

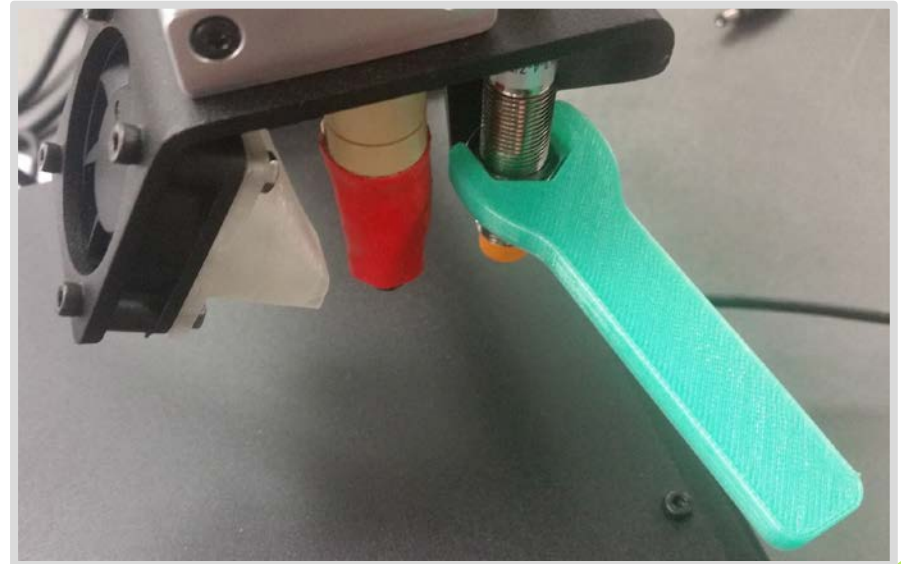
3D Printing - Day 2

The background features a central teal band with the word 'Calibration' in white. This band is flanked by dark teal shapes that resemble mountain peaks or hills, set against a light lime green background. The overall style is modern and minimalist.

Calibration


Mechanical - Z Calibration

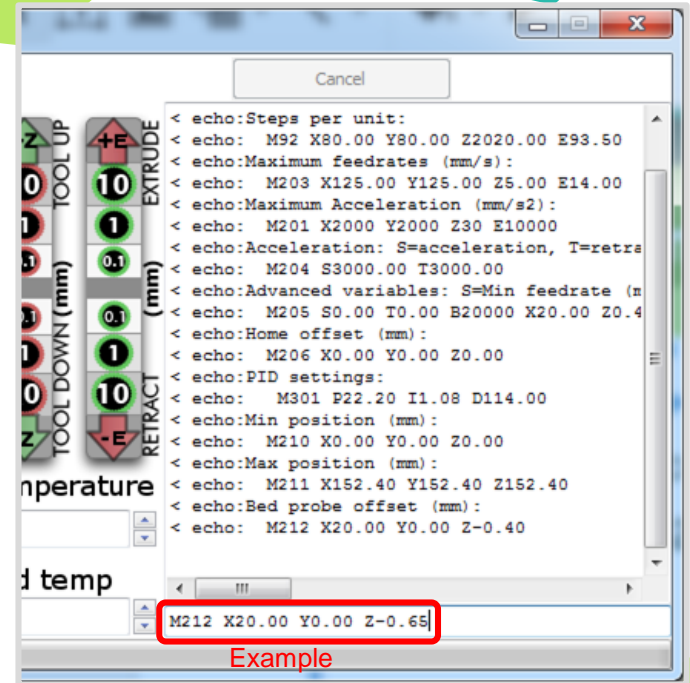
1. Loosen both hex nuts on the inductive sensor.
2. Manually lower the Z carriage by twisting the Z lead screw until the nozzle tip is about 1 papers width above the print surface.
3. Place the black plastic spacer underneath the Z probe sensor so the orange end is resting on the spacer and tighten the 2 hex nuts.
4. Power on the printer and start the digital Z calibration process.
5. <http://www.thingiverse.com/thing:1541446>



Submitting G Codes

To send codes to the printer open the Pronterface UI window and type them into the textbox below the left pane. Codes must be all caps.

M Code	Function
M500	Saves settings to the firmware.
M501	Lists the setting in the firmware.
M502 	Resets back to factory settings
M212	Set Bed Level Sensor Offset



Digital - Z Calibration

Power on the printer and open Cura to the Pronterface UI window. Type M501 to list the current printer settings. Copy the entire M212 line.

Example: M212 X20.00 Y0.00 Z-0.65

To higher or lower the Z offset type:

M212 Z<mm distance>

Type M500 to save the new distance

Negative moves down
M212 Z-0.10

Positive moves up
M212 Z0.20

Z Calibration G Code Order

1. M501 - Get current settings
2. M212 - Set new setting
3. M500 - Save settings
4. M501 - Check if settings saved

[PrintrBot Support Documentation](#)

The background features a central teal-colored band with the text 'Firmware Flash Process' in white. This band is flanked by dark teal and light green geometric shapes that create a layered, mountain-like effect. The overall design is clean and modern.

Firmware Flash Process

Printer Hardware Troubleshooting

If the printer is unable to communicate with the computer or consistently stops during prints you may need to reflash the firmware to the PrintrBot.

Please refer to the PrintrBot website for detailed instructions to reflash the firmware.

Reflash Process For Windows

Reflash Process For OS X

The background consists of several overlapping, semi-transparent geometric shapes. A large teal shape is the central focus, with darker teal and lime green shapes layered above and below it, creating a sense of depth and movement.

Clogged Nozzle

Clogged Nozzle



Download PDF Tutorial

Accessories

Inductive Sensor Wrench:

<http://www.thingiverse.com/thing:1541446>

Spool Holder:

<http://www.thingiverse.com/thing:1540085>

