HE3D K280 computer operation And compensation calibration method

Dear customer, thank you for you order our product.

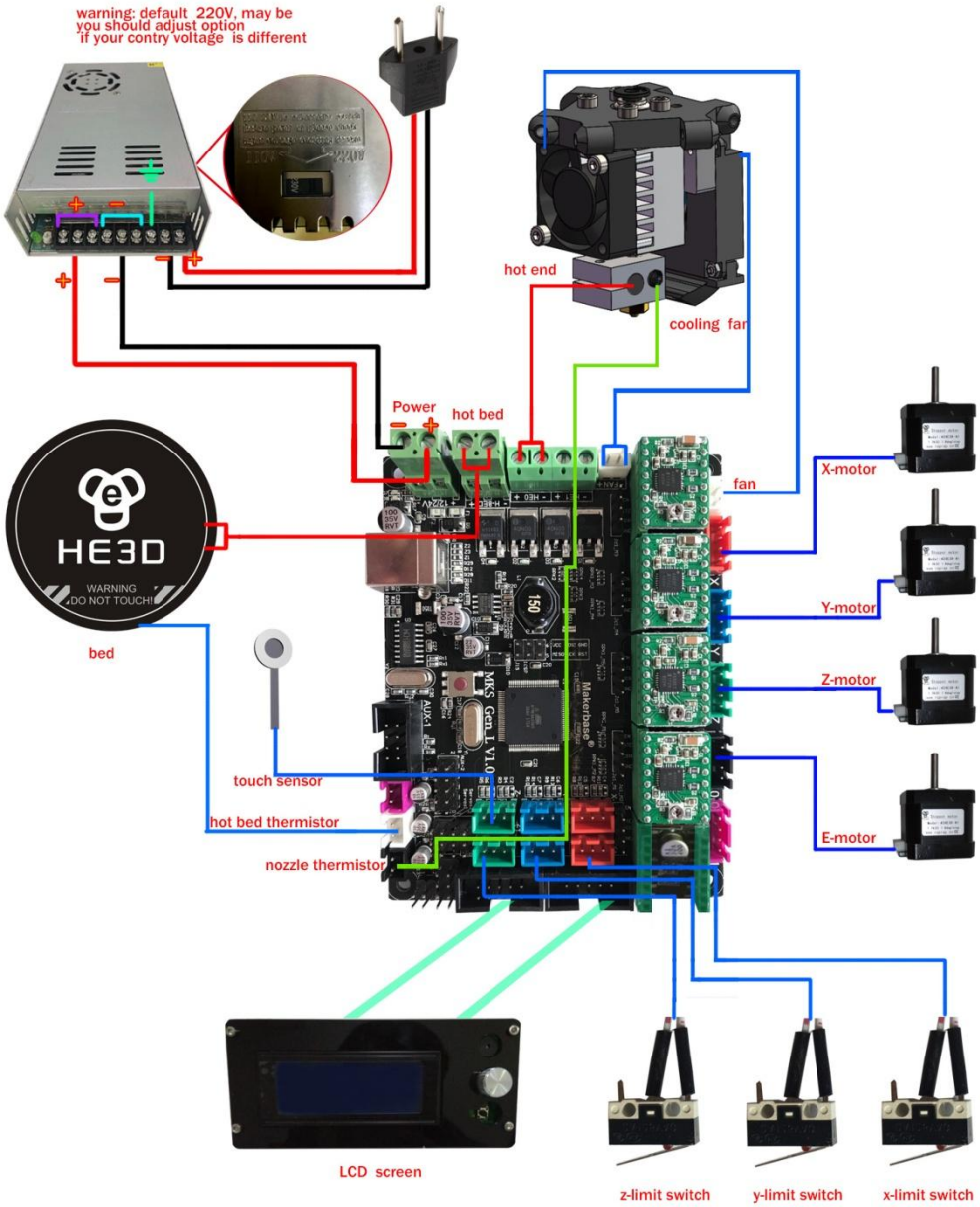
about assembling, you can refer to this youtube link.

https://youtu.be/h9bnhPlEink

[there are two corrections in this video: mention this please.]

and about wiring :

K280 wiring diagram



when you finish building, we could test this printer by computer

method :

