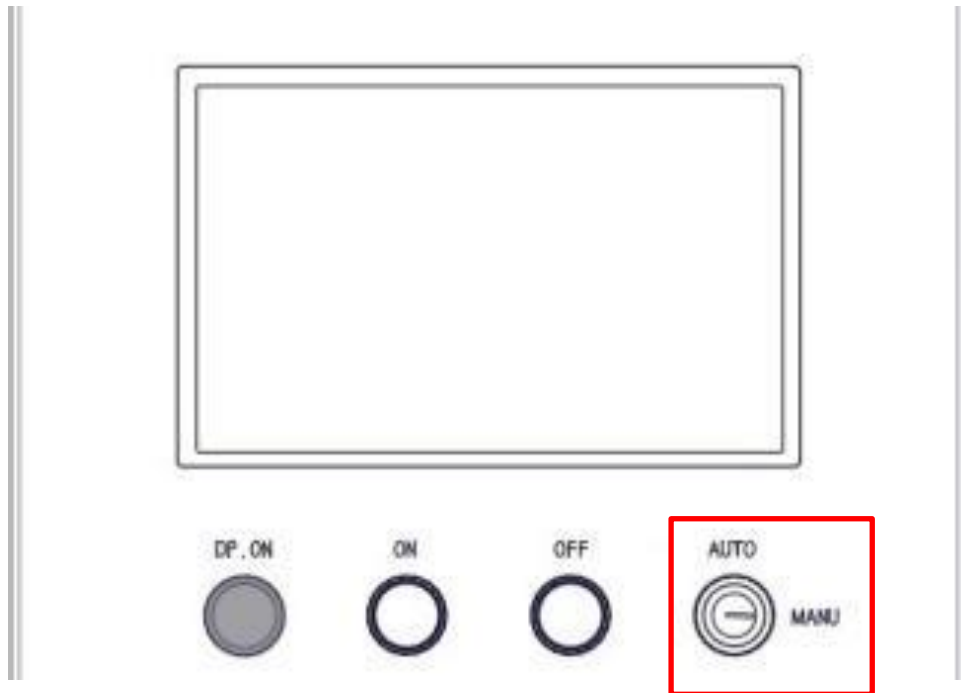


PRO610HT Encoder Calibration Guide

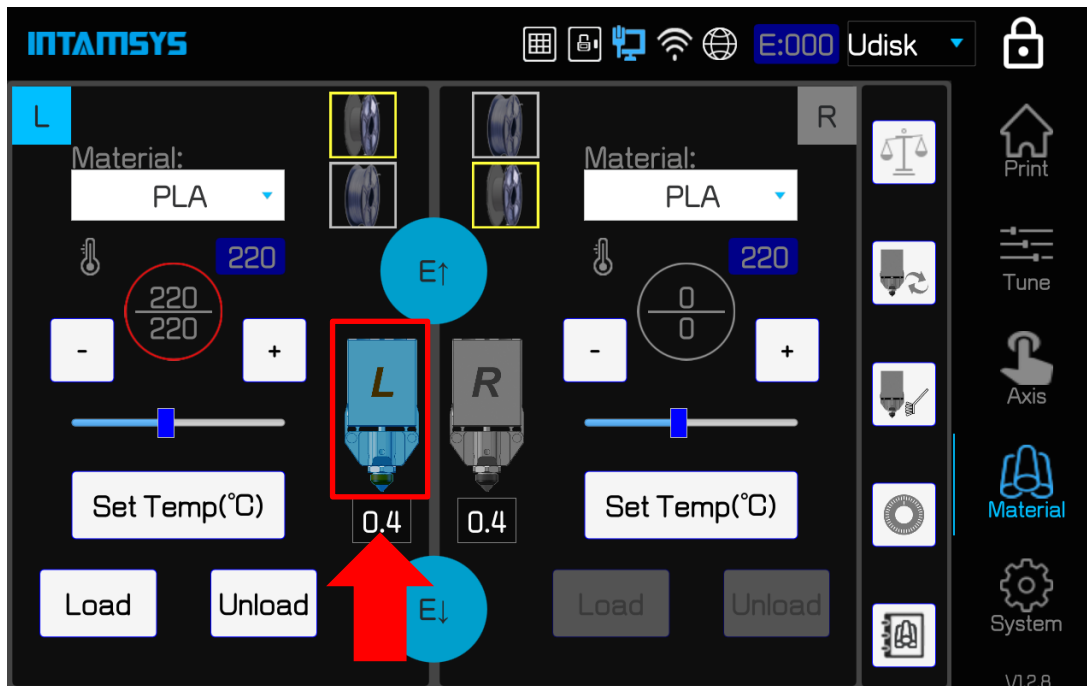
2024/10/28

Step 1: Preparation

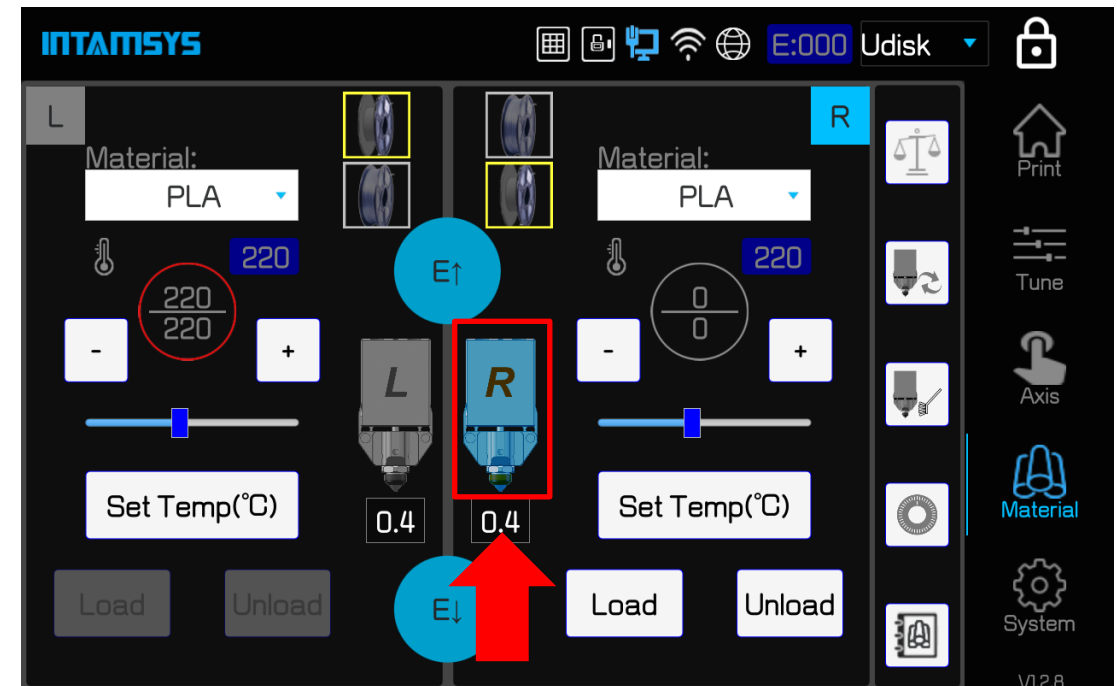


- Software: PRO 610HT V1.2.8.11 or later.
- Firmware: PRO 610HT 1.1.3.54 or later.
- Make sure to switch to MANU mode.
- **Necessarily perform encoder calibration under following circumstances:**
