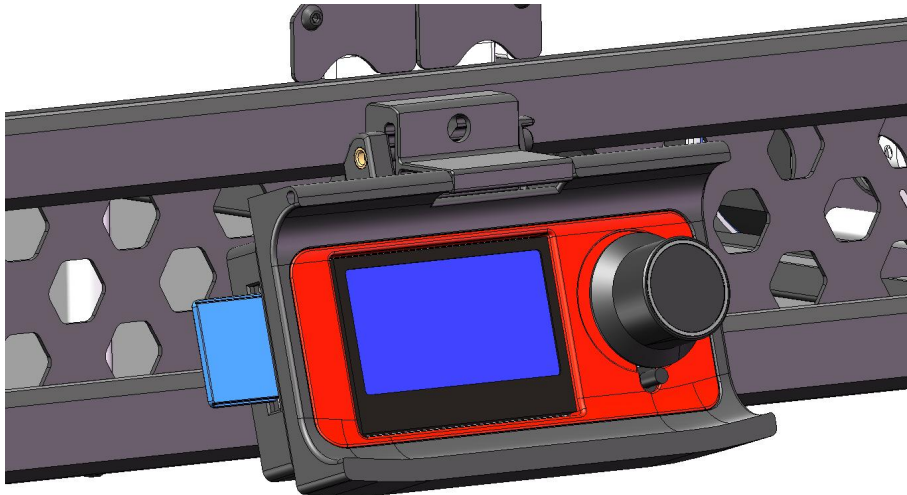


# Start Guide

Open the file of “Configure Wifi.gcode” in SD card, change the Wifi name and password to yours.

```
M552 S0  
G4 P10000  
M587 S"FORMBOT" P"zxcv5678" ; S is your Wifi name, P is your Wifi password  
M552 S1  
M552  
M500
```

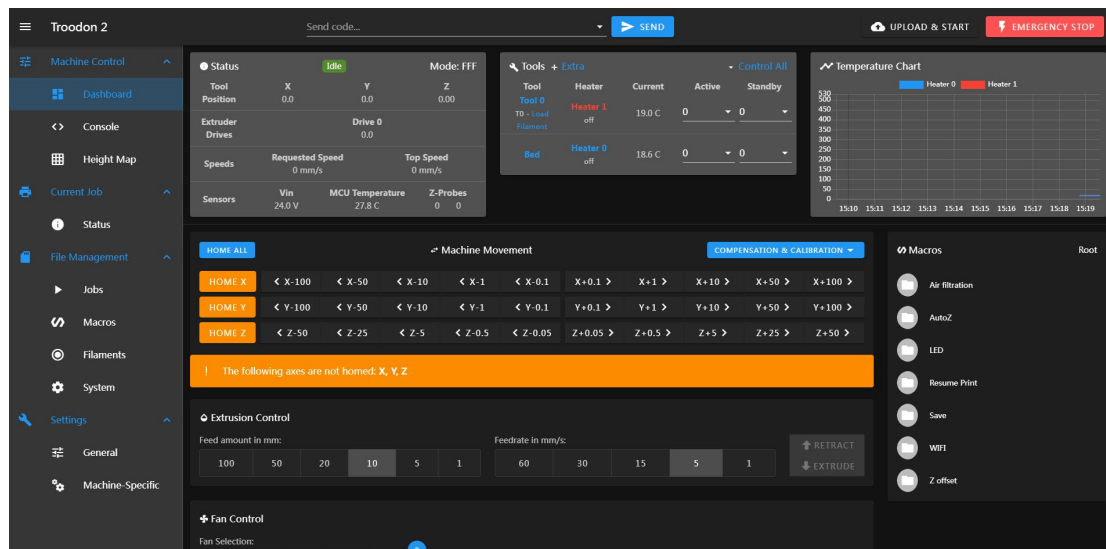
Insert SD card to screen, choose above gcode file for printing.



