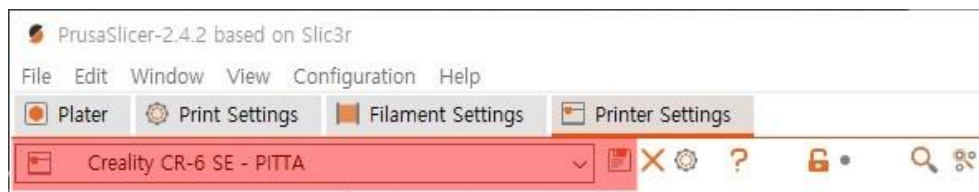


PrusaSlicer Settings for CR-6 SE

1. Install PrusaSlicer

- Download PrusaSlicer from <https://github.com/prusa3d/PrusaSlicer/releases>
- Use PrusaSlicer 2.4.2
- When installing PrusaSlicer, add Printer(ex. Creality CR-6 SE ...), Filament(ex. Generic PLA ...)

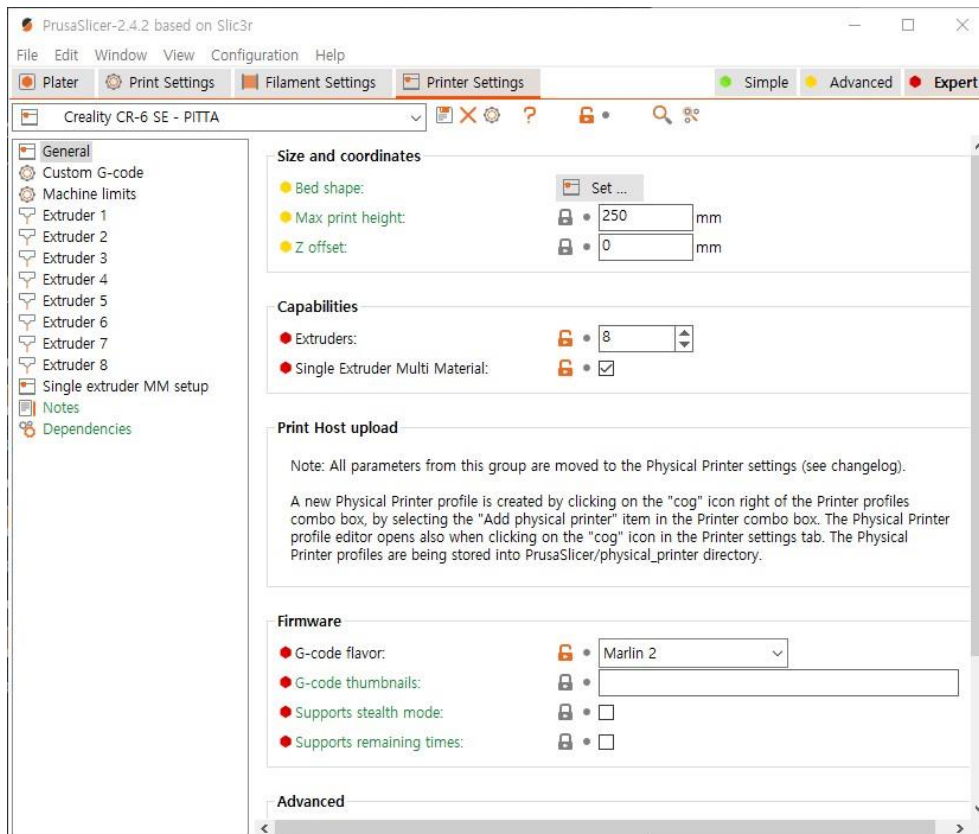
2. Each time you change an option in each setting tab, the setting is renamed to a different name like as “* - PITTA”.



