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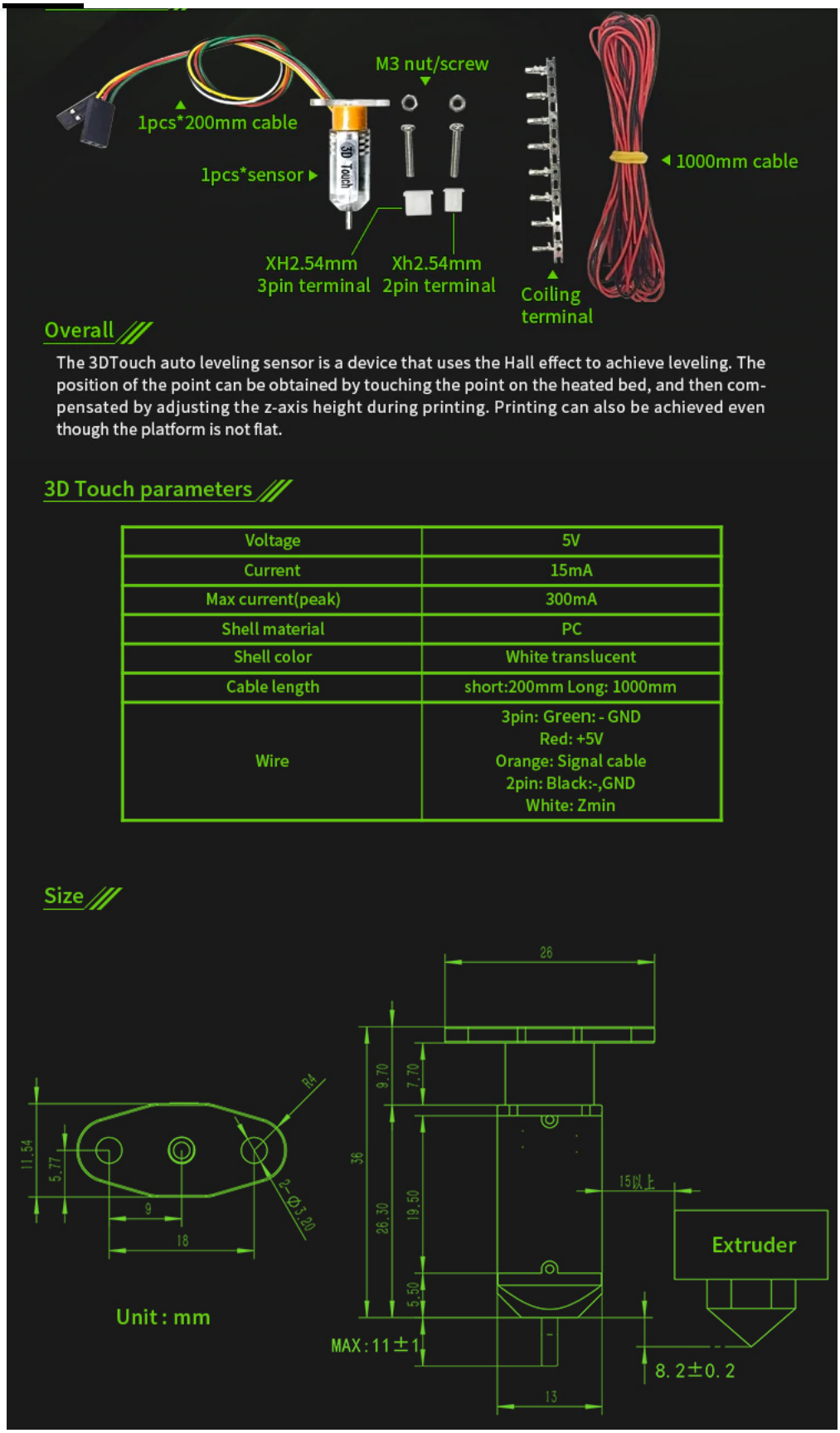

