

Test Steps

Before the official print, the need for unilateral debugging manually, test individual components are working properly. The assembly and connection issues during installation due to negligence before, you can get tested and resolved in a single step debugging steps.

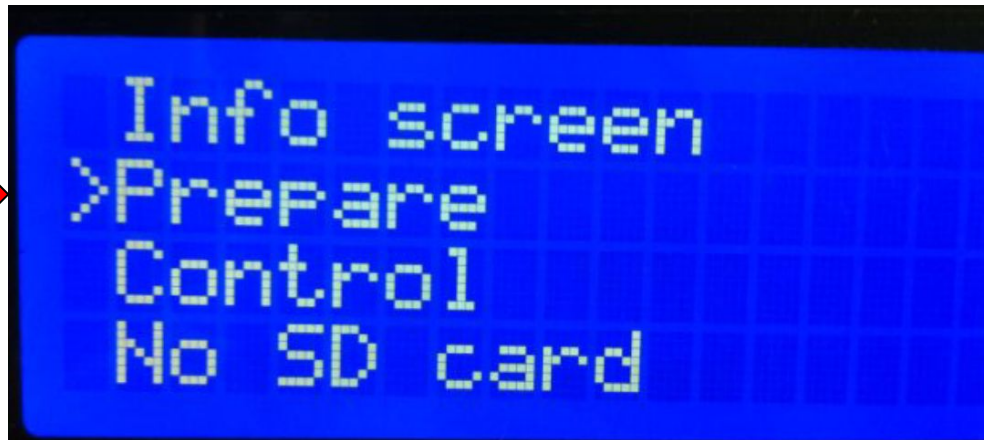
Generally speaking, we need to test the following functions:

- 1. The three-axis motor is running correctly, in the right direction; toward micro switch (limit switch) motion is "negative" direction.**
- 2. The extrusion head heated properly, it can reach a predetermined temperature, and control is stable;**
- 3. The extrusion head motor is running correctly, in the right direction; (Attention to the extrusion head stability needed to reach about 190 °C, and then the motor will be able to exercise).**
- 4. Adjust the Z axis limit switch screw, make the initial distance between the nozzle and the heating plate suitable (like a sheet of A4 paper distance)**

NOTE: Stepping it relates to integrated control software, hardware and mechanical, is to coordinate the work of the entire mechanical and electrical systems. Problems encountered during commissioning, you will need to consult the relevant instructions for analysis and understanding. If you have difficulty, please contact customer service communication to resolve. (service@bld-3d.com).

Step 1: Test each axis direction

Here it is through the LCD screen to test the machine. First, check out LCD screen notes

