

# Operating Announcements for E4 hotend

- Pre-load filaments.

Please following the below steps to pre-load all filaments used in the printing

Step 1: Manually load the filament into the position as shown Fig 1

Step 2: load 25mm filament on LCD screen (Fig 2).

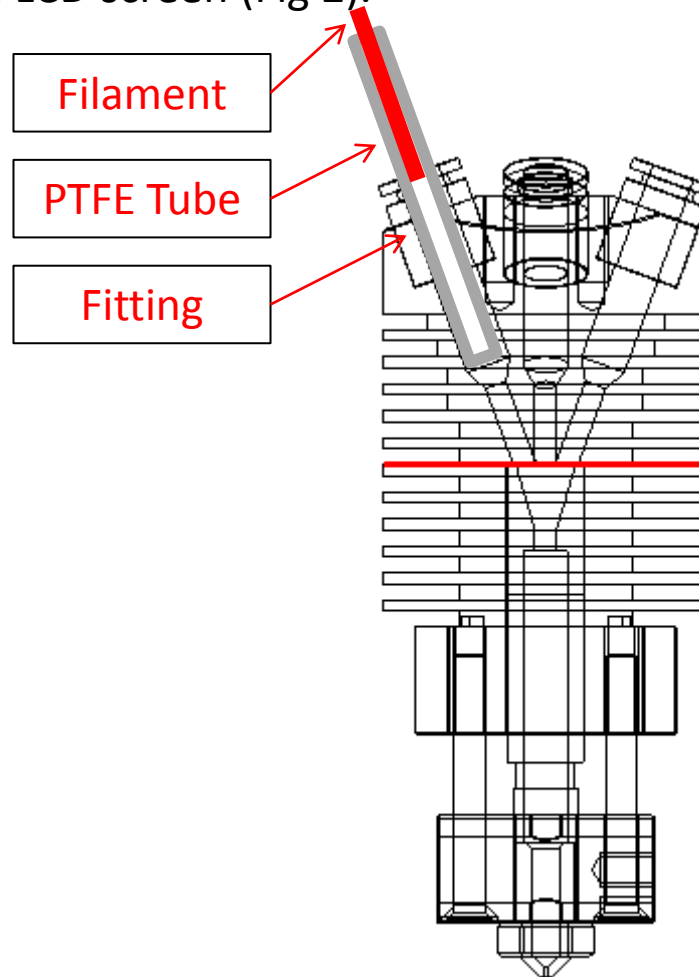
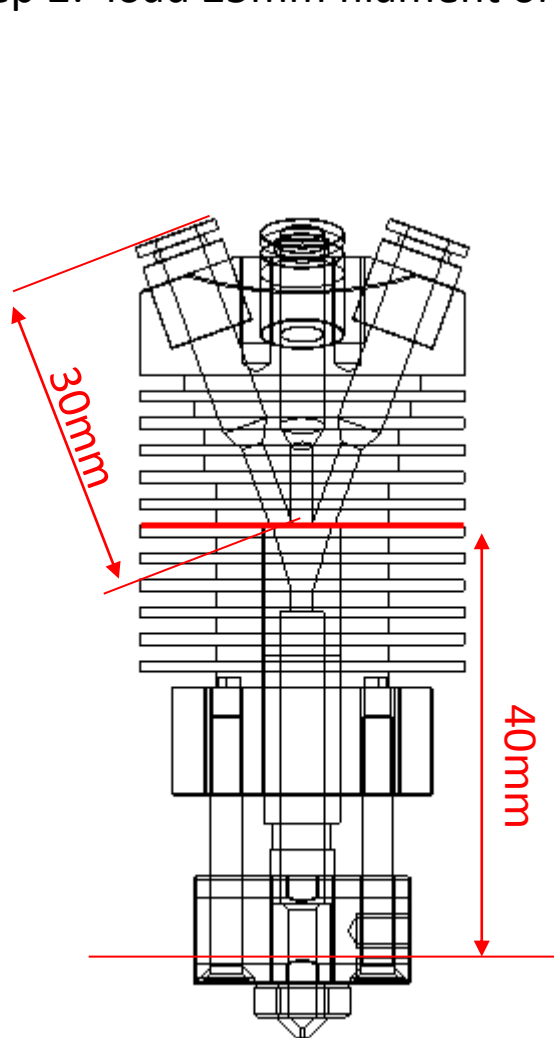


Fig 1

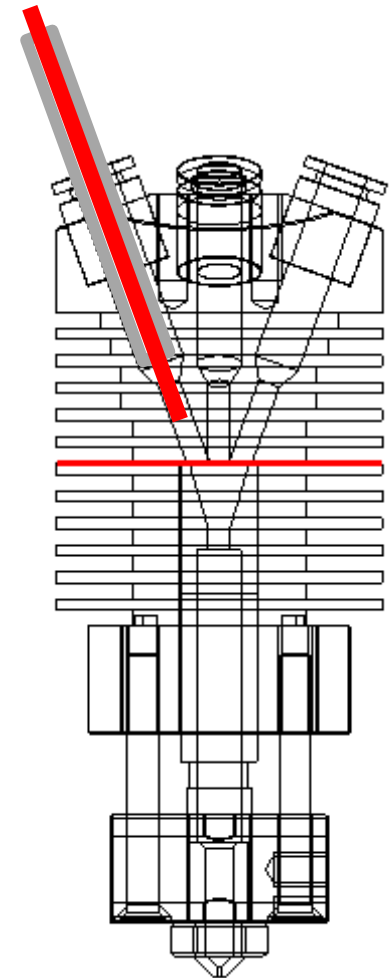


Fig 2

# Operating Announcements for E4 hotend

- **Add command into “start gcode” to load filament:**

Add the below gcode command into the “start gcode” of slicing software, so that the printer can load the filament into the nozzle.

