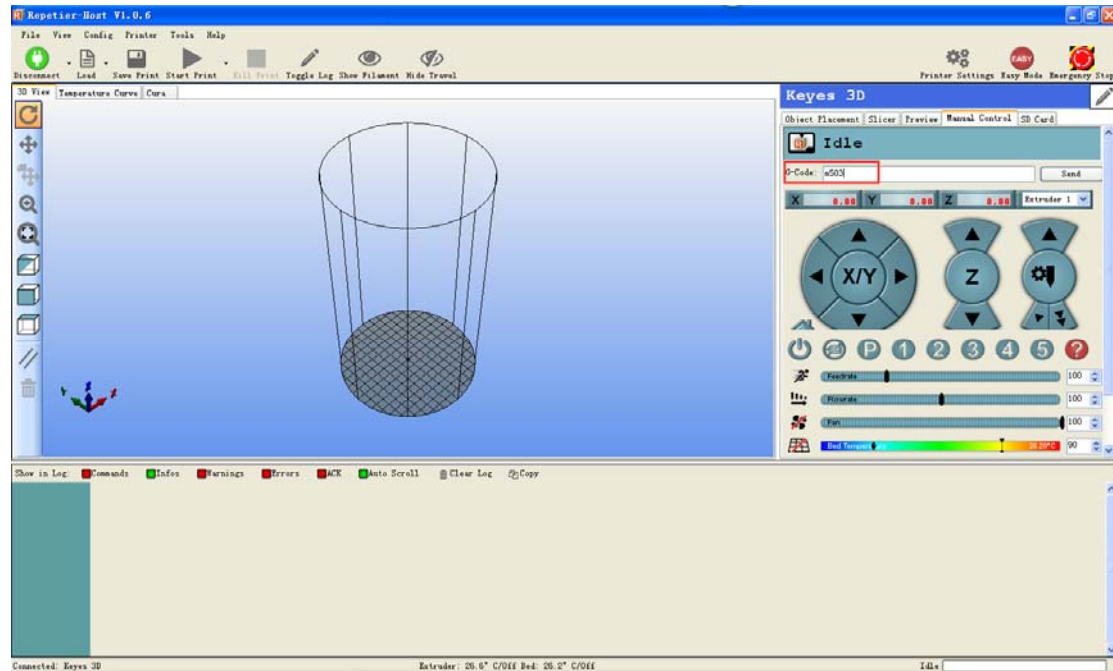
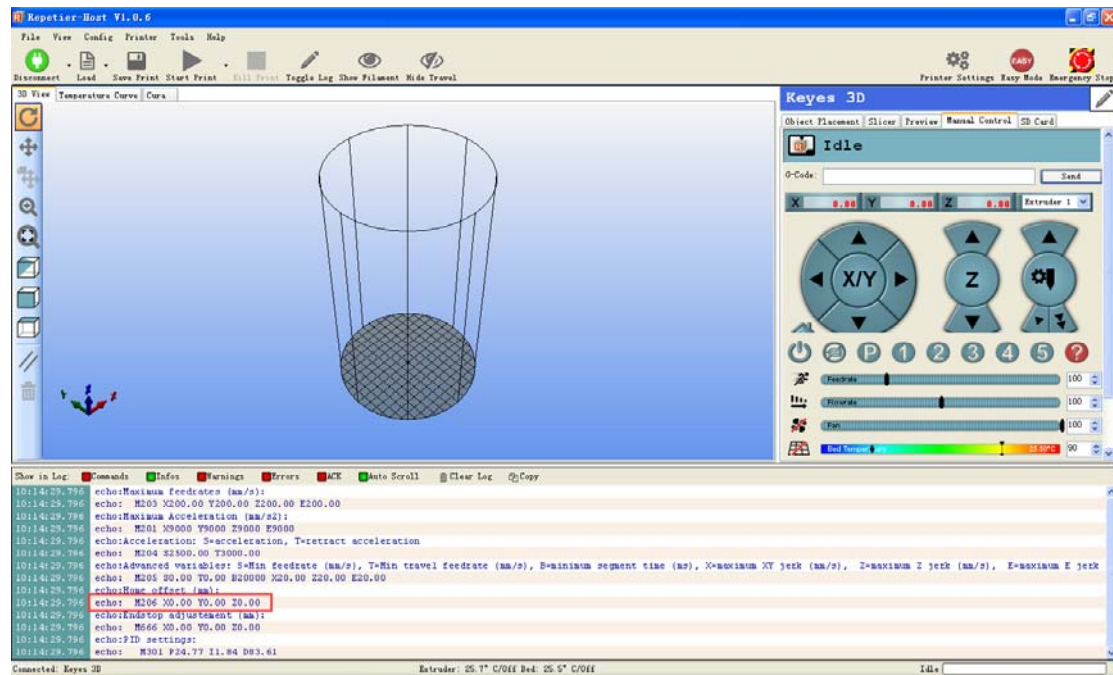