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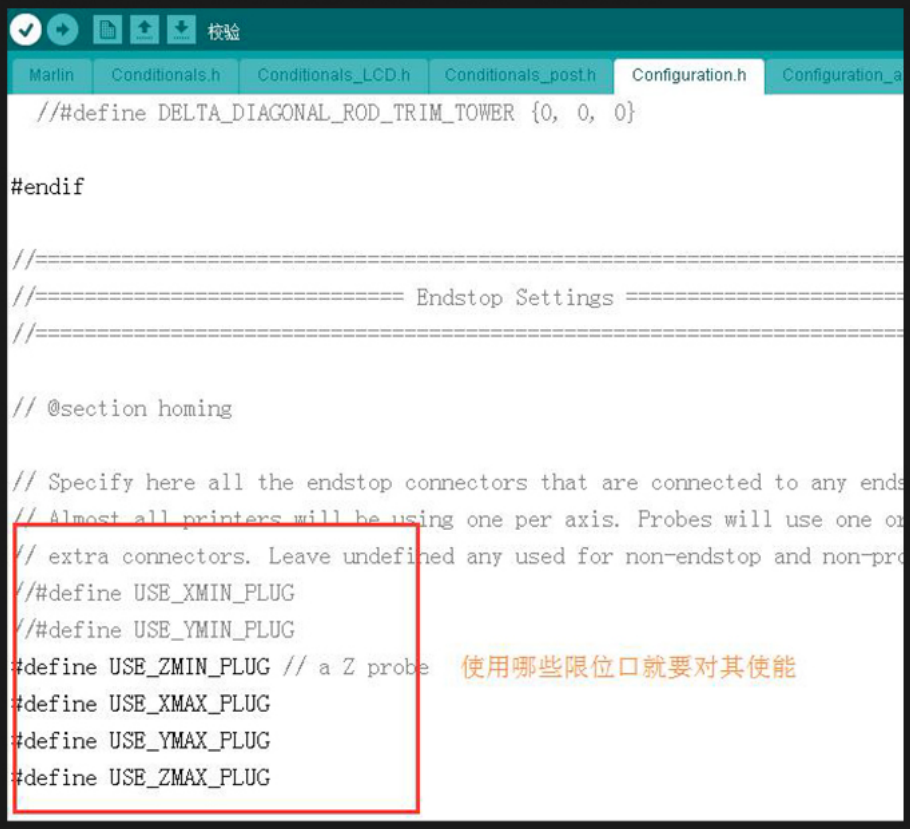
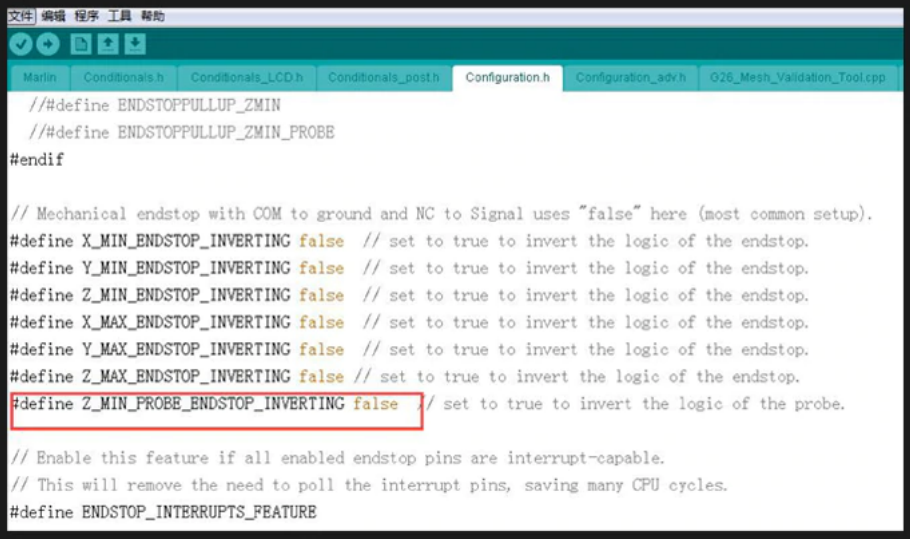
3D Touch Action Instruction Table			
Action	G-code		
	Marlin Firmware	Repetier Firmware	Smoothieware Firmware
Push-pin down	M280 P0 S10	M340 P0 S700	M280 S3.0
Push-pin up	M280 P0 S90	M340 P0 S1500	M280 S7.0
Self-test	M280 P0 S120	M340 P0 S1800	M280 S8.4
Alarm release(Push-pin up)	M280 P0 S160	M340 P0 S2200	M280 S10.6

