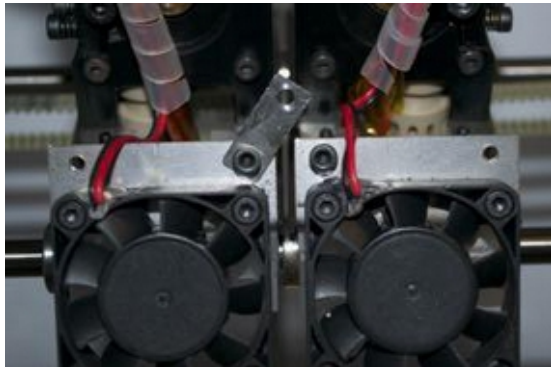


## Second extruder calibration

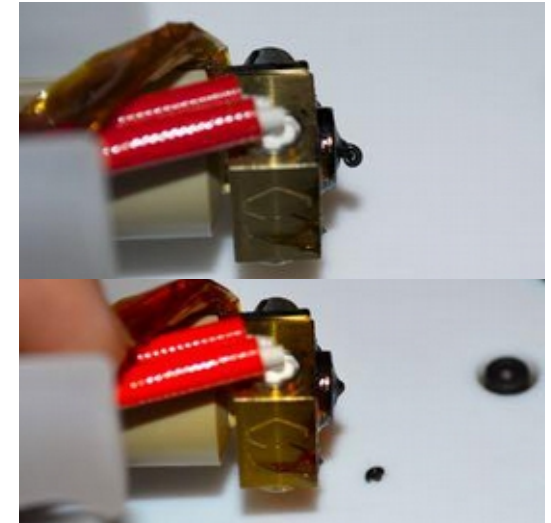
Connect the second extruder to the first through the appropriate connecting plate.



We should also clean the printing plate residue, using a spatula and hot water.



Remove the cold plastic residues from the extruder with the aid of a pliers

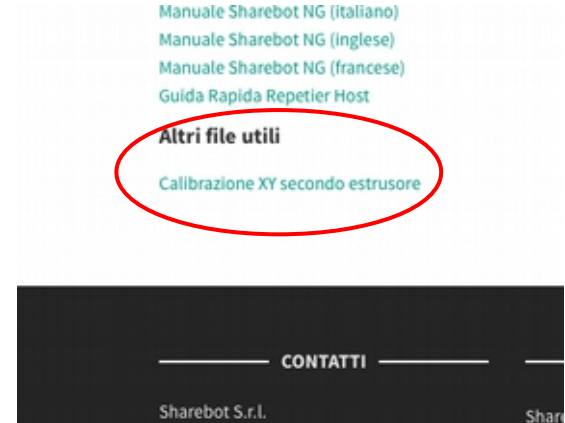
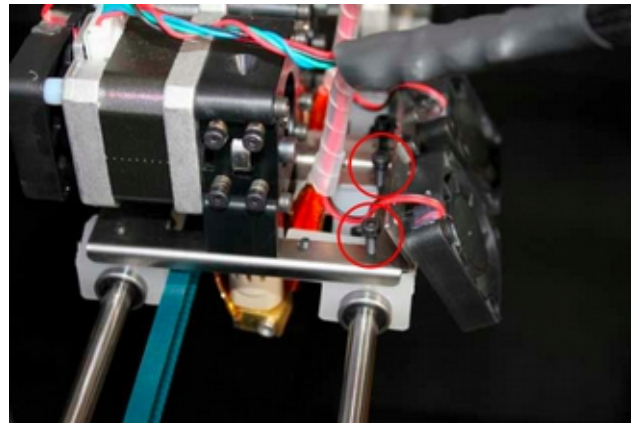


## Second extruder calibration

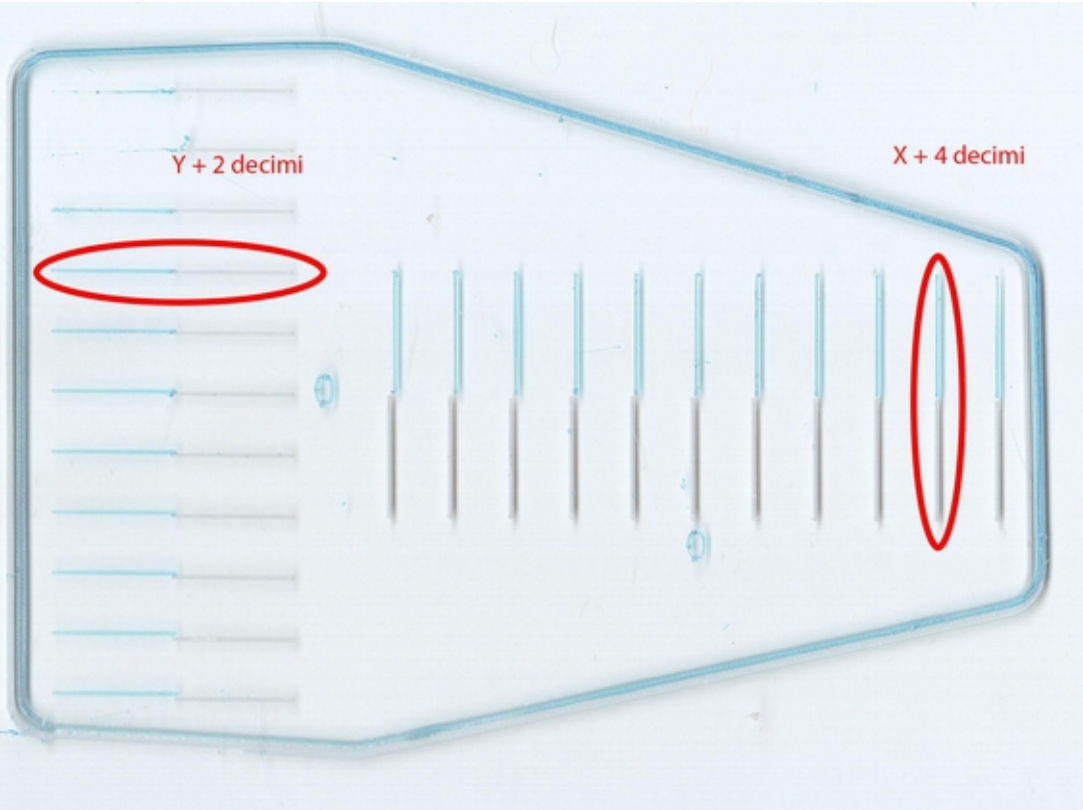
Click from “prepare” menu  
“Manual bed calibration” and  
place the extruder on the  
third calibration screw.