Height adjustment for 3D printer nozzle and heatedbed

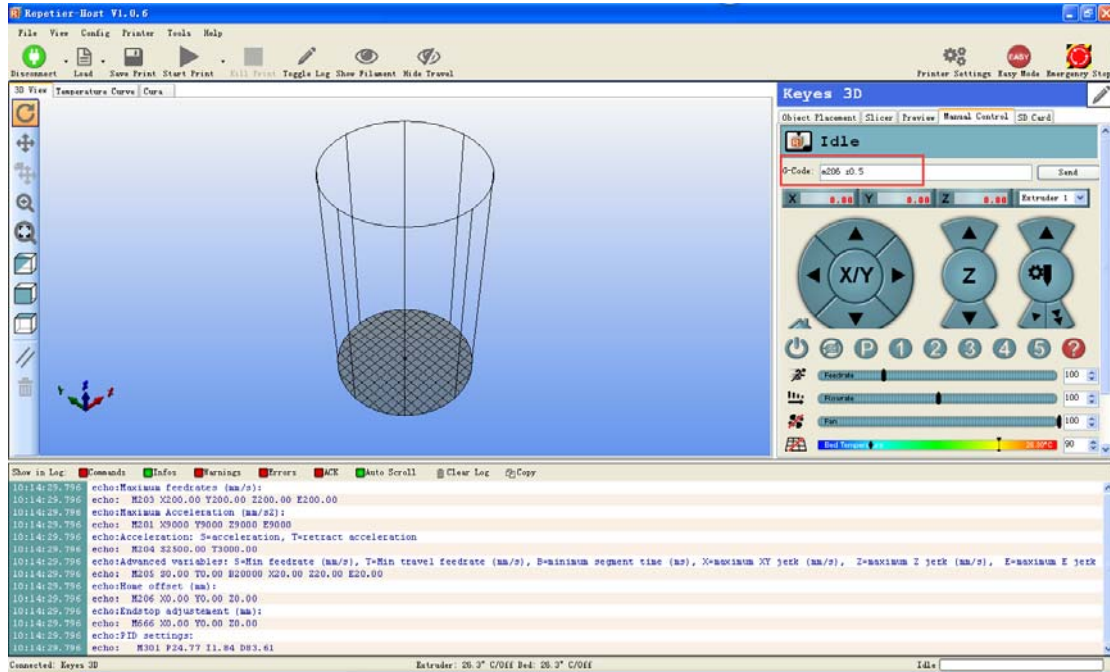
1. First, connect printer to you PC. After the connection, click “manual control” button on the right. You see see interface as below picture. Then, enter M503 showed as red circled. Click send to check configuration of the printer.



