

Jeric B | re:3D | GB3 Dial Indicator

**\*\*NOTE: THESE INSTRUCTIONS ARE FOR PERFORMING BED LEVELING WITH THE GB3 TROLLEY, NOT GB2\*\***

1. Unbox dial indicator



2. Connect the smaller diameter shaft to the dovetail mount by threading it in



3. Slide the dovetail mount onto the back of the dial indicator



4. Hand tighten the shaft to lock it into place



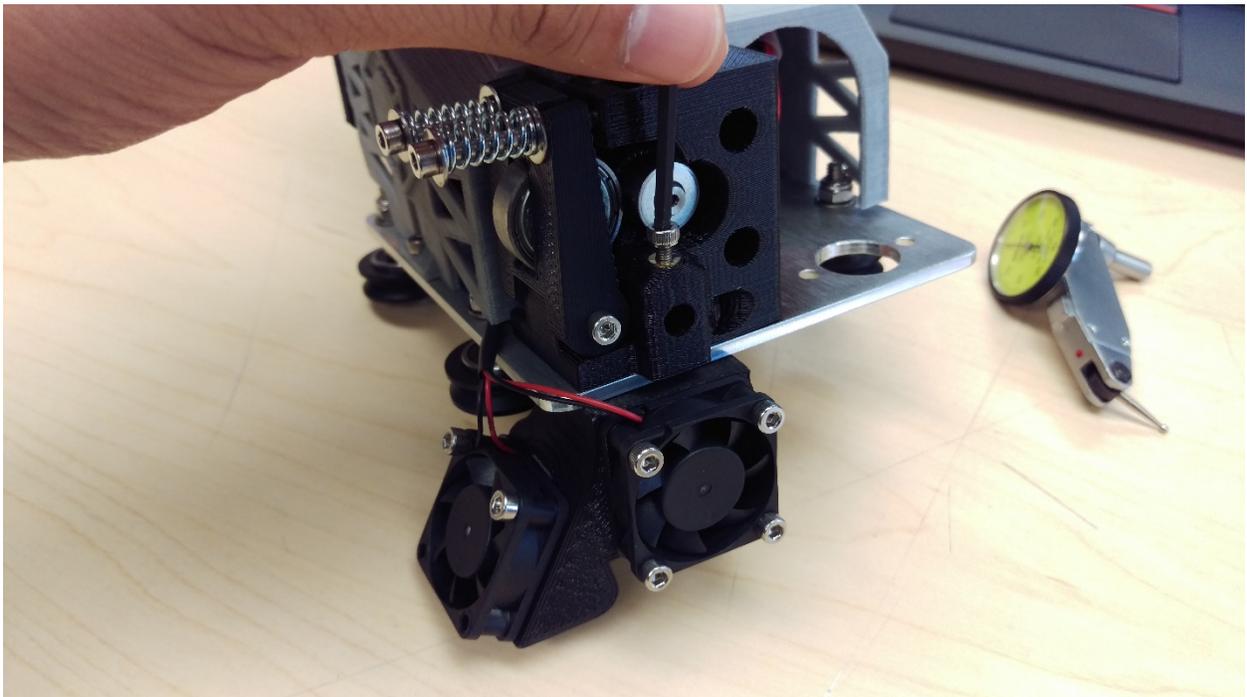
5. Swivel the arm of the dial indicator so it is about 20 degrees away from the vertical as shown



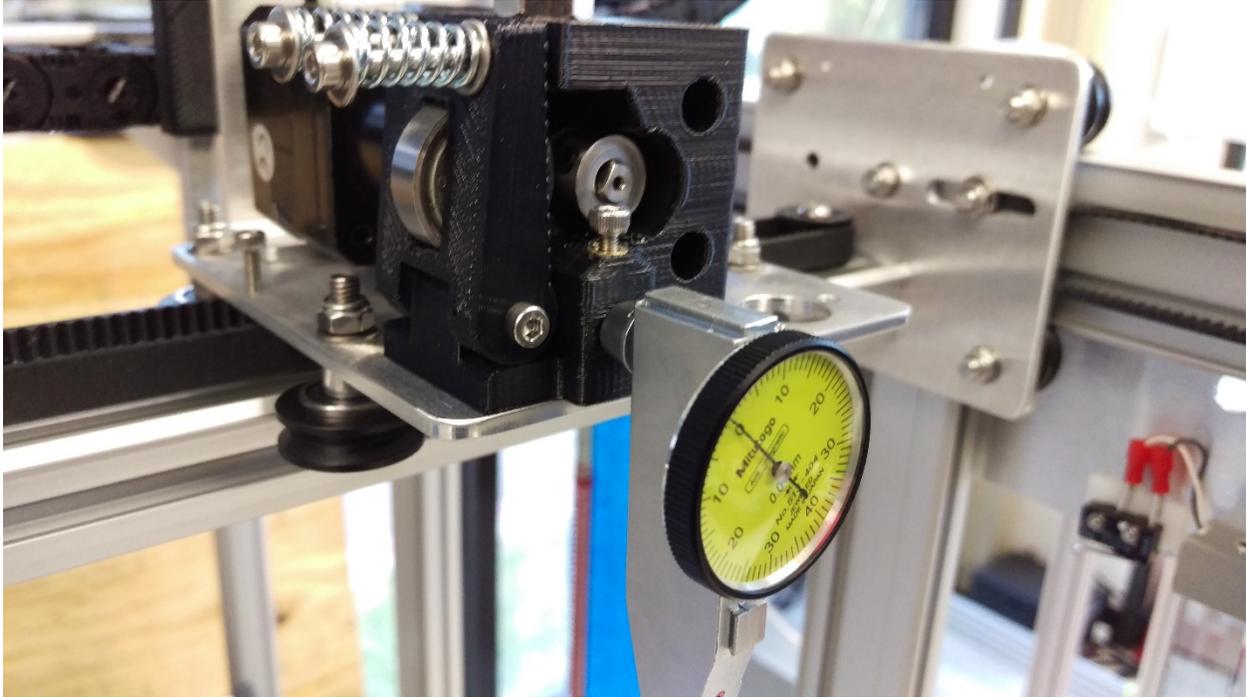
6. Zero the dial indicator by holding the outer rim and rotating the face



