Geeetech Prusa I3 A pro

User Manual



Safety Instructions

Building the printer will require a certain amount of physical dexterity, common sense and a thorough understanding of what you are doing. We have provided this detailed instruction to help you assemble it easily.

However ultimately we cannot be responsible for your health and safety whilst building or operating the printer, with that in mind be sure you are confident with what you are doing prior to commencing with building or buying. Read the entire manual to enable you to make an informed decision.

Building and operating involves electricity, so all necessary precautions should be taken and adhered to, the printer runs on 12V supplied by a certified power supply, so you shouldn't ever have to get involved with anything over 12V but bear in mind there can still be high currents involved and even at 12V they shouldn't be taken lightly.

High temperatures are involved with 3D Printing, the Extrusion nozzle of the hot end can run about 230°C, the heated bed runs 110°C and the molten plastic extruded will initially be at around 200°C, so special care and attention should be made when handling these parts of the printer during operation.

Check the power input of the power supply unit. You can choose either 110V or 220V according to the Power regulation in your country.

We wouldn't recommend leaving your printer running unattended, or at least until you are confident to do so. We cannot be held responsible for any loss, damage, threat, hurt or other negligent result from either building or using the printer.



1 Software resources

1.1 Printer control software Repetier-Host

We use the latest Repetier host V1.6.0 as the printer control software, link for downloading:

http://www.geeetech.com/wiki/index.php/Repetier-Host#Download

After downloading and installation, it can be used.





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1.2 Driver

Connect the printer to computer with USB cable, the motherboard driver installer will automatically

appear. If not, you can download FT232RQ here, which is the driver of GT2560:

http://www.geeetech.com/wiki/index.php/Prusa_I3_X#Install_the_drivers

Download and install, you can find the corresponding serial port in the Windows "Device Manager":



1.3 Arduino IDE

In the process of using the printer you may need to re-upload the firmware, and the software you need to use is Arduino.

About how to upload firmware, please refer to FAQ.



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2 Connect the printer

After the above software is installed, we can connect the printer to the computer. Plug the USB into



Printer Settings icon in the top right corner, and the

the computer, open Repetier host, click the dialog box of printer settings will appear.



Select corresponding COM port of the printer and baud rate 250,000 in the dialog box. Click Apply after the setting. Shown as below.



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inter: I3 Alumin	חניות	▼ m
onnection Printer E	xtruder Printer Shape Scripts Advance	zed
Connector: Serial	Connection 👻	Help
Port:	E0M28	
Baud Rate:	250000 👻	
Transfer Protocol:	Autodetect 👻	
Reset on Emergency	Send emergency command and reconnect	•
Receive Cache Size:	127	
Communication limeou	1t:) [s]	
Use Ping-Pong Cor	mmunication (Send only after ok)	
are stored with eve	is always correspond to the selected pri ry OK or apply. To create a new printer ess apply. The new printer starts with	r, just enter a new



After setting, click the Connect button in the top left corner of Home Page. When the button turns



green and changes into Disconnect, the printer connection is successful.



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3 Printer Setting

3.1 Printer speed

Set the running speed of printer as 1000 in the printer settings in order to avoid collision because of high speed during the test. After follow-up tests are completed it can be changed back to the original value. (Recommend speed of Z-axis should not be too high, 1000 is OK)