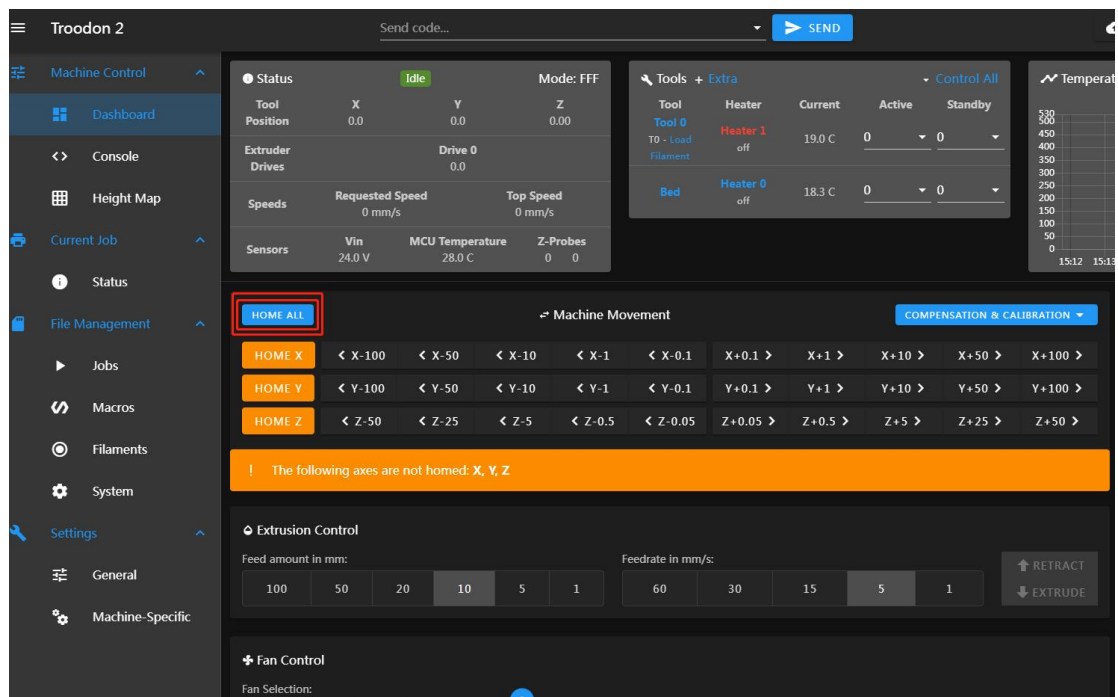
After one minute, you'll see an IP address under “About” menu.