 - Upgrading software from version lower than PRO 610HT V1.2.8.11
 - Upgrading firmware from version lower than PRO 610HT 1.1.3.54
 - After replacing encoder;
 - After restoring factory settings;

Step 2: Switch to Nozzle for Testing

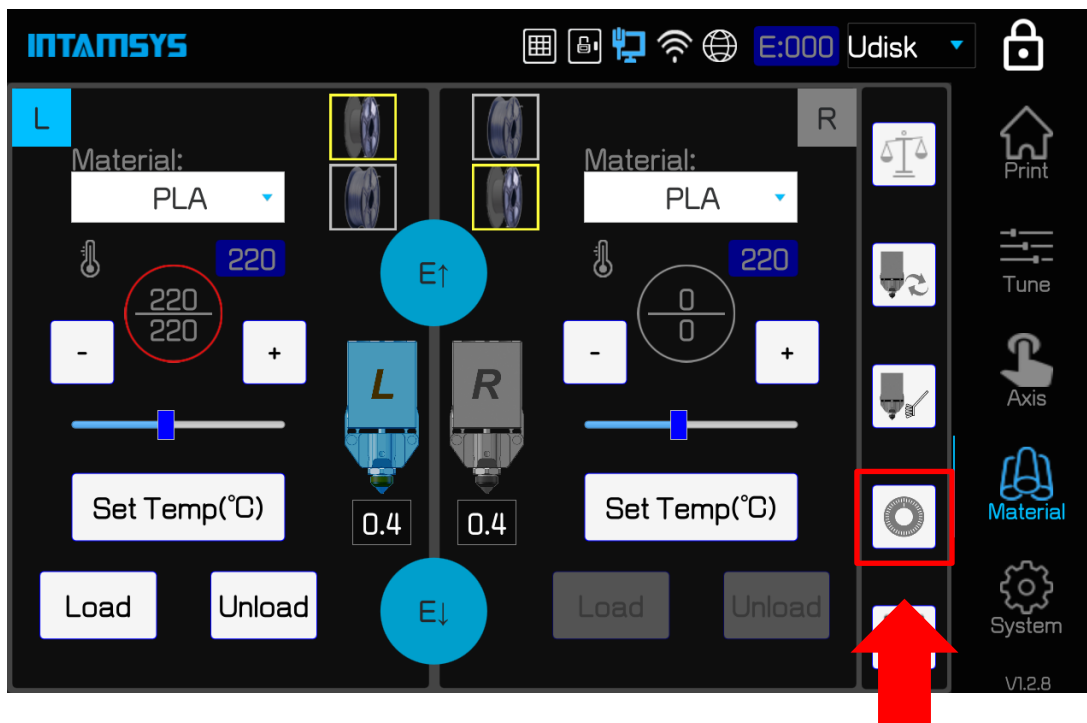


Click on *L nozzle* to switch to left nozzle.