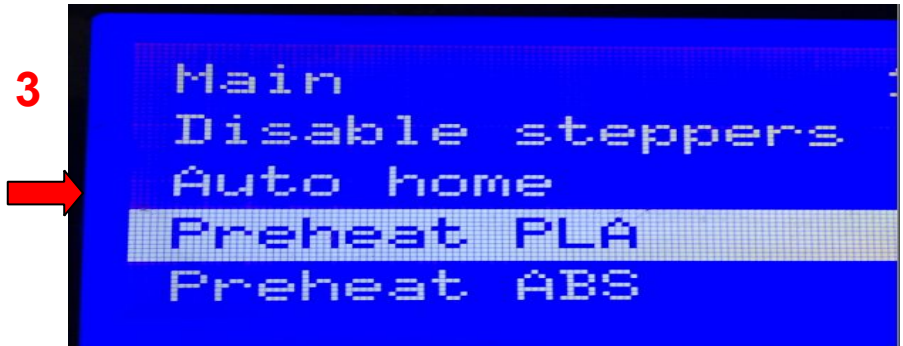
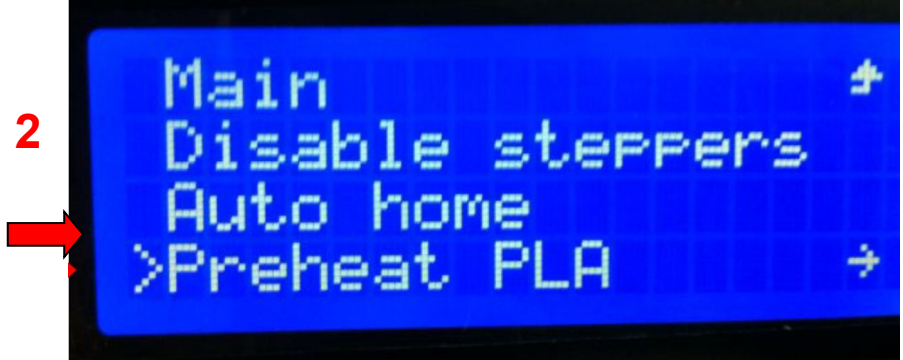
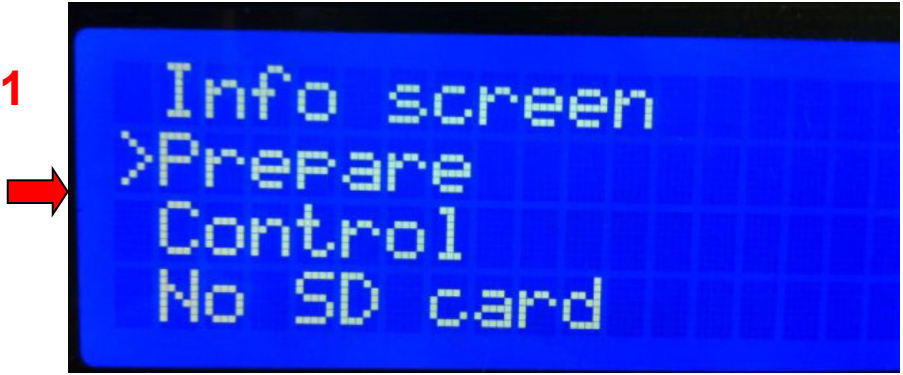


Select "AUTO HOME" instruction, the axes will move to the zero position (bottom left corner), after the hit limit switch stops, meaning the direction is correct.

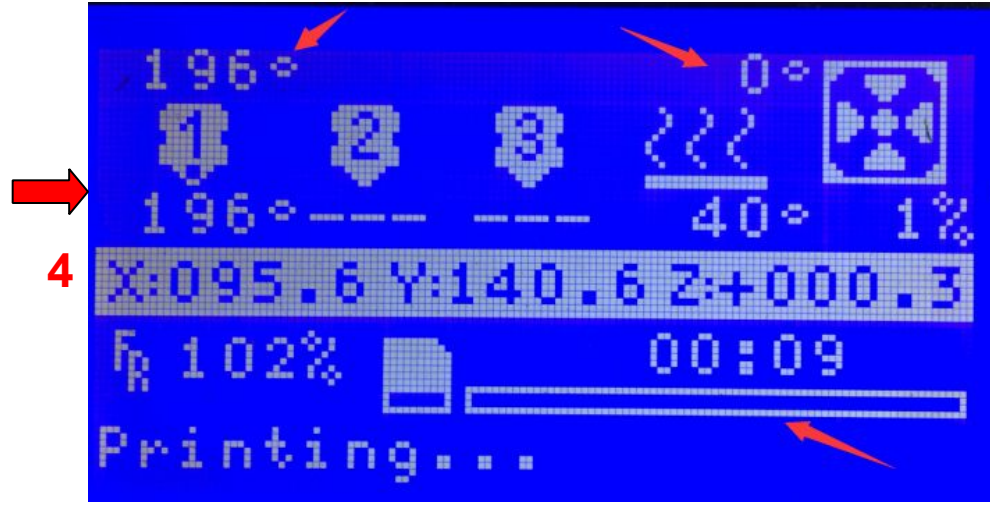
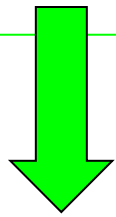
Note:

Make sure the Z-axis limit switch is installed correctly (see assembly section details of the plan) when this command is executed, otherwise the nozzle run into platform.

