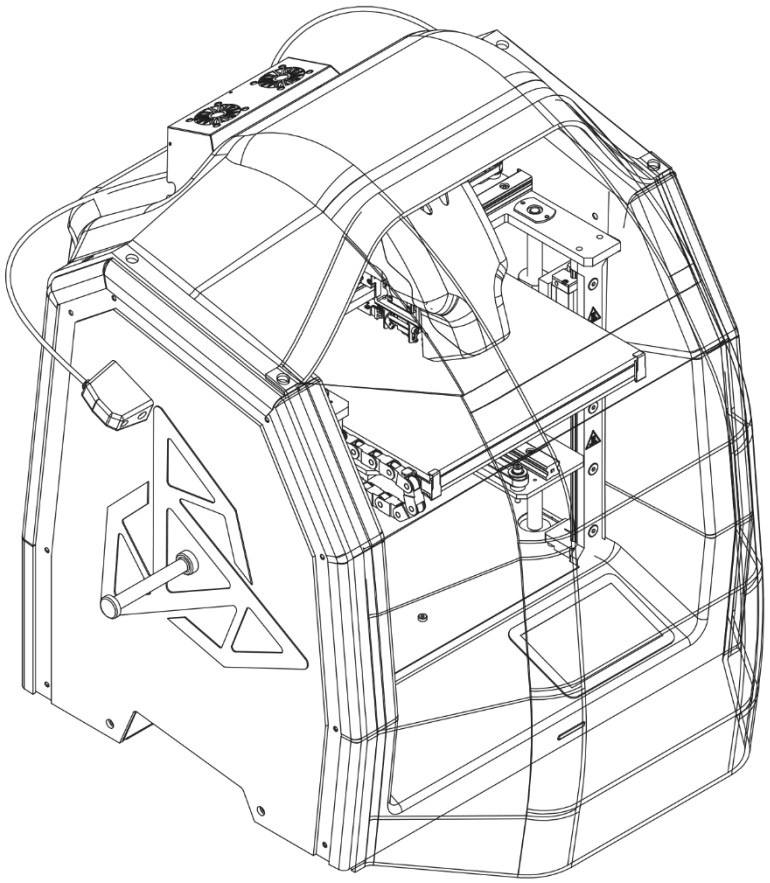
Service manual:

XY AXES CALIBRATION

3DGence DOUBLE P255



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

2. Turn on the printer.

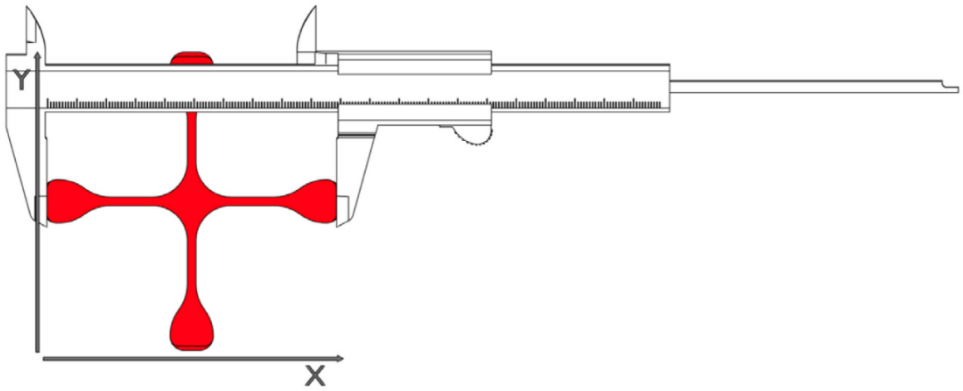
3. Load filament by choosing the following commands from printer's menu:
   Materials → Load Model Material/Load Support Material then follow the instructions on printer's screen.

4. Start the printing of the calibration model.

5. After finishing the printing, wait until the colour lights turn green, then remove the model from the heatbed 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.
   a) Place a caliper on the upper part of the cross, lean the ends of the clamps on as 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.



MEASURMENT:	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: **MENU → ADVANCED → XY CALIB.**
   b) enter the original dimension to X-axis = 100,
   c) enter the measured dimension on X-axis,
   d) enter the original dimension to X-axis = 100,
   e) enter the measured dimension on Y-axis,
   f) save the measurements by choosing: **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.