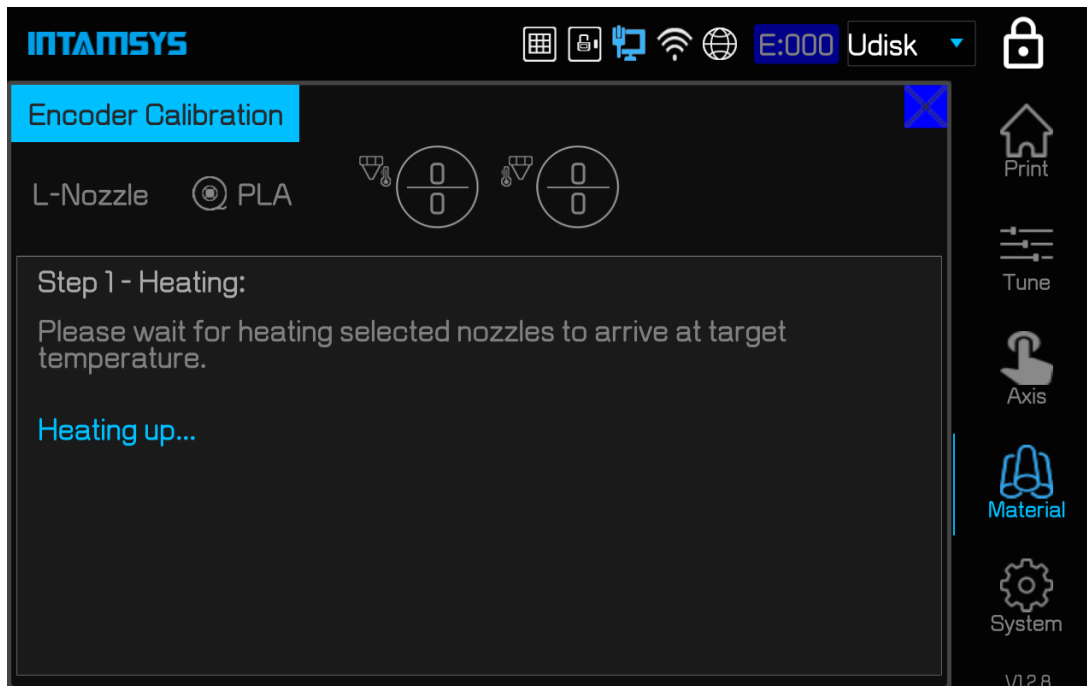
Click on *R nozzle* to switch to right nozzle.

Step 3: Enter Encoder Calibration Page

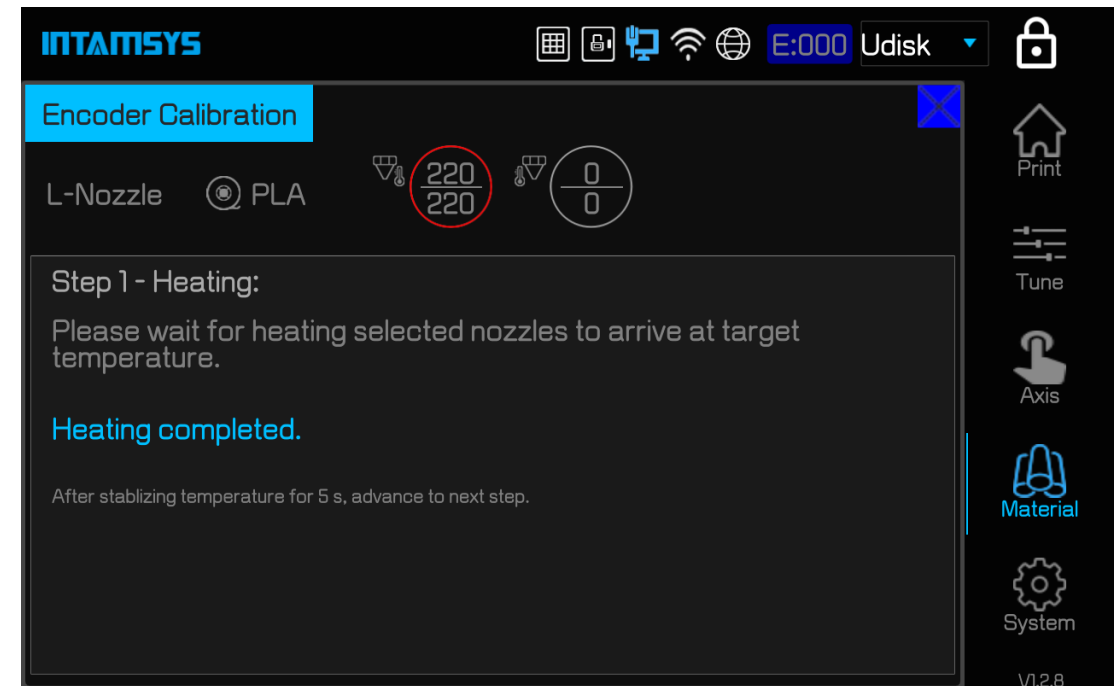


- Take *L nozzle* for example.
- Click on encoder button highlighted in figure to enter encoder calibration page.

