Set Up : Correct Calibration
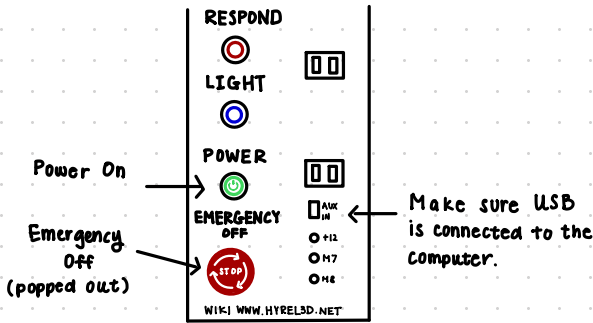
① Step 1: Make sure that the POWER is on,
the EMERGENCY OFF is off, and the Aux is in.

RESPOND

LIGHT

POWER

Power On →

EMERGENCY OFF

Emergency Off (popped out) →

STOP

Aux IN
+12
M7
M8

WIKI WWW.HYREL3D.NET

Make sure USB is connected to the computer.

② Step 2: Time to Calibrate!

a. Check X value by pressing +X 100 and −X 100 in Repetrel and head moves left and right, respectively.

b. Measure the distance between the starting position and ending position and make sure it moves exactly 100 mm.

c. If the moving distance is inaccurate, adjust the x-value in motor scale. (settings → printer → hardware setup)

d. Repeat for the Y-values.

X	Y
REL	X=0 Y=0
MHL	0.0 0.0

100
10
−Y
1

FINE MOVE

10
1
−Z
0.1

z^^0
z↓0

+X 100 10 1

−X 1 10 100

Z = 0.0

1
+Y 10

HOME X-Y

PARK

0.1
+Z
10

ENABLE Z Calibrate

!!!HOT!!!

make sure the head moves 100 mm (10 cm).

1 2 3 4 5
1 2 3 4 5 6 7 8 9 10 11 12 13