Travel feed rate: 1000mm/min

Z-Axis feed rate: 1000mm/min



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Printer:	I3 Alu	minium		▼ 💼			
Connection	Printer	Extruder	Printe	er Shape	Scripts	Advanced	
Travel Fe	ed Rate:		ī	.000		[mm/min]	
Z-Axis Fe	ed Rate:		ī	.000		[mm/min]	
Manual Ex	trusion S	peed:	2	2		20	[mm/s]
Manual Re	traction	Speed:		30		[mm/s]	
Default E	xtruder T	emperature	2	210		°c	
Default H	Default Heated Bed Temperature:			65		°c	
📄 Remove		& Bed Temp ure reques nds.					
Check eve	e temperat ery 3 seco	ure reques nds.	sts from	n Log			[]
Check eve Park Posi	e temperat ery 3 seco tion: X	ure reques ands. : 0	sts from		Z mi	1998 (Tex	[mm] tion after Tob/Kill
Remove Check eve Park Posi	e temperat ery 3 seco tion: X TA to prin	ure reques nds. : O nter displa	sts from 0 Y: ay	n Log	Go Go	to Park Posi	tion after Job/Kill
Remove Check eve Park Posi Send E Disable	e temperat ery 3 seco tion: X TA to prin e Extruden	ure reques ands. : 0	sts from Y: ay b/Kill	n Log	🔲 Go 📝 Di	to Park Posi	tion after Job/Kill Bed after Job/Kill
Remove Check eve Park Posi Send E Disable	e temperat mry 3 seco tion: X TA to prin e Extruden e Motors a	ure reques nds. : O nter displa r after Job/B	sts from Y: ay b/Kill	n Log	🔲 Go 📝 Di	to Park Posi sable Heated	tion after Job/Kill Bed after Job/Kill
Remove Check eve Park Posi Send E Disable Disable Add to con	e temperat ery 3 seco tion: X IA to prin e Extruden e Motors a np. Printi	ure reques nds. : O nter displa r after Job/B	sts from Y: ay b/Kill Kill	0 Log	🔲 Go 📝 Di	to Park Posi sable Heated inter has SD	tion after Job/Kill Bed after Job/Kill card

3.2 Number of Extruder and Nozzle Diameter

The number of extruders is set to 1. The diameter of nozzle is set according to actual size, here is 0.4mm.



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Connection Printer Extruder Printer Shape Sc Number of Extruder: Max. Extruder Temperature: 250	ripts Advar	iced	
Han Raturdan Tana matura 250			
max, Extruder lemperature, ZOU			
Max. Bed Temperature: 110			
- Max. Volume per second 12	[mm ³ /s]		
Diameter: 0.4 [mm] Temperatur	re Offset:	0	[° C]
Diameter: 0.4 [mm] Temperatur	re Offset:	0	[° C]
Color:			
Offset X: O Offset Y:		0	[mm]

3.3 Printer shape

Here the printer shape of I3 aluminum is Classic Printer;

For home position, choose Min;

The printer's maximum printing volume 200 * 200 * 180 (length / width / height)



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Printer:	I3 Alu	minium	~	▼	
Connection	Printer	Extruder	Printer Sha	ape Scripts Advanced	
Printer Typ	pe: C	lassic Pri	nter	▼	*
Home X:	Min	▼ Home	Y: Min	➡ Home Z: Min ➡	
X Min O		X Max	200	Bed Left: O	
Y Min O		Y Max	200	Bed Front: 0	
Print Area	Width:	200		mm	Ξ
Print Area	Depth:	200		mm	
The min and These coord	d max valu dinates ca	an be nega	tive and out:	mm e range of extruder coordinates. side the print bed. Bed he printbed itself starts. By	
The min and These coord left/front	d max valu dinates cs define th he min/max	ies define an be nega ie coordin : values y	tive and out: ates where th ou can even r	e range of extruder coordinates.	
The min and These coord left/front changing th the print b	d max valu dinates cs define th he min/max bed, if su	ies define an be nega ie coordin : values y	tive and out: ates where th ou can even r	e range of extruder coordinates. side the print bed. Bed he printbed itself starts. By move the origin in the center of	

If the object which is being printed is not in the center of the hot bed, you can adjust the following two values to compensate for the distance deviation of X / Y direction:

Bed Left

Bed Right



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800
1

After setting, click Apply>OK

The interface after setting is as following:



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4 Printer Function Test

When we are testing, we can test through LCD control panel or we can also do the test on Repetier Host. The methods are as followings.

4.1 Use Repetier Host to Test

4.1.1 Motor Direction Test

Before testing, please manually place the motors of X / Y / Z axis at the middle of each axis to avoid accidental collision occurring during the test. There is emergency stop button at the top right



corner^{Emergency Stop}, or you can cut off the power. Always be prepared for emergency stop.



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Open Repetier host and connect the printer. Click Home button \frown , then all three axes will move towards the endstop. After they hit the endstop they will move back for a short distance and then stop the movement. The origin location should be in the right front corner of the printer platform. If the moving direction is reversed, you can change the motor direction in firmware. (please refer to FAQ).



4.1.2 Heating Test



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Click the heating button of the hot bed

E A and the extruder

. The slash will disappear and

you will see the temperature rising up.



Meanwhile you can see the temperature changing at the bottom of Repetier.

