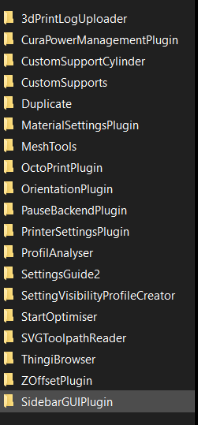
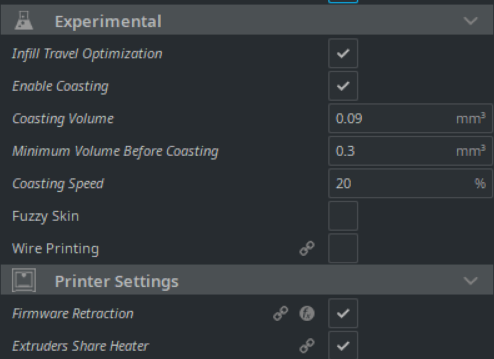
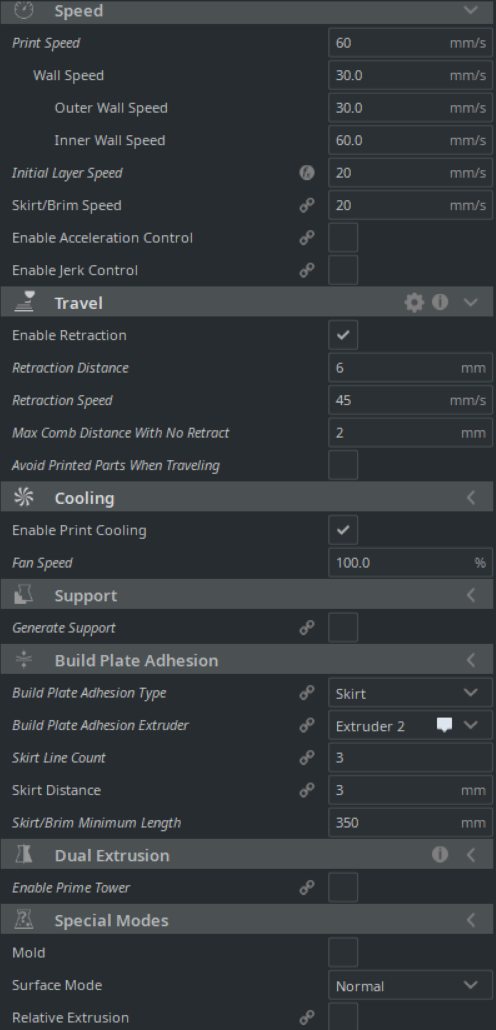
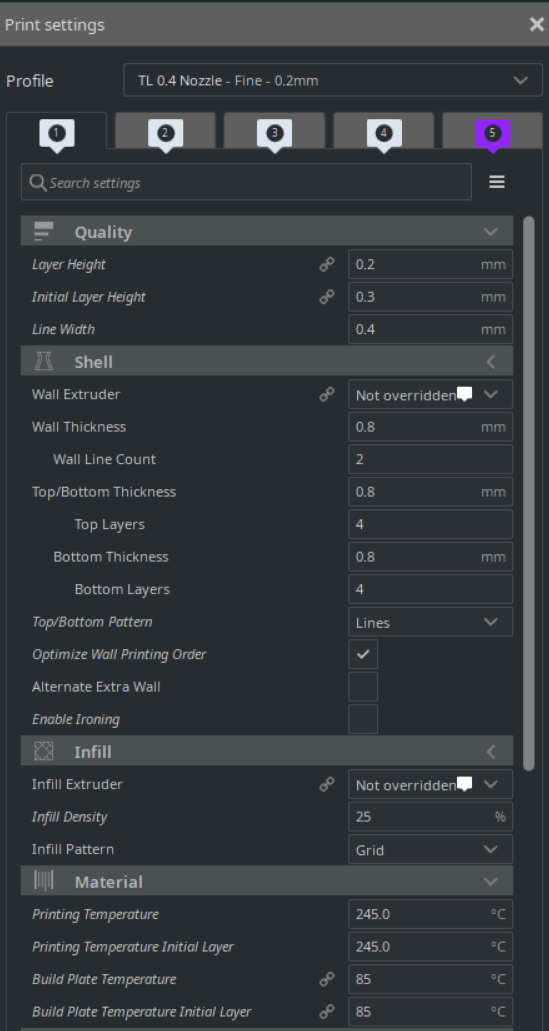
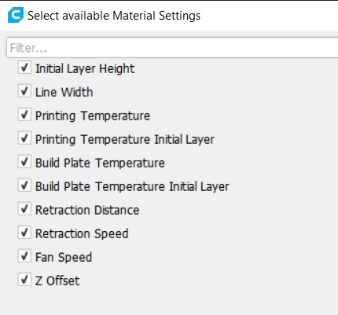
## Plugins