A

connect your printer to your computer

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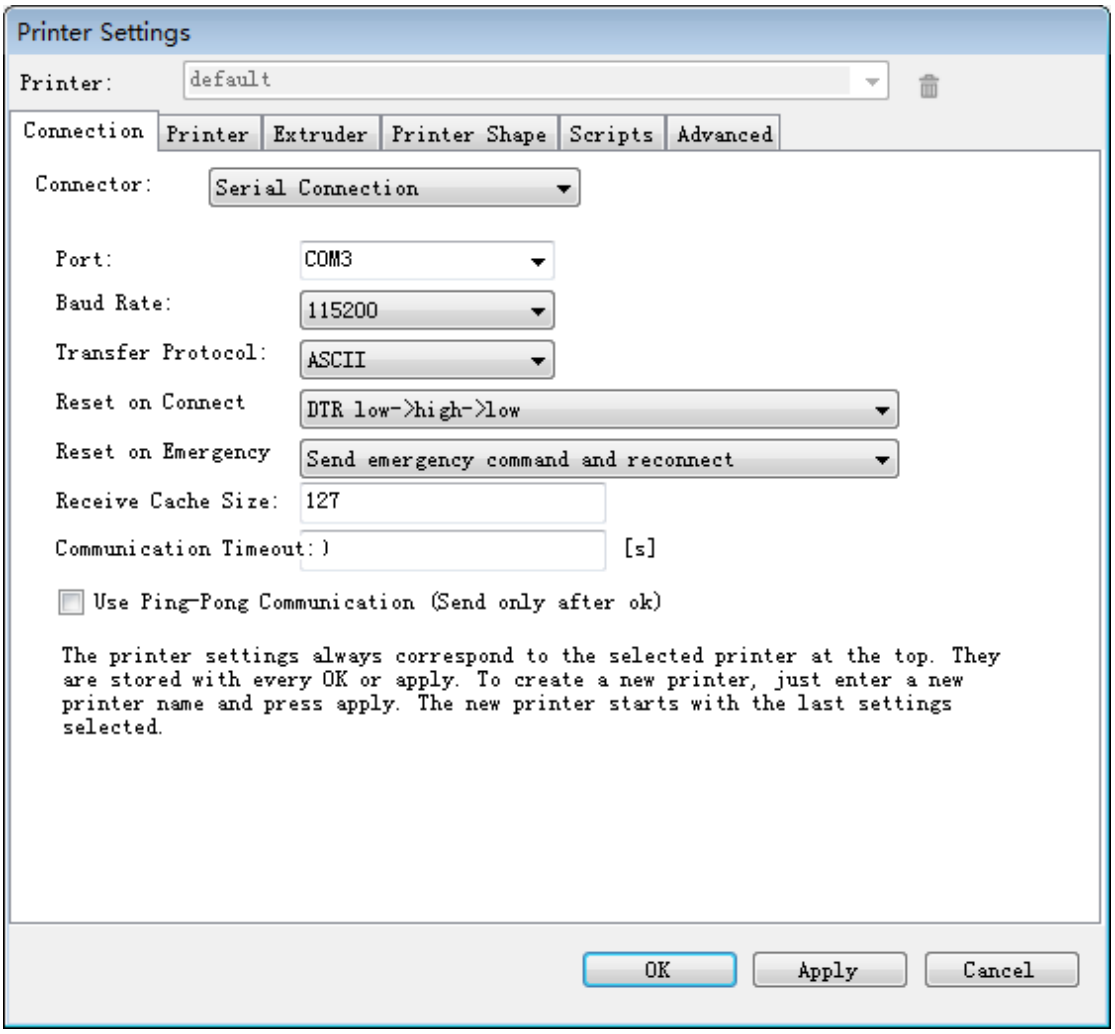
install.

setupRepetierHost_1_5_4.exe (refer to the file link)

https://drive.google.com/drive/folders/0B8opGltFUVLQUmUwLXpoWENVYUU?usp=sharing

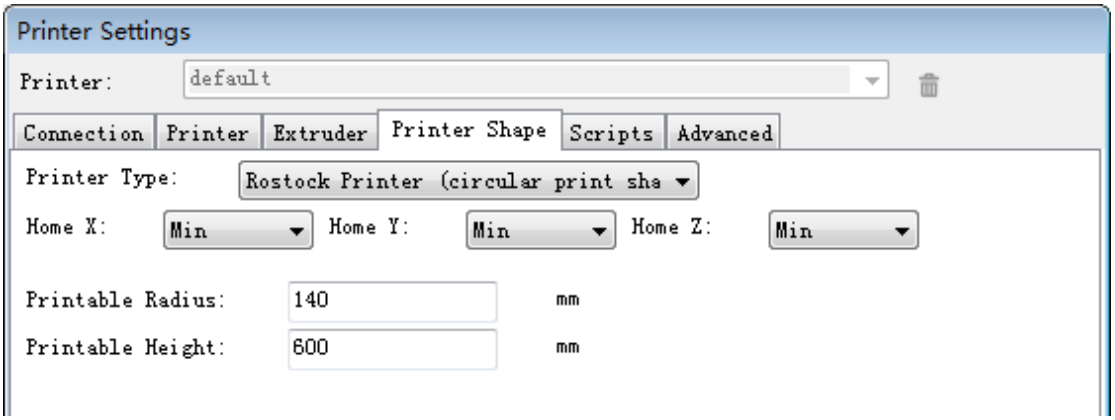
connect your printer to computer.

COM number according to your own number. (refer to pic below)