3. The settings can be modified by the user according to the 3D printer and 3D model.

4. 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

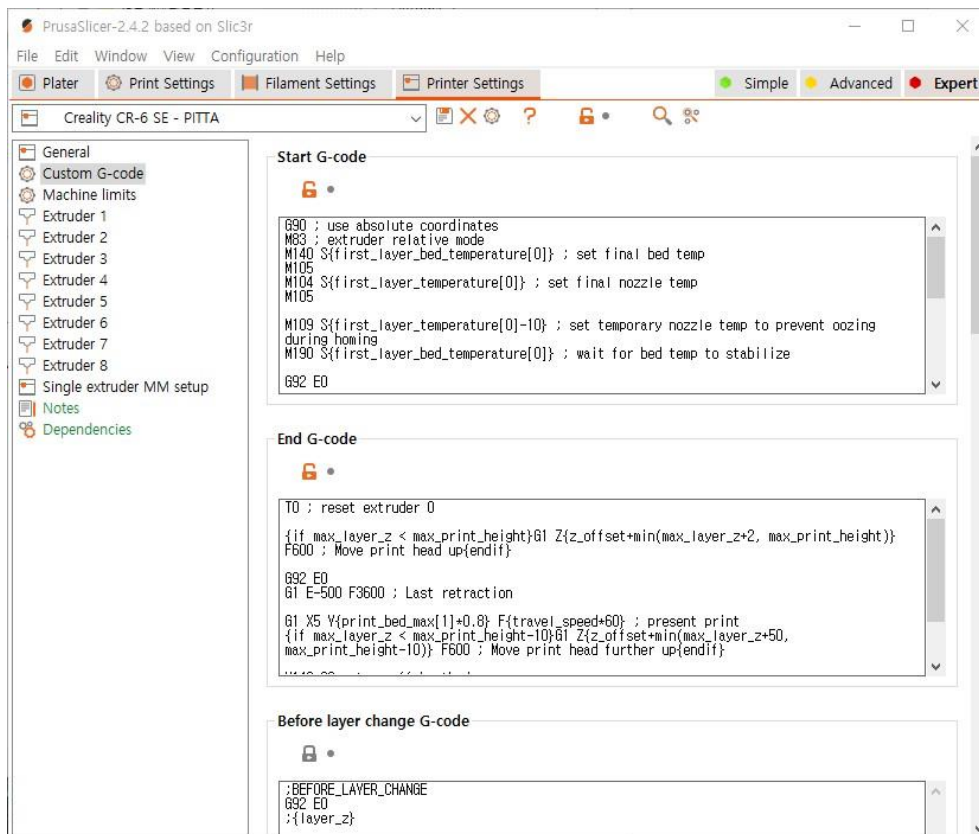
M109 S{first_layer_temperature[0]-10} ; set temporary nozzle temp to prevent oozing
during homing
M190 S{first_layer_bed_temperature[0]} ; wait for bed temp to stabilize

G92 E0

G28 ; home all axis
G1 Z5.0 F240
G1 X2 Y10 F3000
M109 S{first_layer_temperature[0]} ; wait for nozzle temp to stabilize

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 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}

