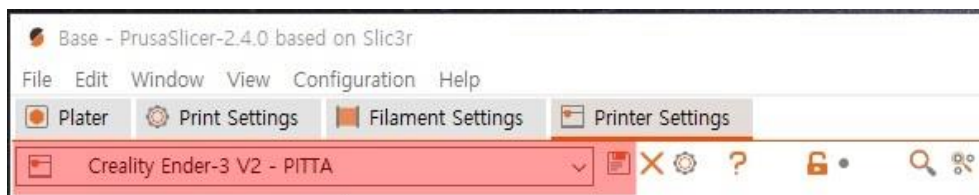


# PrusaSlicer Settings

## 1. Install PrusaSlicer

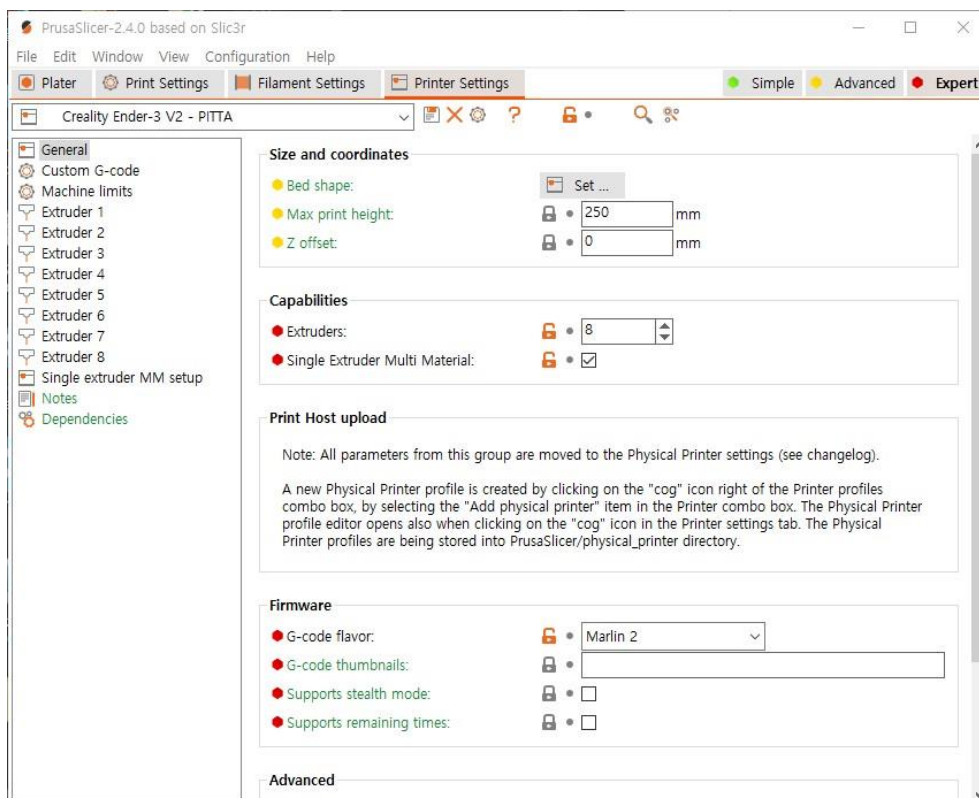
- Download PrusaSlicer from <https://github.com/prusa3d/PrusaSlicer/releases>
- Use PrusaSlicer 2.4.0
- When installing PrusaSlicer, add Printer(ex. Creality Ender-3 V2 ...), Filament(ex. Generic PLA ...)