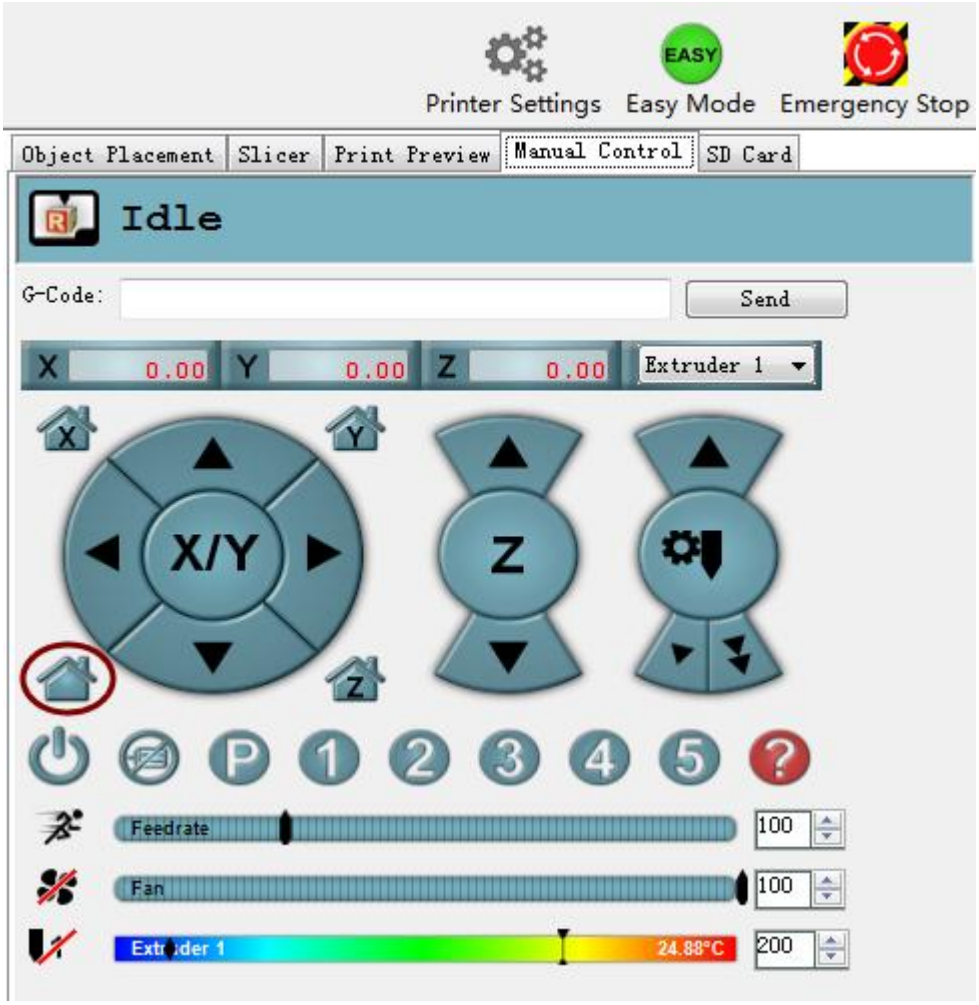
COM number according to your own number

Choose shape:

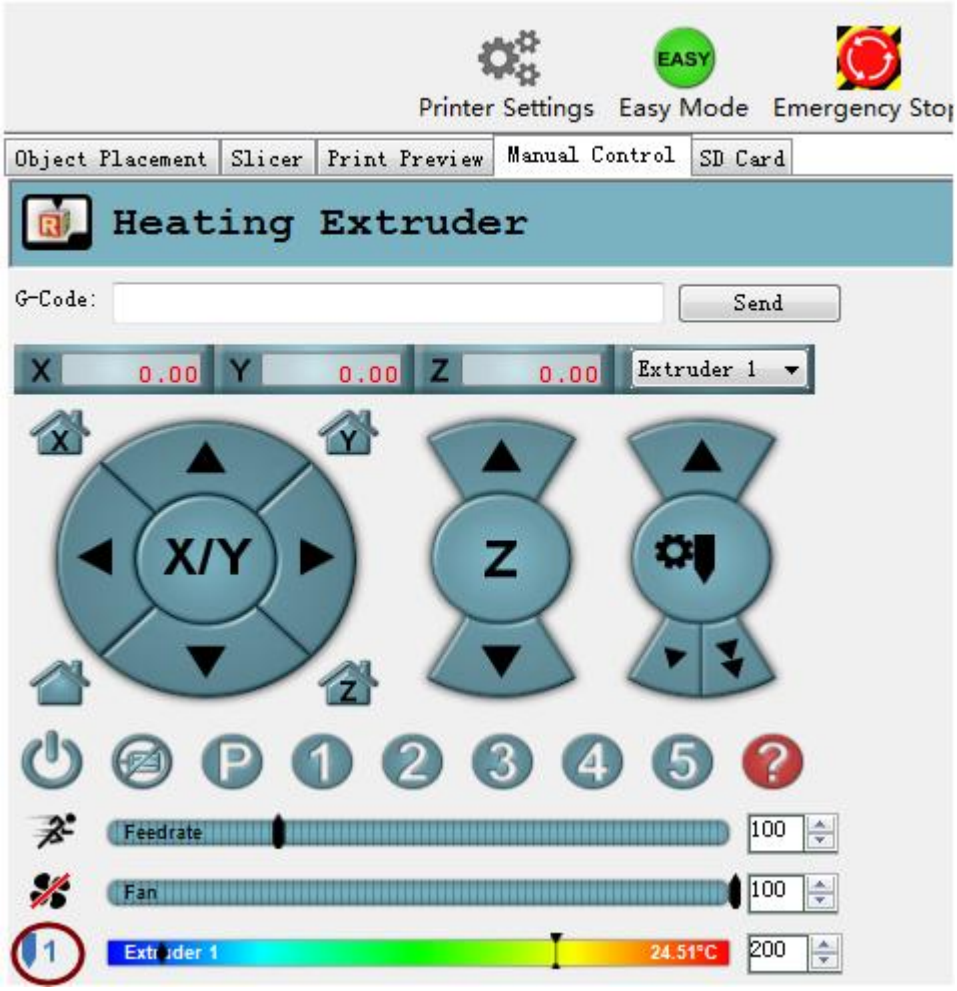


test movement of all axis

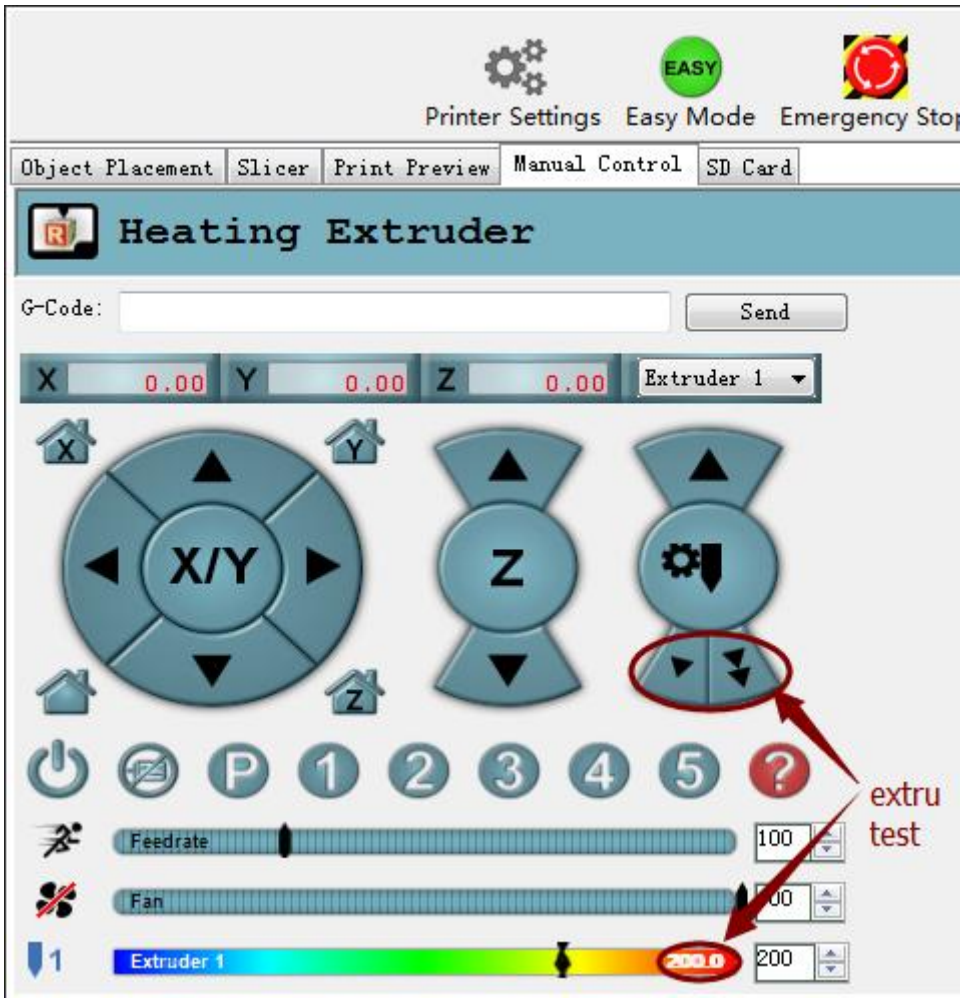
"Go home" cammand



then, test heat system



then, test extruder movement.(when nozzle temperature above 180)