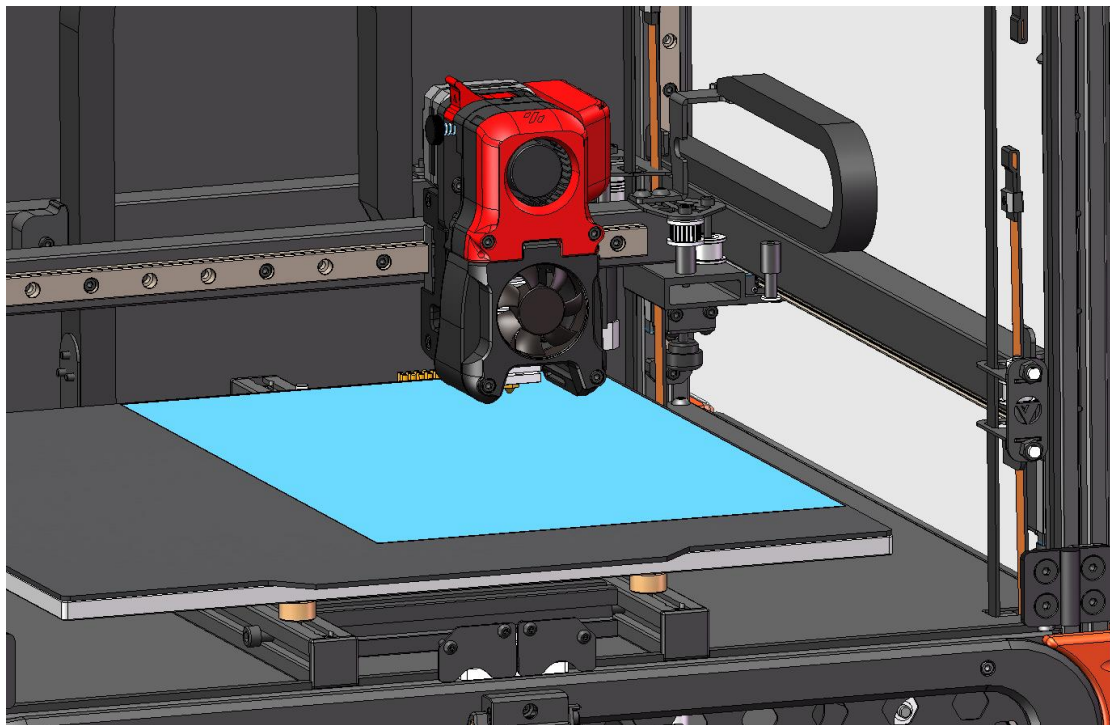
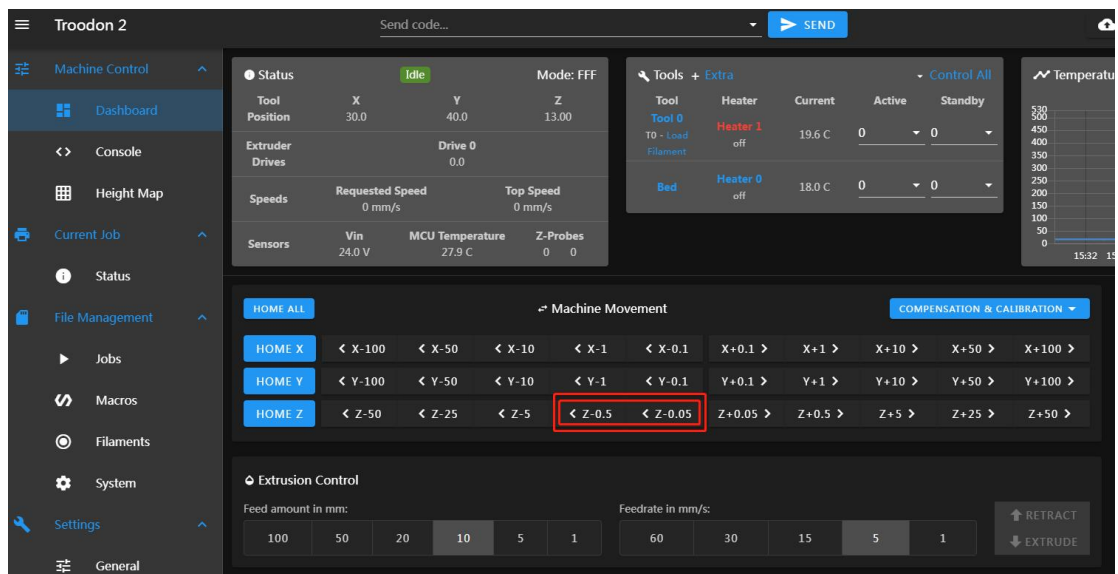
Type the IP address into your browser, then it'll show web console as below.



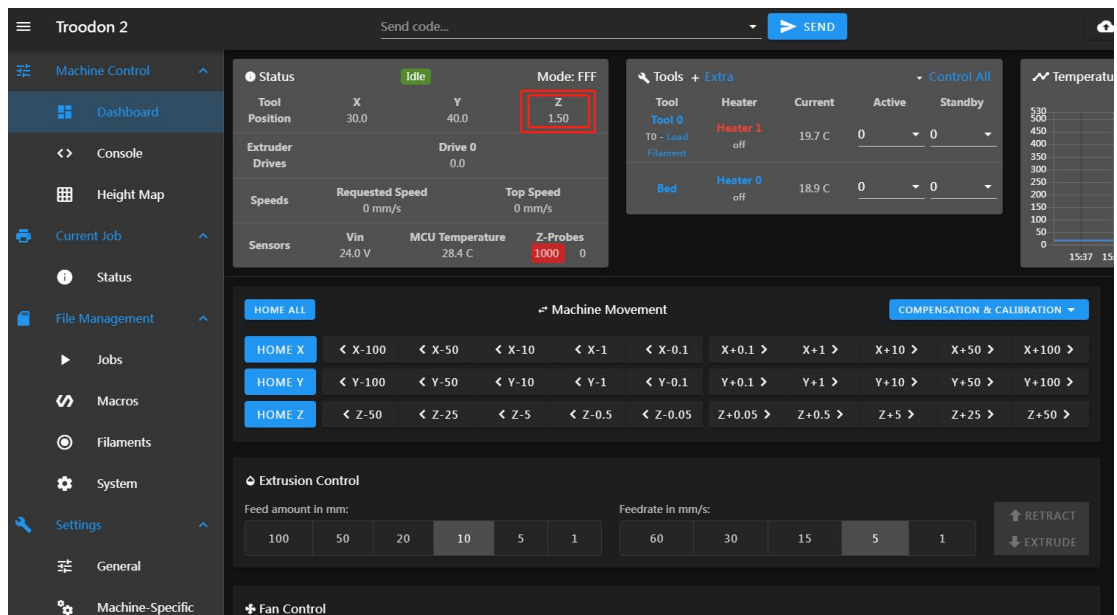
Chick “Home All”, extruder will move to rear right corner.



