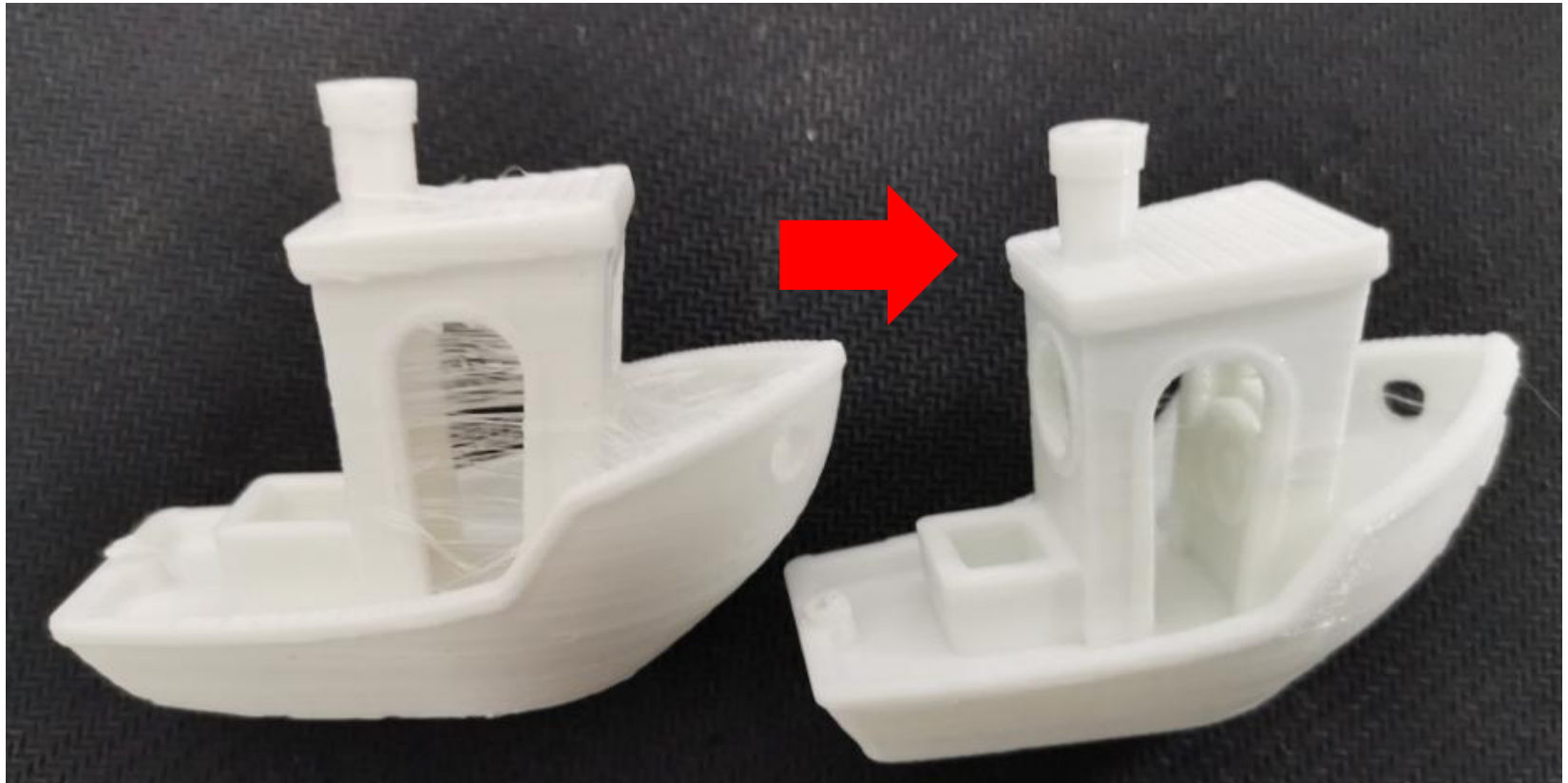




How to improve the Mixing Color hotend Stringing/Oozing issue



How to improve the M3/M4 hotend stringing or Oozing

Step 1: Load the filaments to all the extruders.

PS1: You can load filaments only two extruders too. The more channels you load filaments, the effect if the better.

PS2: The channel without filaments should be closed with hot end clean tool.

