PrusaSlicer setup for Klipper on Artillery Sidewinder X2

Website : https://papy-3d-factory.xyz

Tiktok : https://www.tiktok.com/@papy_3d_factory

Github : https://github.com/Papy-3D-Factory?tab=repositories/

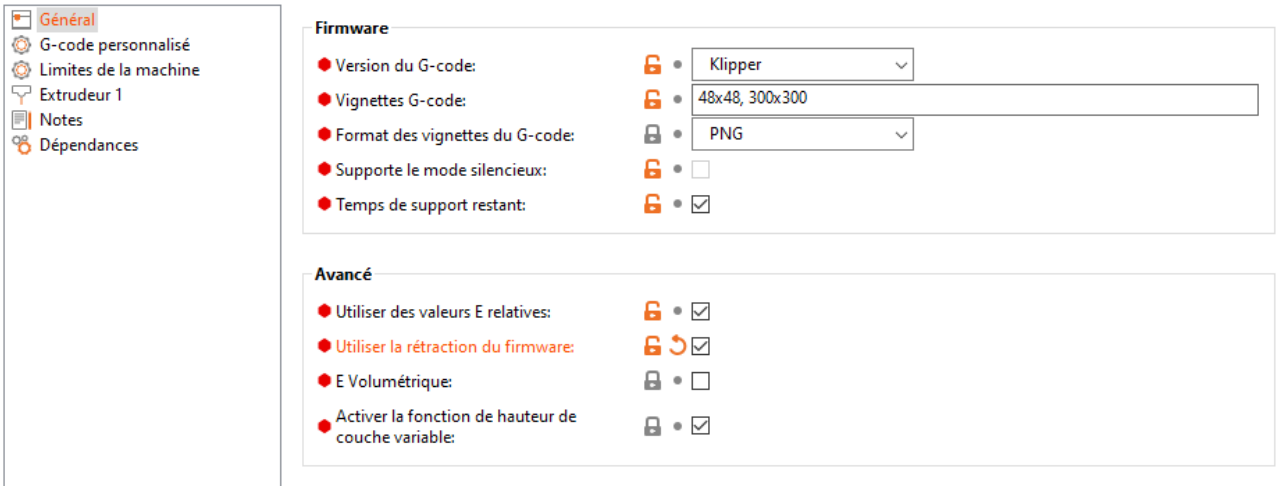
In this second tutorial we will see how to configure PrusaSlicer in order to make it work correctly with Klipper installed on your Artillery Sidewinder X2.

Not using CURA I will not launch into explanations concerning this Slicer.

In PrusaSlicer, go to the 'Printer settings' tab

In 'General' check the option 'Use firmware retraction'

Set the 'G-code version' option to 'Klipper'



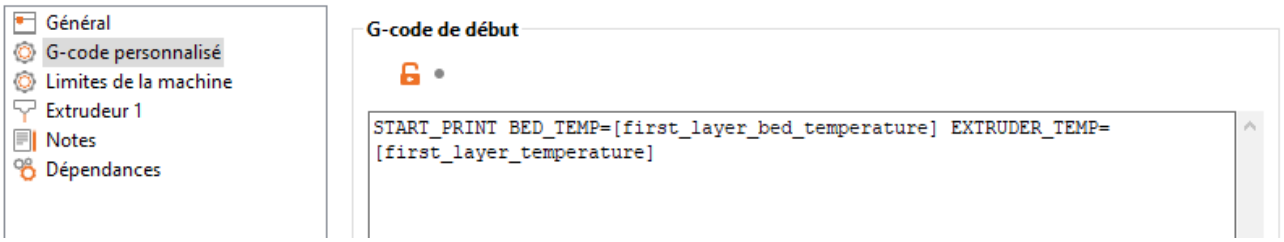
The retraction will now be set in klipper, more precisely in the extruder.cfg file

```
65  [firmware_retraction]
66  retract_length: 3
67  retract_speed: 70
68  unretract_extra_length: 0
69  unretract_speed: 70
```