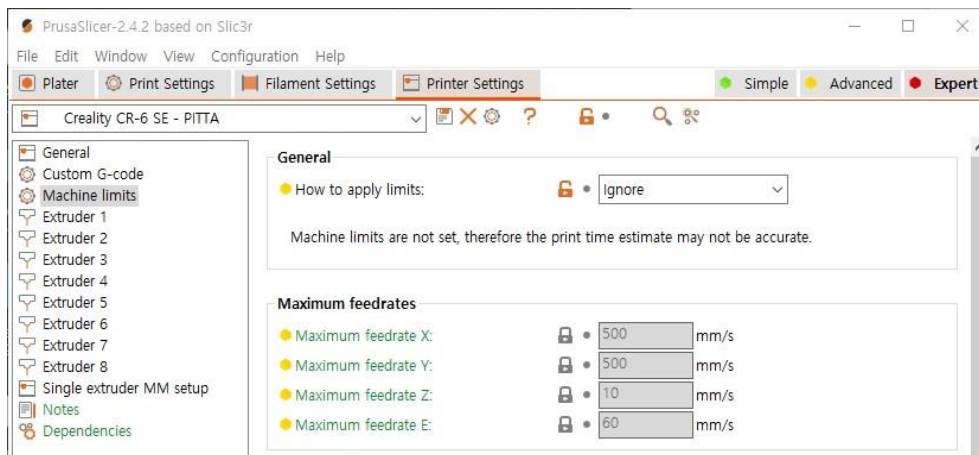
G92 E0
G1 E-500 F3600 ; Last retraction

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
```

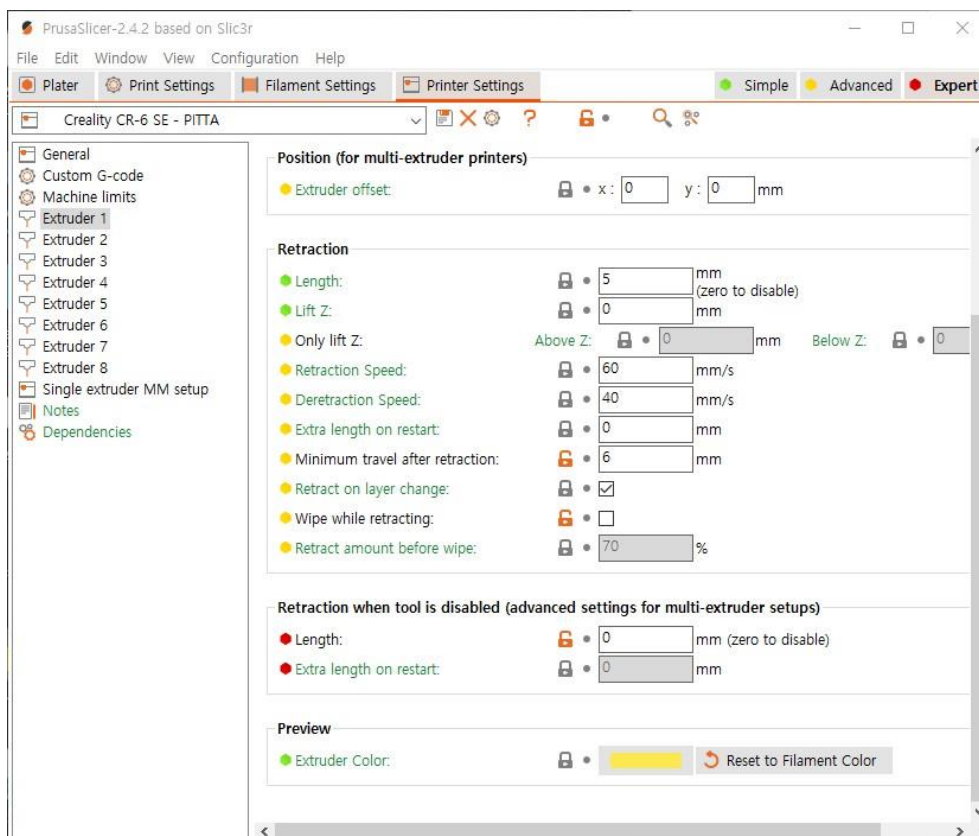
- Machine limits

- General -> How to apply limits : Ignore

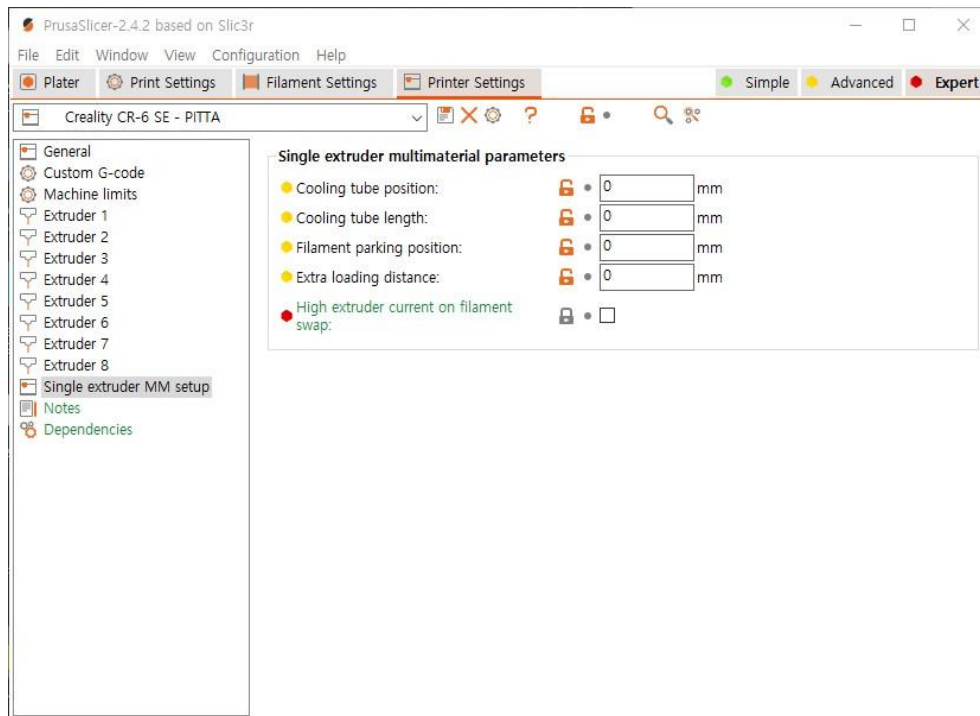


- Extruder 1 ~ 8 (Option values can be changed according to printer characteristics)

- Retraction -> Length : 5
- Retraction -> Minimum travel after retraction : 6