2. Each time you change an option in each setting tab, the setting is renamed to a different name like as “\* - PITTA”.



## 3. Printer Settings

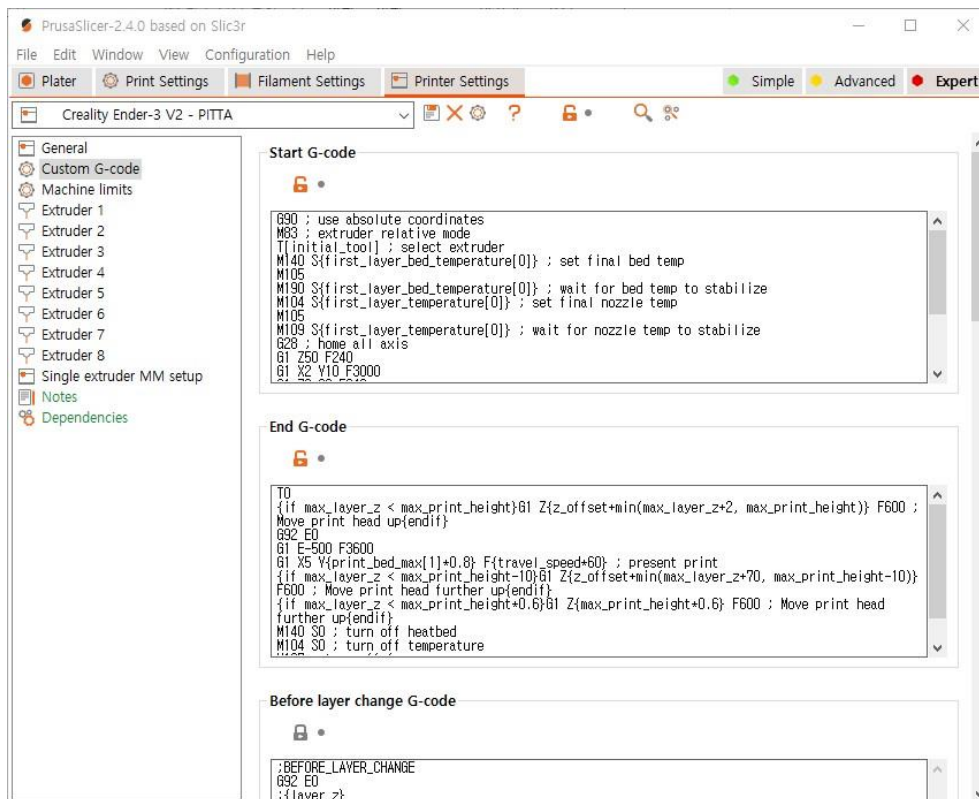
- General Option
  - Capabilities -> Extruders : 8, Single Extruder Multi Material : check
  - Firmware -> G-code flavor : Marlin 2



- Custom G-code

- Change to the Start G-code below

```
; Custom Start G code
G90 ; use absolute coordinates
M83 ; extruder relative mode
M140 S{first_layer_bed_temperature[0]} ; set final bed temp
M105
M104 S{first_layer_temperature[0]} ; set final nozzle temp
M105
M190 S{first_layer_bed_temperature[0]} ; wait for bed temp to stabilize
M109 S{first_layer_temperature[0]} ; wait for nozzle temp to stabilize
G92 E0
G28 ; home all axis
G1 Z5.0 F240
G1 X2 Y10 F3000
T[initial_tool] ; select extruder
G1 Z0.28 F240
G92 E0
G1 Y140 E10 F1500 ; prime the nozzle
G1 X2.3 F5000
G92 E0
G1 Y10 E10 F1200 ; prime the nozzle
G92 E0
```