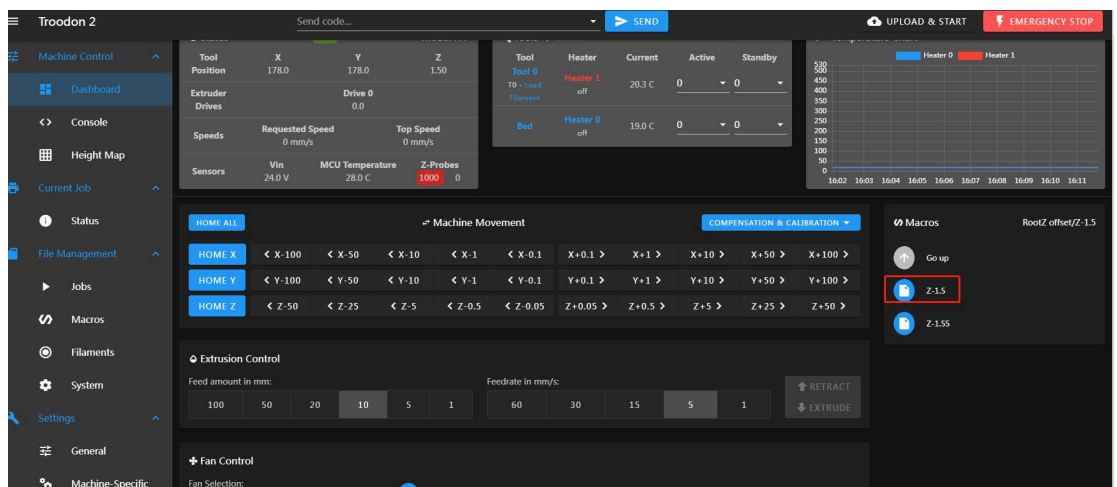
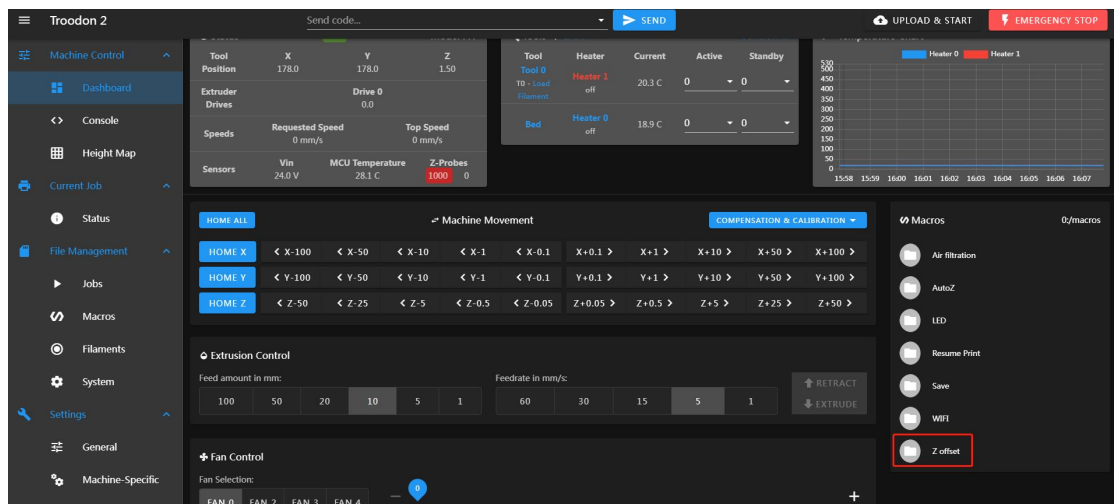
Move down Z axis to lower the extruder until it can pass through ONLY one paper between nozzle and bed.



