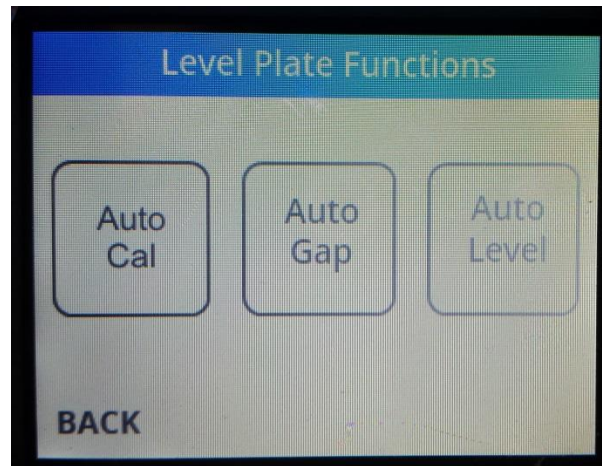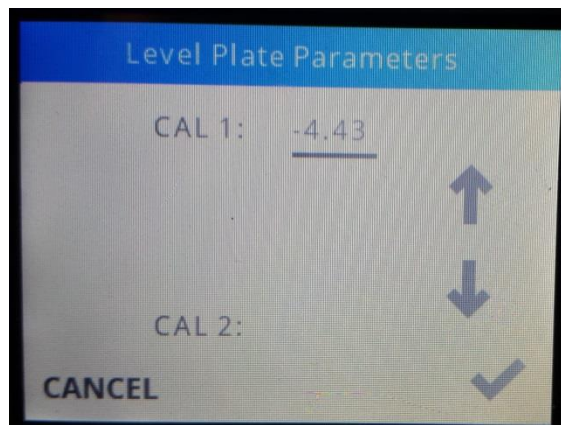# User Auto Level- Autogap Check Sheet V1.0
2014-1024

☐ Get Gap gauge from supplies envelope in packaging

☐ Check nozzles and clear filament from tips of each nozzle

☐ Set Cal 1 & 2
- Go to SETUP menu and press Calibration Icon
- Press Auto Cal icon to recalibrate printer

- Set Cal 1
  - Bed will raise and lower and come to stop at nozzle
  - Using arrows, lower plate 1.0, and place gap gauge underneath LF nozzle in center of plate
  - Gently raise back up toward the nozzle tip
  - As the plate gets near the tip, slowly tap the up arrow and check the resistance of the gap gauge each time by pulling on the gap gauge.
  - Once the gap gauge has a moderate resistance when pulling out, the nominal Cal 1 is set
    - Note that if the plate comes too high causing heavy resistance when pulling on the gap gauge, the plate needs to be lowered 0.5 to 1.0 and starting over.
    - Once the Cal 1 is set do NOT save or leave screen.

- o Set Cal 2
  - ▪ Press space in right side of Cal 2 to automatically set value
  - ▪ WORKING will appear in the space and the green LED will come on as the printer automatically sets the value.
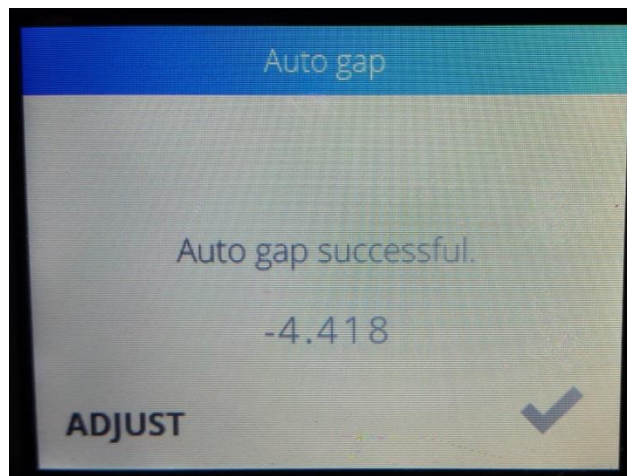 - ▪ Once the motion stops and a value appears, then press the check mark to save.

☐ Calibration Check A- Autogap
- o Run Auto GAP from Calibration Menu
- o The printer will go thru an automated routine and tell you if it is successful and give a value
- o Record value

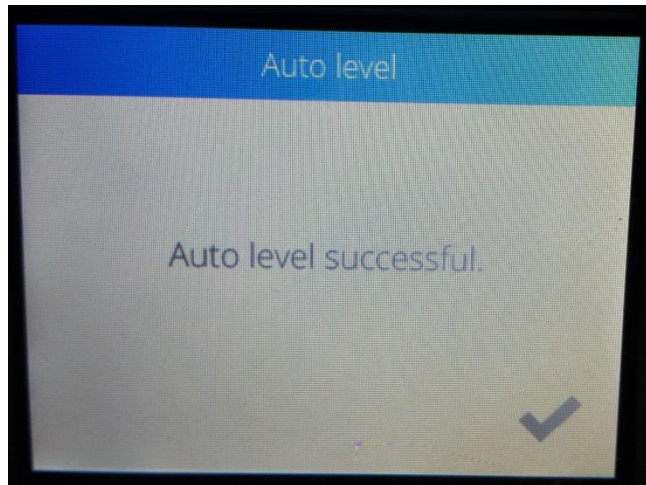   If (Cal 1 – Autogap value) > +/-0.05, reset Cal 1\Cal 2
    If (Cal 1 – Autogap value) ≤ +/-0.05, go to Check B-Autolevel

- o Press power or cancel button, do not save
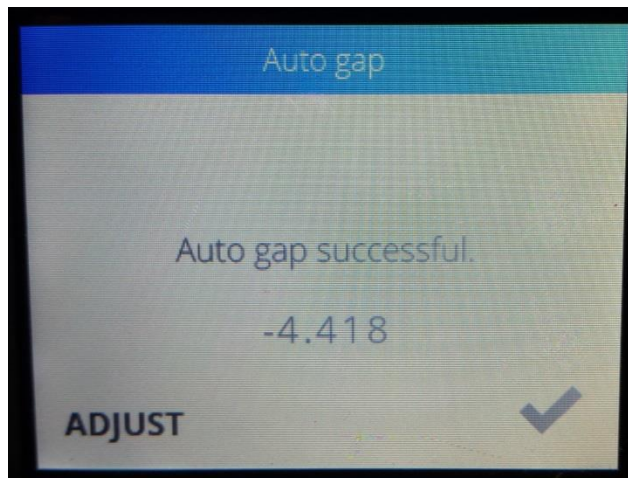
☐ Calibration Check B- Autolevel
- Unplug Power from printer for ~15 seconds
- Remove plate and add back to printer
- Run Auto Level from Auto Level Icon Menu
  - Once Auto Level is successful, press check mark to continue

  - Printer will rest your printing auto gap

    If (Cal 1 – Autogap) > +/-0.05, reset Cal 1\Cal 2
    If (Cal 1 – Autogap) ≤ +/-0.05, SAVE using check mark.

☐ Print test print PLA_ GAP.cube3

FAIL

PASS

If FAIL, repeat checklist.
If PASS Autolevel-Autogap calibration is complete.