T	
Info Screen	1
Prepare	+
Bed Leveling	H
Configuration	÷
Change Filament	Ē

a.

50V0

Main Auto Home Probe Z Offset Level Bed Auto Z-Align

1.Press the knob> Main →Bed Leveling→Auto Z-Align



The machine will auto-home first, then the entire X-axis will rise to

the top for calibration, then descend to auto-home.



When the machine hits the top it makes a noise, this is normal, just keep waiting for it to go down

You don't need to adjust this step every time you level, only do it when you feel that the Xaxis beam is not level enough



We are using a bi-metal throat, so setting the retraction distance too high may cause clogging. In our tests, a retraction distance of **0.5mm** was the most suitable. The following are the retraction parameters in Sovol Cura and Prusaslicer



Retract at Layer Change	5	~	
Retraction Distance	5	0.5	mm
Retraction Speed	5	40.0	mm/s
Retraction Retract Speed		40.0	mm/s
Retraction Prime Speed		40.0	mm/s
Retraction Extra Prime Amount		0.0	mm³
Retraction Minimum Travel		1.5	mm
Maximum Retraction Count	5	10	
Minimum Extrusion Distance Window	5	0.5	mm
Combing Mode 🖉	5	Off	~
Retract Before Outer Wall	0	~	
Layer Start X		0.0	mm
Layer Start Y		0.0	mm
Z Hop When Retracted			

## Retraction mm G 3 0.5 Length: (zero to disable) • 0 Lift Z: mm B . 0 Only lift Z: Above Z: mm H • 40 mm/s Retraction Speed: 6 3 40 Deretraction Speed: mm/s A • 0 Extra length on restart: mm Minimum travel after retraction: G • 2 mm 6 • 🗹 Retract on layer change: Wipe while retracting: G . 0 Retract amount before wipe: 1%

## Tips

When printing ABS or other high temperature filaments, we suggest to print in the enclosure to avoid model cracking.



20% fan speed can improve print quality slightly when printing most high temperature filaments, if you find it is not good after setting fan speed 20%, then please do not turn on the fan.

