



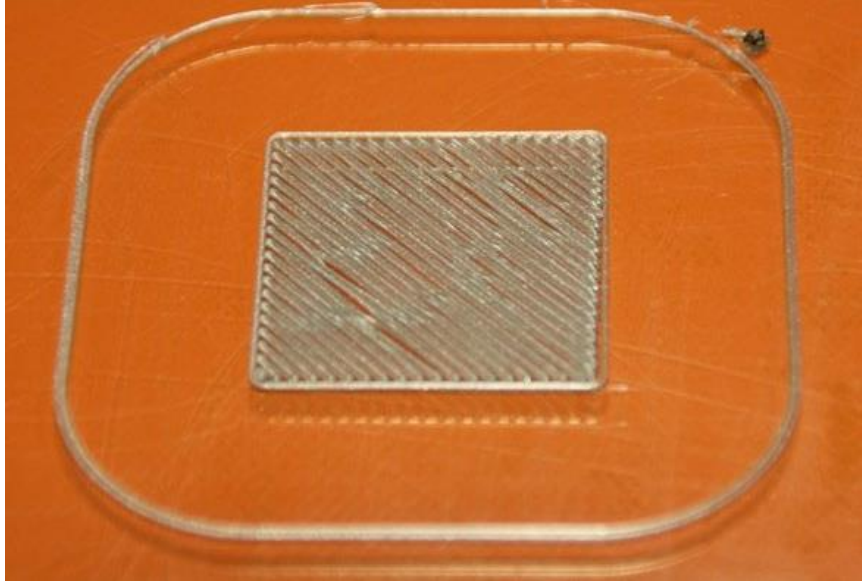
Baby-stepping

How to baby-step the Z axis height

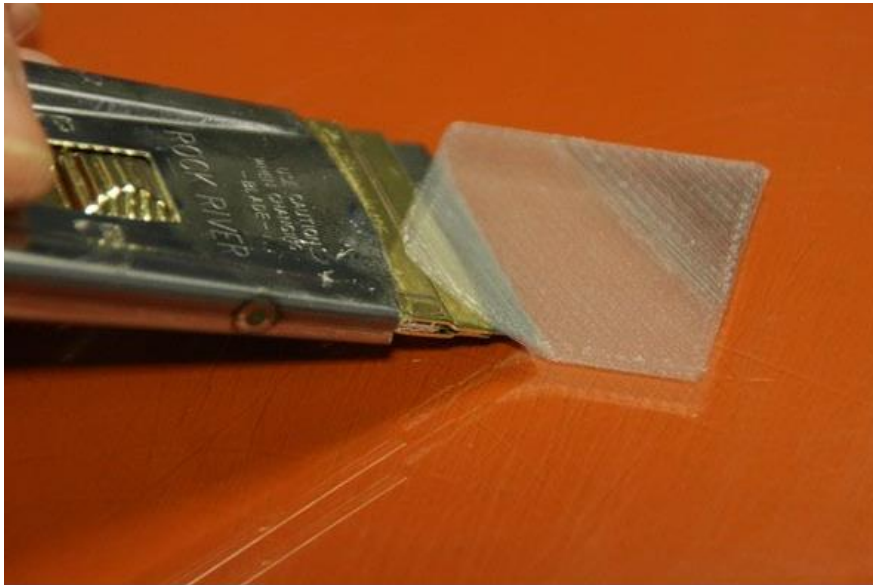
Baby-stepping

If the nozzle is too far or too close to the bed, this can be adjusted by a process of baby-stepping the distance of the nozzle from the bed.

Too far from the bed



Too close to the bed



Baby-stepping

Baby-stepping is done on the LCD Screen by selecting Tune → Babystep Z
Turning the Knob clockwise raises the Extruder; counter-clockwise lowers the Extruder.
1 click on the Knob, while rotating it, adjusts the Extruder by 5 microns.



Ensure the layers are smooth and touching each other with no bumps.



If the Z height has to be baby-stepped more than $\pm 0.30\text{mm}$, please refer to the following work instructions to recalibrate the machine:

- Bed Level Process WI6100-0011