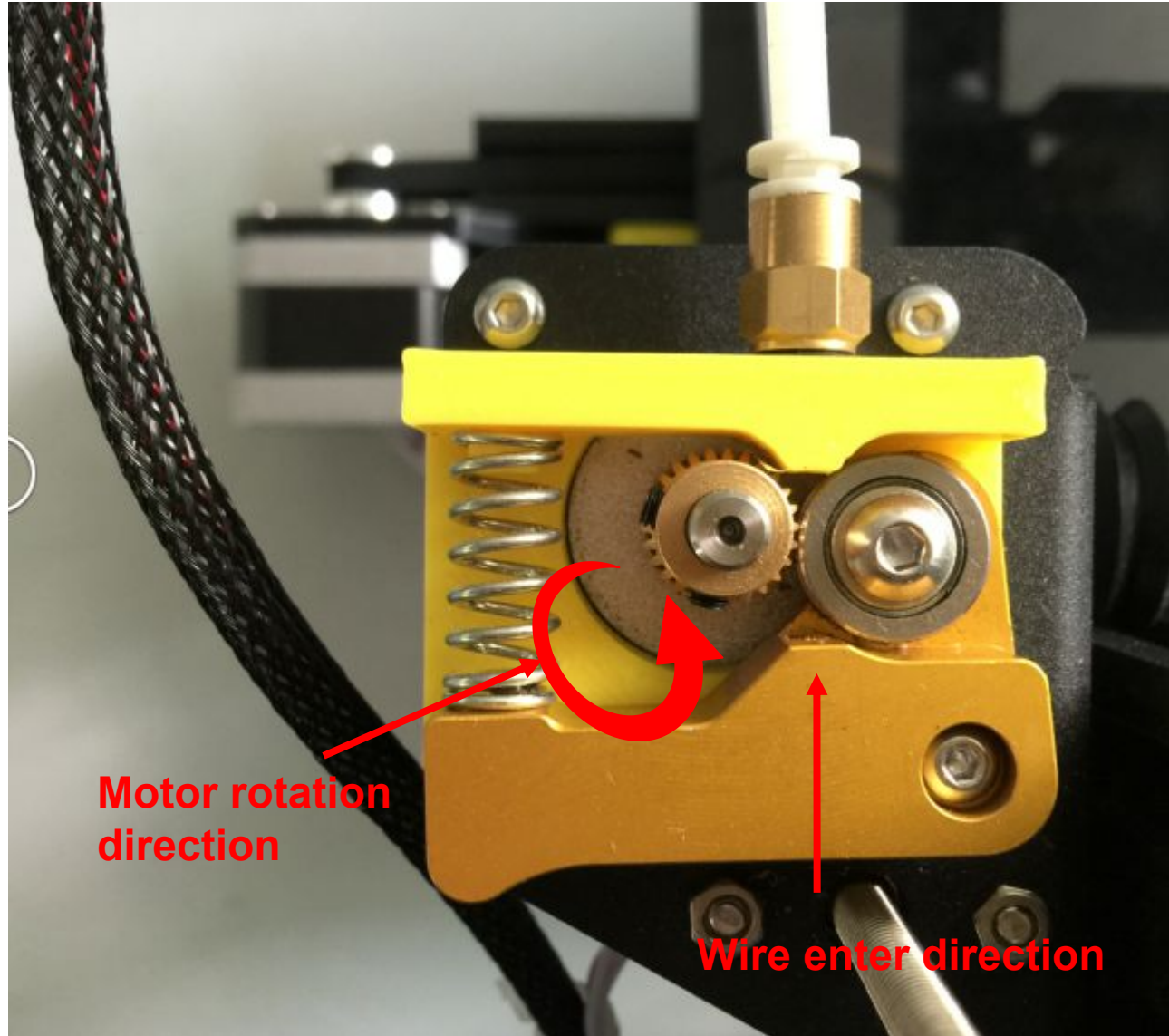
Step 2: Preheat Nozzle



By operating steps, such as: current temperature display nozzle 196 °C, platform 0°C