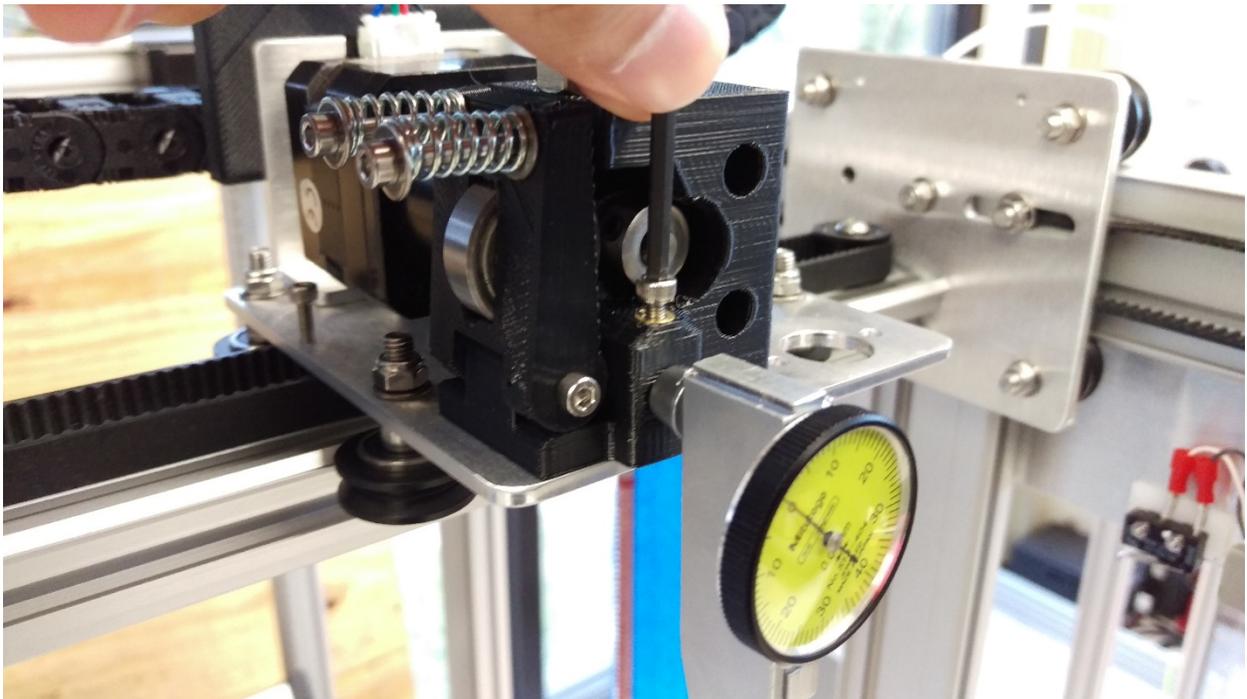
7. Loosen the M3 SHCS set screw on the front of the extruder assembly with a 2.5mm Allen Key (shown on trolley separate from GB)



8. Insert the shaft of the dial indicator into the cavity at the front of the extruder assembly



9. Keeping the dial indicator as vertical as possible, lock it into place by tightening the M3 SHCS set screw with the 2.5 mm Allen Key



10. (level with same directions as on Wiki—listed below for reference)
11. Ensure dial indicator feeler arm is lower than the nozzle so that it contacts the bed surface before the nozzle
12. Move the trolley to the center of the print area

13. Slowly raise the bed until it makes contact with the dial indicator and moving the needle approx. 0.010 in/0.254 mm
14. Disable the motors to move the trolley freely by hand
15. Use your hand to push the trolley plate and move the print head towards all four corners of the bed
16. Determine lowest corner. Adjust bed leveling nut on underside of bed to pull the three other corners to about the same level
17. Fine tune all around until all corners are within 0.005" or 0.127mm
18. When bed is level, tighten the M5x12 screws affixing bed side plates to bed support rails. Repeat for all four corners and verify the leveling hasn't changed
19. Remove dial indicator by loosening set screw. You may want to retighten the set screw after to make sure it doesn't fall out
20. Disassemble the dovetail mount from the dial indicator and place everything in the dial indicator case as before