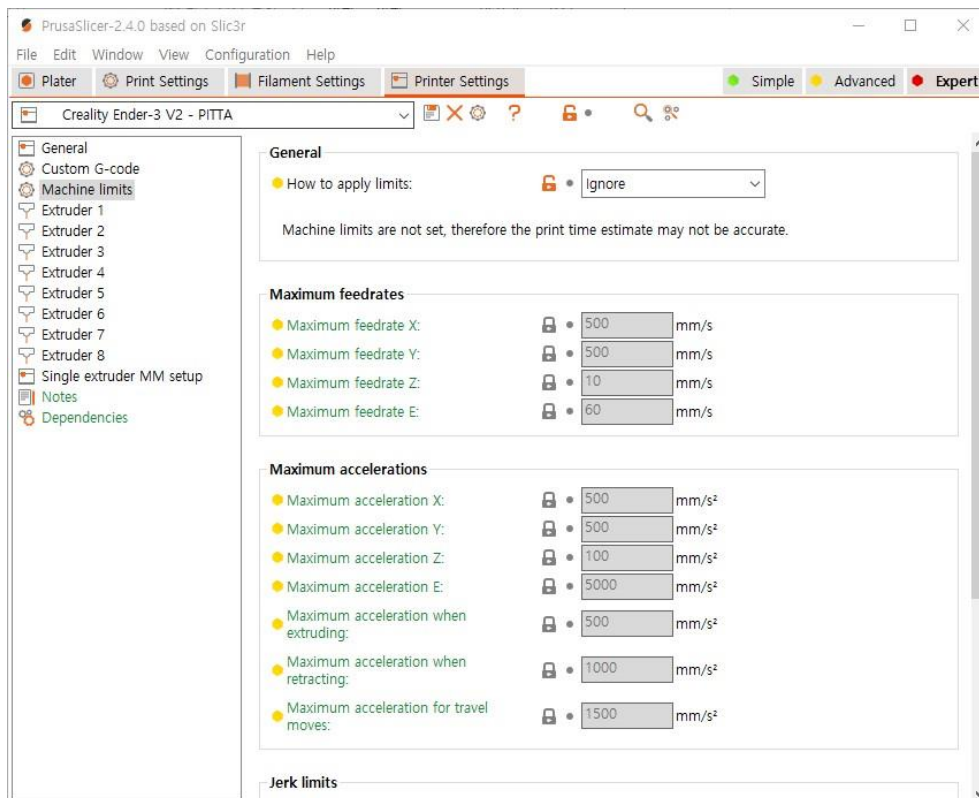


- Change to the End G-code below

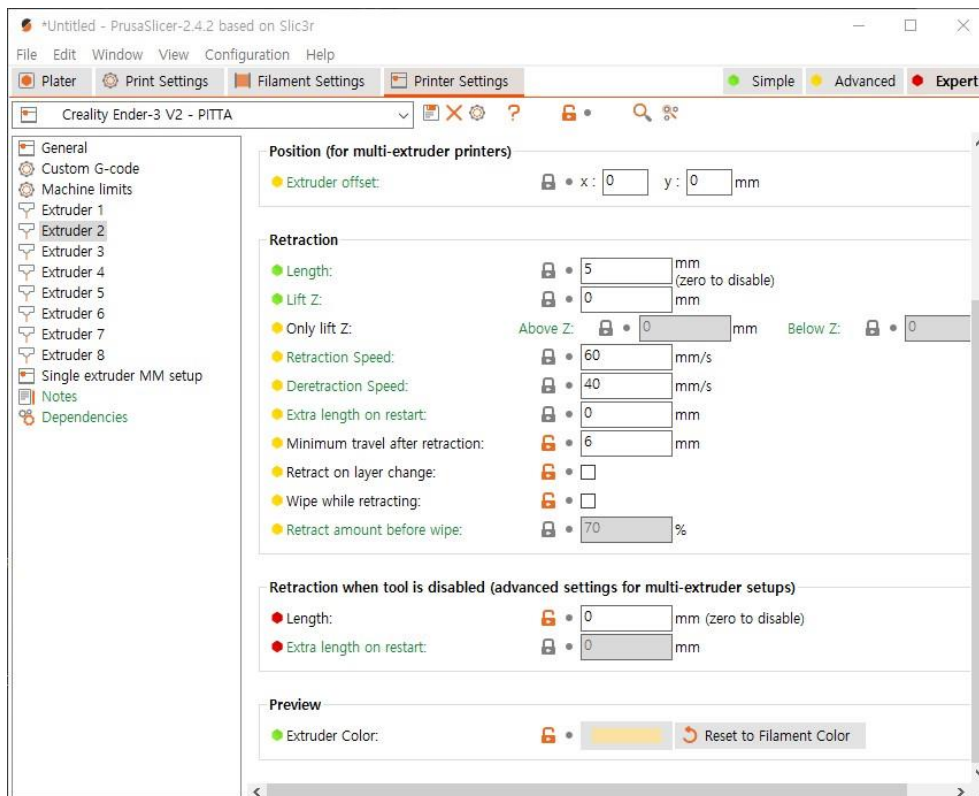
```
; Custom End G code
T0 ; reset extruder to 0
{if max_layer_z < max_print_height}G1 Z{z_offset+min(max_layer_z+2, max_print_height)} F600 ;
Move print head up{endif}
G92 E0
G1 E-500 F3600 ; Last Retraction
G1 X5 Y{print_bed_max[1]*0.8} F{travel_speed*60} ; present print
{if max_layer_z < max_print_height-10}G1 Z{z_offset+min(max_layer_z+50, max_print_height-10)}
F600 ; Move print head further up{endif}
M140 S0 ; turn off heatbed
M104 S0 ; turn off temperature
M107 ; turn off fan
M84 X Y E ; disable motors
```