- Retraction -> Wipe while retracting : uncheck
- Retraction when tool is disabled -> Length : 0
- Preview -> Extruder Color : Changed to a random color to distinguish the extruder



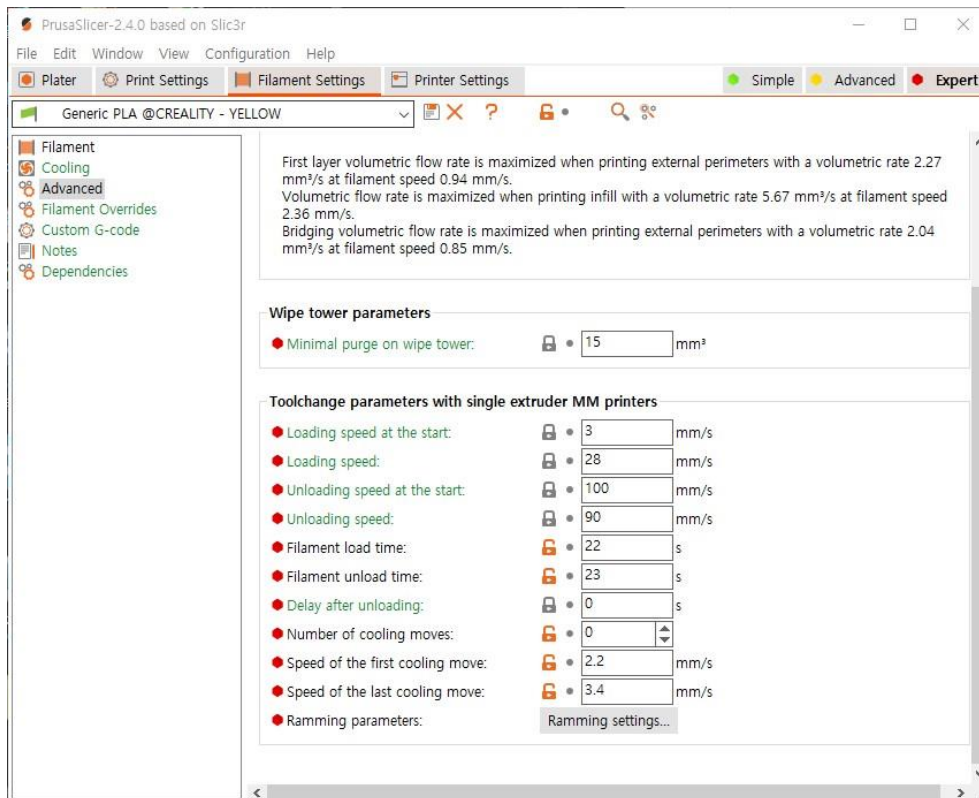
- Single extruder MM setup
 - Cooling tube position -> 0
 - Cooling tube length -> 0
 - Filament parking position -> 0
 - Extra loading distance -> 0



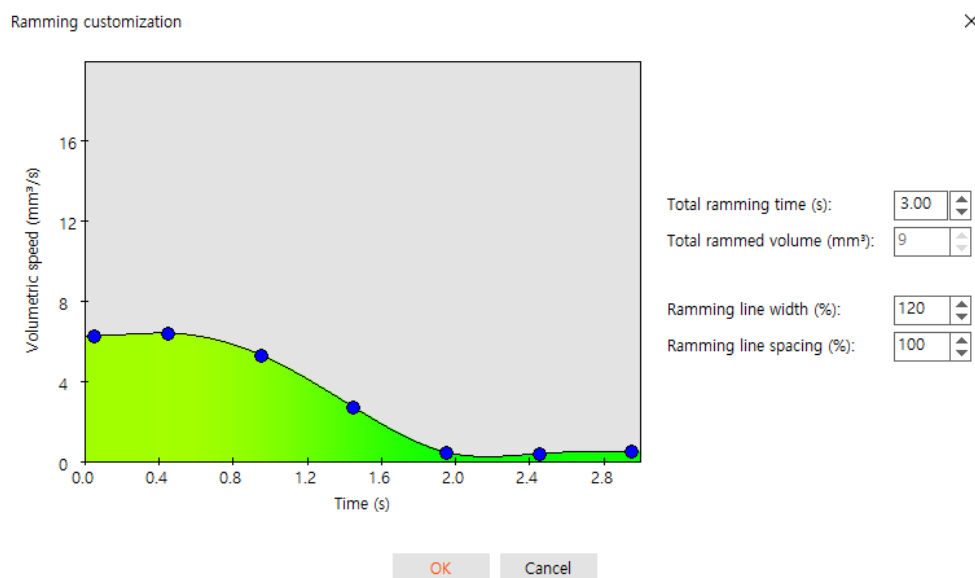