If the hot bed or extruder can heat, please refer to FAQ.



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4.1.3 Extruder test

Please note: The extruder will not begin working until the temperature reaches above 170 °C.

Heat the extruder to 200 $^{\circ}$ C, and then insert the filament into hotend via push-in fitting. When you are pushing the filament, press the release handle slightly with one hand and push the filament with the other hand through the feeding port.

Please note that the filament must be in the slot of the idler wheel, otherwise feeding will not be fluent.



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After pushing the filament into the bottom of hotend, use the feeding button on Repetier (as shown in following picture) to do manual feeding. If the nozzle can extrude filament fluently, the extruder



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is working well. If not, please refer to FAQ.

Note: If the moving direction of the motor is reversed, which means you found the filament going backwards when you click to feed downwards, change the motor direction of the extruder in the firmware to solve the problem. This method is the same with that for X/Y/Z axis motor.

Heating Extruder	
G-Code:	Send
X 0.00 Y 0.00 Z 0.00 Extruder	1 🔻
00000000000000000000000000000000000000	0
* (Feedrate	100 🚔
Hi Flowrate	100 🌲
🎢 (Fan	100 🚔
Bed Tempera Tre 25.50°C	65 🚖
1 Extrader 1 24.90°C	210 🌲
Debug Options Echo Info Errors Dry Run	OK

4.2 Use LCD Control Panel to Test

4.2.1 Motor Direction Test

Functions of the knob on LCD:



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- 1. Press the knob: OK or enter the sub-menu
- 2. Turn the knob: to scroll through the options, or change parameters

Note: Turn the knob during printing; you can change the Feed rate in real time.



After learning about the functions of the knob on the LCD, press the knob to enter sub-menu and choose Prepare:



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Choose Move axis:



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Choose Move 1mm:

(Note: the extruder can only support two options: Move 1mm and Move 0.1mm. The 10mm option is disabled.)



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Choose the axis that you want to move by using Move X/Y/Z options. Turning the knob can make each axis move left and right or back and forth.



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After testing each axis, you can choose Prepare>Auto home in the menu to make it back to home position.



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If you want to manually move the motor, you can unlock the motor. Unlocking method: Prepare>Disable steppers:



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4.2.2 Heating Test

In the Control menu, you can select temperature setting of hotbed and extruder.

Choose control:



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Choose temperature:



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Select the temperature you want to set:



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After setting, store it:



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Then you can choose Prepare> Preheat PLA to preheat hot bed and extruder.



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So far, function tests of the printer are done.

5 Heatbed Leveling

Before printing, we need to do hotbed leveling. Only after this step can quality of printed parts get improved. Otherwise the un-leveling gap between the hotbed and extrusion head will affect the filament adhering to the hotbed thus cause poor print quality or even not printing.



5.1 Homing

Home the printer.

5.2 Coarse tuning of distance between the nozzle and the hotbed

*If the nozzle is far from the surface of hotbed, loosen the M3x45mm screw to extend the bottom part.

Then the printer will home at a relatively lower place, the distance between the nozzle and the hotbed will be decreased.

*If the nozzle is too close to the surface of hotbed, tighten the M3x45mm screw to shorten the bottom part.

Then the printer will home at a relatively higher place, the distance between the nozzle and the hotbed will be increased.

You may need to calibrate for many times at this step.

The recommended distance between the nozzle and the hotbed is 0.5-1mm.



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5.3 Fine Tuning

After the initial adjustment, home the printer. Disable the stepper motors(), manually move the extruder to the four corners of the hot bed and fine-tuning the wing nut at each corner to level the distances between the extrusion head and four corners. During adjustment, you can put a piece of A4 paper(half fold it) between the nozzle and hotbed. If you can feel a bit friction when you pull the paper back and forth, the distance is proper.

After finishing the adjustment of four corners, the entire leveling process is done. You can also move the extrusion head to the center of hotbed to verify leveling outcome.



