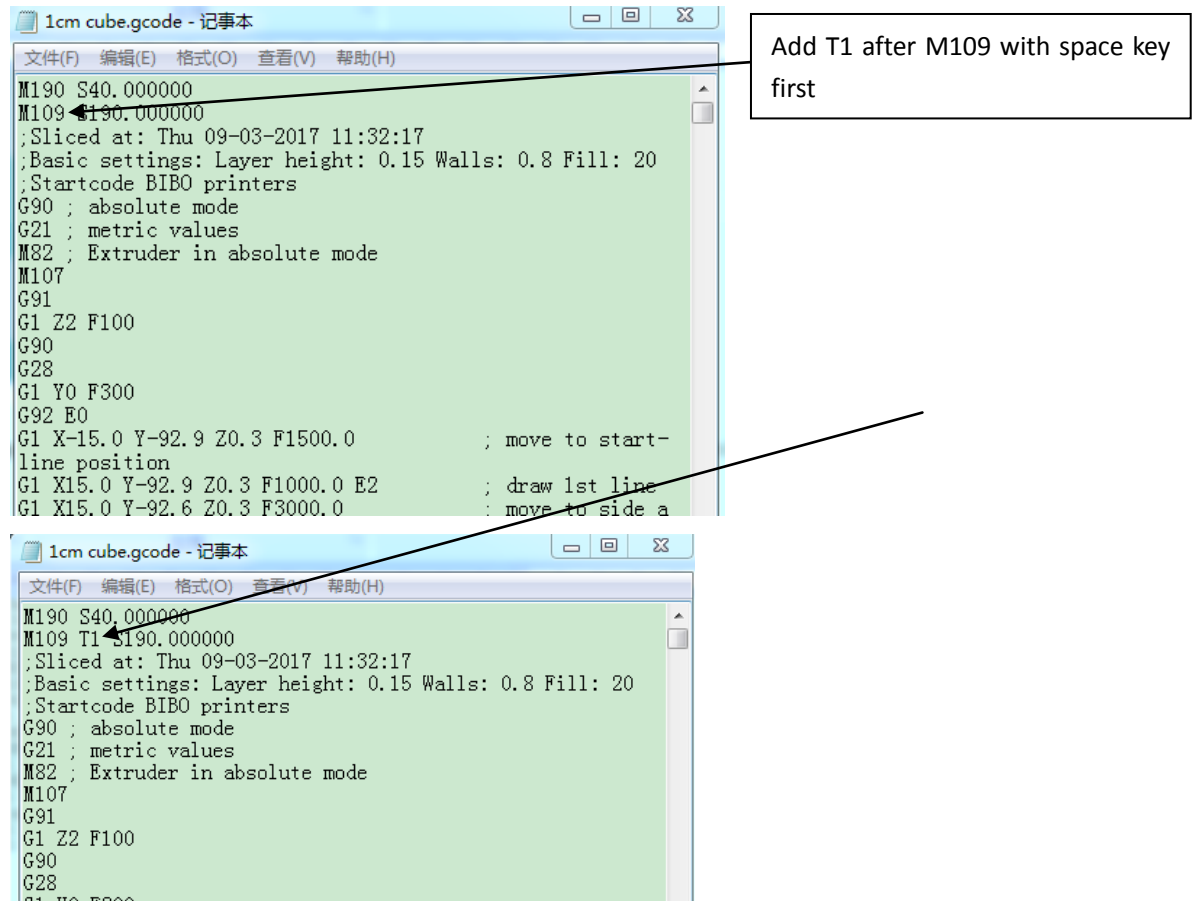


The second extruder printing or support printing

1. Only E2 to Print the object

If you are using Cura 15.04.6 or lower version, please save the gcode file on the

computer then open it by repetier host or notepad.



Then add

T1

G92 E0

before G1 X-15.0 :

```

1 M190 S40.000000
2 M109 T1 S180.000000
3 ;Sliced at: Wed 25-10-2017 09:04:02
4 ;Basic settings: Layer height: 0.15 Walls: 0.8
5 ;Startcode BIBO printers
6 G90 ; absolute mode
7 G21 ; metric values
8 M82 ; Extruder in absolute mode
9 M107
10 G28
11 G1 Z9 F100
12 T0
13 M302
14 G90
15 G92 E0
16 G28
17 G1 Y0 F600 E10
18 G92 E0
19 G1 X-15.0 Y-92.9 Z0.3 F1500.0 ; move to start
20 G1 X15.0 Y-92.9 Z0.3 F1000.0 E2 ; draw 1st li

```

If this place is E10, please revise E10 to be E0

To

```

2 M109 T1 S180.000000
3 ;Sliced at: Wed 25-10-2017 09:04:02
4 ;Basic settings: Layer height: 0.15 Walls: 0.8
5 ;Startcode BIBO printers
6 G90 ; absolute mode
7 G21 ; metric values
8 M82 ; Extruder in absolute mode
9 M107
10 G28
11 G1 Z9 F100
12 T0
13 M302
14 G90
15 G92 E0
16 G28
17 G1 Y0 F600 E0
18 G92 E0
19 T1
20 G92 E0
21 G1 X-15.0 Y-92.9 Z0.3 F1500.0 ; move to start

```

If this place is E10, please revise E10 to be E0

Important: This is also the start gcode in repetier host. Cura's default printing extruder is the right extruder and **will not show T0 (T0 means E1) in gcode file. So when you finish or cancel E2 printing, start a E1 printing gcode file sliced by cura, the printer will continue to print with E2, not E1, as no T0 shows in Cura' s gcode file. Please restart the printer and E1 printing will be ok.**