Marlin settings

Marlin settings(take Marlin V1.1.X as example)3pin cable connects to D11, 2pin cable connects to Zmin.
(1)Set leveling pin, which can’ t use the same pin as endstop.
Generally, on Delta machines, we use Zmin pin for BLtouch, Zmax pin for endstop. On I3 machines, we use Zmin pin as BLtouch, Zmax pin for endstop or don’ t use endstop.



(2)Set leveling type



```
*/
#define Z_MIN_PROBE_USES_Z_MIN_ENDSTOP_PIN

/**
 * Z_MIN_PROBE_ENDSTOP
 *
 * Enable this option for a probe connected to any pin except Z-Min.
 * (By default Marlin assumes the Z-Max endstop pin.)
 * To use a custom Z Probe pin, set Z_MIN_PROBE_PIN below.
 *
 *  - The simplest option is to use a free endstop connector.
 *  - Use 5V for powered (usually inductive) sensors.
 *
 *  - RAMPS 1.3/1.4 boards may use the 5V, GND, and Aux4->D32 pin:
 *    - For simple switches connect...
 *      - normally-closed switches to GND and D32.
 *      - normally-open switches to 5V and D32.
 *
 * WARNING: Setting the wrong pin may have unexpected and potentially
 * disastrous consequences. Use with caution and do your homework.
 *
 */
//#define Z_MIN_PROBE_ENDSTOP
//#define Z_MIN_PROBE_PIN Z_MAX_PIN
```

(4)Enable BLtouch

```
 * Z Servo Probe, such as an endstop switch on a rotating arm.
 */
//#define Z_ENDSTOP_SERVO_NR 0    // Defaults to SERVO 0 connector.
//#define Z_SERVO_ANGLES {70,0}   // Z Servo Deploy and Stow angles

/**
 * The BLTouch probe uses a Hall effect sensor and emulates a servo.
 */
#define BLTOUCH
#if ENABLED(BLTOUCH)
  #define BLTOUCH_DELAY 100   // (ms) Enable and increase if needed
#endif

/**
 * Enable if probing seems unreliable. Heaters and/or fans - consistent with the
 * options selected below - will be disabled during probing so as to minimize
```

(5)Set the offset value of the leveling switch probe from the nozzle in the XYZ direction

```
 *    T |           | H
 *      |    (-)    | T
 *      |           |
 *      O-- FRONT --+
 *    (0,0)
 */
#define X_PROBE_OFFSET_FROM_EXTRUDER 0     // X offset: -left  +right  [of the nozzle]
#define Y_PROBE_OFFSET_FROM_EXTRUDER -20   // Y offset: -front +behind [the nozzle]
#define Z_PROBE_OFFSET_FROM_EXTRUDER -1.8  // Z offset: -below +above  [the nozzle]

// X and Y axis travel speed (mm/m) between probes
#define XY_PROBE_SPEED 4000
```