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6 Slice Settings

With one more step, we can start printing, set the slice parameters such as print material diameter, the speed, the layer height, etc. to achieve better print quality. Open slic3r, which is a slice software coming with Repetier host. As shown below:

Object Placement	Slicer	Printer Settings Easy N	
object Hatement		Print Preview Manual (Control SD Card
Slice	e wit	h Slic3r	Kill Slicing
Slicer: Slic3r		•	• C Manager
Print Setting: Printer Settings:		uminum PLA	Configuration
Filament settings:	[12 at.	אטיזואני דעג	
Extruder 1:	I3 al	uminum PLA	•
Override Slic3r		gs to Override	
Enable Support		mm	

You will be presented with the following interface:



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💋 Slic3r	-					
File Window Help						
Print Settings Filament Settings	Printer Settings					
I3 aluminum PLA 🔻 🗒 🥥	Layer height					
Layers and perimeters	Layer height:	0.2	mm			
Skirt and brim	First layer height:	0.35	mm or %			
🚊 Support material ⓒ Speed	○ Vertical shells					
Multiple Extruders	Perimeters:	3	(minimum)			
 Advanced Output options Notes 	Spiral vase:					
	Horizontal shells					
	Solid layers:	Top: 3	Bottom: 3	×		
	Quality (slower slicing)					
	Extra perimeters if needed:					
	Avoid crossing perimeters: Detect thin walls:	v				
	Detect bridging perimeters:					
	Advanced					
	Seam position:	Aligned -				
	External perimeters first:					
Version 1.2.9 - Remember to chec	k for updates at http://slic3r.org/					

6.1 Printing Setting

Set layer height and the first layer height in the Print setting tab. Generally speaking, layer height can be set as 0.1-0.3mm. Considering of accuracy and speed, 0.2mm is the most appropriate layer height. The layer height is set as 0.35mm by default.


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🧕 Slic3r	-			
File Window Help				
Print Settings Filament Settings	Printer Settings			
I3 aluminum PLA 🛛 🛨 🔚 🥥	Layer height			
Layers and perimeters Infill	Layer height: First layer height:	0.2 0.35	mm mm or %	
 interview Support material interview Support Material	Vertical shells			
Advanced	Perimeters:	3	(minimum)	
Output options	Spiral vase:			
<section-header> Notes</section-header>	Horizontal shells Solid layers: Quality (slower slicing) Extra perimeters if needed: Avoid crossing perimeters: Detect thin walls: Detect bridging perimeters:	Top: 3 V V V	Bottom: 3	×
	Advanced Seam position: External perimeters first:	Aligned 🔻		
Version 1.2.9 - Remember to chee	k for updates at http://slic3r.org/			

6.2 Filament Setting

Set filament diameter and print temperature in the Filament setting tab. Filament we use here is 1.75mm PLA. Usually the temperature of the extrusion head is 195-210°C, and the temperature of hotbed is 60-70°C. Here we separately set them as 200°C and 65°C.



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e Window Help			
rint Setting; Filament Settin	ngs Printer Settings		
3 aluminum PLA → 🔚 ▶ Filament ≩ Cooling	 Filament Color: Diameter: Extrusion multiplier: 	1.75 mr 1	n
	Temperature (°C) Extruder:	First layer: 200	Other layers: 200
	Bed:	First layer: 65	Other layers: 65

6.3 Printer Setting

Set the shape and size of hotbed and the number of extruders in the Printer setting> General tab.



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ngs Printer Settings	
Size and coordinates	
Bed shape:	Set
x: 200 y: 200 x: 0 y: 0	(0, 0) OK Cancel
API Key:	
Firmware G-code flavor:	RepRap (Marlin/Sprinter/Repetier) 🔻
Advanced Use relative E distances:	
	Bed shape: x: 200 y: 200 x: 0 y: 0 API Key: Firmware G-code flavor: Advanced



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le Window Help rint Settings Filament Setti	ngs Printer Settings	
3 aluminum PLA 🔹	and the second s	
<mark>〕General</mark> ② Custom G-code ▼ Extruder 1	Bed shape:	ي: Set
	Z offset:	0 mm
	Capabilities Extruders:	1
	OctoPrint upload	
	Host or IP:	GBrowse
	API Key:	
	Firmware	
	G-code flavor:	RepRap (Marlin/Sprinter/Repetier) 🔻
	Advanced	
	Use relative E distances:	

Meanwhile set the extrusion head diameter as 0.4mm (input the actual diameter of your own printer):



