

# Qidi X3 series printers initial calibration

Initial calibration to go thro for new Qidi X3 series printers. As an example will use X-Max 3, but same applies to all printers

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# WIP: Max volumetric speed calibration

Qidi own profiles are eagerly fast. For example their profile for Qidi own gray Rapido PLA max volumetric flow is set to  $25\text{mm}^3/\text{s}$ , while realistic quality print speed is more around  $18\text{-}22\text{mm}^3/\text{s}$ . Some lucky people have reported that they can also go up to  $35\text{-}36\text{mm}^3/\text{s}$  with stock config

Since out of box there's no way knowing at what flow you can archive need to make test for it. Easiest way to test it is using OrcaSlicer built-in calibration

# Bed leveling / tramming

## Adjusting bed leveling screws

It's useful to adjust screws, if bed is tilted or some corners of the bed are off

It can be done manually moving printhead from corner to corner using paper and manually adjusting screws until all 4 corners feel the same. Or can use Klipper built-in helpers for it

## Klipper helper macro

[Klipper Documentation](#)

Add this macro to your **printer.cfg**

```
[screws_tilt_adjust]
horizontal_move_z: 4
screw_thread: CCW-M4
speed: 300

screw1: 7,37
screw1_name: front left
screw2: 262,37
screw2_name: front right
screw3: 262,297
screw3_name: rear right
screw4: 7,297
screw4_name: rear left
```

Click "Save and restart" to load in updated config

Then hit **home** or send **G28** (gCode for homing)

Write **SCREWS\_TILT\_CALCULATE** in commandline to start measuring screws.

You should get output something like this:

```
// 01:20 means 1 full turn and 20 minutes, CW=clockwise, CCW=counter-clockwise
// front left screw (base) : x=7, y=37.0, z=2.48750
```

```
// front right screw : x=262.0, y=37.0, z=2.36000 : adjust CW 01:15  
// rear right screw : y=262.0, y=297.0, z=2.71500 : adjust CCW 00:50  
// read left screw : x=7, y=297.0, z=2.47250 : adjust CW 00:02
```

First screw is used as "base" and others need to be adjusted

Screw on front right need to be turned clockwise one full turn and a quarter

Rear right screw need to be turned counter clockwise 50 minutes, which is about 0.8 turns

Rear left screw need to be turned clockwise 2 minutes, which is about 0.03 turns

Can keep running **G28** (home), **SCREWS\_TILT\_CALCULATE** and adjust screws until happy with end result