为了保证精度，请安装时尽可能让传感器线圈板的顶面低于加热块的底面。

教程里没有提到的不要做，提到的请务必做

在用户目录下执行git clone <https://gitee.com/NBTP/IDM.git> 下载程序包



执行chmod +x IDM/install.sh

然后执行IDM/install.sh进行安装

这一步会自动把脚本创建一个链接放到klipper/klipper/extra目录下

然后

[idm]

serial:

#canbus\_uuid:

*#   Path to the serial port for the idm device. Typically has the form*

*#   /dev/serial/by-id/usb-idm\_idm\_...*

speed: 40.

*#   Z probing dive speed.*

lift\_speed: 5.

*#   Z probing lift speed.*

backlash\_comp: 0.5

*#   Backlash compensation distance for removing Z backlash before measuring*

*#   the sensor response.*

x\_offset: 0.

*#   X offset of idm from the nozzle.*

y\_offset: 21.1

*#   Y offset of idm from the nozzle.*

trigger\_distance: 2.

*#   idm trigger distance for homing.*

trigger\_dive\_threshold: 1.5

*#   Threshold for range vs dive mode probing. Beyond `trigger\_distance +*

*#   trigger\_dive\_threshold` a dive will be used.*

trigger\_hysteresis: 0.006

*#   Hysteresis on trigger threshold for untriggering, as a percentage of the*

*#   trigger threshold.*

cal\_nozzle\_z: 0.1

*#   Expected nozzle offset after completing manual Z offset calibration.*

cal\_floor: 0.1

*#   Minimum z bound on sensor response measurement.*

cal\_ceil:5.

*#   Maximum z bound on sensor response measurement.*

cal\_speed: 1.0

*#   Speed while measuring response curve.*

cal\_move\_speed: 10.

*#   Speed while moving to position for response curve measurement.*

default\_model\_name: default

*#   Name of default idm model to load.*

mesh\_main\_direction: x

*#   Primary travel direction during mesh measurement.*

*#mesh\_overscan: -1*

*#   Distance to use for direction changes at mesh line ends. Omit this setting*

*#   and a default will be calculated from line spacing and available travel.*

mesh\_cluster\_size: 1

*#   Radius of mesh grid point clusters.*

mesh\_runs: 2

*#   Number of passes to make during mesh scan.*

请注意调整配置中的x y方向偏移。确保校准过程中喷头会将线圈移动到原先喷嘴所在xy位置。

将这段配置放进printer.cfg并将serial修改为你查询到的idm的串口号，查询指令为ls /dev/serial/by-id/\*

can版本的话使用常规的查询方法搜索can的uuid并填入

在配置里再加入

[force\_move]

enable\_force\_move: true

方便校准，校准全部结束后可删除

之后把[probe]模块删除

并将z限位修改为probe:z\_virtual\_endstop

还需要设置

[safe\_z\_home]

home\_xy\_position: <你的x轴中心坐标>,<你的y轴中心坐标>

z\_hop: 10

如果你已经配置过safe\_z\_home或者homing\_override，可以忽视这一步

记得设置[bed\_mesh]不然会报错

重启之后将热端移动到中间并徒手(徒手徒手！不要g28之后控制打印头移动)将喷嘴贴到平台上

输入SET\_KINEMATIC\_POSITION x=<平台中心x坐标> y=<平台中心y轴坐标> z=0

之后执行idm\_calibrate的指令

点击-0.1的偏移后确认，会自动进行校准

在控制台输入idm并按tab键可以看到所有支持的指令

将z\_tilt或者quad\_gantry\_level中的horizontal\_z\_move降到trigger\_distance + trigger\_dive\_threshold以下(默认为3)可以使调平进入高速模式，觉得太低可以适当拉高trigger\_dive\_threshold使horizontal\_z\_move可以拉高一些。

含加速计(lis2dw)的版本可以在配置中添加以下内容启用加速计:

[lis2dw]

cs\_pin: idm:PA3

spi\_bus: spi1

[resonance\_tester]

accel\_chip: lis2dw

probe\_points:

    125, 125, 20  #此处设置为你进行共振测量时喷头所处坐标