- Machine limits

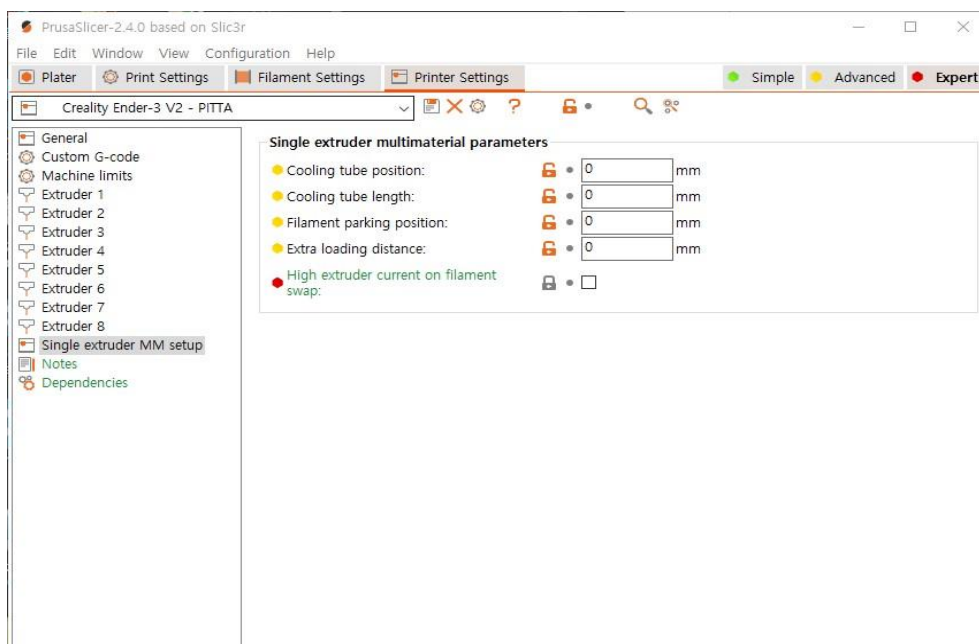
- General -> How to apply limits : Ignore



- Extruder 1 ~ 8 (Option values can be changed according to printer characteristics)
  - Retraction -> Length : 5, Minimum travel after retraction : 6



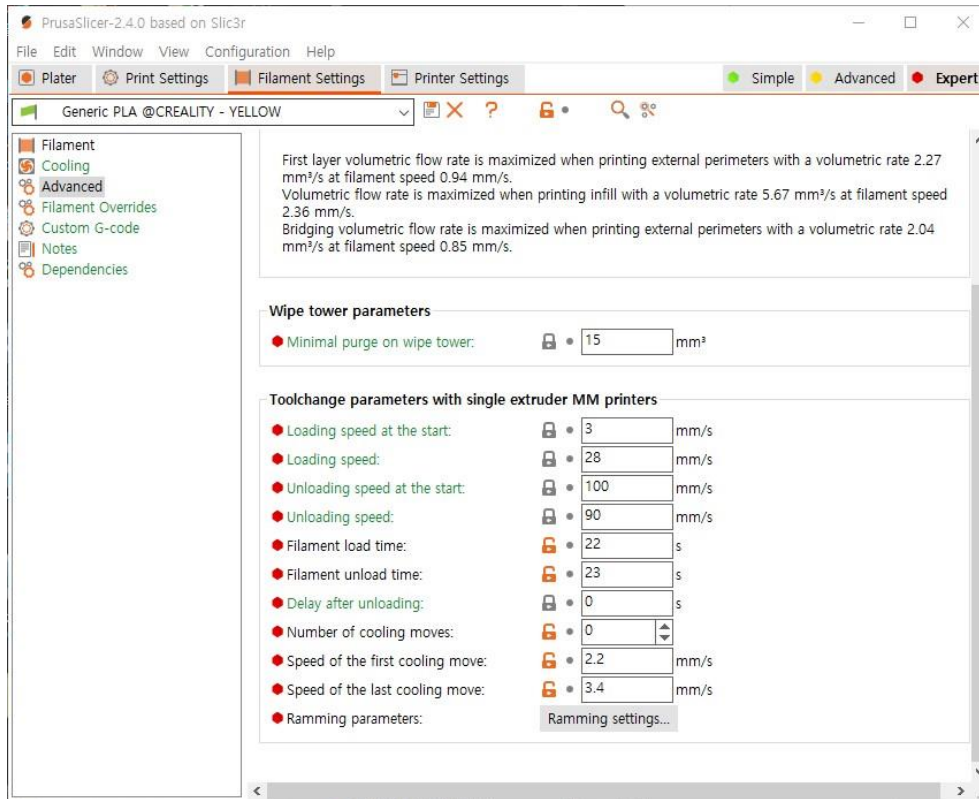
- Single extruder MM setup
  - Cooling tube position -> 0
  - Cooling tube length -> 0
  - Filament parking position -> 0
  - Extra loading distance -> 0