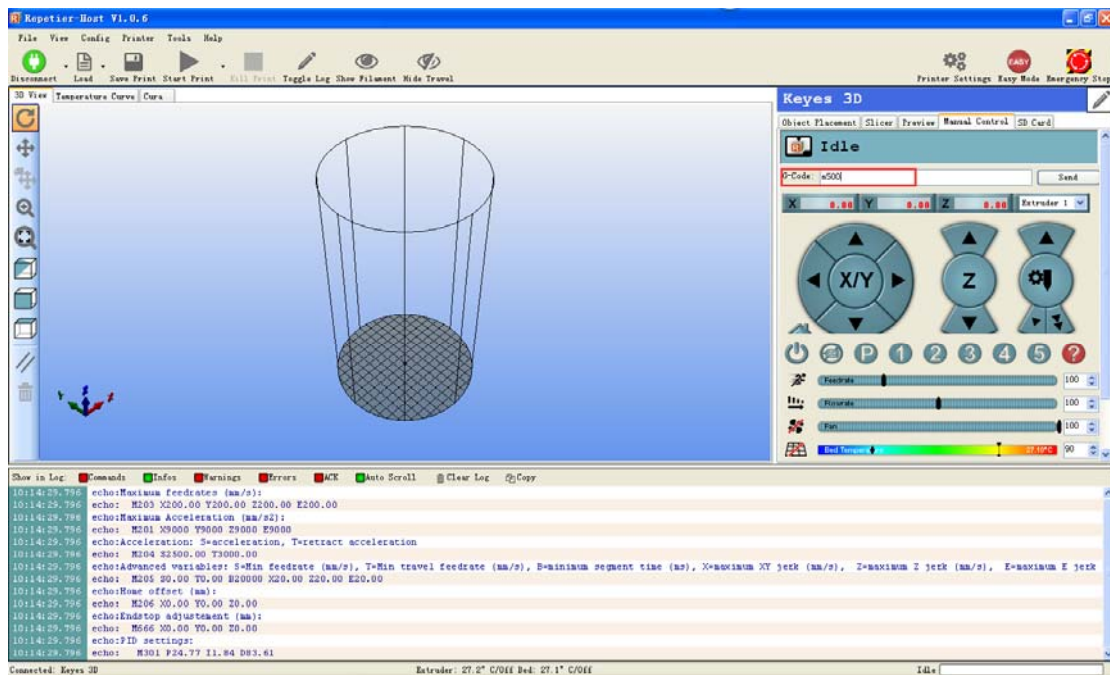
2. Enter M503, you can see content“echo:M206 X0.00 Y0.00 Z0.00”circled in red line.



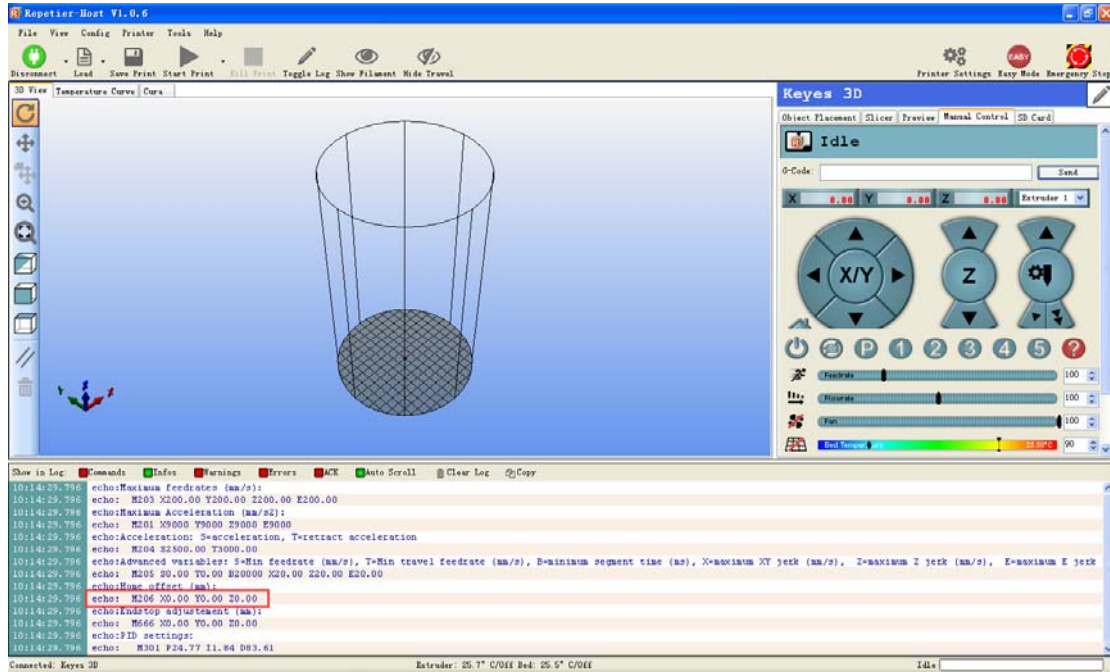
3. If during the test print, the height between the nozzle and the heatedbed is 0.5mm, we enter M206 X0.5 in the red circled box and click send. During the adjustment, the value should increase little by little to avoid nozzle pressing heatedbed due to high value and damaging the nozzle.



