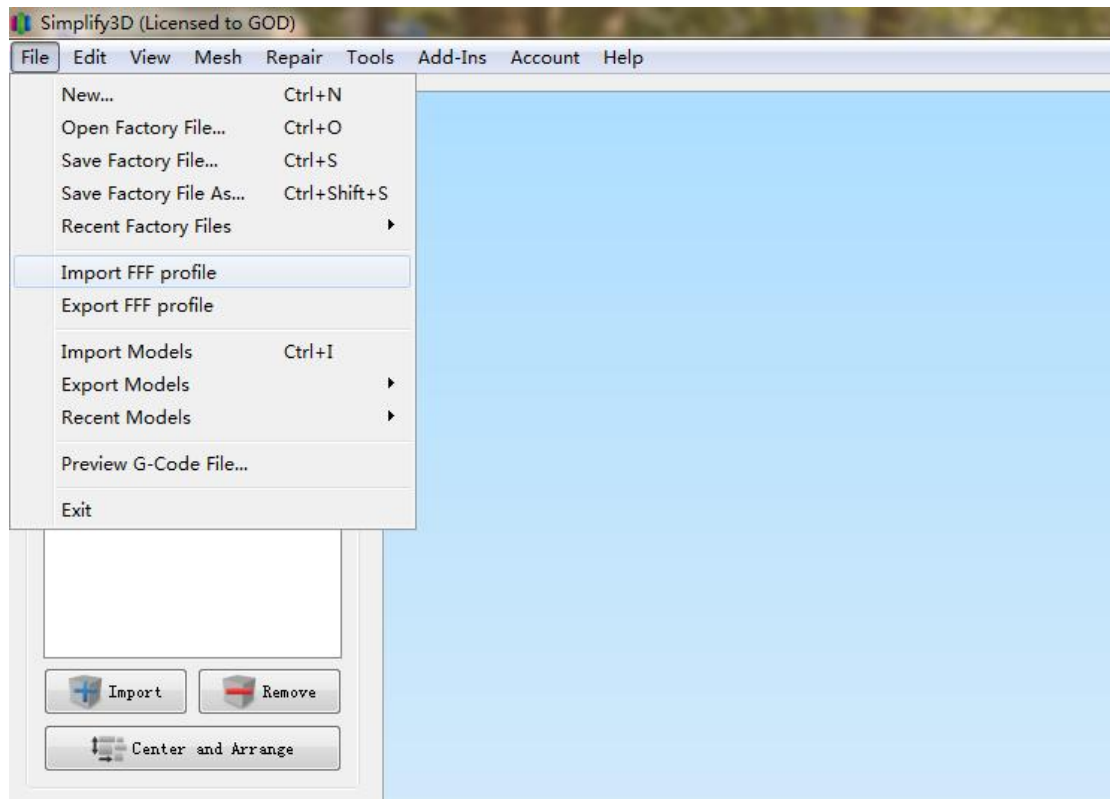## 1. Load Simplify3D Profile:
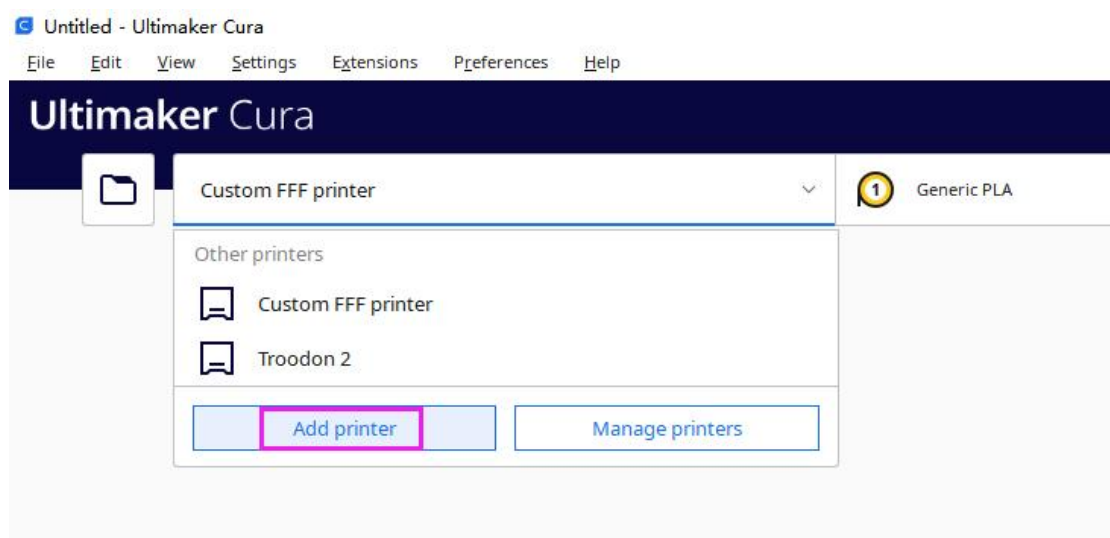
Open Simplify3D and choose "File" -> "Import FFF profile" to load the profile from SD card.