Step 3: Test Extrusion Machine Direction

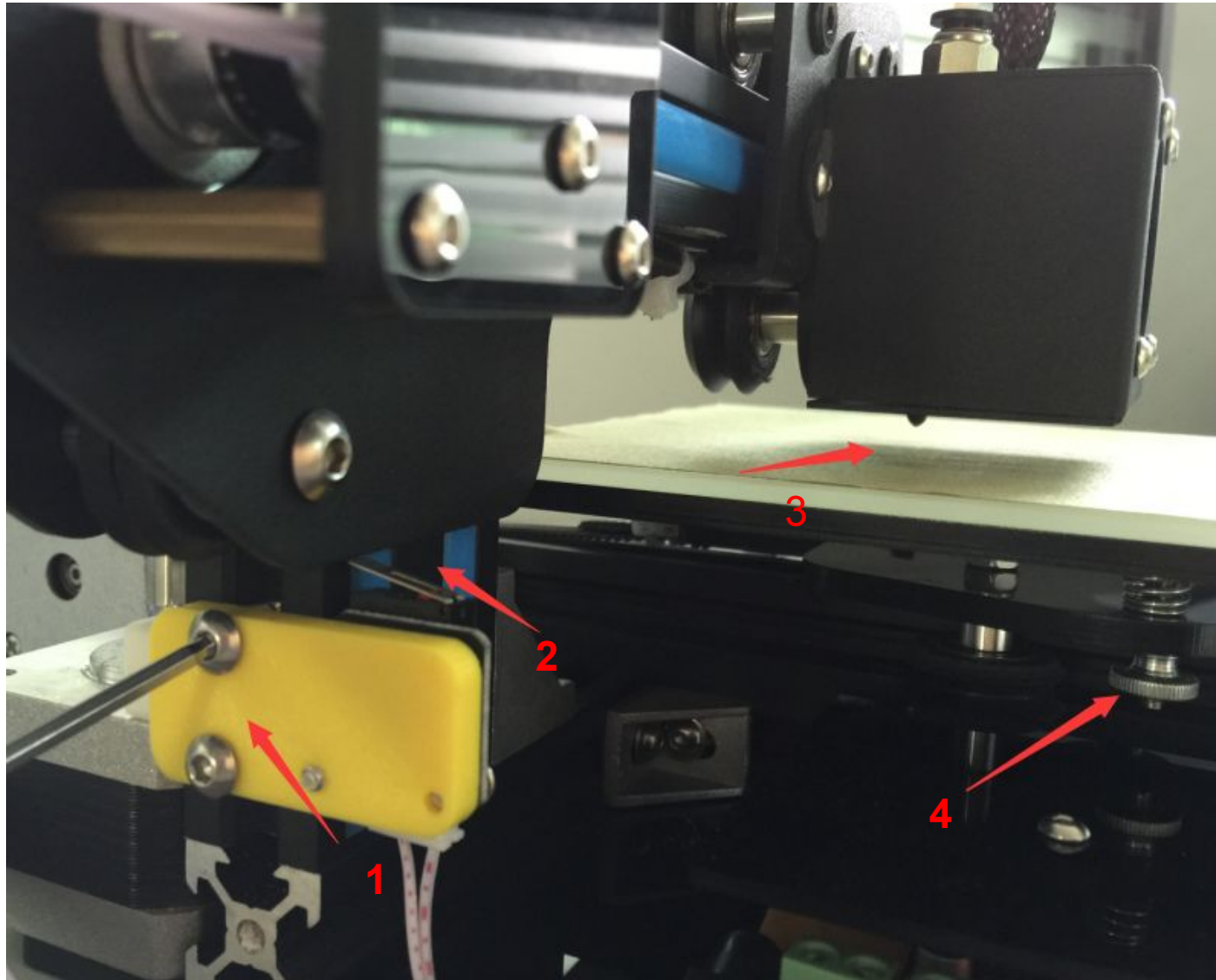


Step Four: Leveling

Leveling machine is very important, a direct impact on the effect of print. Once adjusted, subsequent printing can no longer adjust.

Adjustment step:

1. No.1 limit switch is only a rough position, when the machine is installed, the height from the floor is about 30MM;
2. LCD control panel after selecting Auto home, Z-axis downward movement, hit No.2 limit switch stop, then turn off the power;
3. Observe No.3 position, nozzles and platform distance, via No.4 position hands twist nut to fine-tuning. Distance between the nozzle and the platform is the thickness of a piece of A4 paper, that is 0.1MM



Step Four: Leveling

Need grip "mobile glass platform" by a clip when leveling, yellow part is textured paper.

