touches the 3D Printing Nozzle

Step 5 — Leveling: Part III



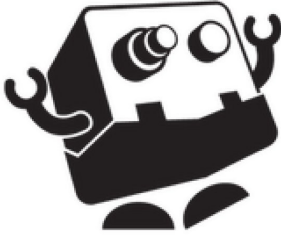
- Now that we have the Leveling Platform level with the cardboard we can fine tune
- We are going to repeat the last step of this guide however we are going to use a Business Card in place of the cardboard
 - This time we want the Nozzle of the 3D Printing Attachment to make a mark on the Business Card as we pull it out from under the Nozzle
- ① Identify each mark, as we have in the *third image*
 - Three marks that you make on your Business Card should look consistent. When they are uniform the platform is level

Step 6 — Leveling: Part IV



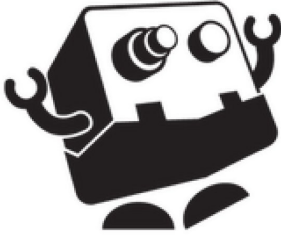
- Now is a good time to apply tape to your *Leveling Platform*
- ① **Remove the Leveling Platform** to apply tape, **do not** apply tape with the Leveling Platform inside BoXZY
- Beginners should use [wide blue painters tape](#) before using other tape
 - You can also use masking tape or [Kapton Tape](#) as a printing surface. [BuildTak](#) is one option made specifically for this purpose.
- ✦ It is important that the tape be applied smoothly and remain flat. Do not layer the tape or let one strip of tape stick over top of another

Step 7 — Leveling: Part VII



- After applying tape to your Leveling Platform and before every time you 3D Print perform the following actions:
 - **Unlock** your **3D Printing Attachment** and *lift* it off of the Leveling Platform
 - **Place** a **business card** directly *below* the 3D Printing Attachment
 - **Set** the **3D Printing Attachment** gently *on top* of the Business Card and lock the 3D Printing Attachment in place
 - **Slide** the **business card** out from *under* the 3D Printing Attachment and you are ready to start printing

Step 8 — Unstable Leveling Platform



- Before you start printing you should check the Leveling Platform's stability
- Place your hand flat on top of the center of your Leveling Platform
 - **Do Not** push down on the platform
- Slide your hand around in a circle as it rests on top of the platform
 - The Leveling Platform should *not* wiggle, wobble or rattle on the Leveling Pegs
- If you have an issue with the platform being unstable you may have an issue with the magnets on the bottom of the Leveling Platform
 - Check the magnets and if you see inconsistencies please contact us with a photo of the magnets