Step 4: Heating

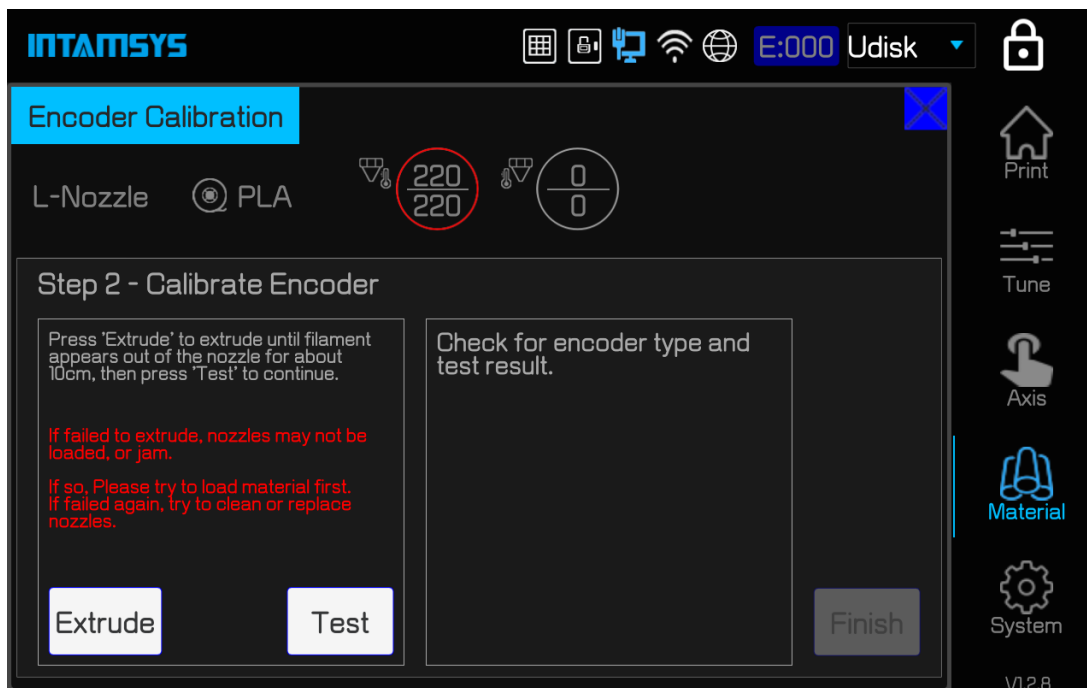


Please wait for selected nozzle to be heated to target temperature.



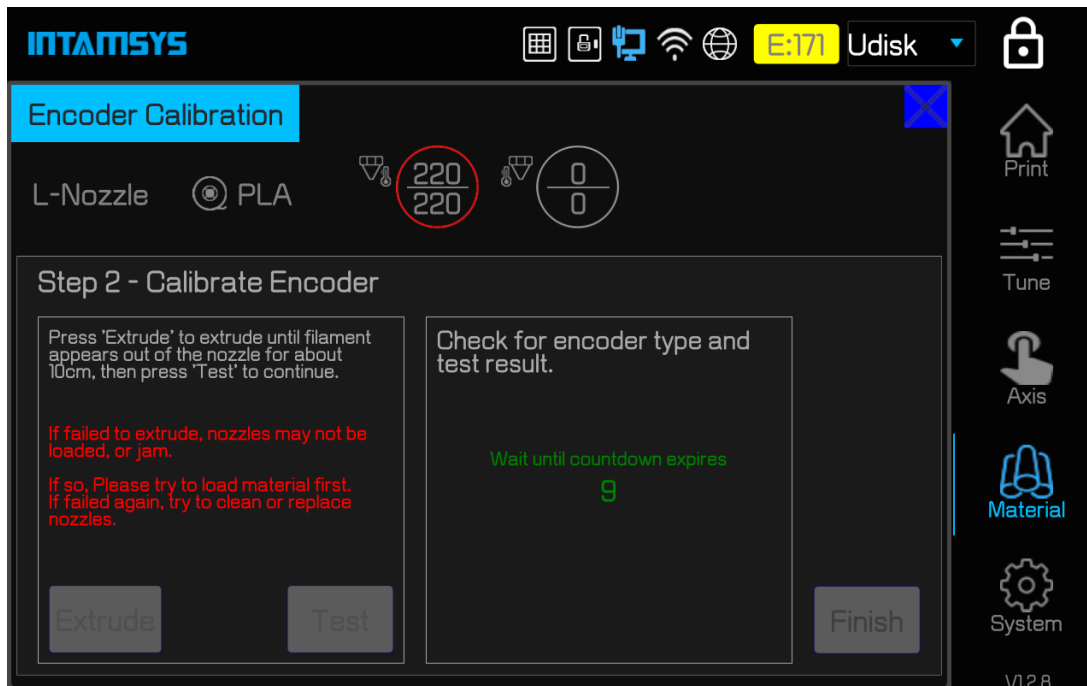
After arriving at target temperature and keeping within $(target-10, target+30)^{\circ}\text{C}$ range for 5 seconds, move on to next step automatically.