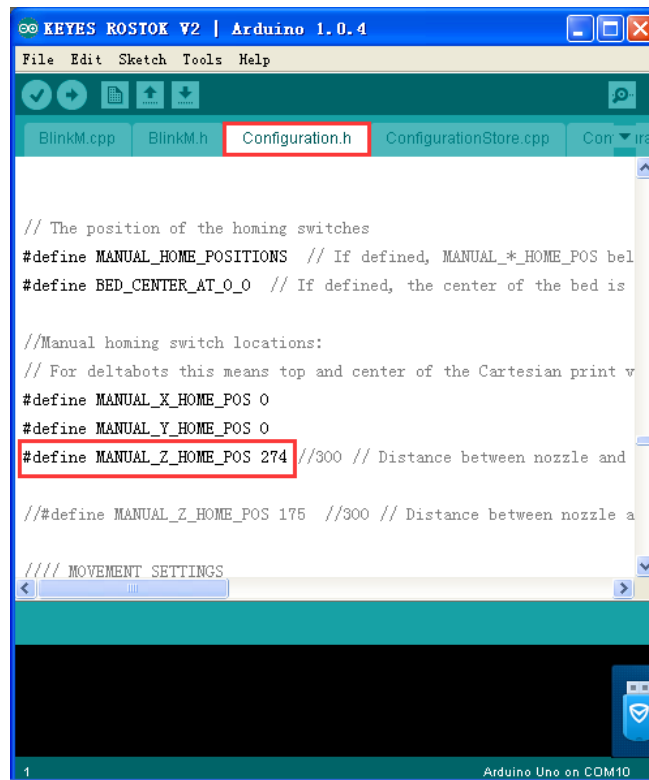
4. After entering M206 X0.5 and click send, we should save the adjusted parameter. Enter M500 in the red circled box; click send and modification will be saved.



5. After saving the modified value, let's reenter M503 and click send. See if the red circled value has been changed to 0.5. If so, the modification is succeeded. If in this value, there is still height between the nozzle and the heatbed. Please adjust by repeating step 1-4.



6. If the value gets bigger and bigger according to the above method and there is still height between the nozzle and the heatbed, please check the line `#define MANUAL_Z_HOME_POS 273mm` in firmware file Configuration.h as shown in below picture. First, use a ruler to measure the height between nozzle and heatbed when nozzle is at its highest position. If the height is more than 273mm, change the value here to the actual measured value. For example, if the actual measured height is 274mm, change the code into: `#define MANUAL_Z_HOME_POS 274`.



Of course, there is another way to do this without changing the firmware parameters. See

below picture; add a screw to the arrow indicated area; and if one axis adds a screw, other two axes need screws too. For example, if the the height between the nozzle and the heatbed is 1MM, the distance between the screw and the microswitch is 1MM. After the adjustment, do the test print to see if it works.

