**3D Print Calibration**

**Extruder Steps Calibration**

First Measure out 120mm and mark the filament from known measuring point from extruder (before it enters the extruder).

Move Extruder 100mm at 100mm/min speed using following G-Code

G1 E100 F100

After Extruder Stops Measure Out the remaining filament length.

I measured out 25mm remaining which means i have under extruded about 5mm.

New E Steps = Desired Distance / Measured Distance \* Current E Steps

98 = 100 / 95 \* 93

Enter this value to your config file.

Current Value is 100 Steps

**Extrusion Multiplier / Flow Rate**

Use calibration cude and print no infill, no top / bottom and only one line with wall.

Just print up to the point we can measure

New Extrusion Multiplier = Desired Wall Thickness / Measured Wall Thickness \* Existing Extrusion Multiplier

Desired Wall Thickness

On Simplify 3D is is Auto Calculated, normally for .4mm nozzle size it is 0.48mm

On Cura it marked as 0.5 mm for 0.4mm nozzle size

On Slic3r it 0.5 mm for 0.4 mm nozzle size

91 = 0.4 / 0.44 \* 100

Current Value for PLA 93

Current Value for PETG