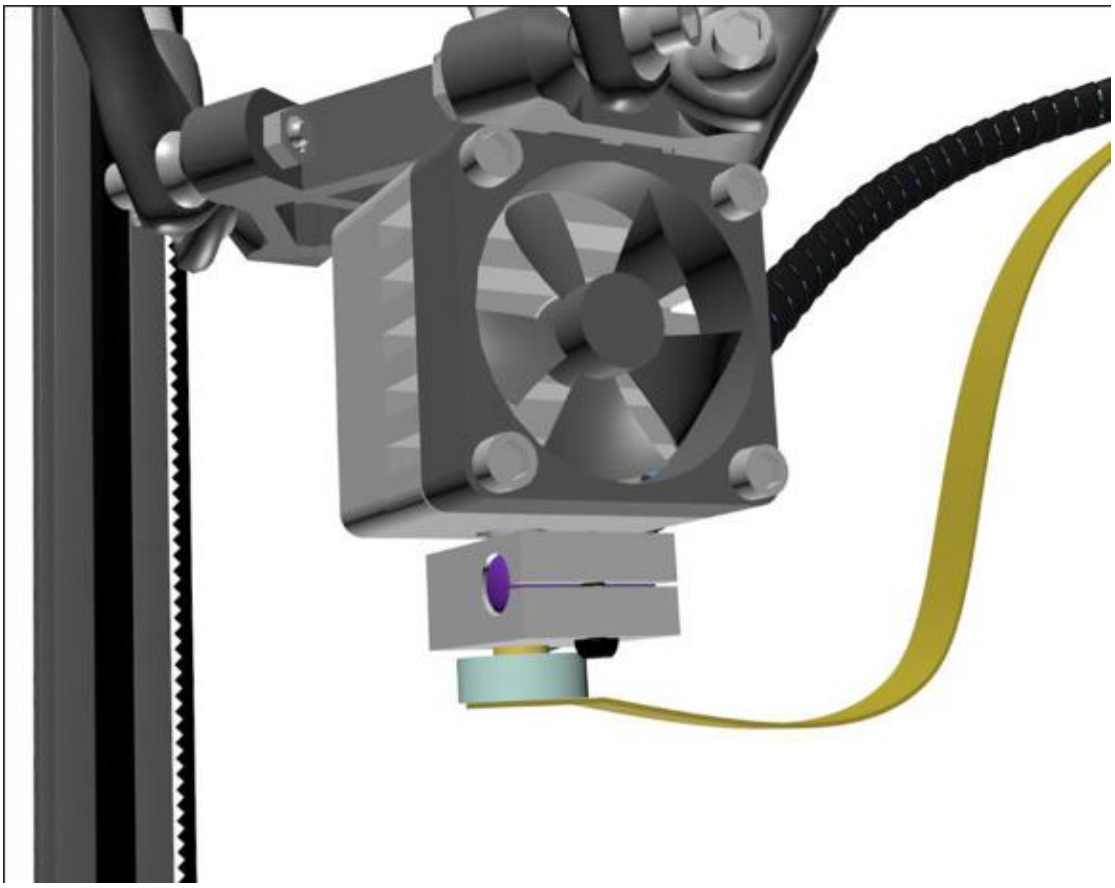
B

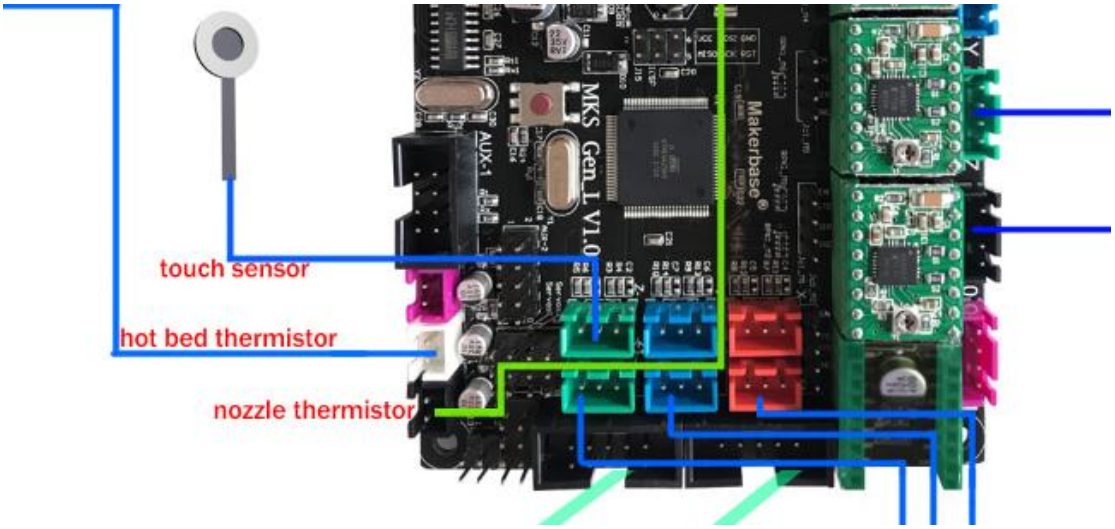
Calibration

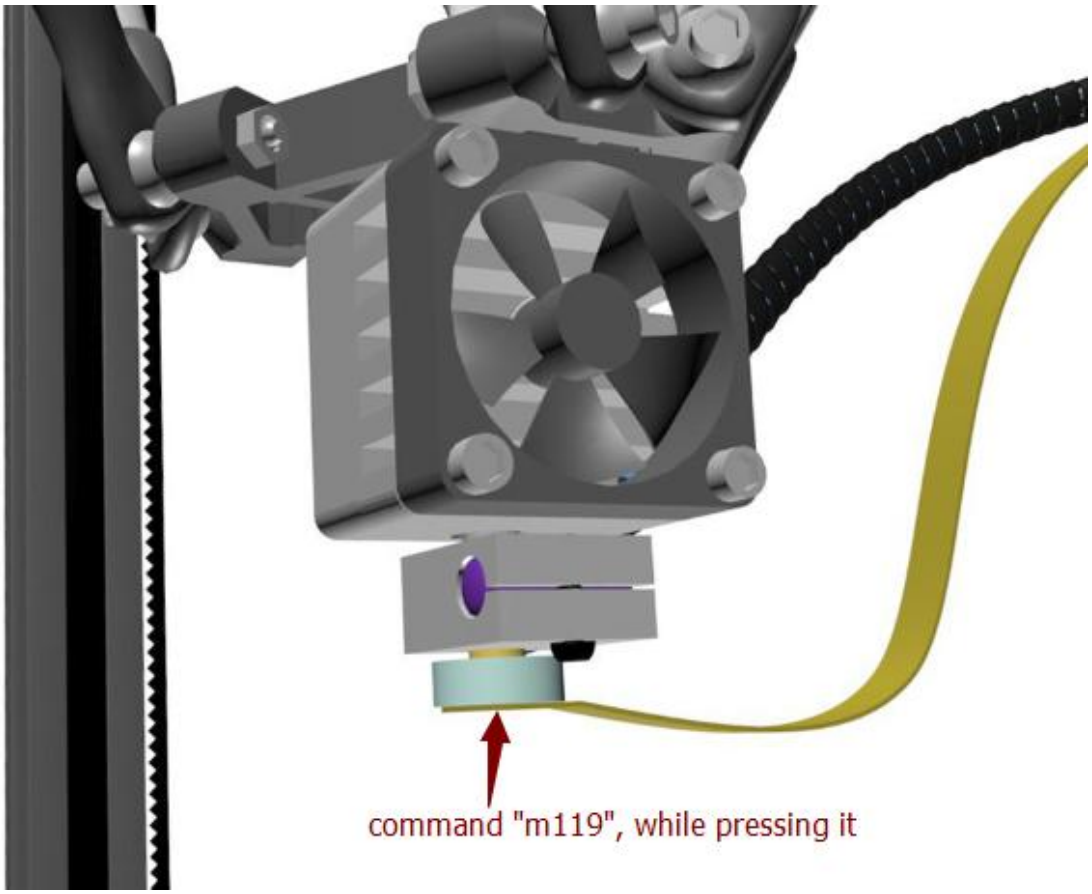
After all testing process, we could calibrate the printer now.

1) level

At first, put on the z-probe [touch sensor or soft socket]




touch sensor
hot bed thermistor
nozzle thermistor
MKS Gen_L V1.0
Makerbase
AUX-1

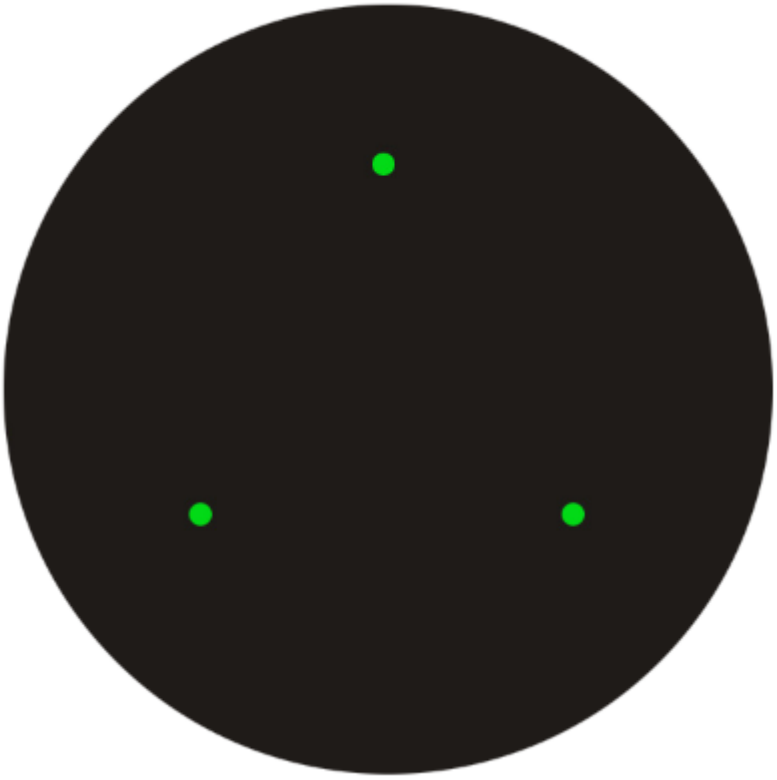



```
endstops hit: x_max:L y_max:L z_min:L z_max:L Z-probe state:L
endstops hit: x_max:L y_max:L z_min:H z_max:L Z-probe state:H
```

when pressing

Then, we could command “G29”