5. Filament Settings

- Advanced -> Toolchange parameters with single extruder MM printers

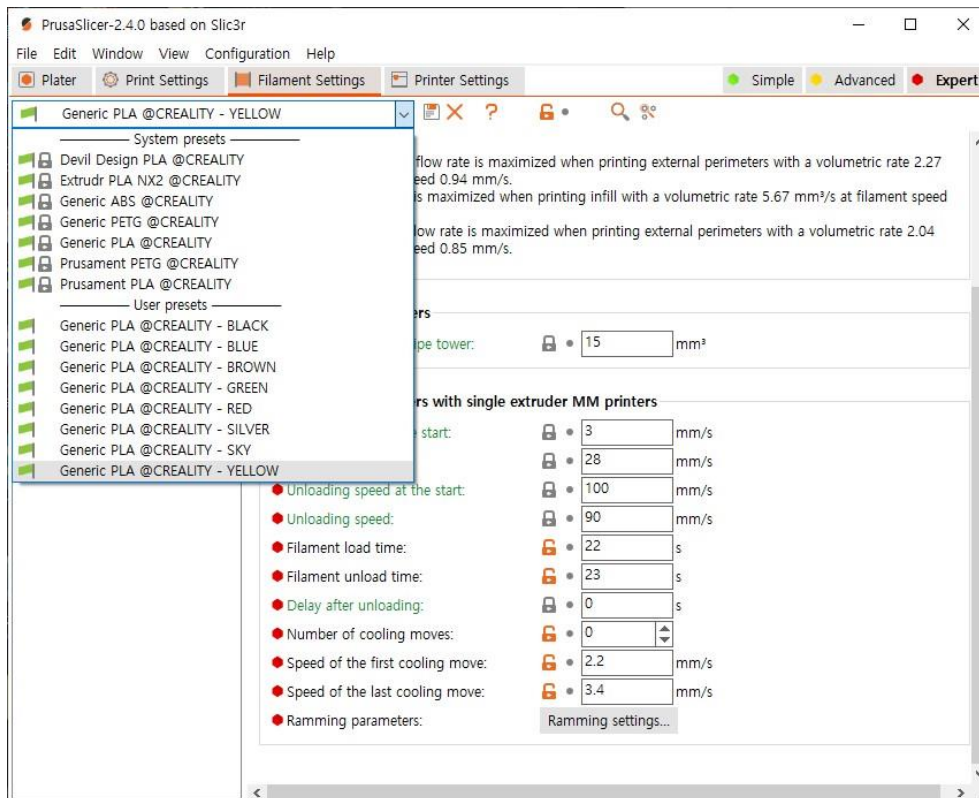
- Filament load time -> 22
- Filament unload time -> 23
- Number of cooling move -> 0



- Recommended Ramming parameters

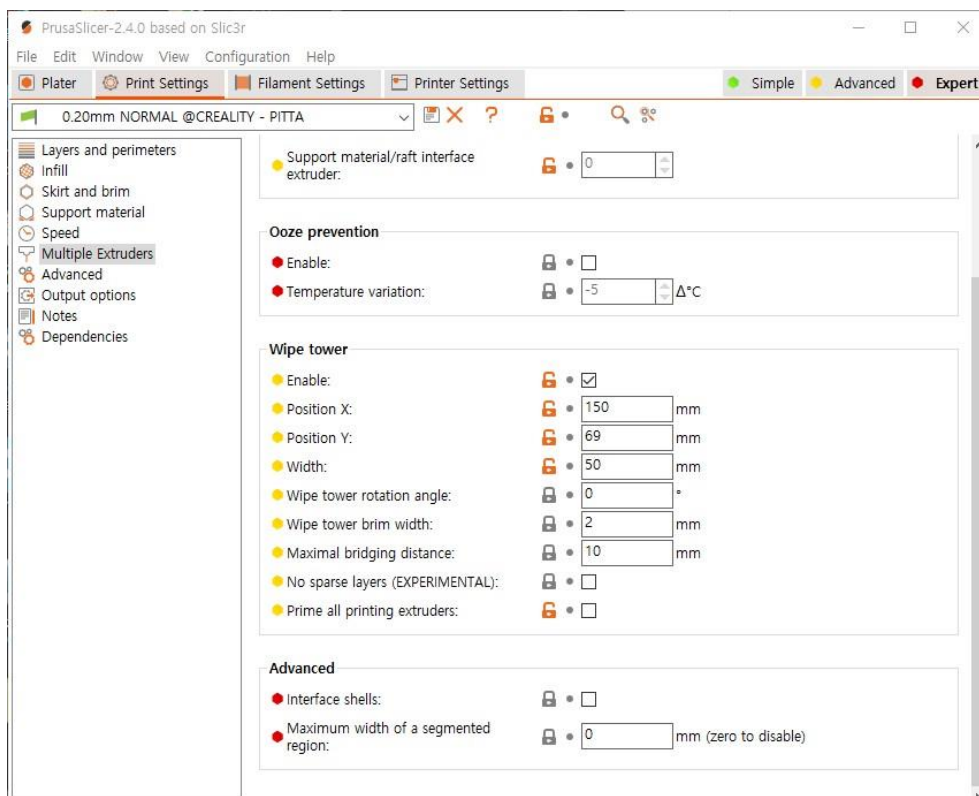


- Add filament color to distinguish filaments when printing in 8 colors (Optional if using filaments with the same characteristics)