2. Load Cura Profile:

Download and install Cura from https://ultimaker.com/software/ultimaker-cura
Open Cura -> choose "Add printer".

Choose "Custom" -> "Custom FFF printer".

Change the Printer name to Troodon 2.0, then click "Add".

Change the Machine Settings as below:

Copy Start G-code from below:

G28

M98 P"Nozzle-clean.g"

G32

M98 P"Nozzle-clean.g"

M98 P"AutoZ.g"

G92 E0

G1 E-10 F1800

G1 X350 Y350 F10000

G92 E0

G1 E10 F540

G92 E0

G1 E-0.30000 F3600

G1 Z0.2500 F1000

G1 X100 Y350 E43.5631 F1000

G92 E0

G1 E-0.30000 F5400

Copy End G-code from below:

G91

G1 E-5.00 F1000

G1 Z+1.00 X+20.0 Y+20.0 F20000

G1 Z+10.00 F20000

G90

G28 X0 Y0

G91

G1 E-5.00 F500

G90

M104 S0

M140 S0

M106 S0

M84

Change the Extruder Settings as below:

Choose "Manage printers".
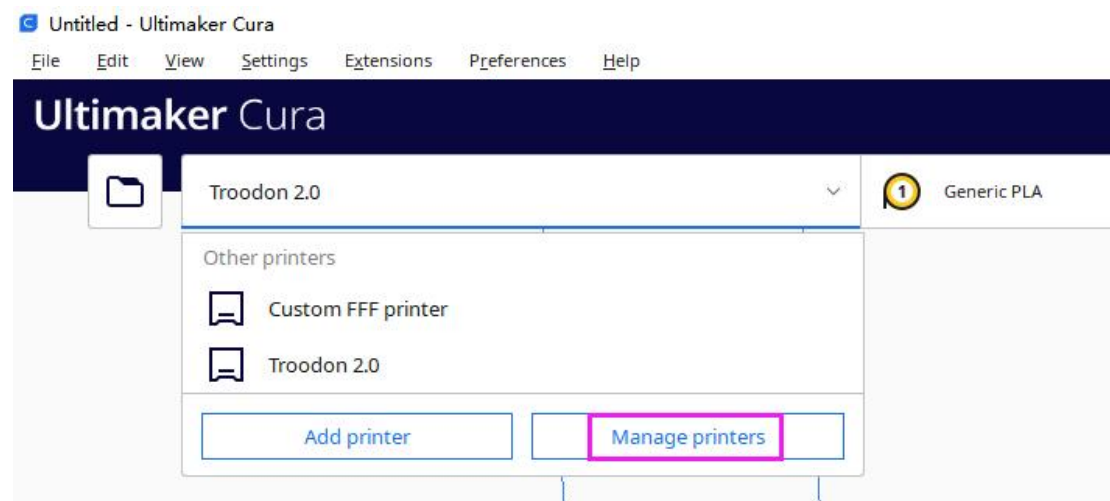
Choose "Profiles" -> "Import" to load the Troodon 2.0.curaprofile from SD card.