Marlin

Here is the polar code section in "configuration.h" of Marlin bugfix 2.1.x. You can find all my modifications made (configuration.h and configuration_adv.h) by pressing "ctrl F" then "Polaris":

```cpp
#define POLAR //Polaris
#if ENABLED(POLAR)
  #define DEFAULT_SEGMENTS_PER_SECOND 120   //Polaris If movement is choppy try lowering this value
  #define PRINTABLE_RADIUS X_BED_SIZE          //Polaris (mm) Maximum travel of X axis

  // Movements fall inside POLAR_FAST_RADIUS are assigned the highest possible feedrate
  // to compensate unwanted deposition related to the near-origin motion problem.
  #define POLAR_FAST_RADIUS 1.5f            // (mm)

  // Radius which is unreachable by the tool.
  // Needed if the tool is not perfectly aligned to the center of the polar axis.
  #define POLAR_CENTER_OFFSET 0.0f          // (mm)

  #define FEEDRATE_SCALING                  //Polaris Convert XY feedrate from mm/s to degrees/s on the fly
#endif
```

WARNING !!!

The firmware for the TFT35 screen and the SKR E3 v3.0 motherboard is not provided because not having this hardware, I was not able to test it ! My version of the firmware is made for an LCD12864 screen and an Sbase v1.3 motherboard, so you will have to make modifications if you don't want use an Sbase/LCD12864