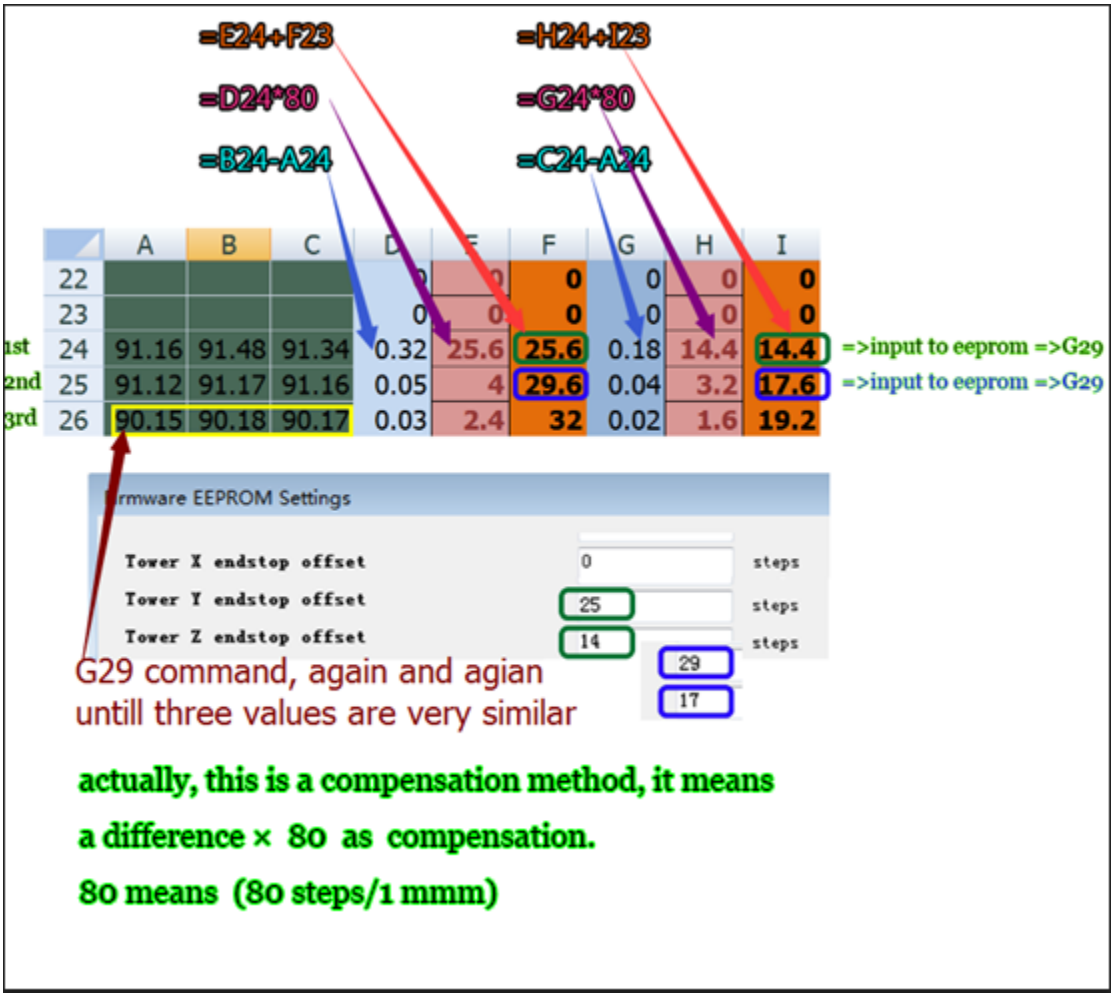
It will hit three points on the plate



Then, give three values (example pic below)

```
Z-probe:91.16 X:-66.00 Y:-38.00
Z-probe:91.48 X:66.00 Y:-38.00
Z-probe:91.34 X:0.00 Y:66.00
```

Calculation and

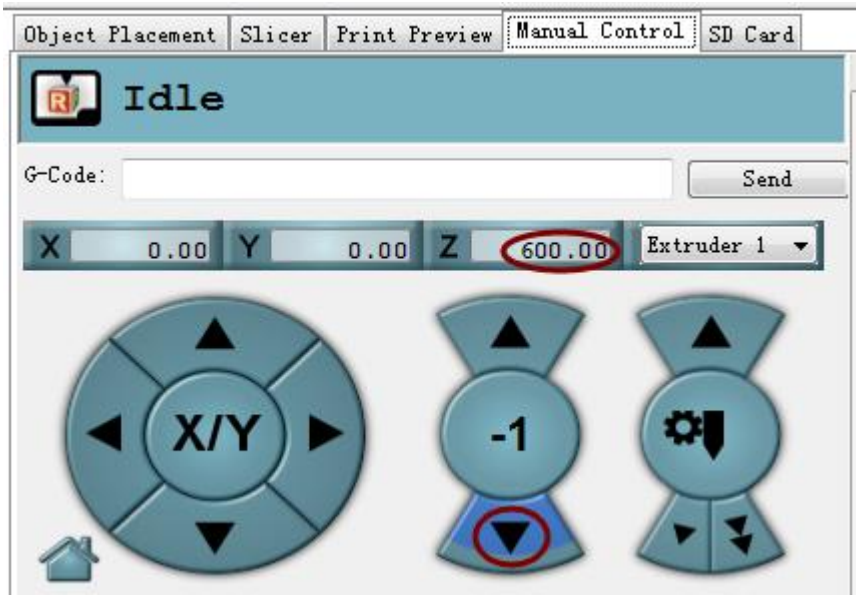


2) Re define the maxium height.

