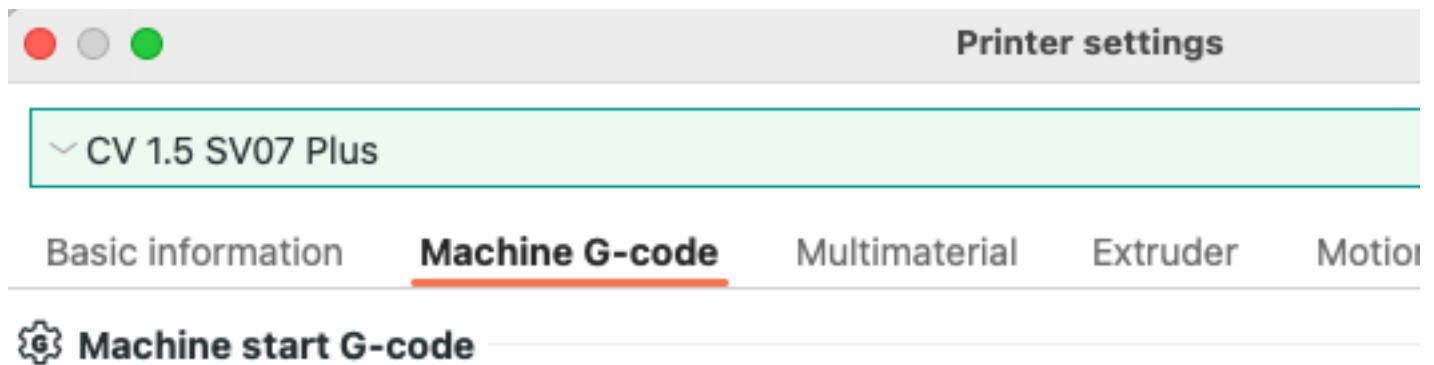


How to set up OrcaSlicer

You can skip this Guide, in case you use the **OrcaSlicer Presets for Sovol SV07/SV06**
<https://www.printables.com/model/607280>

Machine start G-Code

- In the **Printer** Settings, open the "**Machine-G-Code**" section:



- The following text block contains **minimized text lines**, so it has no line breaks on copy & paste, which would later lead to error messages.
- **Select** the following **ENTIRE** text block. **Do not copy line-per-line!** Copy & Paste the **entire** text block into the **Machine start G-code**:

; This is a text block with minimized lines.

;;; KPA Start

M140 S[bed_temperature_initial_layer_single] ; Let a Power failure Resume feature pickup the temperature.
M104 S[nozzle_temperature_initial_layer] ; Let a Power failure Resume feature pickup the temperature.

;;; KPA End

- You don't need anything else in your **Machine-G-Code**. If you have G-Code commands in there, comment them out, or delete them.

Machine end-G-Code

- For the **Machine end G-Code** section, copy & paste this text block:

; KPA Start

_End_Print

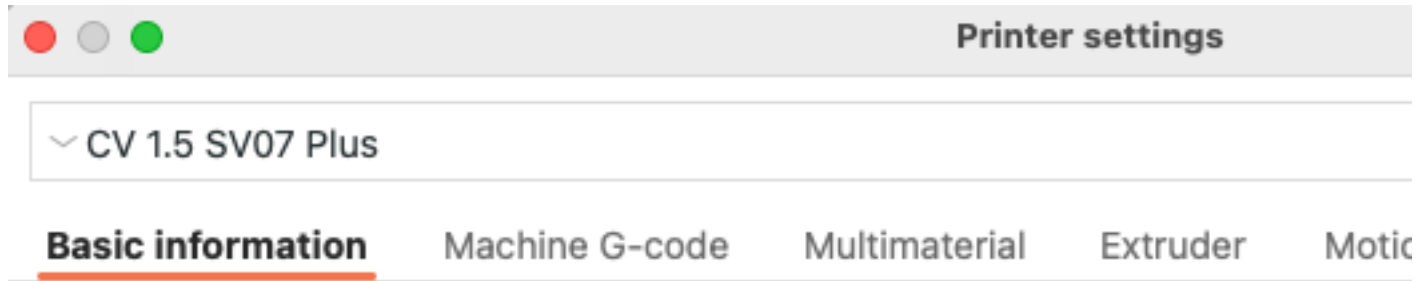
; KPA End

- This is a macro of the Printer Additions which cleans up state, lifts up the extruder a bit higher, retracts a bit more, and turns off the heaters, motors, fans.


- You don't need anything else in your **Machine end G-Code**. If you have g-code commands in there, comment them out, or delete them.

Slicer Modes

- In the **Printer** Settings, open the "**Basic Information**" section:



- Set the **G-code flavor** to "Klipper".
- Tick the checkbox of **Use relative E distances**.

 **Advanced**

Printer structure	<input type="text" value="v Undefined"/>
G-code flavor	<input type="text" value="v Klipper"/>
G-code thumbnails	<input type="text" value="32x32, 400x300"/>
Format of G-code thumbnails	<input type="text" value="v PNG"/>
Use relative E distances	<input checked="" type="checkbox"/>

Object Exclusion

- In the **Process** Settings --> "**Others**" --> "**G-code output**", tick the checkboxes for "**Label Objects**" and "**Exclude Objects**".



G-code output

Reduce infill retraction



Add line number



Verbose G-code



Label objects



Exclude objects



[input_1

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Thank you!

Christian 😊