

*Druckbetthaftung

Ablauf vor dem Druckstart:

1. Homing aller Achsen "G28"
2. Aufheizen (Nozzle kann bei 170 bleiben)
3. Z-Tilt
4. Homing Z "G28 Z"
5. Bedmesh vor jedem Druck
6. Primeline / Start Print

Lässt man einen Punkt weg oder verdreht die Reihenfolge, kann es nicht mehr funktionieren

Vorlage Startcode:

Cura Startcode

Startcode im Slicer:

```
START_PRINT BED={material_bed_temperature_layer_0} EXTRUDER={material_initial_print_temperature}
```

Einfügen in Klipper:

```
[gcode_macro START_PRINT]
gcode:
    ##### set defaults #####
    {% set extruder = params.EXTRUDER|default(0) %}
    {% set bed = params.BED|default(0) %}
    ##### end off definition #####
    #SET_TEMPERATURE_FAN_TARGET temperature_fan=Chamber ; VORON or enclosure
    #probe_reset[] ; VYPER Set on if you use strain gauge on vyper
    M83 ; Extruder realtive mode
    #STATUS_HEATING ; NEOPIXEL
    {action_respond_info("Heat Bed")}
    M190 S{bed} ; Bed heat up
    {action_respond_info("Heat Extruder")}
    M109 S{extruder} ; Extruder heat up standby temp 170
```

```

#STATUS_HOMING[] ; NEOPIXEL
G28
#_CG28 ; Homing Check
#STATUS_CALIBRATING_Z
# G34[] ; VYPER ztilt
#_CG34[] ; VYPER zTilt
#G32[] ; VORON QGL
#_CG32 ; VORON QGL check
#G28 Z[] ; activate if you use ztilt ord qgl
#STATUS_MESHING[] ; NEOPIXEL
BED_MESH_CLEAR
BED_MESH_CALIBRATE
[]#BED_MESH_PROFILE LOAD="Name"
#BED_MESH_PRINT_AREA AREA_START_X={params.AREA_START_X|float}
AREA_START_Y={params.AREA_START_Y|float} AREA_END_X={params.AREA_END_X|float}
AREA_END_Y={params.AREA_END_Y|float}
#SET_GCODE_OFFSET Z= ; Offset reset
#NOZZLE_CLEAR[] ; VORON For Nozzle Drive Mod
#NOZZLE_DRIVE ; For Nozzle Drive Mod
G92 E0.0 ; Reset extruder length
G90 ; Absolute positioning

```

Super Slicer

Startcode im Slicer:

```
START_PRINT BED={first_layer_bed_temperature} EXTRUDER={first_layer_temperature}
```

Einfügen in Klipper:

```

[gcode_macro START_PRINT]
gcode:
    #### set defaults ####
    {% set extruder = params.EXTRUDER|default(0) %}
    {% set bed = params.BED|default(0) %}

```

```

#### end off definition ####

#SET_TEMPERATURE_FAN_TARGET temperature_fan=Chamber ; VORON or enclosure

#probe_reset[] ; VYPER Set on if you use strain gauge on vyper

M83 ; Extruder realtive mode

#STATUS_HEATING ; NEOPIXEL

{action_respond_info("Heat Bed")}

M190 S{bed} ; Bed heat up

{action_respond_info("Heat Extruder")}

M109 S{extruder} ; Extruder heat up standby temp 170

#STATUS_HOMING[] ; NEOPIXEL

G28

#_CG28 ; Homing Check

#STATUS_CALIBRATING_Z

# G34[] ; VYPER ztilt

#_CG34[] ; VYPER zTilt

#G32[] ; VORON QGL

#_CG32 ; VORON QGL check

#G28 Z[] ; activate if you use ztilt ord qgl

#STATUS_MESHING[] ; NEOPIXEL

BED_MESH_CLEAR

BED_MESH_CALIBRATE

[]#BED_MESH_PROFILE LOAD="Name"

#BED_MESH_PRINT_AREA AREA_START_X={params.AREA_START_X|float}

AREA_START_Y={params.AREA_START_Y|float} AREA_END_X={params.AREA_END_X|float}

AREA_END_Y={params.AREA_END_Y|float}

#SET_GCODE_OFFSET Z= ; Offset reset

#NOZZLE_CLEAR[] ; VORON For Nozzle Drive Mod

#NOZZLE_DRIVE ; For Nozzle Drive Mod

G92 E0.0 ; Reset extruder length

G90 ; Absolute positioning

```

End-Code:

Cura

END_PRINT

Super Slicer

END_PRINT

[Link](#)

<https://www.youtube.com/embed/P-HjyB1EbOY>

Revision #2
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