Step 5: Calibrate Encoder



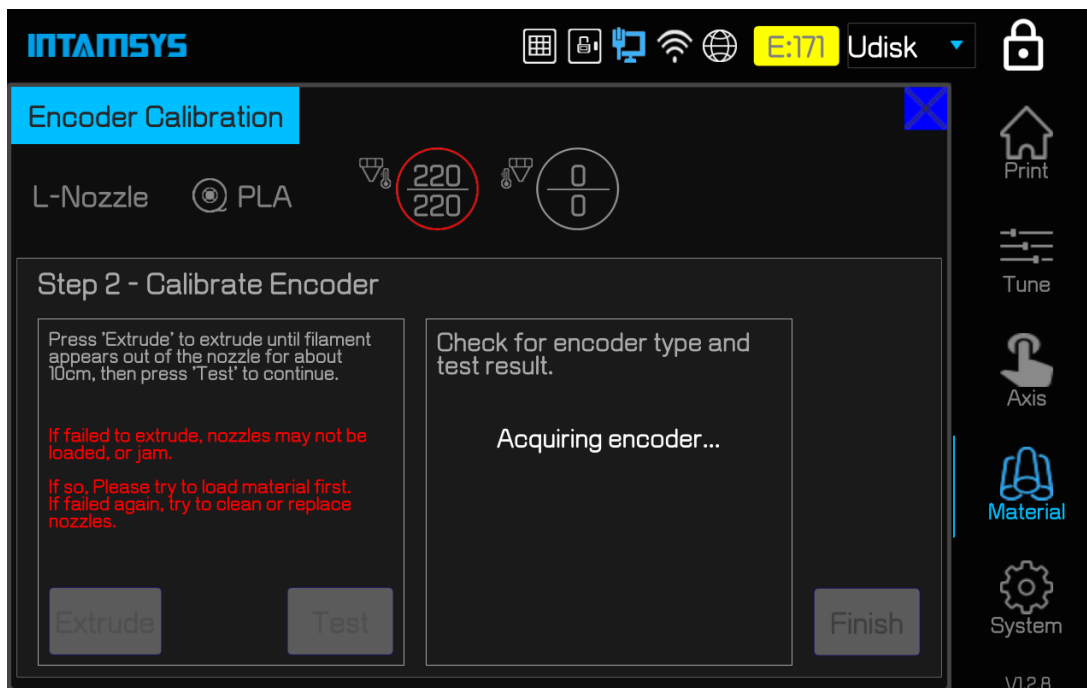
- Please keep pressing *Extrude* button to extrude filament to appear out of nozzle for about 10cm, then click on *Test* button.
- If failed to extrude, nozzles may not be loaded, or jam.
- If so, Please try to load material first.
- If failed again, try to clean or replace nozzles.

Step 5: Calibrate Encoder (cont.)