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nt Settings Filament Settings	Printer Settings			
aluminum PLA 🛛 🛨 🔚 🤤	Size			
 General Gustom G-code 	Nozzle diameter: 0.4		mm	
	Position (for multi-extruder printe	ers)		
	Extruder offset:	x: 0	y: 0	mm
	Retraction			
	Length:	2		mm (zero to disable)
	Lift Z:	0		mm
	Speed:	40		mm/s
	Extra length on restart:	0		mm
	Minimum travel after retraction:	2		mm
	Retract on layer change:	1		
	Wipe while retracting:			
	Retraction when tool is disabled	(advance	ed setting	s for multi-extruder setups)
	Length:	10		mm (zero to disable)
	Extra length on restart:	0		mm

6.4 Other Settings

In addition to the above parameter settings, parameters like the speed of the printer are also very important to print quality. It requires user's long-term using experience and exploration.

Here we'd like to give you a setting for reference, please download the attachment <u>config.ini.</u> You can import it into slic3r to view it through the following steps.

Open slic3r>File>Load Config:



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Window Help			
Load Config	Ctrl+L		
Export Config	Ctrl+E		
Load Config Bundle		12.00	
Export Config Bundle		0.2	mm
Quick Slice	Ctrl+U t:	0.35	mm or %
Quick Slice and Save As	Ctrl+Alt+U		
Repeat Last Quick Slice	Ctrl+Shift+U		
Slice to SVG	Ctrl+G	3	(minimum)
Repair STL file			
Preferences	Ctrl+,		
Quit			
	Solid layers:	Top: 3	Bottom: 3
	Quality (slower slicing) Extra perimeters if needed: Avoid crossing perimeters: Detect thin walls: Detect bridging perimeters:		
	Advanced		
	Seam position:	Aligned -	
	External perimeters first:		

Find "I3 aluminum PLA config.ini" file in the dialog box and open it.



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Then you can successfully import the config.ini file. Click the Save button to rename and save it.



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File Window Help				
Print Settings Filament Setting	s Printer Settings			
I3 aluminum PLA conf 🕤 🔚 🌗	Layer height			-
Layers and perimeters	Layer height:	0.2	mm	
Infil	×	0.35	mm or %	
Skirt and Save preset				-
Speed	tings asi			
Multiple E	PLA config 🚽 🚽	2		
Advanced OK	Cancel	3	(minimum)	
Output op				
🚽 Notes				
	Horizontal shells			
	Solid layers:	Top: 3	Bottom: 3	
	145			-
	12.			
	Quality (slower slicing)			
	Quality (slower slicing) Extra perimeters if needed: Avoid crossing perimeters:	V		
	Extra perimeters if needed: Avoid crossing perimeters: Detect thin walls:			
	Extra perimeters if needed: Avoid crossing perimeters:			
	Extra perimeters if needed: Avoid crossing perimeters: Detect thin walls: Detect bridging perimeters:			
	Extra perimeters if needed: Avoid crossing perimeters: Detect thin walls:			
	Extra perimeters if needed: Avoid crossing perimeters: Detect thin walls: Detect bridging perimeters:			
	Extra perimeters if needed: Avoid crossing perimeters: Detect thin walls: Detect bridging perimeters: Advanced			

7 Begin Printing

So far, all the preparatory work is completed. The next step is to import the model file for slicing and printing. For 3D printer, the file format of the model is generally .stl file. We can download for free and print those models which are shared online , and you can also design your own creative objects for printing. Here we print a simple plate. You can download the model file here: <u>plate.stl</u>.



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7.1 Load print model

_	-	
=	= 1	
=	= 1	

In the main interface of Repetier host, click the Load button Load . Choose the file you have

downloaded and open it.





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7.2 Model Slicing

After the file is loaded, you can use the following buttons to enlarge, shrink or rotate it.



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After the size setting, choose the slicing parameters which were imported previously in the dropdown menu, and click **slice with slic3r**.



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)bject Placement	Slicer	Print	Preview	Manual Co	ntrol	SD Card	
Slic	e wit	h S	lic3r		К	ill Slicin	g
Slicer: 2 Slic31				•	¢¢,	Manager	_
				Cor	nfigur	ation	
Print Setting:	I3 al	uminum	PLA				
Printer Settings:	I3 al	uminum	PLA				-
Filament settings:							
Extruder 1:	I3 al	uminum	PLA				-
🔲 Override Slic3	r Settin	ngs	1				
Copy Prin	. Settin	gs to C)verride				
☐ Enable Suppor ✓ Enable Coolin							
Layer Height: 0	. 2		mm				

In this way, .gcode file which can be recognized by the printer is generated.



