

The most current firmware solution for XChange is Marlin-bugfix-2.0.x, which has had revisions made by a Marlin firmware dev now merged into the official branch. The primary change is the ability to define M206 offsets while using Marlin's tool change functionality.

Tool presets are stored on the "auto0.g" file, which should be loaded to the printer's SD card (card should be inserted prior to powering the printer on).

The format for tool head configuration in auto0.g is as follows:

```
M810 M206 X0Y0Z0 | M92 E93 | M301 P21.3I1.54D76.55 | M204 P500 R500 T500  
| M900 K0.0 | M305 R4700 T100000 B4092; Stock Head
```

M81X - Tool number

M206 - Toolhead offset relative to zero

M92 - E-step calibration

M301 - PID calibration

M204 - Acceleration values

M900 - Linear Advance settings

M305 - Thermistor parameters

Please exercise caution when using this experimental firmware and tool changing configuration files. Be especially careful when attempting bed leveling, and ensure that Z safe homing is enabled. It is recommended to use only manual mesh bed leveling with XChange for now.