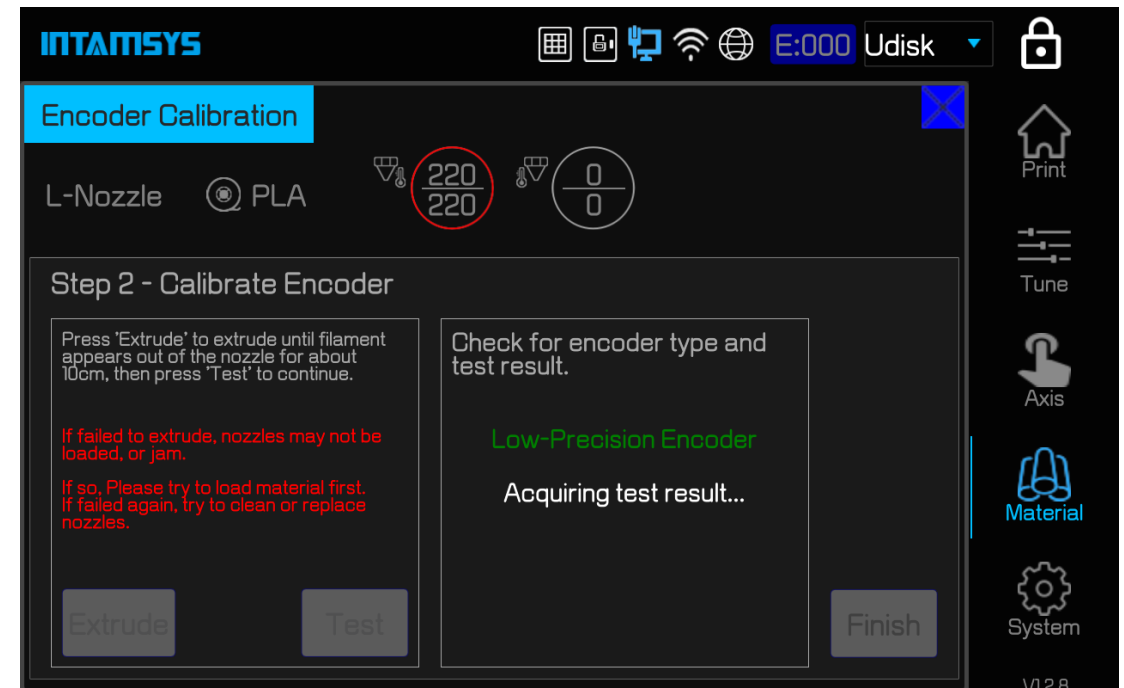


- Click on *Test* button on left panel. 10s-countdown appears on right panel.
- After countdown expires, page will acquire encoder type and test result automatically.

Step 5: Calibrate Encoder (cont.)

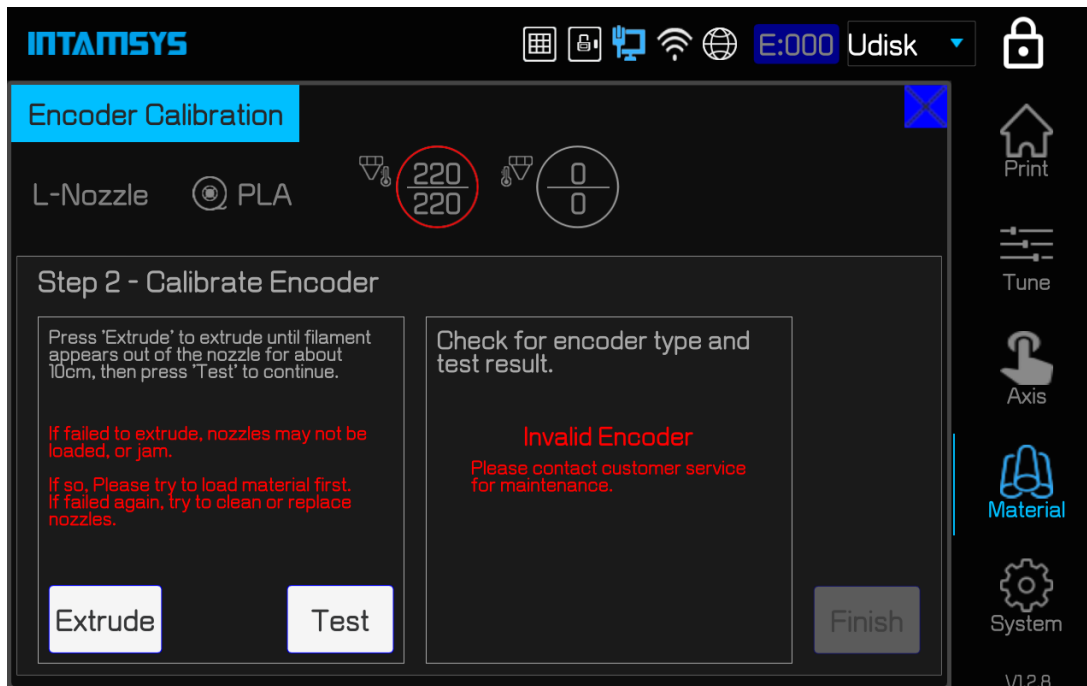


Acquiring encoder... appears on right panel. Page will wait for response from firmware.