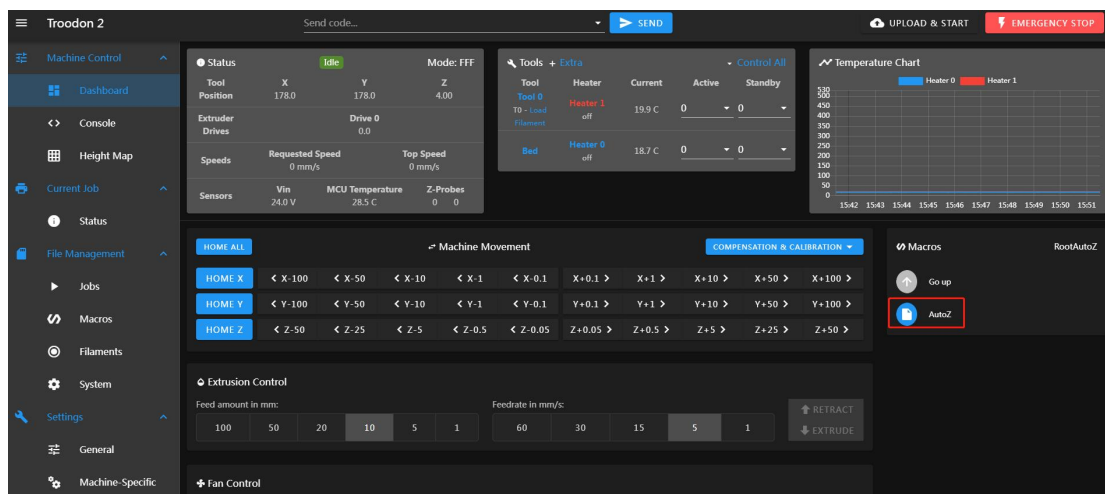
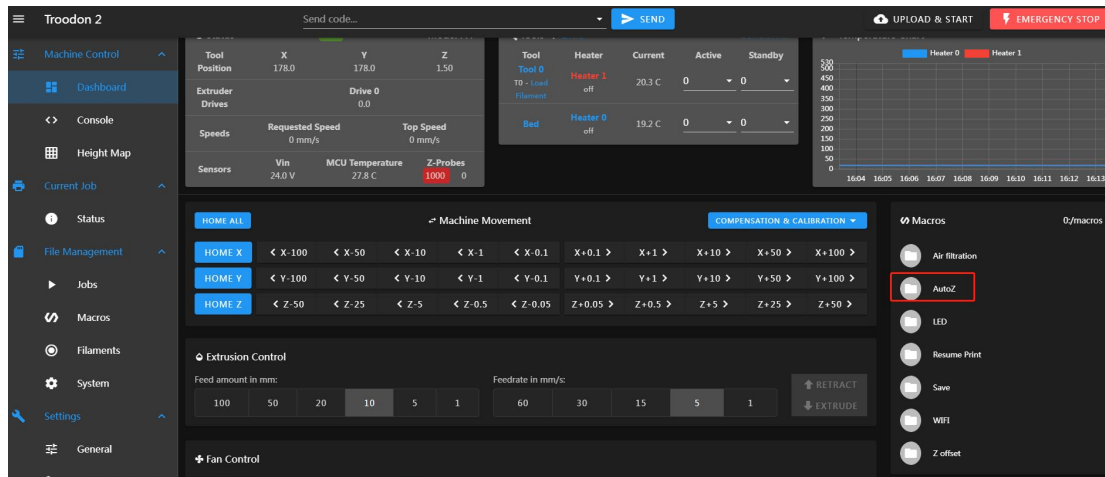
Now you'll see a Z axis coordinate value in below position, use this value minus 3, then you'll get Z offset. For example, if the Z axis coordinate value is 1.5, Z offset should be  $1.5 - 3 = -1.5$



