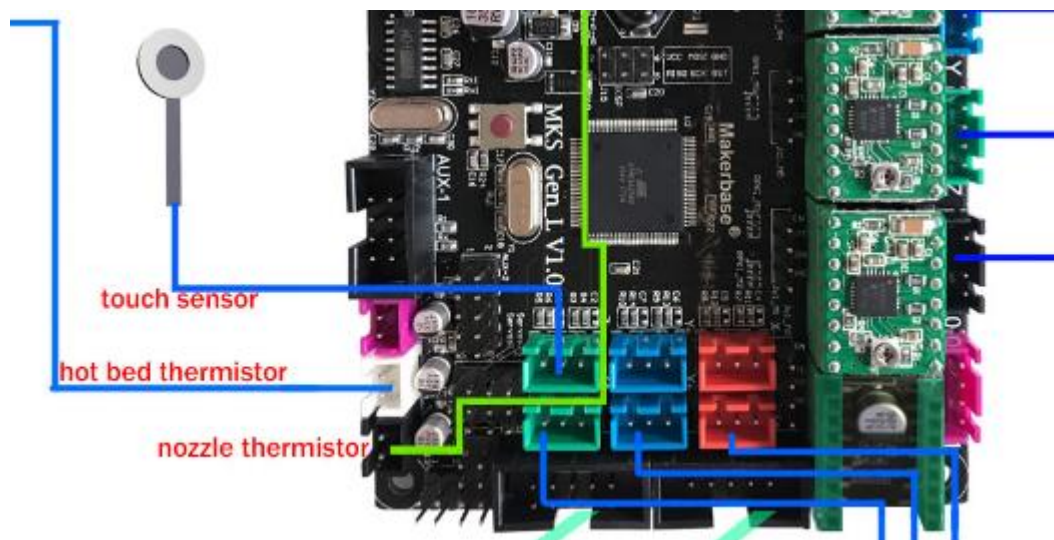
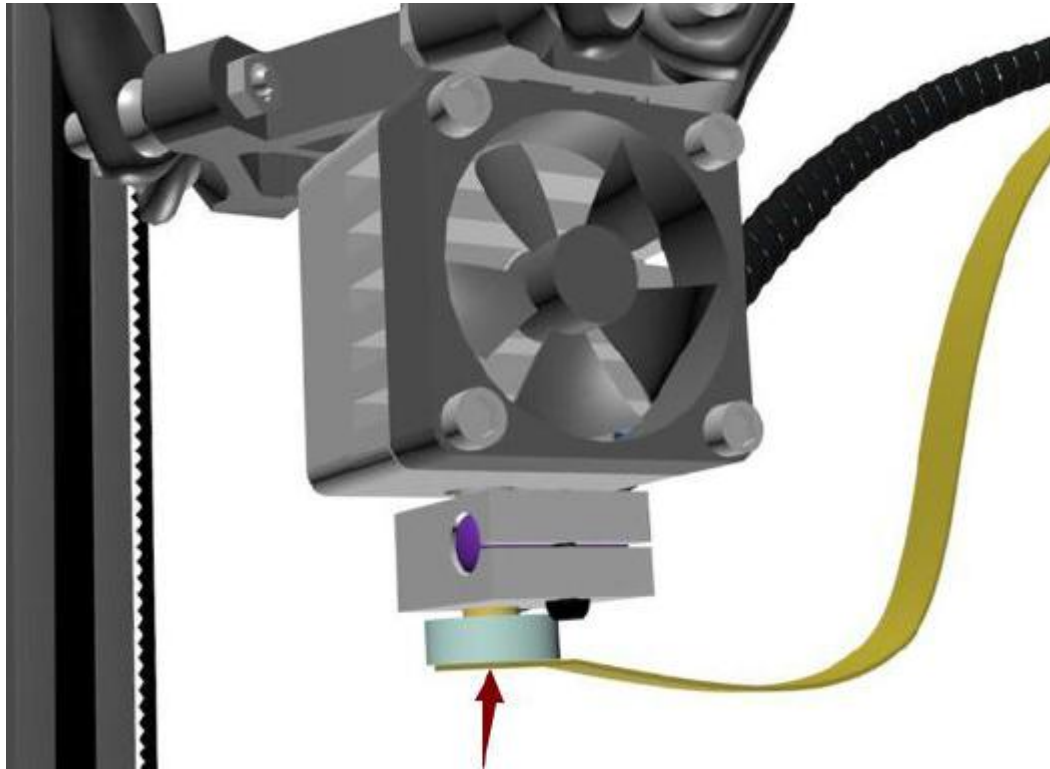