In 'Custom G-code',

In the 'G-code start' part put:

```
START_PRINT BED_TEMP=[first_layer_bed_temperature] EXTRUDER_TEMP=[first_layer_temperature]
```



In the 'end G-code' part put:

```
END_PRINT
```

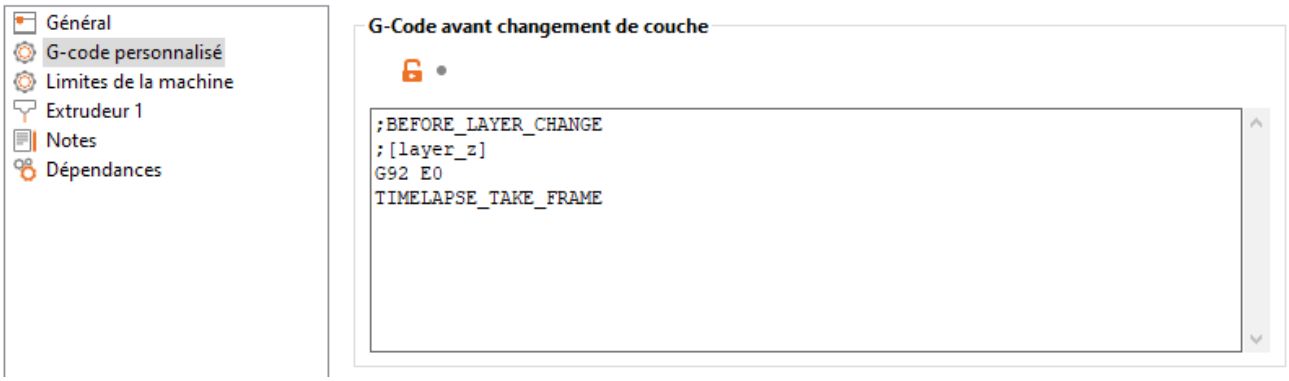
In the 'G-code before layer change' part put:

```
;BEFORE_LAYER_CHANGE

;[layer_z]

G92 E0

TIMELAPSE_TAKE_FRAME
```

