

# G-CODE OUTPUT

;TYPE:Custom  
;BEGINNING OF CUSTOM START GCODE

G21 ; set units to millimeters  
G90 ; use absolute coordinates  
M83 ; use relative distances for extrusion

M140 S65; set bed to temperature

G10 P0 S0 R-30  
G10 P1 S215 R170  
G10 P2 S0 R-30  
G10 P3 S0 R-30

M568 P0 A1; set T0 to standby  
M568 P1 A1; set T1 to standby  
;M568 P2 A1; set T2 to standby - not yet built  
;M568 P3 A1; set T3 to standby - not yet built

;Homing  
G28 C ; home c  
G28 Y ; home y  
G28 X; home x

;Homing Z  
G0 X150 Y100 F6000; pre-move to bed center  
M116; wait for all temperatures this allows bed more heatsoak time and instant printing after probing Z  
instead of waiting for hotends  
G28 Z; home z

G29 S1; Activate mesh compensation

; END OF CUSTOM START GCODE

G21 ; set units to millimeters  
G90 ; use absolute coordinates  
M83 ; use relative distances for extrusion  
T-1 ;DOCK CURRENT TOOL  
T1 ;PICKUP NEXT TOOL  
; Filament gcode  
**G10 S200 P1 ; set temperature**  
M116 ; wait for temperature to be reached

# CUSTOM G-CODE (IN SLICER)

;BEGINNING OF CUSTOM START GCODE

G21 ; set units to millimeters

G90 ; use absolute coordinates

M83 ; use relative distances for extrusion

M140 S[first\_layer\_bed\_temperature]; set bed to temperature

G10 P0 S[first\_layer\_temperature\_0] R{temperature[0]+standby\_temperature\_delta}

G10 P1 S[first\_layer\_temperature\_1] R{temperature[1]+standby\_temperature\_delta}

G10 P2 S[first\_layer\_temperature\_2] R{temperature[2]+standby\_temperature\_delta}

G10 P3 S[first\_layer\_temperature\_3] R{temperature[3]+standby\_temperature\_delta}

M568 P0 A1; set T0 to standby

M568 P1 A1; set T1 to standby

;M568 P2 A1; set T2 to standby - not yet built

;M568 P3 A1; set T3 to standby - not yet built

;Homing

G28 C ; home c

G28 Y ; home y

G28 X; home x

;Homing Z

G0 X150 Y100 F6000; pre-move to bed center

M116; wait for all temperatures this allows bed more heatsoak time and instant printing after probing Z instead of waiting for hotends

G28 Z; home z

G29 S1; Activate mesh compensation

; END OF CUSTOM START GCODE