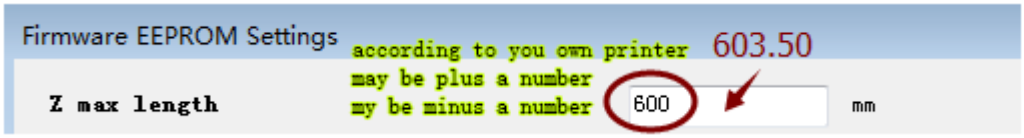
“Gohome” command , let the nozzle at the highest position,

Descending the nozzle, until it reach the plate, then, read the value, then

calculate the value of the nozzle actually travelled.



Then , change the original value. (according to your own testing)



C

how to print

1)

the file that the printer could print is *.gcode.

and *.stl could convert to *.gcode

so, if you want to print some model.

you should have a *.stl file.

then. we use software convert it to gcode.

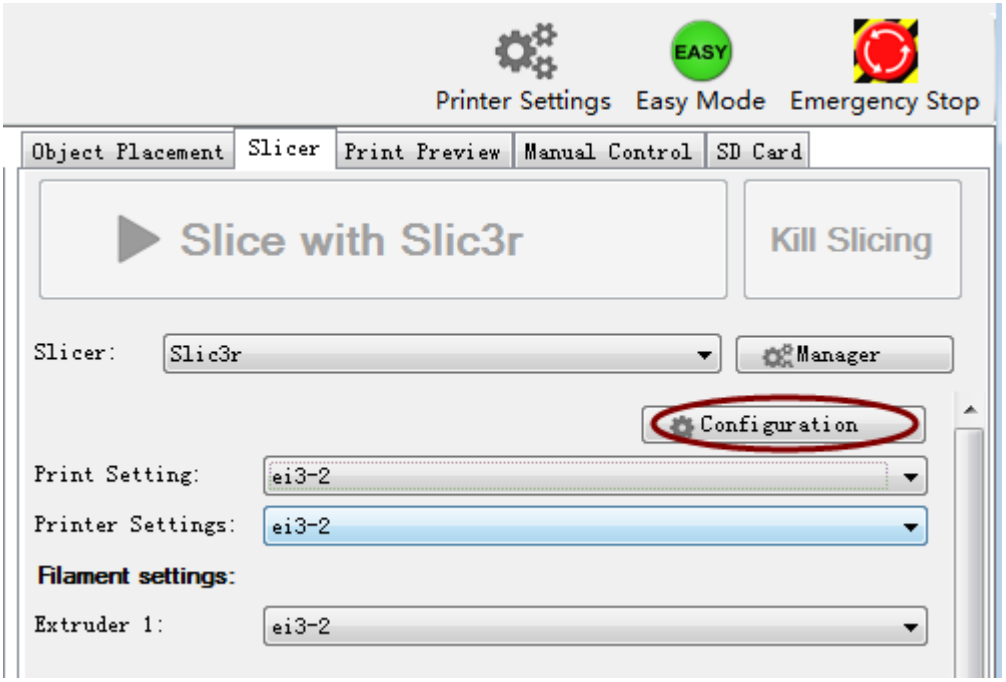
2)

we take the repetier as an example.