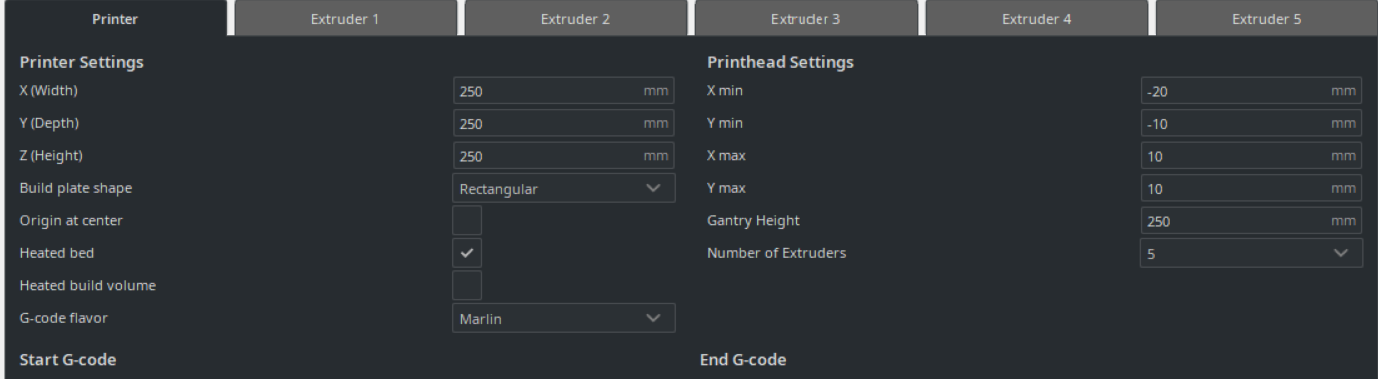
## Setting visibility

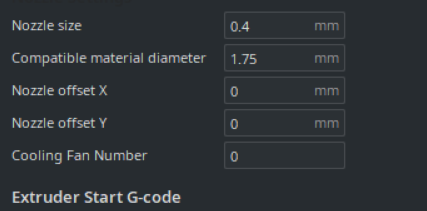


## Material Settings



Printer





# Gcode

## Start code

;Start Script

;Octolapse script:

; --- Global Settings

; layer\_height = {layer\_height}

; smooth\_spiralized\_contours = {smooth\_spiralized\_contours}

; magic\_mesh\_surface\_mode = {magic\_mesh\_surface\_mode}

; machine\_extruder\_count = {machine\_extruder\_count}

; --- Single Extruder Settings

; speed\_z\_hop = {speed\_z\_hop}

; retraction\_amount = {retraction\_amount}

; retraction\_hop = {retraction\_hop}

; retraction\_hop\_enabled = {retraction\_hop\_enabled}

; retraction\_enable = {retraction\_enable}

; retraction\_speed = {retraction\_speed}

; retraction\_retract\_speed = {retraction\_retract\_speed}

; retraction\_prime\_speed = {retraction\_prime\_speed}

; speed\_travel = {speed\_travel}

; --- Multi-Extruder Settings

; speed\_z\_hop\_0 = {speed\_z\_hop, 0}

; speed\_z\_hop\_1 = {speed\_z\_hop, 1}

; speed\_z\_hop\_2 = {speed\_z\_hop, 2}

; speed\_z\_hop\_3 = {speed\_z\_hop, 3}

; speed\_z\_hop\_4 = {speed\_z\_hop, 4}

; speed\_z\_hop\_5 = {speed\_z\_hop, 5}

; speed\_z\_hop\_6 = {speed\_z\_hop, 6}

; speed\_z\_hop\_7 = {speed\_z\_hop, 7}

; retraction\_amount\_0 = {retraction\_amount, 0}

; retraction\_amount\_1 = {retraction\_amount, 1}

; retraction\_amount\_2 = {retraction\_amount, 2}

; retraction\_amount\_3 = {retraction\_amount, 3}

; retraction\_amount\_4 = {retraction\_amount, 4}

; retraction\_amount\_5 = {retraction\_amount, 5}

; retraction\_amount\_6 = {retraction\_amount, 6}

; retraction\_amount\_7 = {retraction\_amount, 7}

; retraction\_hop\_0 = {retraction\_hop, 0}

; retraction\_hop\_1 = {retraction\_hop, 1}

; retraction\_hop\_2 = {retraction\_hop, 2}

; retraction\_hop\_3 = {retraction\_hop, 3}

; retraction\_hop\_4 = {retraction\_hop, 4}

; retraction\_hop\_5 = {retraction\_hop, 5}

; retraction\_hop\_6 = {retraction\_hop, 6}

; retraction\_hop\_7 = {retraction\_hop, 7}

; retraction\_hop\_enabled\_0 = {retraction\_hop\_enabled, 0}

; retraction\_hop\_enabled\_1 = {retraction\_hop\_enabled, 1}

; retraction\_hop\_enabled\_2 = {retraction\_hop\_enabled, 2}

; retraction\_hop\_enabled\_3 = {retraction\_hop\_enabled, 3}

; retraction\_hop\_enabled\_4 = {retraction\_hop\_enabled, 4}

; retraction\_hop\_enabled\_5 = {retraction\_hop\_enabled, 5}

; retraction\_hop\_enabled\_6 = {retraction\_hop\_enabled, 6}

; retraction\_hop\_enabled\_7 = {retraction\_hop\_enabled, 7}

; retraction\_prime\_speed\_0 = {retraction\_prime\_speed, 0}

; retraction\_prime\_speed\_1 = {retraction\_prime\_speed, 1}

; retraction\_prime\_speed\_2 = {retraction\_prime\_speed, 2}

; retraction\_prime\_speed\_3 = {retraction\_prime\_speed, 3}

; retraction\_prime\_speed\_4 = {retraction\_prime\_speed, 4}

; retraction\_prime\_speed\_5 = {retraction\_prime\_speed, 5}

; retraction\_prime\_speed\_6 = {retraction\_prime\_speed, 6}

; retraction\_prime\_speed\_7 = {retraction\_prime\_speed, 7}

; retraction\_retract\_speed\_0 = {retraction\_retract\_speed, 0}

; retraction\_retract\_speed\_1 = {retraction\_retract\_speed, 1}