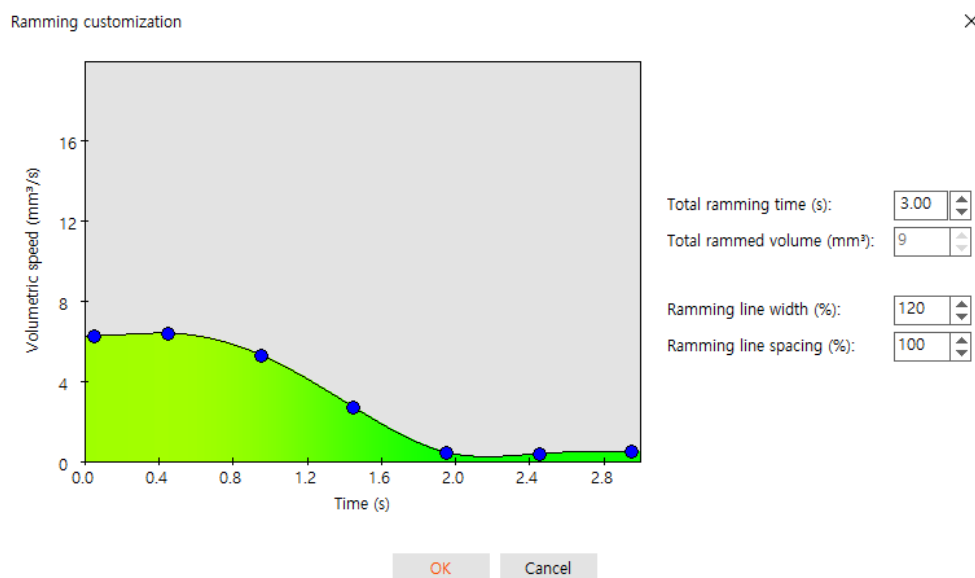
#### 4. Filament Settings

- Advanced -> Toolchange parameters with single extruder MM printers

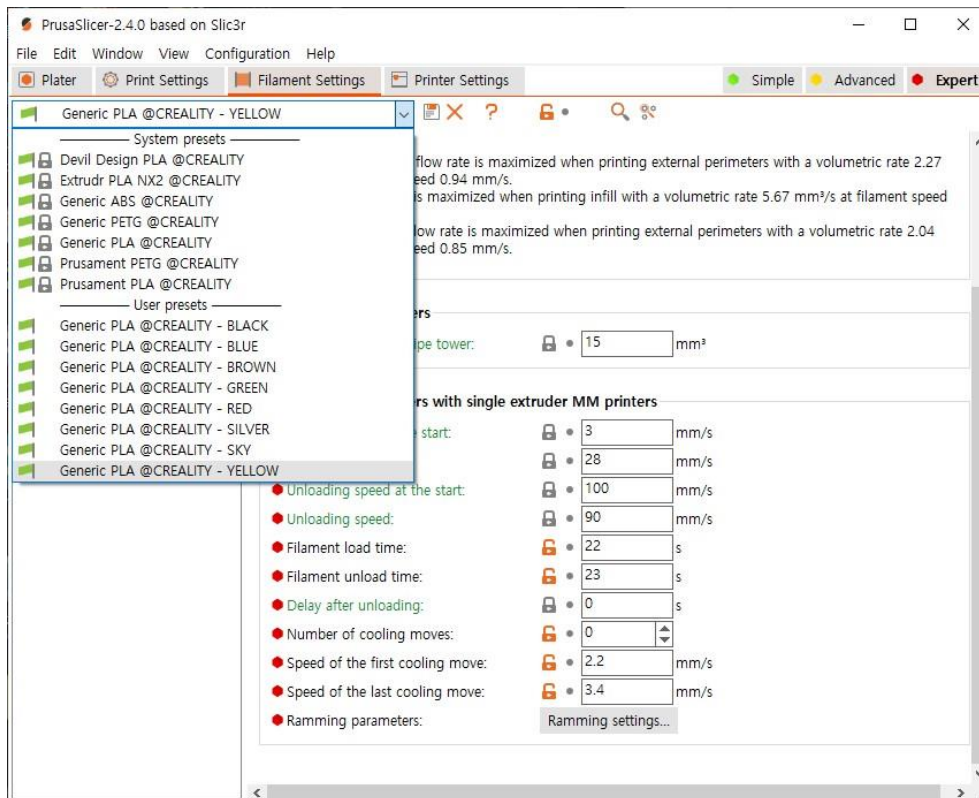
- Filament load time -> 22
- Filament unload time -> 23
- Number of cooling move -> 0



- Recommended Ramming parameters