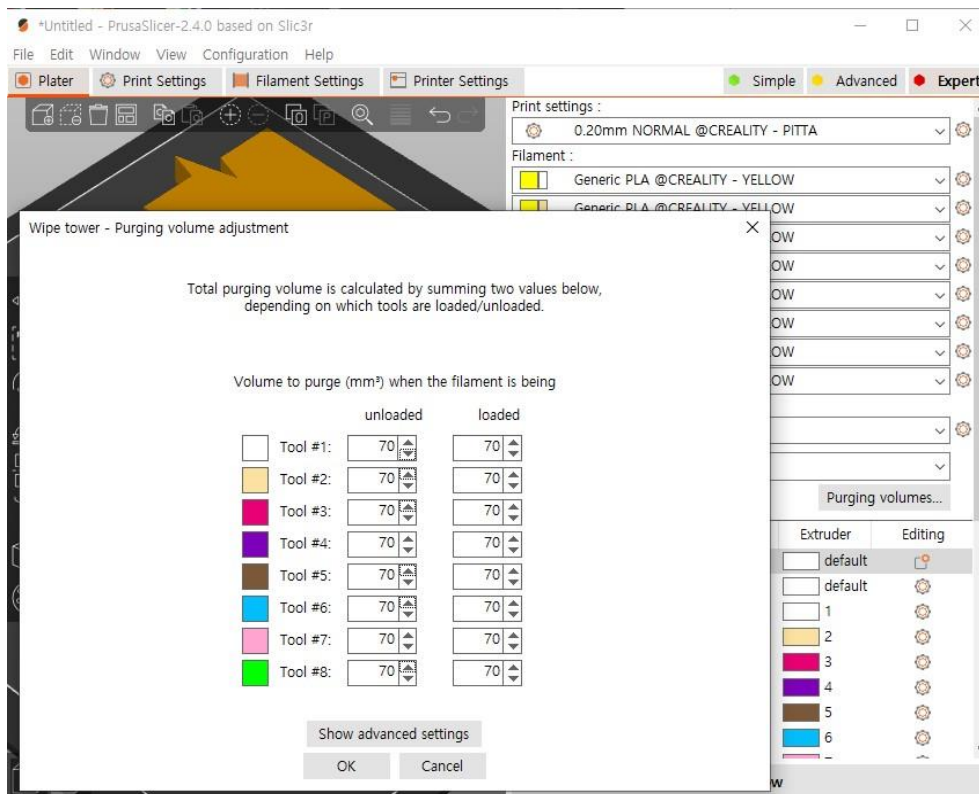


6. Print Settings (Applied to each print quality preset)

- Multiple Extruders
 - Wipe tower -> Enable



7. Change Purging volumes according to the 3D model



8. Completion of setting If the setting has been saved normally, the Prusa Slicer screen will appear as shown below. And the setting presets in the upper right corner of the screen should be user presets of the modified settings.

