

# [Anycubic 4max Pro] Nivelado

It is essential to level the print platform of a 3D printer. Once leveled, it is not necessary to level every time before each prints. Please follow the procedures below:

## Manual leveling

1. Before leveling, in order to avoid burns from a hot nozzle, it is highly recommended to cool down first. Click "Tools" → "Cooling" on the screen, wait the temperature in the highlighted box to drop down to below 60°C.
2. On Home Menu, click "Tools" → "Home" → "Home All".
3. Return to the "Home Menu", click "Setup" → "Motor" to disable the motors so the motors/axis could be moved freely.
4. Return to the "Home Menu", click "Tools" → "Home" → "Home Z". Lock the Z axis to prevent the Z axis from falling during leveling.
5. As shown below, Put a leveling paper (average A4 paper) onto the print platform, and then manually move the print head back and forth to let the print head travel to 4 corners and center one by one (1) → (2) → (3) → (4) → (5). When nozzle has been moved to point (1), manually adjust (tighten or loose) the corresponding knob underneath the print platform.
  1. Avoid nozzle rub against the platform directly without the paper in-between.
  2. Loosen the knob clockwise, the platform rises. Tighten the knob, the platform descends.
  3. Leveling is to adjust the distance between nozzle and print platform to about a piece of paper thin (~ 0.1 - 0.2 mm). Therefore, when just feel the drag resistance as pulling the paper, it means good leveling for this particular point.
  4. Note: "just feel the drag resistance" means the paper can be moved, but with resistance.
  5. Please do so to the rest points and the center spot.
  6. Do the same operation at point (3) and point (4).
  7. For point 5, adjust all the 4 nuts underneath until feeling the drag resistance as pulling the paper.
  8. Perform double check to ensure the results, and check the points in diagonal order: (1) → (3), (2) → (4).
  9. Poor leveling will affect the print results, please be patient to level and verify the platform's 4 corners and center spot, so that the distance between nozzle and print platform is about a piece of paper thin (~ 0.1 - 0.2 mm).

## Print test

Insert the memory card into the memory card slot. Click on the Home Menu "Print" to enter the file list. There is a printable test file included - owl\_pair (author: etotheipi, [www.thingiverse.com](http://www.thingiverse.com)). Single click on owl\_pair and click Print. The machine will be automatically heating the platform and nozzle before printing.

There might be 3 kinds of results for the first layer of the test prints

- A: Lack of extrusion, the nozzle rub against the platform.
- B: Good extrusion and adhesion.
- C: Large gap, filaments are not even adhere to the platform.

In case of "nozzle too close" or "nozzle too high" (A or C), please manually fine tune the corresponding nuts under the platform.

It may need adjustment for few times until satisfying results such as B.

**Note:** It is recommended leave the top open while print PLA filament, because PLA needs heat dissipation, opening the top cover could help improving the printing quality; On the other hand, for printing ABS filament, it is recommended to cover the top to maintain a relative high environment temperature, which helps improving the printing quality, and also keep the ABS odor inside the chamber.

## Supplements to leveling

In some rare cases, after Home all, the nozzle can be still much lower than the platform, even after fully tighten the 4 nuts

underneath. On the opposite, sometimes the nozzle is still too high from the platform, even after fully loosen the 4 nuts underneath.

How to solve this: Adjust Z end stop down (up) to proper position. See next page for details.

**Case 1.** The nozzle is still much lower than the platform, even after fully tighten the 4 nuts underneath.

- Loosen the two screws of the sheet metal of Z end stop with a hex wrench, move the sheet metal of Z end stop **down** to the appropriate position, and then tighten the two screws.

**Case 2.** The nozzle is still too high from the platform, even after fully loosen the 4 nuts underneath.

- Loosen the two screws of the sheet metal of Z end stop with a hex wrench, move the sheet metal of Z end stop **up** to the appropriate position, and then tighten the two screws.

After adjusting the sheet metal of Z end stop, you need to click Tool → Home → Home all to verify the results. After this, please level the platform again, as shown in the above leveling steps.

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