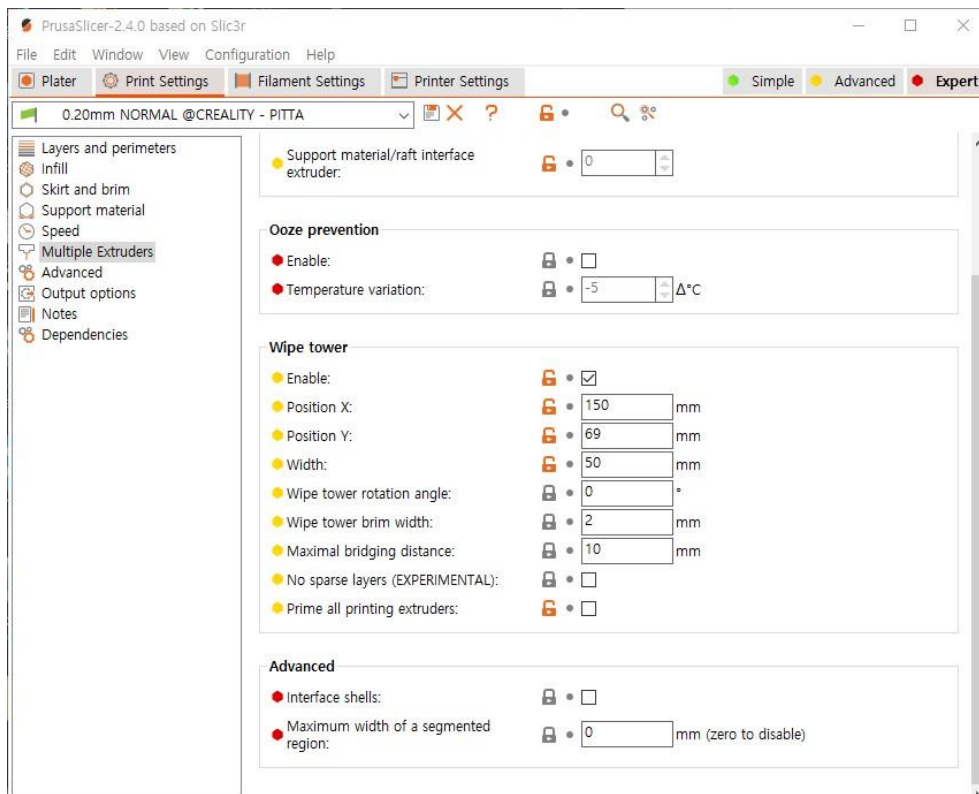


- Add filament color to distinguish filaments when printing in 8 colors (Optional if using filaments with the same characteristics)



## 5. Print Settings

- Multiple Extruders
  - Wipe tower -> Enable, Position X, Position Y, Width





## 6. Change Purging volumes according to the 3D model