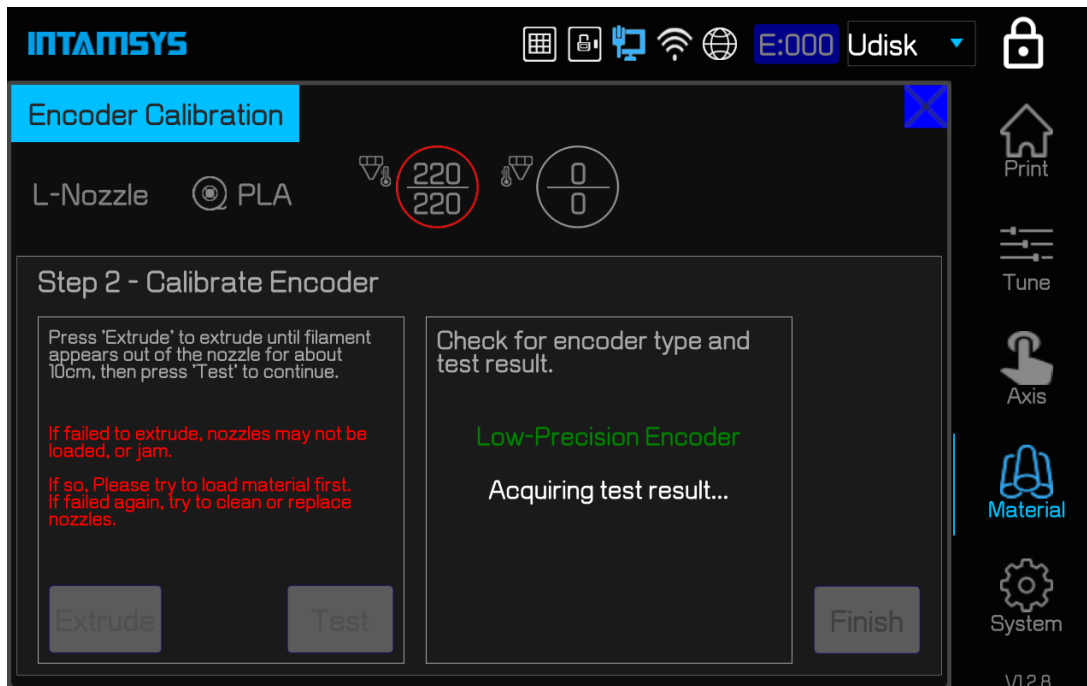
Moments later, encoder type will appear on right panel marked in green. Test result to be acquired shortly after.

Step 5: Calibrate Encoder (cont.)

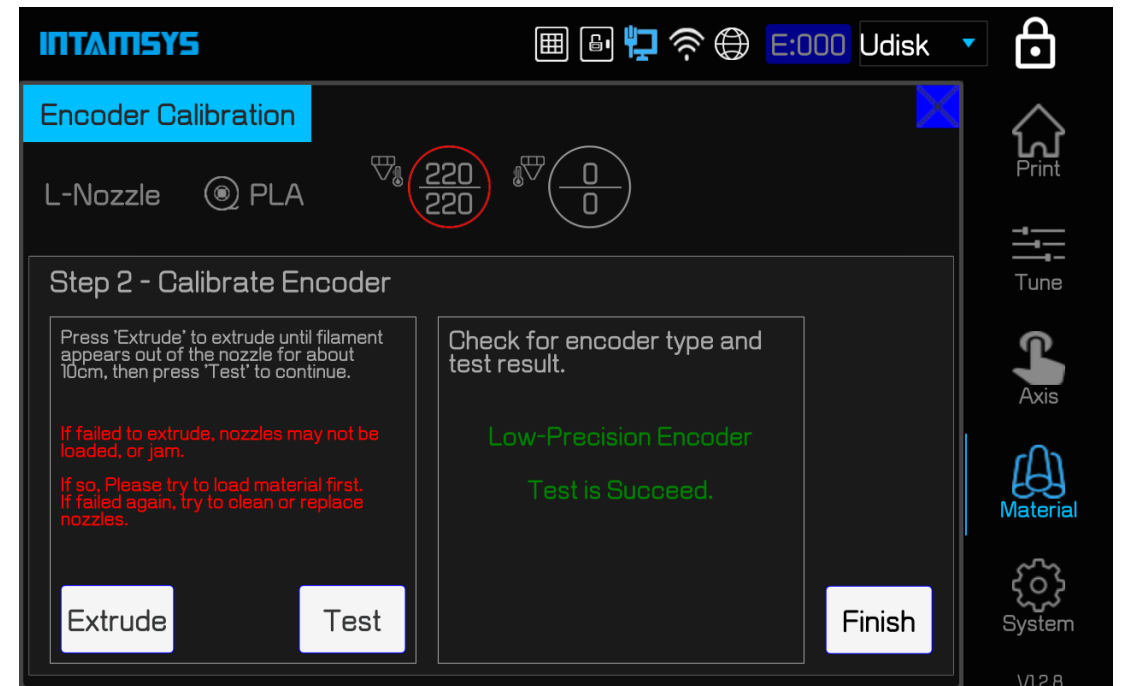


- Encoder is abnormal if red *Invalid Encoder* appears on right panel.
- *Extrude* and *Test* buttons are available under such case. Current step, *Calibrate Encoder*, may be performed multiple times.
- If failed multiple times, please contact customer service for maintenance.

Step 5: Calibrate Encoder (cont.)