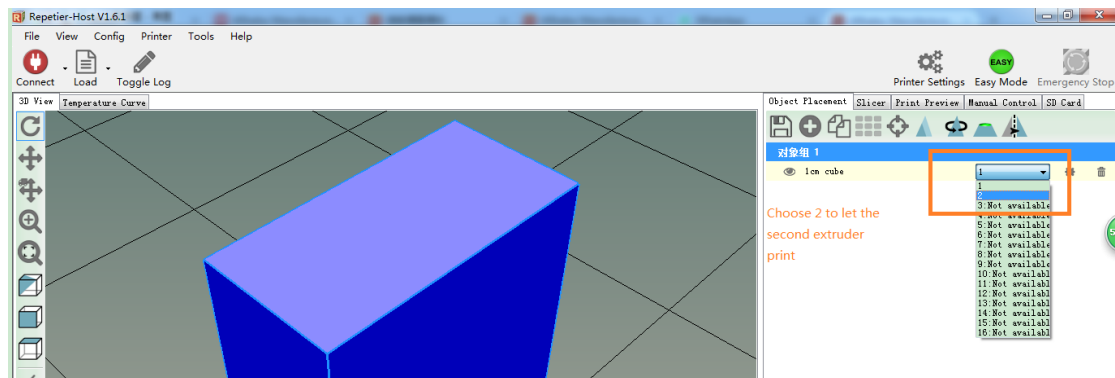
Now you can print the object with the second extruder successfully.

2. E2 to print the object, and E1 to Print support.

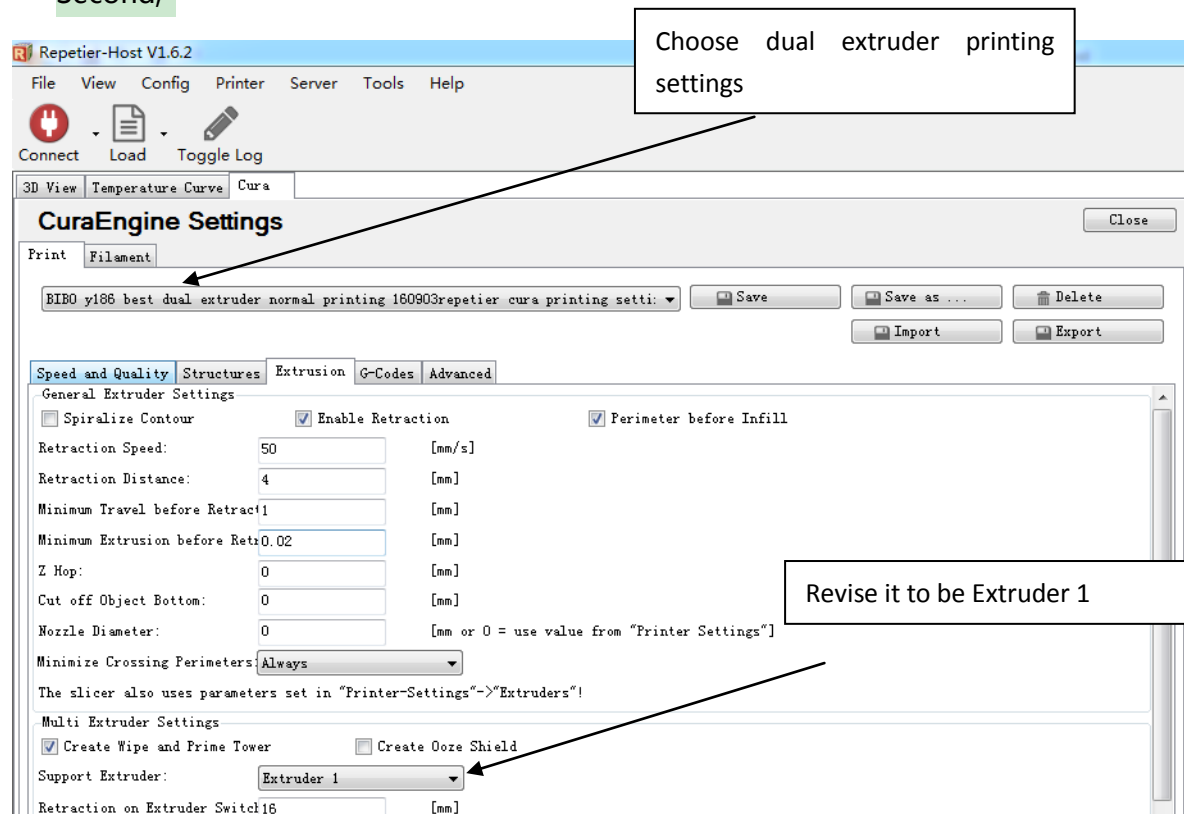
It is hard for Cura 15.04.6 to realize this printing way.

But for repetier host, it is easy to revise.




First to choose extruder 2 to print the object.



Second,



Finally, Choose dual extruder printing settings and slice it.



Printer SettingsEasy ModeEmergency Stop


Object Placement

Slicer

Print Preview

Manual Control

SD Card

 Slice with CuraEngine

Kill Slicing

Slicer: CuraEngine

Configuration

Print Settings:

Print Configuration: IB0 y186 best dual extruder normal printing

Adhesion Type: None

Quality: Very High Quality (150)

Support Type: Touching Bed

Speed:

SlowFast

Print Speed: 60 mm/s

Outer Perimeter Speed: 42 mm/s

Infill Speed: 68 mm/s

Infill Density 32%

Choose dual extruder printing settings