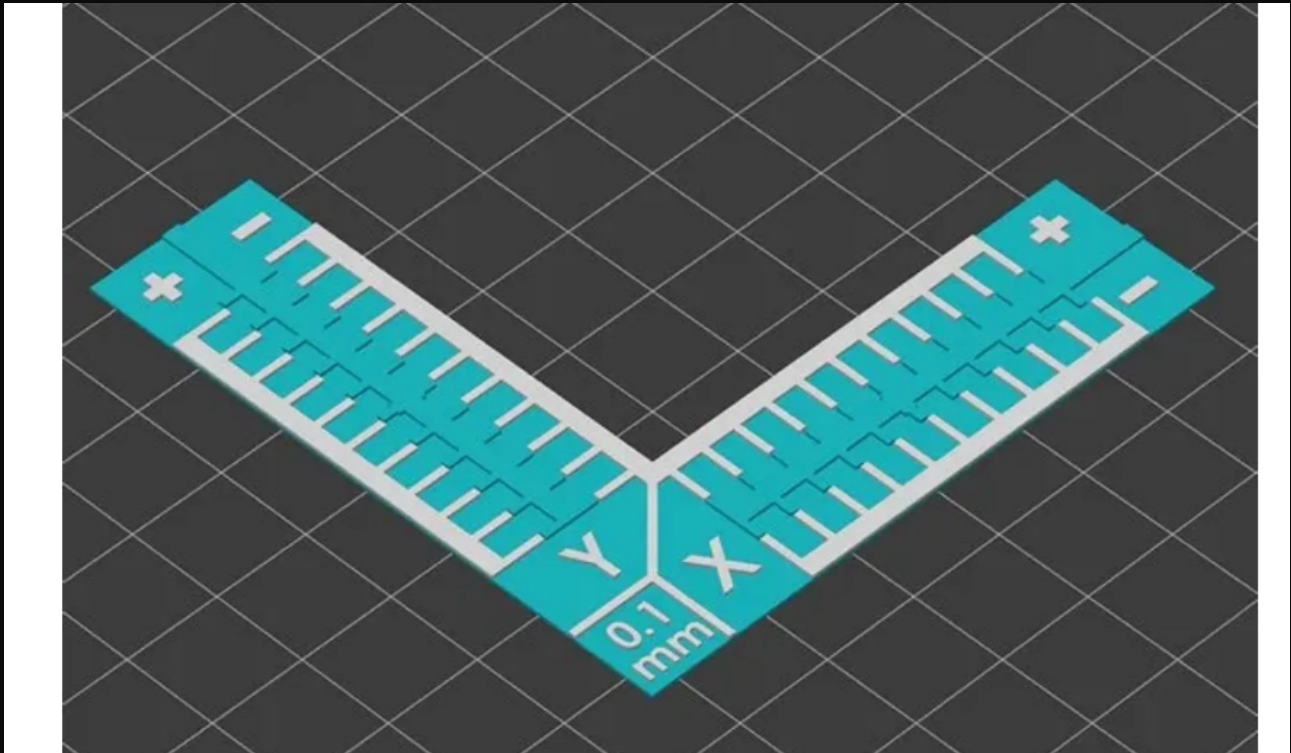


XY Offset Calibration Guide

For IDEX / dual-extruder printers using the Offset XY test model



Quick reading rule

1 division = 0.1 mm

What you adjust

The second print head relative to the first

1. How to use the test

Print both parts of the model: one with the first head and one with the second head. After printing, find where the lines align best on the X scale and on the Y scale.

The side marked + is a positive value. The side marked - is a negative value. Each step equals 0.1 mm.

Example	Reading
Best match on X at mark 3 on the - side	X = -0.3 mm
Best match on Y at mark 2 on the + side	Y = +0.2 mm

2. How to correct the print head

You are adjusting the offset of the second head relative to the first head.

Because different printers and firmware may interpret offset signs differently, use this practical method below.

If the test shows	Enter the value
X = -0.3 mm, Y = +0.2 mm	Enter these values for head 2 and reprint the test
The new print is closer to the center	The sign is correct
The new print is farther from the center	Use the same values with the opposite sign

3. Correct result

Calibration is correct when the best alignment is at the center on both the X and Y scales.

Recommended workflow: print the test, adjust the second head offset, and print the test again until both readings are centered.