How to set up PrusaSlicer

This will setup PrusaSlicer for the **Klipper Printer Additions**, and if you like for **Object Exclusion**, too. I made this guide with PrusaSlicer 2.6/2.7.

Start G-code

• Click **Printer Settings** --> **Custom G-code** section.

PrusaSlicer V2.5 and higher

• 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**:
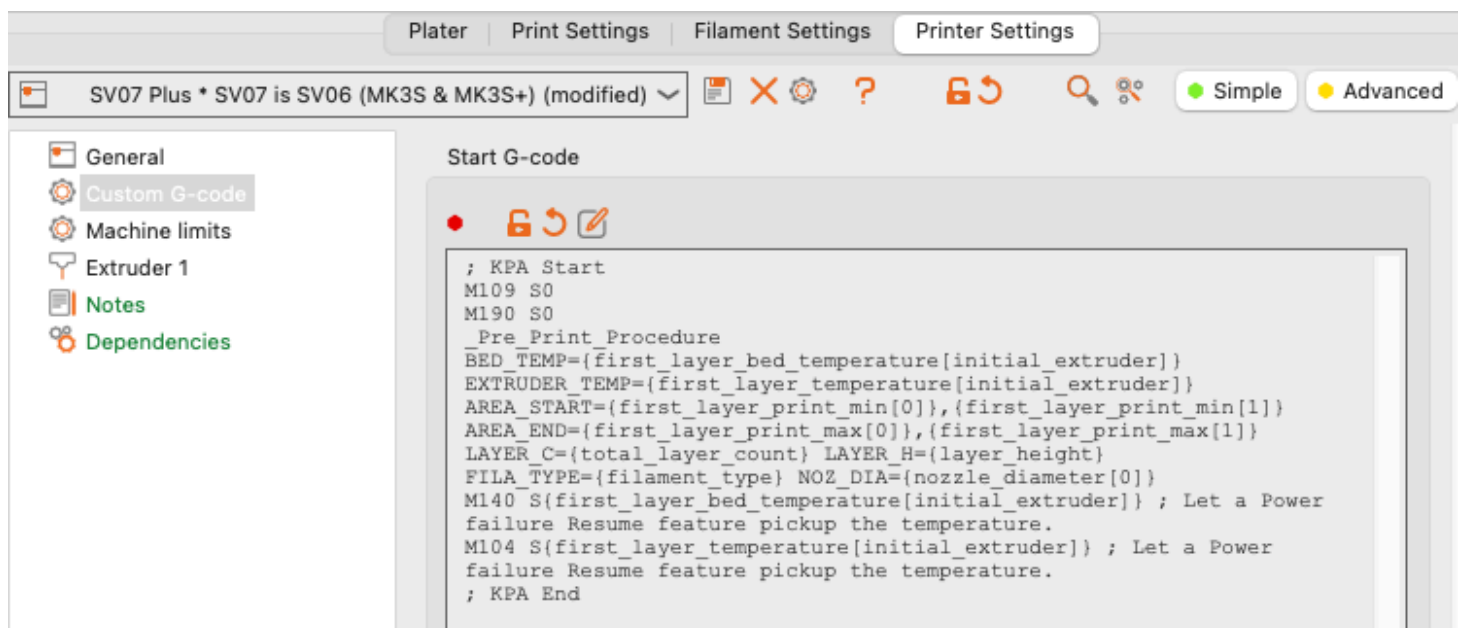
; This is a text block with minimized lines.
;;; KPA Start
M109 S0
M190 S0
_Pre_Print_Procedure BED_TEMP={first_layer_bed_temperature[initial_extruder]} EXTRUDER_TEMP={first_layer_temperature[initial_extruder]} AREA_START={first_layer_print_min[0]},{first_layer_print_min[1]} AREA_END={first_layer_print_max[0]},{first_layer_print_max[1]} LAYER_C={total_layer_count} LAYER_H={layer_height} FILA_TYPE={filament_type[0]} NOZ_DIA={nozzle_diameter[0]}
M140 S{first_layer_bed_temperature[initial_extruder]} ; Let a Power failure Resume feature pickup the temperature.
M104 S{first_layer_temperature[initial_extruder]} ; Let a Power failure Resume feature pickup the temperature.
;;; KPA End

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

• You don't need anything else in your start-g-code. If you have g-code commands in there, comment them out, or delete them.

