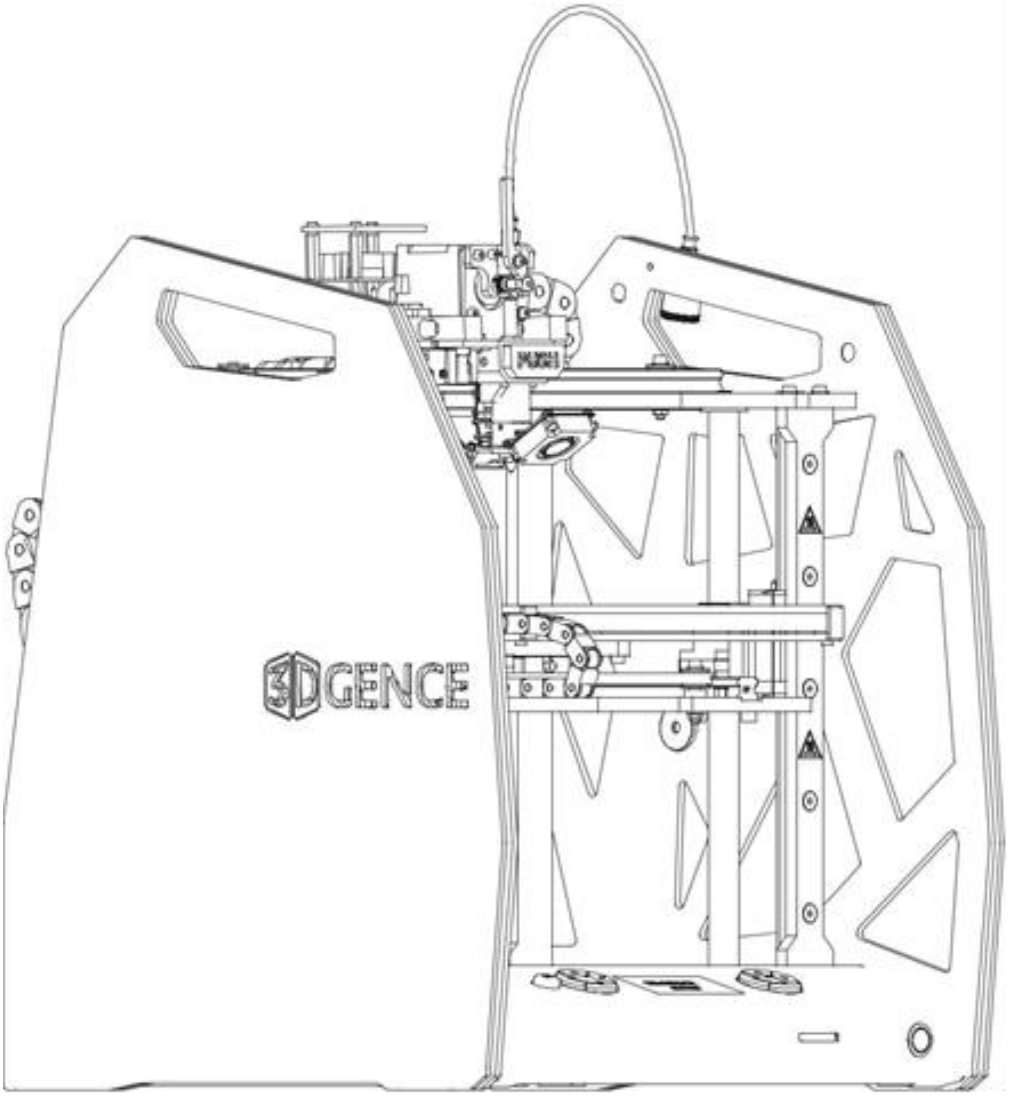
Service manual:

XY AXES CALIBRATION

3DGence ONE



1. Prepare model calibration .gcode using 3DGence Slicer. The *Dimmension_Calibration.stl* model is available on www.3dgence/support in *Your files* catefgory (*Your files* category is available after creating an account and registering the device).
2. Turn on the printer.

3. Load filament by choosing the following commands from printer's menu:
OK – Prepare – Load Filament
then follow the instructions on printer's screen.

4. Start the printing of the calibration model by choosing following commands from printer's menu:

OK – Print – Print file - .gcode with calibration model

5. After finishing the printing, wait until the colour lights turn green, then remove the model from the ehatbed and wait about 5 minutes to stabilize the temperature.

6. Put the cross on a flat surface and check the measurements on X-axis and Y-axis.
Signature of axes:

a) Place a caliper on the upper part of the cross, lean the ends of the clamps on a surface, put the limb of the cross into outside large jaws.
b) Check and note down the measure on X-axis and Y-axis.

Repeat the actions for each axis 5 times. Reject the highest and the lowest measurement from each group. Calculate the average.

MEASUREMENT:	X:	Y:
	100,08	100,07
	100,06	100,06
	100,05	100,08
	100,04	100,06
	100,05	100,05
AVERAGE:	100,05	100,06

7. If the measurements are between 99,95 - 100,05 mm (the tolerance +-0,05 mm) and the difference between the measurements on X-axis and Y-axis is between 0 – 0,5 – the printer is calibrated correctly.

8. If the printing does not comply with these requirements, make following corrections:
a) choose from printer's menu following commands: **OK – Calibration – XY Calibration**
b) enter the original dimension to X-axis = 100 and accept it by choosing OK,
c) enter the measured dimension on X-axis and accept it by choosing OK,
d) enter the original dimension to X-axis = 100 and accept it by choosing OK,
e) enter the measured dimension on Y-axis and accept it by choosing OK,
f) save the measurements by choosing: **CALCULATE & SAVE**.

9. Print the model again, then repeat the actions until the measurements oscillate between 99,95 – 100,05 (the tolerance ± 0,05) and the difference between the measurements will be around 0 – 0,05.