

Orca - Start/End gcode



- Super Slicer - Probablemente el mejor programa para generar Gcode para tu impresora 3D
- Orca Slicer - Crear Perfil Hellbot Magna2

Start/End Gcode para Anycubic 4max Pro

Start Gcode

Valores que trae el Orca 2.2.0 por defecto para la Anycubic 4Max.

```
M190 S[bed_temperature_initial_layer_single]
M109 S[nozzle_temperature_initial_layer]
PRINT_START EXTRUDER=[nozzle_temperature_initial_layer]
BED=[bed_temperature_initial_layer_single]
; You can use following code instead if your PRINT_START macro support Chamber and print area
bedmesh
; PRINT_START EXTRUDER=[nozzle_temperature_initial_layer]
BED=[bed_temperature_initial_layer_single] Chamber=[chamber_temperature]
PRINT_MIN={first_layer_print_min[0]},{first_layer_print_min[1]}
PRINT_MAX={first_layer_print_max[0]},{first_layer_print_max[1]}
```

Código G inicial del barquito en mi Orca

```
; EXECUTABLE_BLOCK_START
M73 P0 R137
M201 X2000 Y2000 Z300 E5000
M203 X300 Y300 Z12 E25
M204 P2000 R5000 T2000
M205 X9.00 Y9.00 Z0.20 E2.50 ; sets the jerk limits, mm/sec
;TYPE:Custom
M190 S50
M109 S215
PRINT_START EXTRUDER=215 BED=50
; You can use following code instead if your PRINT_START macro support Chamber and print area
bedmesh
; PRINT_START EXTRUDER=215 BED=50 Chamber=0 PRINT_MIN=121.778,85.7173
PRINT_MAX=173.907,115.051
G90
G21
M83 ; use relative distances for extrusion
; filament start gcode
M106 S0
;LAYER_CHANGE
;Z:0.2
;HEIGHT:0.2
;BEFORE_LAYER_CHANGE
;0.2
G92 E0

G1 E-.9 F1500
;_SET_FAN_SPEED_CHANGING_LAYER
G1 X128.277 Y87.599 F18000
G1 Z.6
G1 Z.2
```

```
G1 E.9 F1500
M204 S300
;TYPE:Skirt
;WIDTH:0.5
G1 F3000
G1 X129.266 Y87.435 E.03658
...
```



Código G inicial modificado para SuperSlicer

```
M190 S[first_layer_bed_temperature]; calienta cama y espera
M104 S[first_layer_temperature]; calienta hotend sin esperar
M280 P0 S160; reset 3dtouch
G28 ; home all axes
G29; nivelar
G1 Z5 F5000 ; lift nozzle
G1 Y100 F5000; Evita pinzas
M109 S[first_layer_temperature]; espera hotend
```



Otro ejemplo

```
G90 ; use absolute coordinates
M83 ; extruder relative mode
M140 S[bed_temperature_initial_layer_single] ; set final bed temp
M104 S150 ; set temporary nozzle temp to prevent oozing during homing
G4 S10 ; allow partial nozzle warmup
G28 ; home all axis
G1 Z50 F240
G1 X2 Y10 F3000
M104 S[nozzle_temperature_initial_layer] ; set final nozzle temp
M190 S[bed_temperature_initial_layer_single] ; wait for bed temp to stabilize
M109 S[nozzle_temperature_initial_layer] ; wait for nozzle temp to stabilize
G1 Z0.28 F240
G92 E0
G1 Y140 E10 F1500 ; prime the nozzle
G1 X2.3 F5000
G92 E0
G1 Y10 E10 F1200 ; prime the nozzle
G92 E0
```



El código que funcionaba con el Cura.

```
G21 ;metric values
G90 ;absolute positioning
M82 ;set extruder to absolute mode
M107 ;start with the fan off
G28 X0 Y0 ;move X/Y to min endstops
G28 Z0 ;move Z to min endstops
G1 X-3 Y40 ;Anycubic 4Max Pro Brush
G1 X-3 Y5 ;Anycubic 4Max Pro Brush
G1 X-3 Y40 ;Anycubic 4Max Pro Brush
G1 X-3 Y5 ;Anycubic 4Max Pro Brush
G1 Z5.0 F60 ;move the platform down 5mm
G92 E0 ;zero the extruded length
G1 F200 E3 ;extrude 3mm of feed stock
G92 E0 ;zero the extruded length again
G1 F60
```

```
M117 Printing...
G5
```

End Gcode

Valores que trae el Orca 2.2.0 por defecto para la Anycubic 4Max.

```
PRINT_END
```



Código G final modificado para SuperSlicer

```
M104 S0 ; turn off temperature
M140 S0 ; turn off bed
M107 ;Turn off fan
G1 X205 Y205 F5000; Aparta cabezal
M84 ; disable motors
```



El código que funcionaba en el Cura.

```
M104 S0 ; turn off extruder
M140 S0 ; turn off bed
M84 ; disable motors
M107
G91 ; relative positioning
G1 E-1 F300 ;retract the filament a bit before lifting the nozzle, to release some of the
pressure
G1 Z+0.5 E-5 ;X-20 Y-20 F60 ;move Z up a bit and retract filament even more
G90 ; absolute positioning
G1 X140 Y215 Z200 F3000
M84 ; steppers off
G90 ; absolute positioning
M300 P300 S4000
```

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