Step 2: Set Auto-Retract to On , and set the relevant parameters such as Retraction distance and Retraction speed.

```
Configuration      ↑
Auto-Retract:      On
Retract mm:        +008.00
Retract V:         15
Hop mm:            +000.00
```

```
Retract mm:        +008.00
Retract V:         15
Hop mm:            +000.00
Unretr. mm:        +000.00
Unretract V:       10
```

Retract mm: 8~10

Unretr. mm: 0

Retract V: 10~20

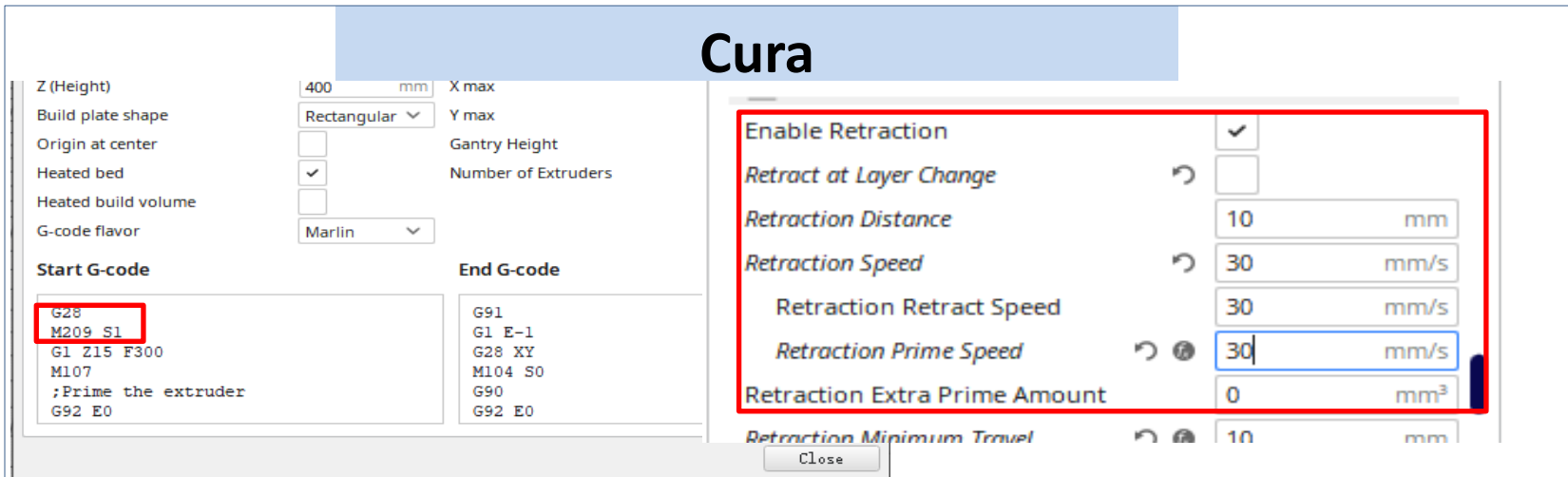
Unretr. mm: 8~15

Hop mm: 0~1 (set to 0 if you have set the Z hop in slicing setting)

How to improve the Mixing Color hotend stringing or Oozing

You can also add a M209 command in the “start gcode” of slicing software

1. Add a “**M209 S1**” command on the start code
2. Enable Retraction and set the retraction distance to 8~10mm and retraction speed to 30mm/s



How to improve the Mixing Color hotend stringing or Oozing

Repetier-HOST

Speed and Quality | Structures | Extrusion | **G-Codes** | Advanced

Start G-Code
End G-Code
Before Extruder Switch
After Extruder Switch

Create Default

You can add dynamic values, that get replaced during slicing.

Temperatures:
{TEMP0}, {TEMP1}
{BED}

```
; Default start code
G28 ; Home extruder
M209 S1; Firmware retraction
G1 Z15 F{Z_TRAVEL_SPEED}
M107 ; Turn off fan
G90 ; Absolute positioning
M82 ; Extruder in absolute mode
{IF_BED}M190 S{BED}
; Activate all used extruder
{IF_EXT0}M104 TO S{TEMP0}
G92 E0 ; Reset extruder position
; Wait for all used extruders to
{IF_EXT0}M109 TO S{TEMP0}
```

Speed and Quality | Structures | **Extrusion** | G-Codes | Advanced

General Extruder Settings

☐ Spiralize Contour ☒ Enable Retraction

Retraction Speed: 30 [mm/s]
Retraction Distance: 8 [mm]
Minimum Travel before Retract: 5 [mm]
Minimum Extrusion before Retract: 0.5 [mm]
Z Hop: 0 [mm]
Cut off Object Bottom: 0 [mm]
Nozzle Diameter: 0.4 [mm or 0 = use va]

Simplify 3D

Extruder | Layer | Additions | Infill | Support | Temperature | Cooling | G-Code | **Scripts** | Speeds | Other | Advanced

Starting Script | Layer Change Script | Retraction Script | Tool Change Script | Ending Script

```
G28 ; home all axes
M209 S1
G1 Z5 F3000 ; lift
G1 X5 Y10 F1500 ; move to prime
G1 Z0.2 F3000 ; get ready to prime
G92 E0 ; reset extrusion distance
G1 Y150 E15 F600 ; prime nozzle
G1 Y100 F5000 ; quick wipe
```

Add Extruder

Retraction

☒ Retraction Retraction Distance 8.00 mm
Extra Restart Distance 0.15 mm
Retraction Vertical Lift 0.00 mm
Retraction Speed 30.0 mm/s
☐ Coast at End Coasting Distance 0.20 mm
☒ Wipe Nozzle Wipe Distance 5.00 mm