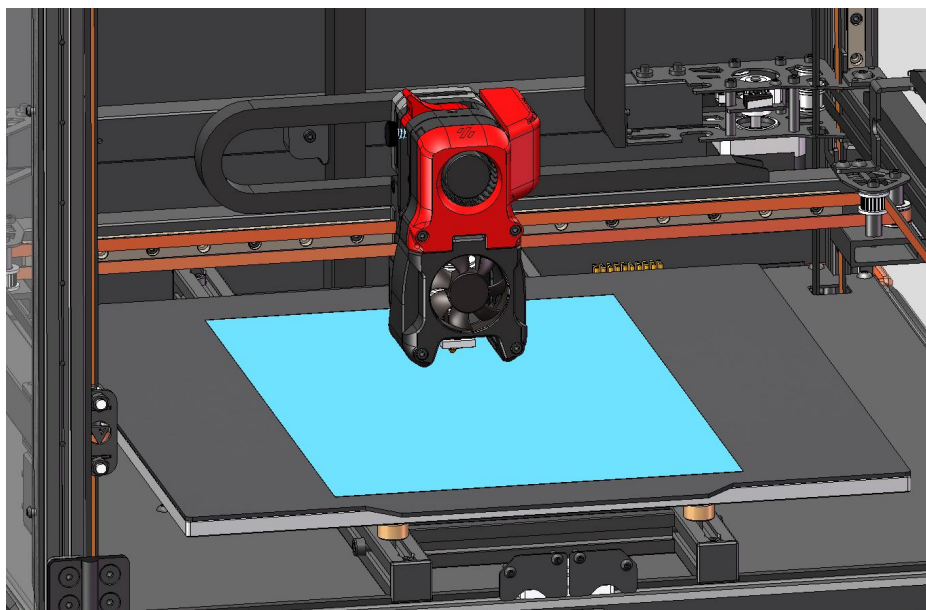
Click Macros -> Z offset, choose the Z offset you calculated in above step.



Click Macros -> AutoZ, the printer will execute gantry leveling, extruder will go to hit the Z endstop, then move back to the middle.

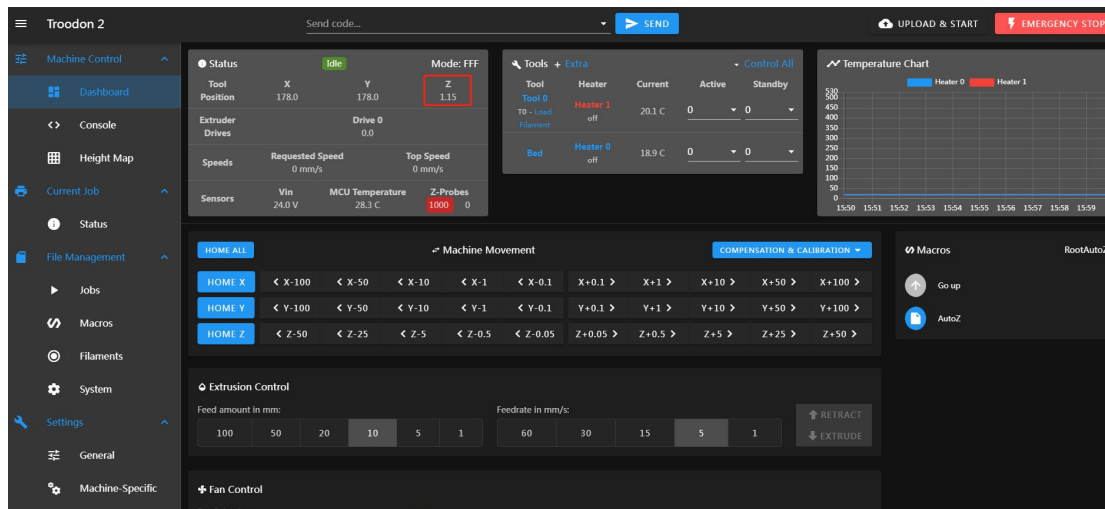


Move down Z axis to lower the extruder until it can pass through ONLY one paper between nozzle and bed.