PrusaSlicer before version 2.5 (untested)

- 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**:

```
; KPA Start
M109 S0
M190 S0
_Pre_Print_Procedure BED_TEMP={first_layer_bed_temperature} EXTRUDER_TEMP={first_layer_temperature[initial_extruder] + extruder_temperature_offset[initial_extruder]} AREA_START={first_layer_print_min[0]},{first_layer_print_min[1]} AREA_END={first_layer_print_max[0]},{first_layer_print_max[1]} LAYER_C={total_layer_count} LAYER_H={layer_height} FILA_TYPE={filament_type[0]} NOZ_DIA={nozzle_diameter[0]}
M140 S{first_layer_bed_temperature} ; Let a Power failure Resume feature pickup the temperature.
M104 S{first_layer_temperature[initial_extruder] + extruder_temperature_offset[initial_extruder]} ; Let a Power failure Resume feature pickup the temperature.
; KPA End
```

End G-code

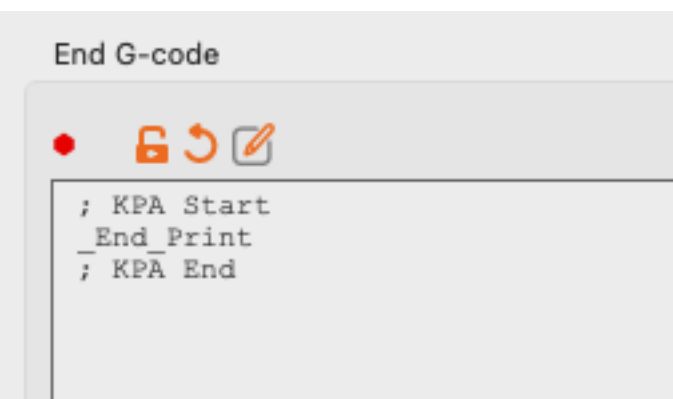- For the End G-code section, copy & paste this text block:

```
; 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.
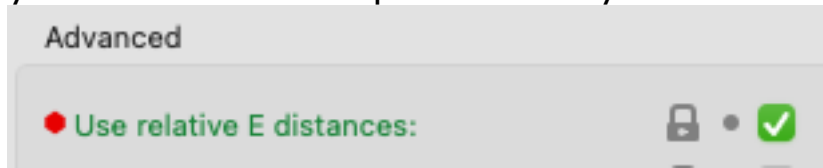

Slicer Modes

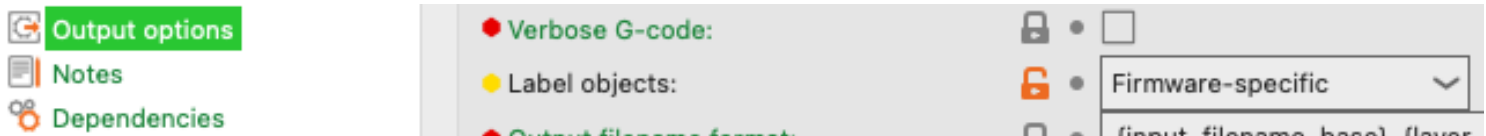- In the **Print Settings**, under the **General**-section, set the g-code flavor to "Klipper":
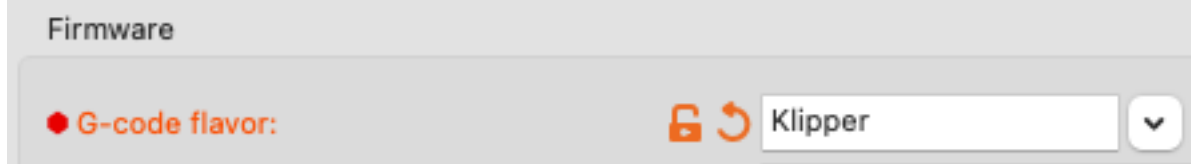
• Also in the **General**-section, turn ON "Use relative E distances". Otherwise your extruder will spin like crazy.

Object Exclusion

Open **Print Settings**, --> "**Output options**" and set "Label objects" to "Firmware-specific". In older releases of PrusaSlicer there's just a checkbox to tick.

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Thank you!
Christian 🙂