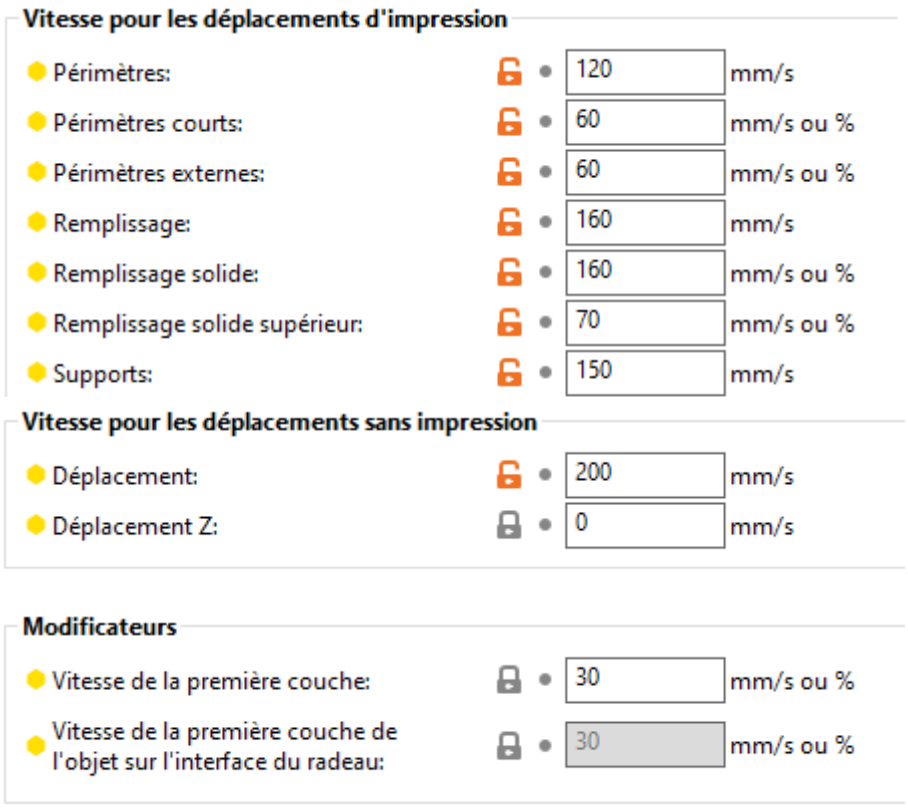


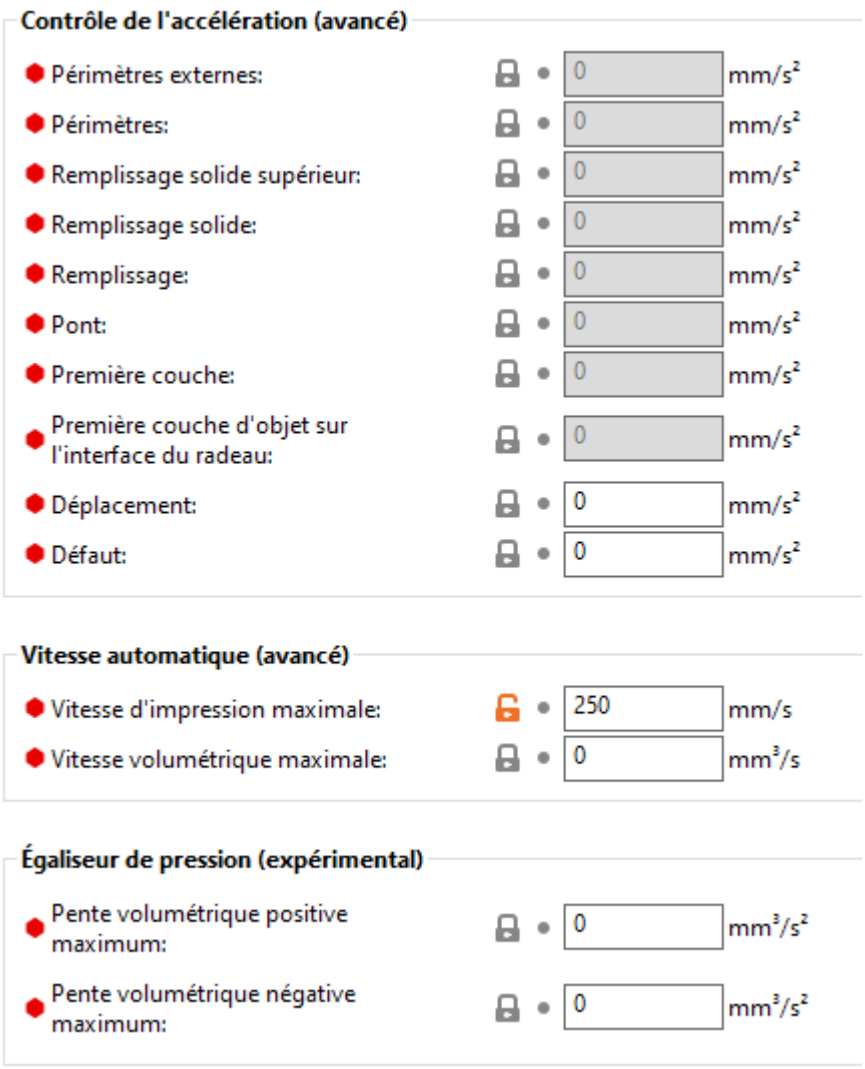
Print speeds:

here are the print speed settings I use, they work for me, above that a loss of quality is felt.

It's up to you to test and adjust them according to your printing environment (filament quality, nozzle quality, improvement of the printer made, input shapper calibrated or not, stability of the printer support, etc.)

These values are not to be taken literally, they are only for information and valid for MY print environment.





Keep in mind that there is no turnkey solution that will give you perfect prints,

that all the settings offered to you are only there to guide you in your handling of Klipper.

Only your experience and your tests will allow you to have optimum printing results.

Hope this tutorial has helped you...

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