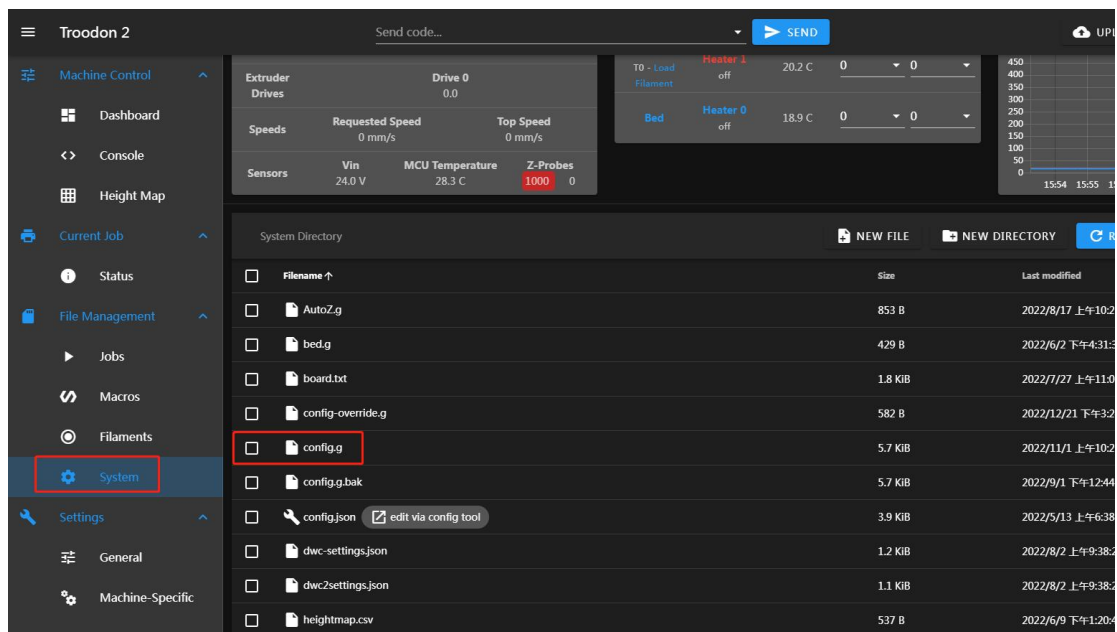




you'll see a new Z axis coordinate value, use 3 minus this value, you'll get AutoZ. For example, if the Z axis coordinate value is 1.15, AutoZ should be  $3 - 1.15 = 1.85$



Click System -> Config.g



Change below value to 1.85, then save it, printer will restart.

```
0:/sys/config.g
; accelerations
M201 X2000 Y2000 Z800 E3000
M203 X40000.00 Y40000.00 Z12000.00 E6000.00
M201 X12000 Y12000 Z4500.00 E400.00
M306 X1800 Y1800 Z1800 E800 I30
M94 S30
; set motor currents (mA) and motor idle factor in per cent
; Set idle timeout

; Axis limits
M208 X0 Y0 Z0 S1
M208 X54 Y55 Z320 S0
; set axis minima
; set axis maxima

; ---filament sensing---
M591 D0 F1 C"PC14" S1

; Endstops
M574 X1 Z1 F"FF2"
M574 Y1 S1 F"TC15"
; configure switch-type (e.g. microswitch) endstop for low end on X via pin xstop
; configure switch-type (e.g. microswitch) endstop for low end on Y via pin ystop

; Z-Probe
M574 Z2 S2
M583 P5 C"FF4" X0 Y0 Z1 H10 F300 T6000
G31 P500 X0 Y-25 Z3
M587 X35:310 Y35:310 S55
; disable Z probe but set dive height, probe speed and travel speed
; define mesh grid

; Z-SWITCH
; This is the microswitch which is pressed by the Nozzle
M583 X1 P5 C"PC14" Y18000 F180 HS A10 S0.0025 R0
G31 X1 P500 X0 Y0 Z1 S1

; Heaters
M308 S0 P"PA0" T"thermistar" T100000 R3950 ; configure sensor 0 as thermostat on pin bedtemp
M360 H0 C"PD12" T0
; create bed heater output on bed and map it to sensor 0
M307 HS A-1 C-1 D-1
; set PID tuned settings for heater 0
M140 H0
; map heated bed to heater 0
M143 H0 S130
; set temperature limit for heater 0 to 125C

M308 S1 P"PB3" T"pt1000" ; configure sensor 1 as thermostat on pin e0temp
M360 H1 C"PB3" T1
; create nozzle heater output on e0heat and map it to sensor 1
M307 SH A517-3 C013-3 T01-1 Y24 T0
; enable nozzle heater output on e0heat and set PID limits
```

Now you can start to print. :)