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Last step, click Start Print button to print.



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7.3 Stand-alone print with SD Card

If you want to print Stand-alone, you can save the .gcode file in SD card for printing.

Note: The printer only recognizes .gcode file in the SD card, and the file can not be placed in any

folder!

Steps are as follows:

7.3.1 Save

Click Save for SD Print, and select the save button in the dialog box.



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7.3.2 Generate file

Choose a save path to save the generated .gcode file which can be used for SD card printing.



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7.3.3 Print

Insert the SD card into the SD card slot at the back of the LCD control panel, and choose the corresponding .gcode to print.

Press the knob on LCD, rotate the knob to enter the main menu and choose Print from SD option.



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Choose corresponding .gcode file to begin printing.



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Heating



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When heating is completed, it begins printing automatically.



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8 FAQ

If you encounter any problems during use, you can come to our forum:

<u>http://www.geeetech.com/forum/</u>, and there are detailed solutions answer in the forum. Common problems are as follows:



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8.1 How to upload firmware?

The motherboard of the printer is already burned with firmware when it leaves the factory. If you have firmware problem when you are using the product and need to upload firmware, you need to use the Arduino IDE to burn. Arduino1.0.1 is recommended, and the download address is:

https://www.arduino.cc/en/Main/OldSoftwareReleases#1.0.x



The way of uploading firmware, please refer to:

http://www.geeetech.com/forum/viewtopic.php?f=13&t=17181

Firmware download address, please refer to:

http://www.geeetech.com/forum/viewtopic.php?f=10&t=17046



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Common parameters settings of firmware, please refer to: http://www.geeetech.com/forum/viewtopic.php?f=13&t=17194

8.2 How to change the motor direction in firmware?

In the configuration.h tab of firmware, find the following codes. Change the true of corresponding axis into false or false into true, and save the firmware and burn into the printer. (Because you don't know the firmware which has been burned by mother board is true or false, it may be necessary to burn both of the two parameters.)

#define INVERT_X_DIR true #define INVERT_Y_DIR false #define INVERT_Z_DIR true

#define INVERT_E0_DIR false



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💿 Marlin Arduino 1.0.1	
File Edit Sketch Tools Hel	p
	<u>@</u>
Marlin BlinkM.cpp B	linkM.h Configuration.h Configuratio
// Disables axis when it's :	not being used.
#define DISABLE_X false	
#define DISABLE_Y <mark>false</mark>	
#define DISABLE_Z false	
<pre>#define DISABLE_E false // :</pre>	For all extruders
#define DISABLE_INACTIVE_EX	TRVDER true //disable only inactive extrud
#define INVERT_X_DIR true	// for Mendel set to false, for Orca set
#define INVERT_Y_DIR true	// for Mendel set to true, for Orca set
#define INVERT_Z_DIR false	// for Mendel set to false, for Orca s
	// for direct drive extruder v9 set to t:
	// for direct drive extruder v9 set to
#define INVERT_E2_DIR false	// for direct drive extruder v9 set to
// ENDSTOP SETTINGS:	· · · · · · · · · · · · · · · · · · ·
✓ Sets direction of endsto: ✓ III	ns when homing: 1=MAX -1=MTN
320	Arduino Mega 2560 or Mega ADK on COM28

8.3 User manual of Repetier Host

For detailed user manual of Repetier Host, please refer to Wiki:

http://www.geeetech.com/wiki/index.php/Repetier-Host

8.4 Possible causes for motor' s non-action

http://www.geeetech.com/forum/viewtopic.php?f=13&t=17038

8.5 Extruder does not work normally

http://www.geeetech.com/forum/viewtopic.php?f=13&t=17097



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8.6 The hotbed or extruder can not be heated

http://www.geeetech.com/forum/viewtopic.php?f=13&t=17117

8.7 LCD error: MAX/MIN TEMP error

http://www.geeetech.com/forum/viewtopic.php?f=13&t=17030

8.8 No information or displaying black square on LCD

http://www.geeetech.com/forum/viewtopic.php?f=13&t=17040

8.9 Time.h/endstop hit or other abnormalities

http://www.geeetech.com/forum/viewtopic.php?f=13&t=17037