

# Setting the Home Offsets for Micro Swiss Direct Drive Extruder kit Leveling probe installed with TH3D Unified Firmware

## Adjusting origin offsets

```

1013 //=====
1014 //***** COMMUNITY FEATURES *****
1015 //=====
1016 //=====
1017 //=====
1018 // HOME OFFSET ADJUSTMENT -----
1019 // If you need to adjust your XY home offsets from defaults then you can uncomment the HOME_ADJUST_LC
1020 // custom XY offsets. This is provided for convenience and is unsupported with included product suppe
1021 // How to use - measure (home XY then jog using the LCD 1mm at a time) the X and Y distance the nozzl
1022 // the build plate and then put those as NEGATIVE values below, positive values will NOT work (move y
1023 #define HOME_ADJUST
1024 #define X_HOME_ADJUST_LOCATION -5
1025 #define Y_HOME_ADJUST_LOCATION -10
1026 //=====
1027 // LINEAR ADVANCE -----
1028 // See here on how to use Linear Advance: http://marlinfw.org/docs/features/lin_advance.html
1029 // NOTE: Linear Advance does NOT work with the Creality Silent boards, CR-10S Pro, CR-10S Max, and CR
1030 // #define LINEAR_ADVANCE
1031 // Change the K Value here or use M900 KX.XX in your starting code (recommended).
1032 #define LINEAR_ADVANCE_K 0
1033
Done uploading.
avrdude: 116908 bytes of flash written
avrdude done. Thank you.

```

We will need to modify two lines of the code in Configuration.h tab.

- Open Configuration.h tab and find these lines:

```
#define X_HOME_ADJUST_LOCATION
#define Y_HOME_ADJUST_LOCATION
```

- Add negative offsets amount to each line:

```
#define X_HOME_ADJUST_LOCATION -5
#define Y_HOME_ADJUST_LOCATION -10
```

- Flash the firmware
- Offsets amount might need to be slightly tweaked 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.