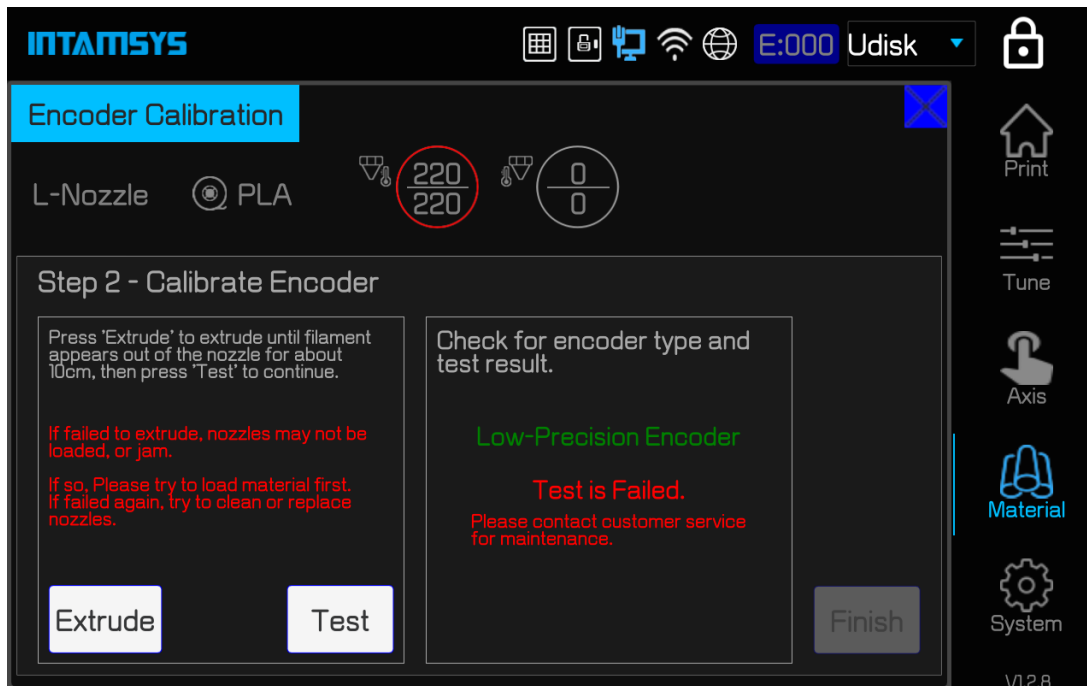


Acquiring test result... appears on right panel. Page will wait for response from firmware.



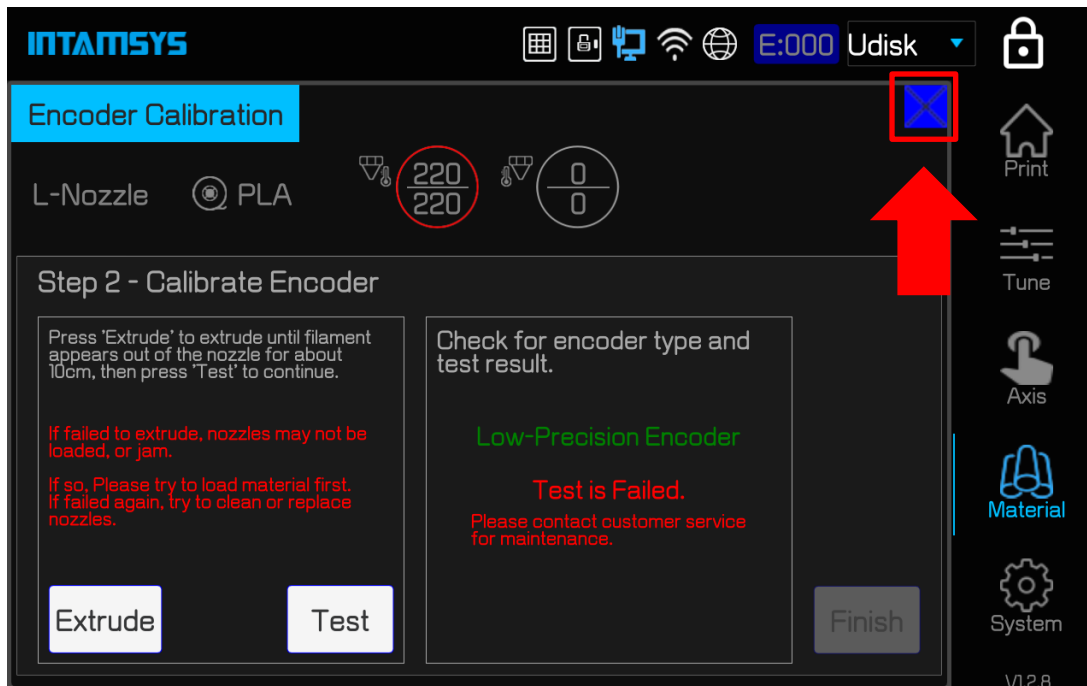
Moments later, if *Test is Succeed* appears on right panel, encode calibration is successful. Click on *Finish* button to conclude.

Step 5: Calibrate Encoder (cont.)



- Encoder calibration is failed if red *Test is Failed* appears on right panel.
- *Extrude* and *Test* buttons are available under such case. Current step, *Calibrate Encoder*, may be performed multiple times.
- If failed multiple times, please contact customer service for maintenance.

Premature Exit



- During any stage above, encoder calibration can be prematurely terminated by pressing blue *exit* button on top right corner.

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infinite possibilities