Align the extruders on the  
glass bed using the screws  
behind the fans of the second  
extruder.  
(Z calibration)

Click “calib Dual” from  
“prepare” menu, or download  
from sharebot.it the specific  
gcode.



## Second extruder calibration → how to read the calibration test



While the printer is printing the test, we can easily check again the Z calibration of both extruders, as we do for every first layer.

This procedure is similar to read a caliber.

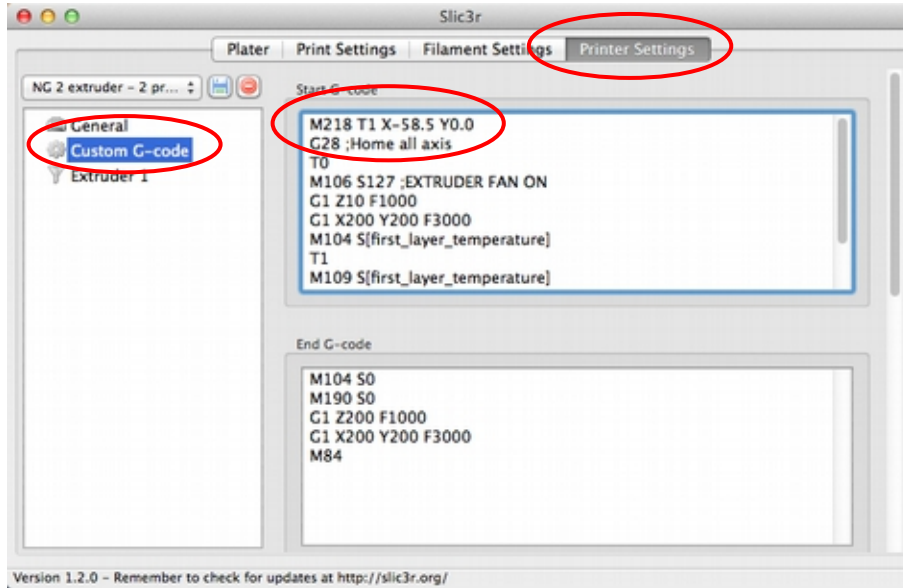
Take a look at the lines printed looking for the aligned ones. In this way we should know how many tenths of a millimeter is the misalignment.

In the example, we read a misalignment:

$Y + 0.2 \text{ mm}$

$X + 0.4 \text{ mm}$

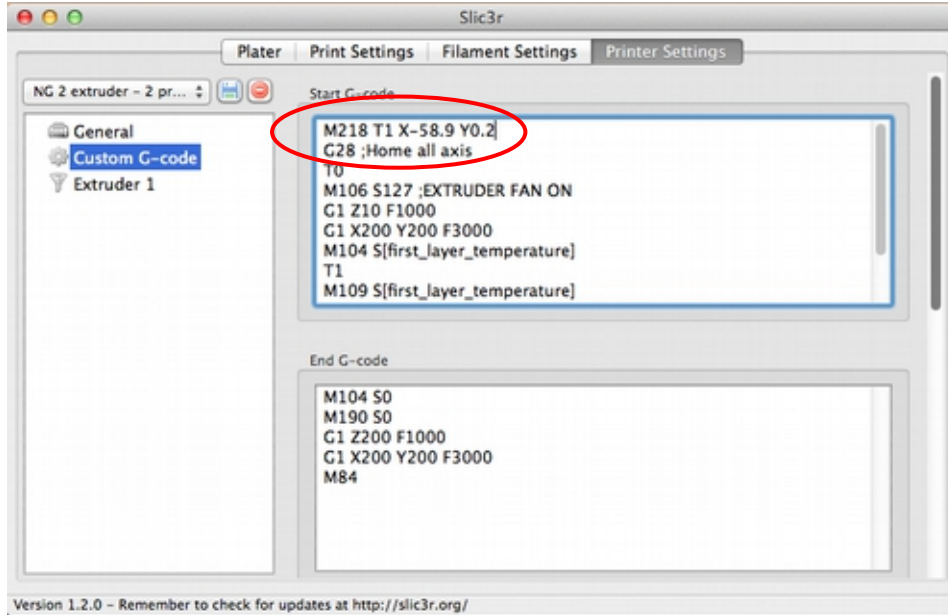
## Second extruder calibration → entering data



Now we have just to enter the misalignment data into Slic3r to align the extruders.

Click “Printer Settings” → “Custom G-code” → “Start G-code” you find the command “M218 T1 X-58.5 Y0”: this is the default data for the “NG 2 extruder - 2 printing” profile.

## Second extruder calibration → entering data



Add the values read before (X + 0.4 and Y + 0.2).

The printer is ready!