; retraction\_retract\_speed\_2 = {retraction\_retract\_speed, 2}

; retraction\_retract\_speed\_3 = {retraction\_retract\_speed, 3}

; retraction\_retract\_speed\_4 = {retraction\_retract\_speed, 4}

; retraction\_retract\_speed\_5 = {retraction\_retract\_speed, 5}

; retraction\_retract\_speed\_6 = {retraction\_retract\_speed, 6}

; retraction\_retract\_speed\_7 = {retraction\_retract\_speed, 7}

; retraction\_speed\_0 = {retraction\_speed, 0}

; retraction\_speed\_1 = {retraction\_speed, 1}

; retraction\_speed\_2 = {retraction\_speed, 2}

; retraction\_speed\_3 = {retraction\_speed, 3}

; retraction\_speed\_4 = {retraction\_speed, 4}

; retraction\_speed\_5 = {retraction\_speed, 5}

; retraction\_speed\_6 = {retraction\_speed, 6}

; retraction\_speed\_7 = {retraction\_speed, 7}

; retraction\_enable\_0 = {retraction\_enable, 0}

; retraction\_enable\_1 = {retraction\_enable, 1}

; retraction\_enable\_2 = {retraction\_enable, 2}

; retraction\_enable\_3 = {retraction\_enable, 3}

; retraction\_enable\_4 = {retraction\_enable, 4}

; retraction\_enable\_5 = {retraction\_enable, 5}

; retraction\_enable\_6 = {retraction\_enable, 6}

; retraction\_enable\_7 = {retraction\_enable, 7}

; speed\_travel\_0 = {speed\_travel, 0}

; speed\_travel\_1 = {speed\_travel, 1}

; speed\_travel\_2 = {speed\_travel, 2}

; speed\_travel\_3 = {speed\_travel, 3}

; speed\_travel\_4 = {speed\_travel, 4}

; speed\_travel\_5 = {speed\_travel, 5}

; speed\_travel\_6 = {speed\_travel, 6}

; speed\_travel\_7 = {speed\_travel, 7}

G28 R5 ; Autohome if unknown

M140 S{material\_bed\_temperature\_layer\_0} ; start preheating the bed

;G29 ; Bed leveling

;M207 [F<feedrate>] [S<length>] Retract length [W<length>] [Z<length>] //To Set

G90 ; Absolute Positioning

M82 ; E Absolute independant of G91 (Relative)

G92 E0 ; Set Position

G1 Z15 F1700 ; Lift up (1800 is max)

G0 X0 F6000; Go to bucket

M211 S0 ; Disable SoftStops

G0 X-5 F500; Go to bucket Closer

M211 S1 ; Enable SoftStops

M107 ; Fan Off

M412 S1 ; Enable Runout Sensor

;Set Mix for Virtual Tools

M163 S0 P0.8

M163 S1 P0.2

M163 S2 P0.0

M164 S3 ; Extruder 4

M163 S0 P0.6

M163 S1 P0.4

M163 S2 P0.0

M164 S4 ; Extruder 5

M163 S0 P0.8

M163 S1 P0.0

M163 S2 P0.2

M164 S5 ; Extruder 6

M163 S0 P0.6

M163 S1 P0.0

M163 S2 P0.4

M164 S6 ; Extruder 7

M163 S0 P0.1

M163 S1 P0.1

M163 S2 P0.8

M164 S7 ; Extruder 8

;/Virtual Tools

;/Colour mixing:

;M165 A0 B0.5 C0.5 ; Set Mix for current tool

M104 S{material\_print\_temperature\_layer\_0} ; start preheating hotend

M190 S{material\_bed\_temperature\_layer\_0} ; wait for Cura Bed setting

M109 S{material\_print\_temperature\_layer\_0} ; wait for Cura Hotend

;/Start Script

## End Code

;End Script

m106 ; Turn on Fan to try and cool retraction good for 1 layer print

G92 E0 ; Set current extruder position to 0

G10 ; Retract

G91 ; Set the interpreter to relative positions

G0 F1700 Z3 ; Lift up by 10mm (relative)

