

Back-end		Remark
Python code	Added Function	
bed_thermal_adjust.py	M140	Set Bed Temperature
	M190	Set Bed Temperature and Wait
config_switch.py	SAVE_CONFIG_MODE	Save session variables, marked in printer.cfg
	TOGGLE_CONFIG_MODE	Toggle saved session variable in printer.cfg
rounded_path.py	ROUNDED_G0	Rounded paths for fast travel
tool.py	ASSIGN_TOOL	Assign tool to tool number
toolchanger.py	INITIALIZE_TOOLCHANGER	Initialize the toolchanger
	RESET_TOOL_PARAMETER	[deprecated] It is not recommended to create and save a tool parameter via the console.
	SAVE_TOOL_PARAMETER	[deprecated] It is not recommended to create and save a tool parameter via the console.
	SELECT_TOOL	Select active tool
	SELECT_TOOL_ERROR	[deprecated] Abort tool change and mark the active toolchanger as failed. This command will cause Klipper shutdown.
	SET_TOOL_PARAMETER	[deprecated] It is not recommended to create and save a tool parameter via the console.
	SET_TOOL_TEMPERATURE	Set temperature for tool
	TEST_TOOL_DOCKING	Unselect active tool and select it again
	UNSELECT_TOOL	Unselect active tool without selecting a new one
tool_probe.py		Provide functions for other back-end code blocks
tool_probe_endstop.py	DETECT_ACTIVE_TOOL_PROBE	Detect which tool is active by identifying a probe that is NOT triggered
	SET_ACTIVE_TOOL_PROBE	Set the tool probe that will act as the Z endstop
	START_TOOL_PROBE_CRASH_DETECTION	Start detecting tool crashes
	STOP_TOOL_PROBE_CRASH_DETECTION	Stop detecting tool crashes
tools_calibrate.py	TOOL_CALIBRATE_PROBE_OFFSET	Calibrate the tool probe offset to nozzle tip
	TOOL_CALIBRATE_QUERY_PROBE	Return the state of calibration probe
	TOOL_CALIBRATE_SAVE_TOOL_OFFSET	Save tool offset calibration to config folder
	TOOL_CALIBRATE_TOOL_OFFSET	Calibrate current tool offset relative to tool 0
	TOOL_LOCATE_SENSOR	Locate the tool calibration sensor

File	G-code	Remark
config_switch.cfg	[gcode_macro CONFIG_TOGGLE]	Save current configuration, and toggle between the configuration with-dock and without-dock.
homing.cfg	[force_move]	Enable the ability to force the printer to move without being homed.
	[homing_override]	Override the default homing routine.
	[gcode_macro _ADJUST_Z_HOME_FOR_TOOL_OFFSET]	Correct the physical Z endstop offset, relative to T0.
	[gcode_macro _APPLY_ACTIVE_TOOL_GCODE_OFFSETS]	Apply active tool gcode offsets.
nozzle_clean.cfg	[gcode_macro CLEAN_NOZZLE]	description: [TOOL=<index>] Leave empty to clean active tool. Set tool number for specific tool. Set "A" or "a" to clean all tools.
	[gcode_macro _SCRUB]	Back-end function for CLEAN_NOZZLE / _CLEAN_MID_PRINT
	[gcode_macro _CLEAN]	
	[gcode_macro _CLEAN_MID_PRINT]	Clean active tool, mid print.
offsets_adjust_record.cfg	TBD	[In development]
overwrite.cfg	[gcode_macro M104]	description: [T=<index>] [S<temperature>] Set tool temperature. T= Tool number, optional. If this parameter is not provided, the current tool is used. S= Target temperature
	[gcode_macro M109]	description: [T=<index>] [S<temperature>] Set tool temperature and wait. T= Tool number, optional. If this parameter is not provided, the current tool is used. S= Target temperature
	[gcode_macro M106]	description: Override "M106" to allow multiple extruders. T= Tool number, optional. If this parameter is not provided, the current tool is used. S= Target temperature
	[gcode_macro M107]	description: Override "M107" to allow multiple extruders. T= Tool number, optional. If this parameter is not provided, the current tool is used.
	[gcode_macro BED_MESH_CALIBRATE]	description: [BASE_BED_MESH_CALIBRATE ADAPTIVE=1] But, accounting for tool_z_offset.
	[gcode_macro QUAD_GANTRY_LEVEL]	Check calibration probe and initialise toolhead before QGL.
	[gcode_macro _CPI_CHECK]	Back-end function for QUAD_GANTRY_LEVEL
	[gcode_macro _QGL]	
print_time_default.cfg	[gcode_macro PRINT_START]	Print time macros
	[gcode_macro PRINT_END]	
	[gcode_macro PAUSE]	
	[gcode_macro RESUME]	
	[gcode_macro CANCEL_PRINT]	
	[gcode_macro _TOOLCHANGER_TURN_OFF_FANS]	Back-end function for PRINT_END
tool_calibrate.cfg	[gcode_macro CALIBRATE_OFFSETS]	description: [TOOL=<index>] Offsets calibration
	[gcode_macro CALIBRATE_ABSOLUTE_Z]	description: [TOOL=<index>] Absolute z offset calibration, in reference to the bed. This function is for calibration probes that can't be used for the calibration of the absolute z.
	_CALIBRATE_ABSOLUTE_Z_VARIABLE	Back-end functions for CALIBRATE_ABSOLUTE_Z. It has to be done this way to overcome some Klipper quirks with handling variables.
	_PROBE_START	
	_PROBE_TOOL	
	_PROBE_CENTRE	
	_RECORD_CURRENT_POSITION	
	_RECORD_PROBE_DEVIATION	
	_CALCULATE_Z_OFFSET	
	_SAVE_Z_OFFSET	
	_CALIBRATE_MOVE_OVER_PROBE	
	[gcode_macro _CHECK_PROBE]	Back-end functions for CALIBRATE_OFFSETS.
	[gcode_macro _CALIBRATE_OFFSETS]	
toolchanger.cfg	[gcode_macro _fan_speed]	Back-end function for _BEFORE_SELECT_TOOL
	[gcode_macro _BEFORE_SELECT_TOOL]	description: [TOOL=<index>] routine to be completed before SELECT_TOOL. Including: - part fan control
	[gcode_macro _AFTER_SELECT_TOOL]	description: [TOOL=<index>] routine to be completed after SELECT_TOOL. including: - check for tool-change failures - turning on/off crash detection - restore position
	[gcode_macro _TOOL_BEFORE_CHANGE]	Back-end function for SELECT_TOOL. description: [TOOL=<index>]
	[gcode_macro _TOOL_AFTER_CHANGE]	
	[gcode_macro _TOOL_DROPOFF]	
	[gcode_macro _TOOL_PICKUP]	
	[gcode_macro _print_time]	Print time static variables
	[gcode_macro _TAP_PROBE_ACTIVATE]	Prevent probing if the nozzle is too hot
	[gcode_macro _INITIALIZE_FROM_DETECTED_TOOL]	Initial from detected tool
	[gcode_macro _TOOLCHANGER_CRASH]	Crash routine.

* Unlike macros in other files, these are all back-end functions, either for each others or for the relevant section in misschanger_settings.cfg