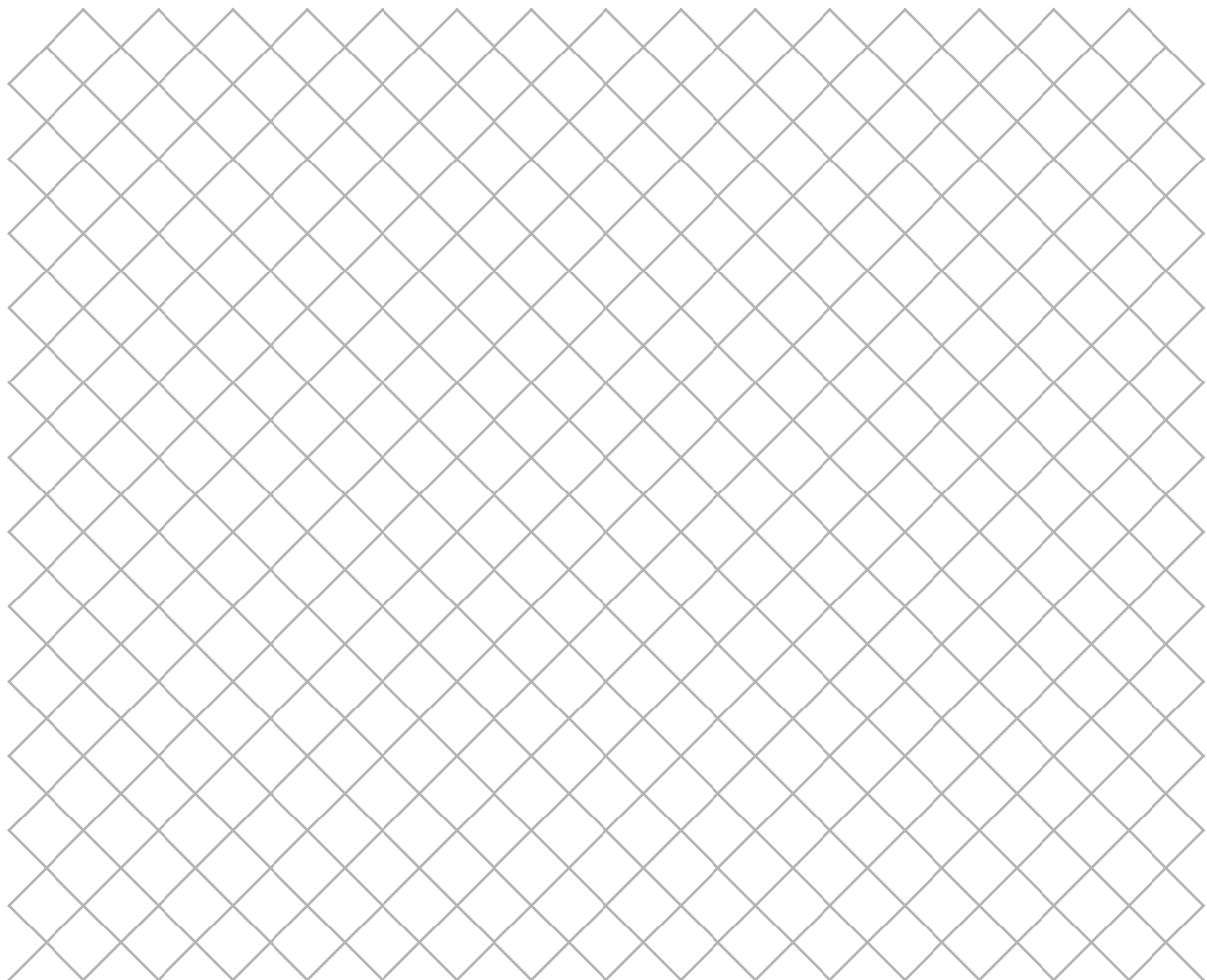




# Ultimaker S5 Material Station

## Decoupler calibration instructions



# Entering calibration mode



1. Open the Material Station door

---

**Note:** The Material Station can be powered on and connected to an Ultimaker S5 when starting this procedure

---

**Note:** For the next steps, keep holding the eject buttons until the instructions specify to release them

---



2. Push and hold the two left eject buttons  
This starts the calibration of decoupler 1



- or
2. Push and hold the two right eject buttons  
This starts the calibration of decoupler 2



3. Remove the power cable from the Material Station and wait 5 seconds



4. Reconnect the power cable to the Material Station and wait 5 seconds



5. Release the eject buttons

---

**Note:** The Material Station now enters calibration mode. The frame LEDs will indicate the progress of the calibration procedure.

---

**Note:** The Material Station will **flash once**.

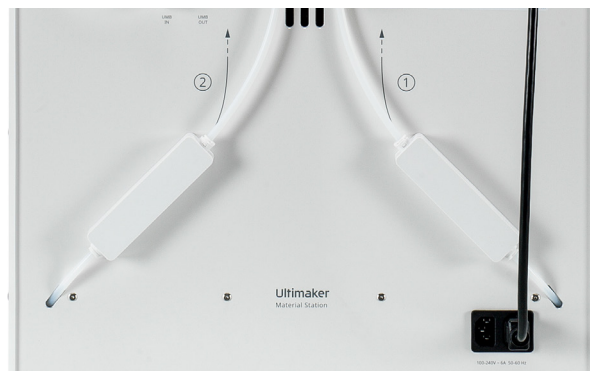
---

# Decoupler calibration

**Note:** Ensure you have access to both the front and the back of the Material Station.  
The calibration is performed on the decoupler at the back, and each step is confirmed by pressing an eject button at the front.

**Note:** Keep the Bowden tube in the specified position until you have pressed the eject button.

**Note:** It does not matter which of the eject buttons you press to confirm each step.



1. Access the correct decoupler at the back of the Material Station



2. Push the slider of the decoupler all the way down, into the spring. You will feel some resistance



3. Confirm by pressing one of the eject buttons

**Note:** The Material Station will flash **two times**.



4. Hold the slider down, but do not compress the spring. Confirm with the eject button

**Note:** The Material Station will flash **three times**.



5. Pull the slider up, but do not compress the spring. Confirm with the eject button

**Note:** The Material Station will flash **four times**.



6. Pull the slider up as far as possible. You will feel some resistance

Confirm the last step by pressing one of the eject buttons. If the calibration was successful, the Material Station frame lights will stay on.

**Note:** If the Material Station goes back to flashing just once during this procedure, the input was unsuccessful. The procedure will start over from step 1.