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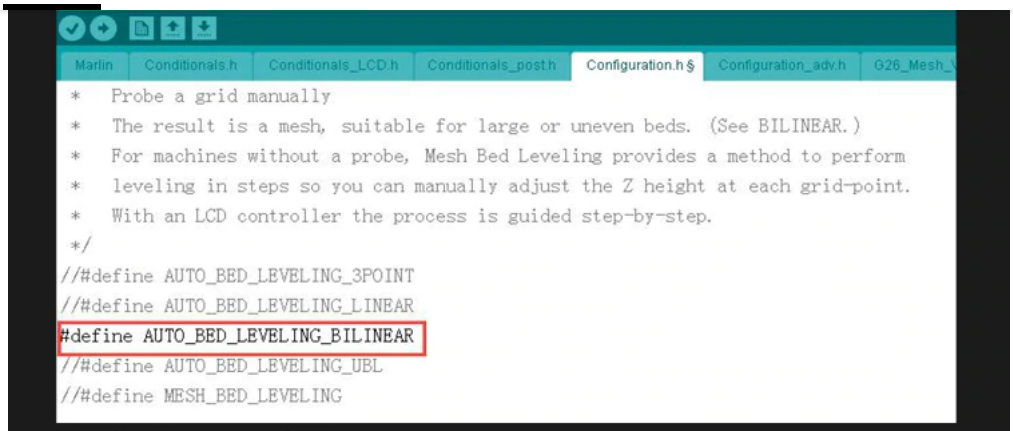
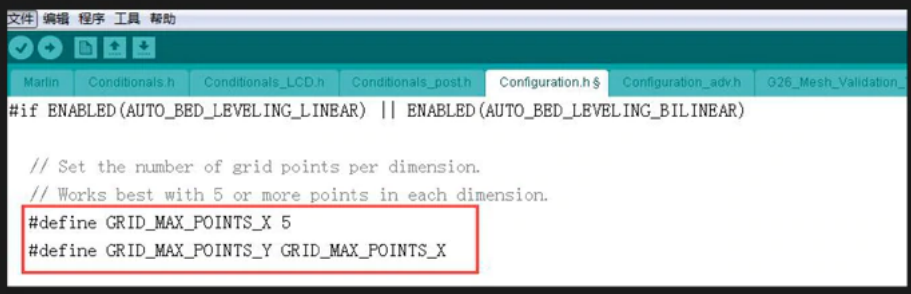
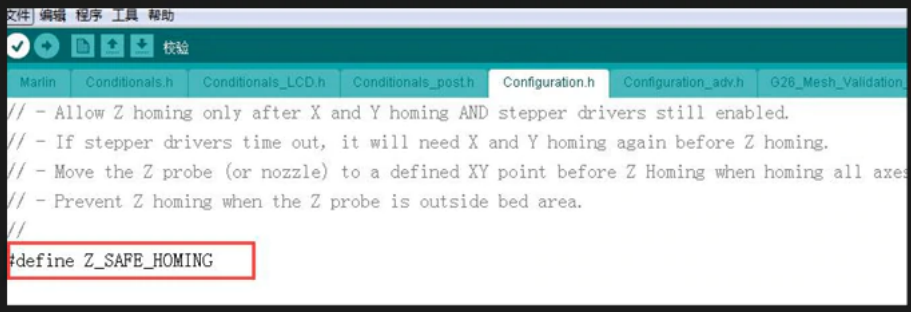


