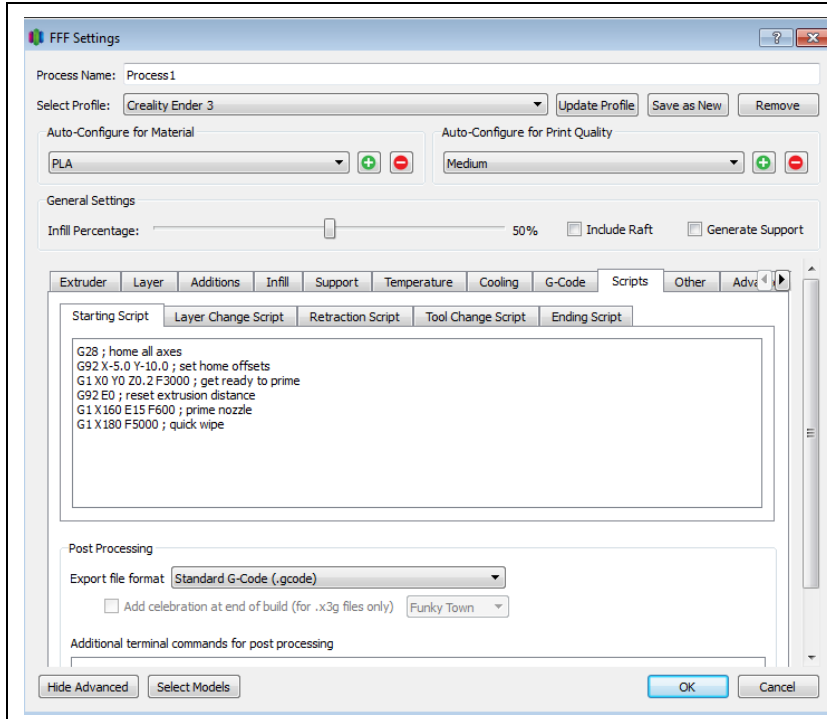


Setting the Home Offsets for Micro Swiss Direct Drive Extruder kit Without any leveling probe installed

Adjusting origin offsets



- Find Starting Gcode section in your Slicer software.

For Cura users, starting Gcode is located under **Printer tab**, not Extruder tab.

- Delete everything that is currently there and replace it with the following code:

```
G28 ; home all axes
G92 X-5.0 Y-10.0 ; set home offsets
G1 X0 Y0 Z0.2 F3000 ; get ready to prime
G92 E0 ; reset extrusion distance
G1 X160 E15 F600 ; prime nozzle
G1 X180 F5000 ; quick wipe
```

- The line: "G92 X-5.0 Y-10.0 ; set home offsets" might need to be tweaked slightly for different printers

Step 27 – Fine tune



Extruder steps/mm needs to be calibrated.
Good starting point is 130 steps/mm

- Download this custom [G-code](#) file to your SD card and run it in your printer. This will set the steps/mm to 130.
- For best results, you will have to fine tune the extrusion multiplier/flow rate in your slicer.

The installation is now complete!

Tips and Tricks

- Reduce the retraction amount. Maximum recommended retraction is 1.5mm @ 35mm/sec.
- With All Metal Hotend, the nozzle temperature might need to be increased by 5-10 °C.
- Make sure the Z-axis rail wheels are adjusted properly to eliminate rail sagging.
- Download and print the [Extruder Knob](#) from Thingiverse. This makes the manual filament changing process very easy.