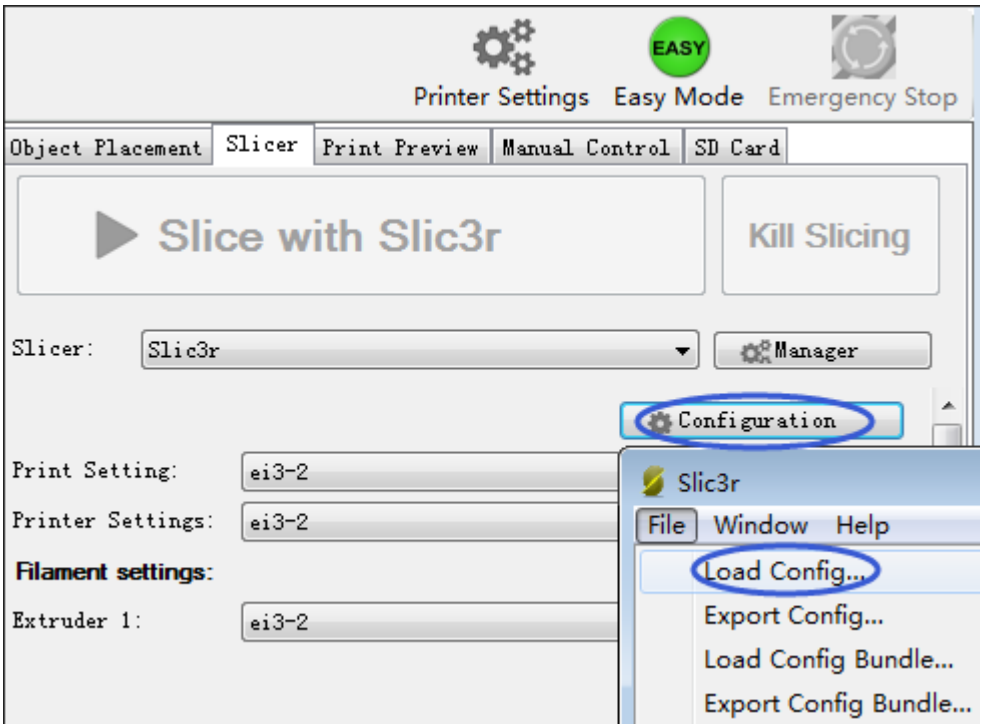
Refer to pic below

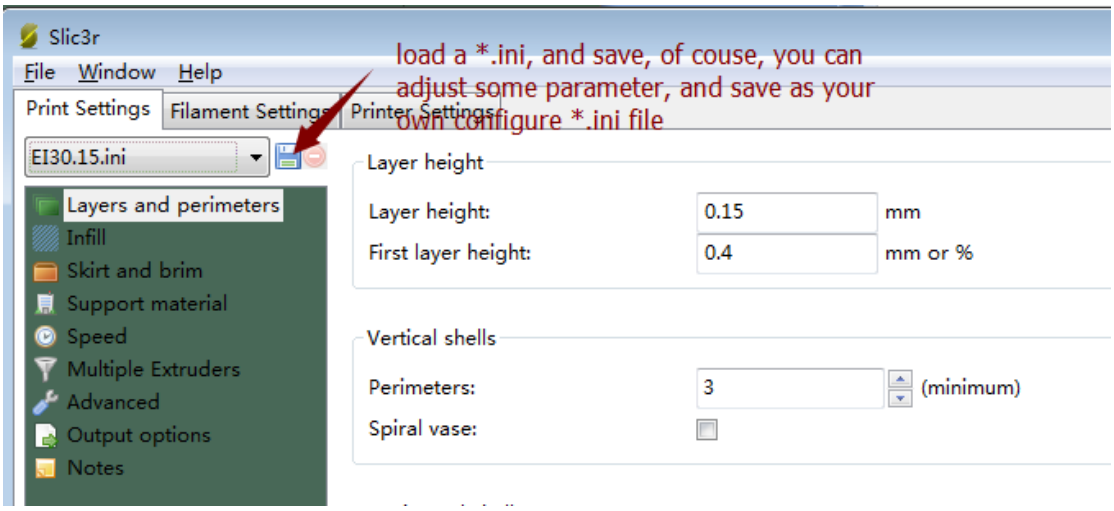
manager:

you can choose slicing software. (here , we use slice3r)

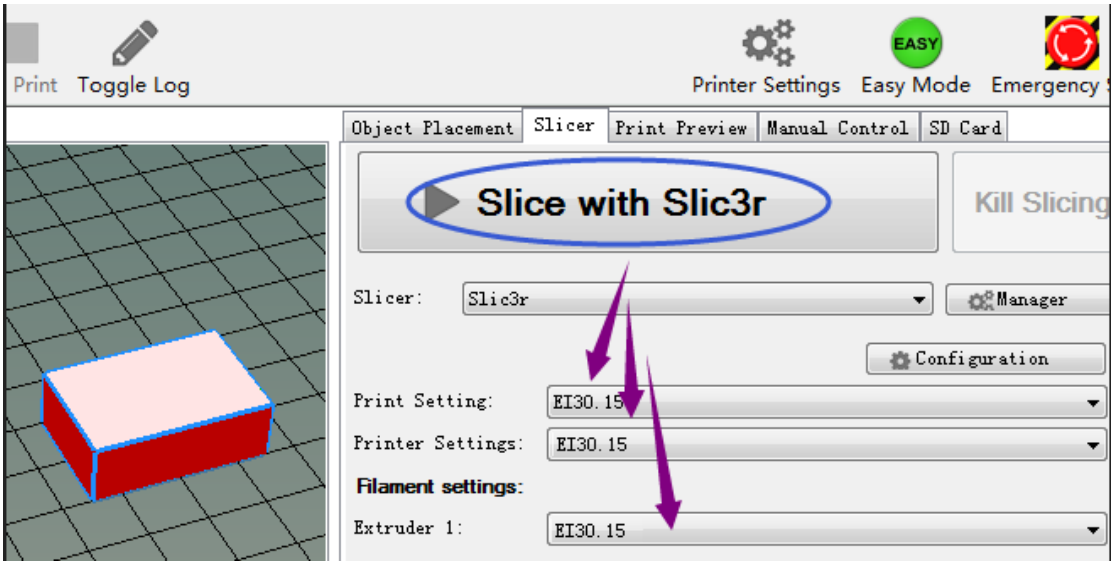


configuration.

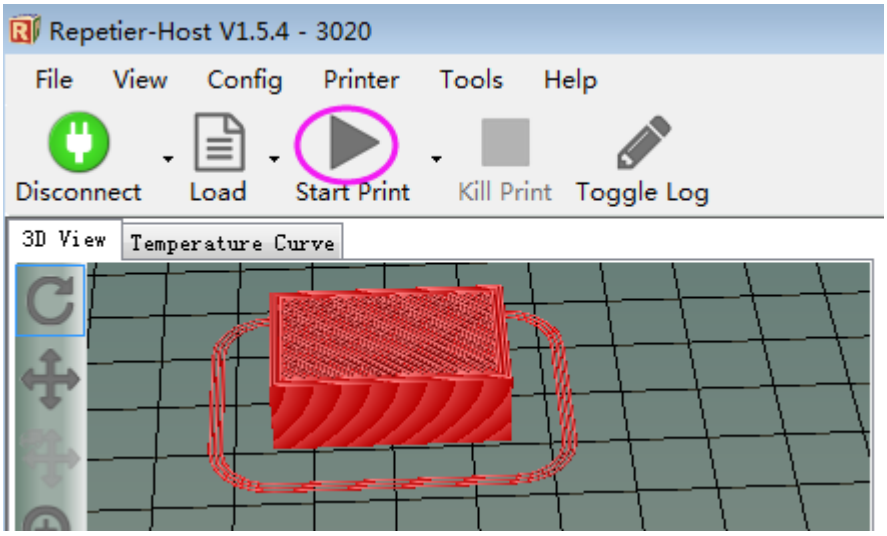




After this. We can slice a *.stl file now



Then, we can print now



Tip: when you print, the distance between nozzle and plate should be 0.3mm or so, if the distance is too big, the structure would be loose too, the total shape would be effected.

After all these process, we could officially, use this printer now!

Enjoy your printing!

Thank you !

If you have question, Welcome to join our facebook group:

delta:
https://www.facebook.com/groups/1787070361537465/

email: support@reprap.cn