# HE3D Delta Printer Auto leveling method

- 1) Put on the Z-probe sensor



- 2) Measure the Z position

Power on the printer.

From LCD screen

Operation as below picture:

```
HE3D  
Welcome !
```

```
⚙ 27/0°   📏 0/0°  
X  0 Y  0 Z  0  
FR100% SD---% ⌚00:00  
HE3D K280 ready.
```

```
Info screen      ⬆  
Prepare          >  
>Auto leveling Bed >  
Control          >
```

```
>Measure Z Pos  
Prepare Leveling >  
Z + 0.1  
Z - 0.1
```

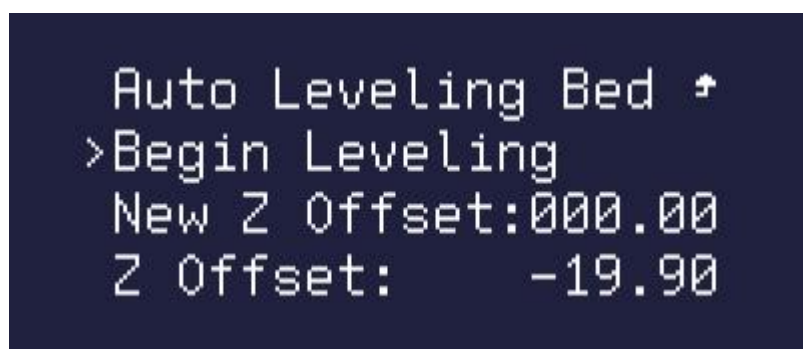
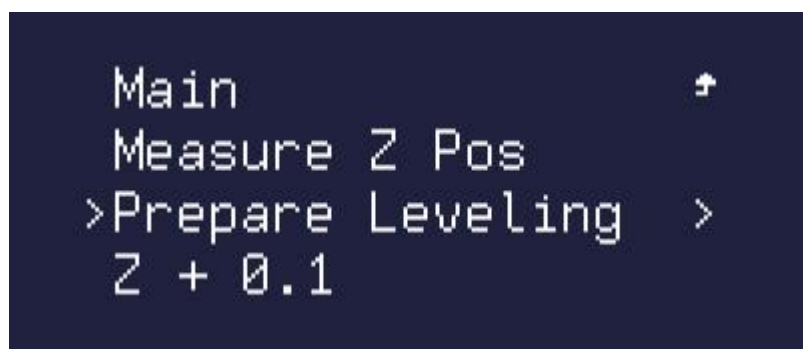
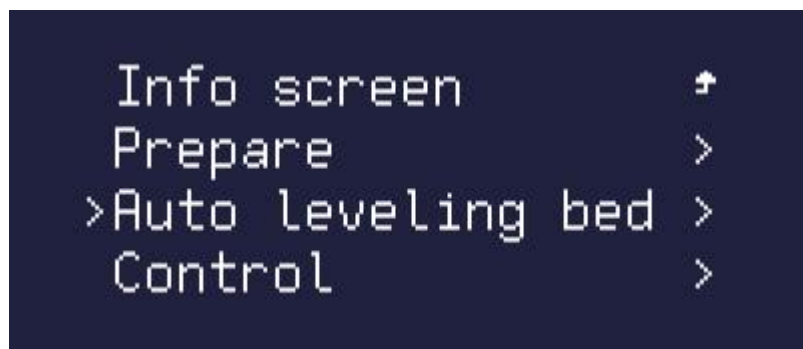
The nozzle will detect the printer table by hit many points,

Then, the nozzle will back the home position, then restart.