;Load filament to nozzle

G92 E0

G1 E15 F60

G1 E40 F120

G1 E60 F60

G92 E0

; prime nozzle

G1 X5 Y10 F1500

G1 Z0.3 F3000

G92 E0

G1 Y250 E15 F600

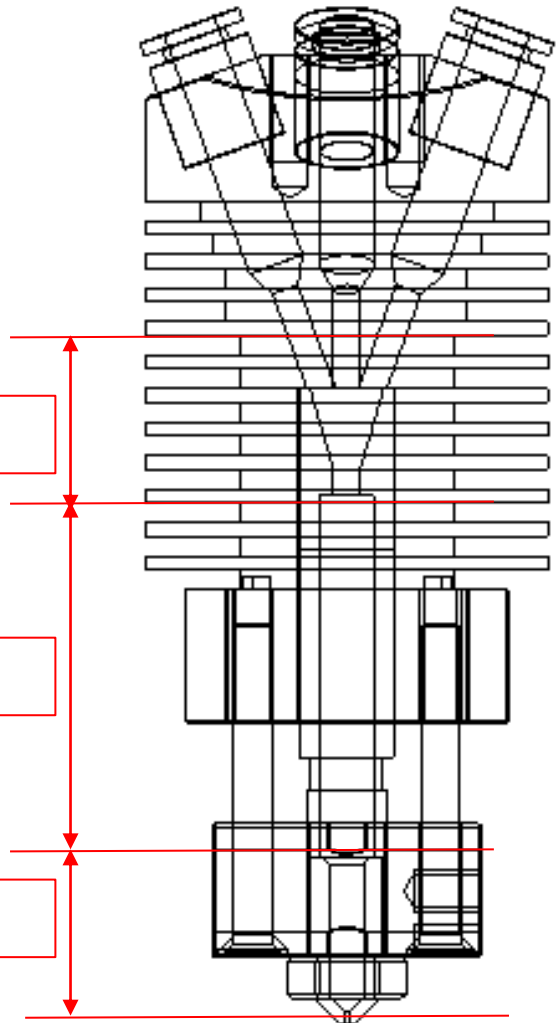
G1 Y100 F5000

G92 E0

stage 1

stage 2

stage 3



# Operating Announcements for E4 hotend

- **Add command into “end gcode” to unload filament:**

Add the below gcode command into the “start gcode” of slicing software, so that the printer can load the filament into the nozzle.

**;Unload filament**

**G1 E-15 F60**

**G1 E-40 F120**

**G1 E-60 F60**

**G92 E0**

## Start G-code

```
G28 ;Home
G1 Z15.0 F6000 ;Move the platform down 15mm
;Load filament to nozzle
G92 E0
G1 E15 F60
G1 E40 F120
G1 E60 F60
G92 E0
;Prime the nozzle
G1 X5 Y10 F1500
G1 Z0.3 F3000
G92 E0
G1 Y250 E15 F600
G1 Y100 F5000
G92 E0
```

## End G-code

```
M104 S0
M140 S0
;Retract the filament
G92 E0
G1 E-15 F60
G1 E-40 F120
G1 E-60 F60
G92 E0
G28 X0 Y0
M84
```

# Operating Announcements for E4 hotend

- When switch extruder, it need to load and unload filament too, so you need to add command into “Extruder start gcode ” and “Extruder end gcode” to all extruder settings.

**ZONESTAR E4**

Printer	Extruder 1	Extruder 2	Extruder 3	Extruder 4
<b>Nozzle Settings</b>				
Nozzle size		0.4 mm		
Compatible material diameter		1.75 mm		
Nozzle offset X		0 mm		
Nozzle offset Y		0 mm		
Cooling Fan Number		0		
<b>Extruder Start G-code</b>		<b>Extruder End G-code</b>		
G1 E15 F60 G1 E40 F120 G1 E60 F60		G1 E-15 F60 G1 E-40 F120 G1 E-60 F60		

**ZONESTAR E4**

Printer	Extruder 1	Extruder 2	Extruder 3	Extruder 4
<b>Nozzle Settings</b>				
Nozzle size		0.4 mm		
Compatible material diameter		1.75 mm		
Nozzle offset X		0 mm		
Nozzle offset Y		0 mm		
Cooling Fan Number		0		
<b>Extruder Start G-code</b>		<b>Extruder End G-code</b>		
G1 E15 F60 G1 E40 F120 G1 E60 F60		G1 E-15 F60 G1 E-40 F120 G1 E-60 F60		

**ZONESTAR E4**

Printer	Extruder 1	Extruder 2	Extruder 3	Extruder 4
<b>Nozzle Settings</b>				
Nozzle size		0.4 mm		
Compatible material diameter		1.75 mm		
Nozzle offset X		0 mm		
Nozzle offset Y		0 mm		
Cooling Fan Number		0		
<b>Extruder Start G-code</b>		<b>Extruder End G-code</b>		
G1 E15 F60 G1 E40 F120 G1 E60 F60		G1 E-15 F60 G1 E-40 F120 G1 E-60 F60		

**ZONESTAR E4**

Printer	Extruder 1	Extruder 2	Extruder 3	Extruder 4
<b>Nozzle Settings</b>				
Nozzle size		0.4 mm		
Compatible material diameter		1.75 mm		
Nozzle offset X		0 mm		
Nozzle offset Y		0 mm		
Cooling Fan Number		0		
<b>Extruder Start G-code</b>		<b>Extruder End G-code</b>		
G1 E15 F60 G1 E40 F120 G1 E60 F60		G1 E-15 F60 G1 E-40 F120 G1 E-60 F60		