G90 ; Absolute positioning

G0 X0 F6000

M211 S0 ; Disable SoftStops

G0 X-5 F500; Go to bucket Closer

M211 S1 ; Enable SoftStops

G0 Y200 F2700 ; Move bed forward

m107 ; Fan Off

M104 S0 ; Swith off Hotend

M140 S0 ; Switch off Bed

G90 ; Absolute positioning

G92 E0 ; Set position

M84 ; Disable Steppers

;/End Script

## Extruder 1 Start

;Change Tool

M109 R{material\_print\_temperature}

G91 ; Relative

G1 E25 F100 ; Extrude into Bucket

G1 E5 F50 ; Slow Purge to reduce pressure

G92 E0 ; Set Extruder Position

G90 ; Absolute

G10 ; Retract

; Wait for ooze

G4 S3 ; Wait 2 seconds

G0 X5 F500 ; Wipe

G0 X-5 F4000 ; Wipe

G0 X5 F500 ; Wipe

G0 X-5 F4000 ; Wipe

M211 S1 ; Enable SoftStops

;/Change Tool

## Extruder 1 end

;Change End

G10 ; Retract

G91 ; Relative position

G0 Z0.2 F9000 ; Lift Nozzle

G0 Z1 X-5 F9000 ;lift diagonal

G90 ; Absolute

G0 X0 F6000; Go to bucket

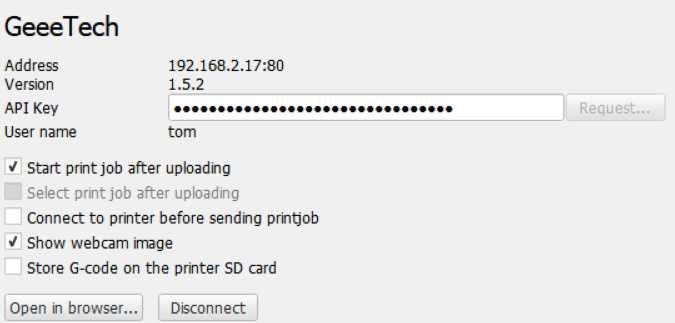
M211 S0 ; Disable SoftStops

G0 X-5 F500; Go to bucket Closer

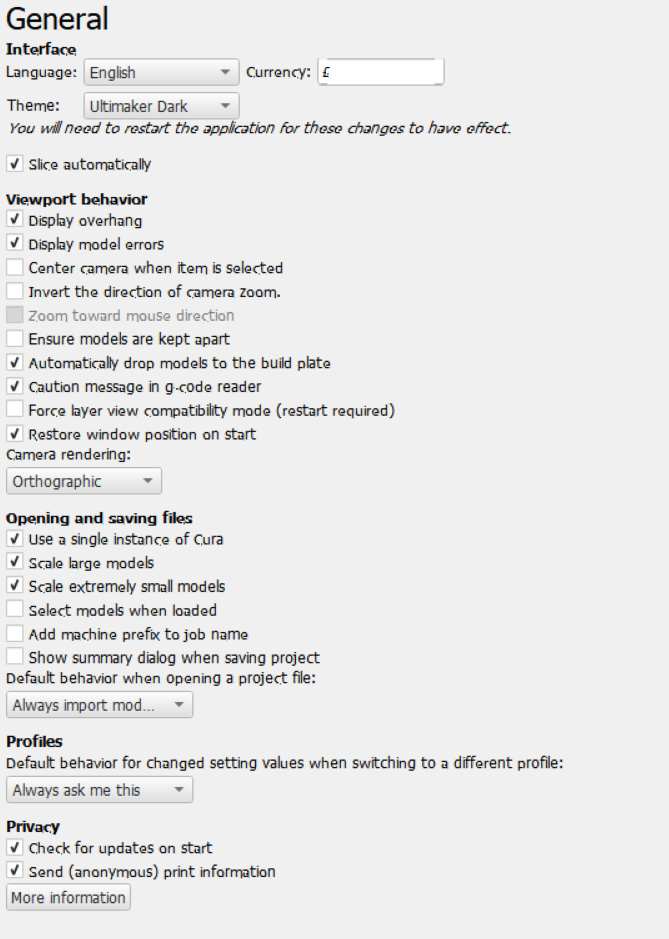
G11 ; Recover

;/Change End

# Octoprint

B12905F201B24472B9F45787457A5CAF

# General Settings



# Post Processing

|  |  |
| --- | --- |
| **Before** | **After** |
| ;/Change Tool\nG92 E0\nG10 | ;/Change Tool\n;Removed Retract G92 E0 |
| M105\nM109 | ;Remove Temp tool changes M105 followed by M109 |
| ;MESH.\*\nG0 F[0-9]{3,} | ;MESH; Adjusted Speed 1:\nG0 F7200 |
| M107\n;MESH.\*\nG0 F[0-9]{3,} | M107\n;Adjusted Speed 2:\nG0 F7200 |

## Path

C:\Users\Tom\AppData\Roaming\cura