### 3) Auto leveling

Now please do as picture below:



The nozzle will detect the printer table by hit many points again.

Then back home, and then down lower nozzle hit the bed. And stop.

After leveling

4) adjust the offset value

Operation as picture below

After leveling, New Z Offset would appear a new value

Choose the Z offset, adjust its value to (New Z offset)

Then, Store

```
Info screen      ↑
Prepare         >
>Auto leveling Bed >
Control         >
```

```
Main            ↑
Measure Z Pos
>Prepare leveling >
Z + 0.1
```

```
Auto Leveling Bed *  
Begin Leveling  
>New Z Offset:-19.92  
Z Offset:      -19.90
```

```
Auto Leveling Bed *  
Begin Leveling  
New Z Offset:-19.92  
>Z Offset:      -19.90
```

```
Z Offset:      -19.92
```

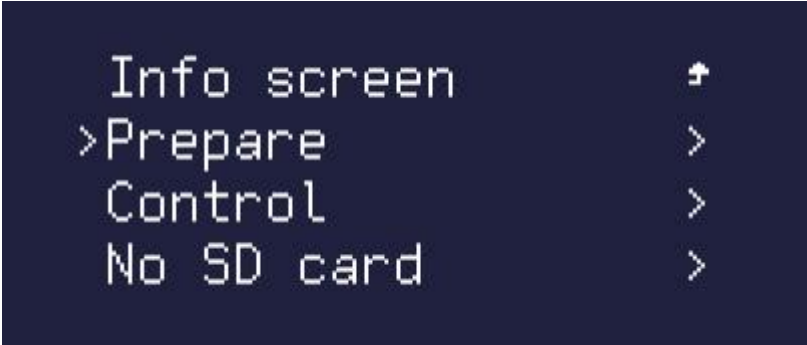
```
Begin Leveling  
New Z Offset:-19.92  
Z Offset:      -19.92  
>Store
```

##### 5) Test print


Pick off the sensor from nozzle

Insert filament.

Preheat the nozzle as picture below



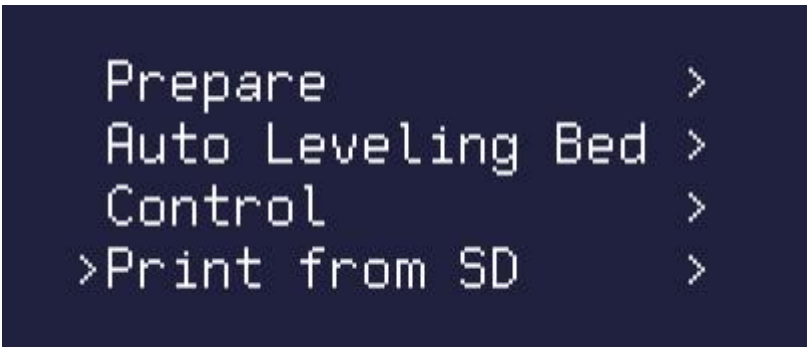
```
Info screen      +
>Prepare         >
Control          >
No SD card       >
```



```
Move axis        >
Disable steppers
>Preheat PLA     >
Preheat ABS      >
```

Insert SD card (which should be some Gcode files in there, or copy some G-code file which you want to print by this printer)

And from LCD screen. Choose G-code file from SD card as picture below.



```
Prepare          >
Auto Leveling Bed >
Control          >
>Print from SD   >
```

Sometimes, when printing, the melt filament could not stick on the printer table. You can choose Pause print. Choose Auto Leveling

Bed . Choose Z +0.1 or Z -0.1 (Push the LCD knob) And store .  
(Push the LCD knob) This operation could lift or down lower the  
nozzle a little bit. So that the nozzle could stay at the more properly  
position to print.

```
Auto Leveling Bed >  
Control >  
>Pause print  
Stop print
```

```
Prepare Leveling >  
Z + 0.1  
>Z - 0.1  
Store
```

```
Prepare Leveling >  
Z + 0.1  
Z - 0.1  
>Store
```

```
Auto Leveling Bed >  
Control  
>Resume print  
Stop print
```