(7)Set leveling points number

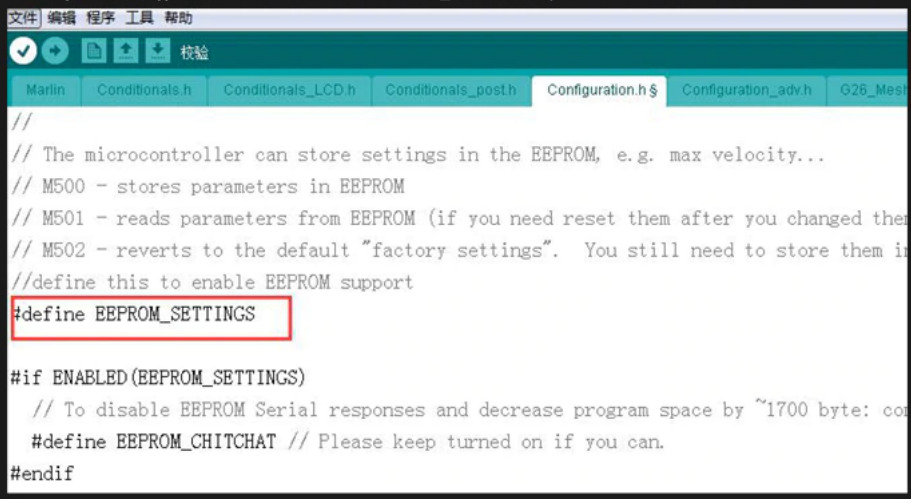


(8)Set homing center



(9)Store the leveling settings

1)Remove "//" before the "#define EEPROM_SETTINGS", start M500 to store the data.



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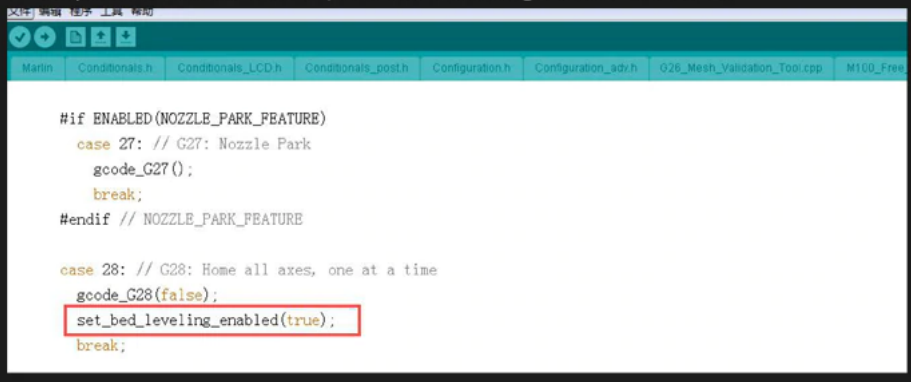
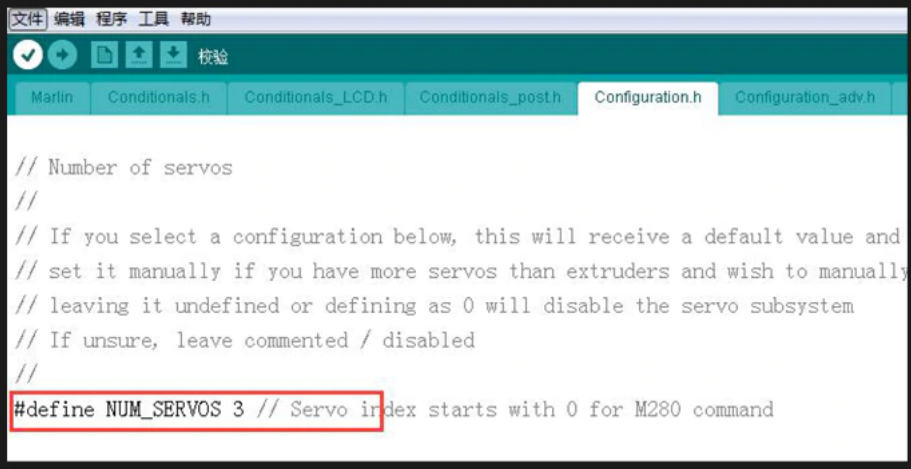
It’s important to add this sentence, otherwise the leveling data can’t be stored.



```
#if ENABLED(NOZZLE_PARK_FEATURE)
  case 27: // G27: Nozzle Park
    gcode_G27();
    break;
#endif // NOZZLE_PARK_FEATURE

case 28: // G28: Home all axes, one at a time
  gcode_G28(false);
  set_bed_leveling_enabled(true);
  break;
```

(10)Remove “//” before the “#define NUM_SERVOS 3”



```
// Number of servos
//
// If you select a configuration below, this will receive a default value and
// set it manually if you have more servos than extruders and wish to manually
// leaving it undefined or defining as 0 will disable the servo subsystem
// If unsure, leave commented / disabled
//
#define NUM_SERVOS 3 // Servo index starts with 0 for M280 command
```