

# StartStopPrinter.cfg

```
#####  
## Start print macro  
#####  
  
[gcode_macro START_PRINT]  
gcode:  
  # Get Params  
  {% set t_extruder = params.T_EXTRUDER|default(205)|float %}  
  {% set t_bed = params.T_BED|default(60)|float %}  
  {% set b_min_x = params.BUILD_MIN_X|default(10)|float %}  
  {% set b_min_y = params.BUILD_MIN_Y|default(10)|float %}  
  {% set b_max_x = params.BUILD_MAX_X|default(133)|float %}  
  {% set b_max_y = params.BUILD_MAX_Y|default(145)|float %}  
  
  #Set LED Red  
  SET_LED LED="Licht" Red=1 GREEN=0 BLUE=0 SYNC=0 TRANSMIT=1  
  
  M117 Bett heizt  
  
  # Start  
  M140 S{t_bed} ; Setze Heatbed Temperatur  
  M190 S{t_bed} ; Warte auf Bed Zieltemperatur  
  
  #Set LED Blue  
  SET_LED LED="Licht" Red=0 GREEN=0 BLUE=1 SYNC=0 TRANSMIT=1  
  
  M117 Home xyz  
  
  G28 ; Home  
  M83 ; Extruder relativer Modus  
  
  M117 Kallibrierung
```

```

# Start probing
#BED_MESH_CALIBRATE PROFILE=mesh1 METHOD=automatic
BED_MESH_CALIBRATE AREA_START={b_min_x},{b_min_y} AREA_END={b_max_x},{b_max_y}

G1 X5 Y5 Z15 F2200
#G1 Z0.2 F3000
G92 E0.0 ; Extruder Reset
G90 ; Absolute Positionierung

#Set LED Red
SET_LED LED="Licht" Red=1 GREEN=0 BLUE=0 SYNC=0 TRANSMIT=1

M117 Hotend heizt

M104 S{t_extruder} ; Setze Hotend Temperatur
M109 S{t_extruder} ; Warte auf Hotend Zieltemperatur

#Set LED White
SET_LED LED="Licht" RED=1 GREEN=1 BLUE=1 SYNC=0 TRANSMIT=1

# _PRIME_LINE;macro

G1 E8 F2000
G1 Z0.3 F3000 ; put down hotend
G1 X5 Y5 F2200

M82 ; Absolute Positionierung
G92 E0 ;zero the extruded length again

M117 Druck aktiv

#####
## End print macro
#####

[gcode_macro PRINT_END]
gcode:
TURN_OFF_HEATERS
G91 ; Relative Position

```

```
G1 E-5 F3000 ; Retract
G1 X-0.5 Y-0.5 E-5
G90 ; Absolute Positionierung
G1 X83 Y145 F2200 ; Bewege den Kopf nach hinten in die Mitte
M107 ; Partcooling Fan deaktivieren
M84
M117 Druck fertig
```

```
#Turn LED off
```

```
SET_LED LED="Licht" RED=0 GREEN=0 BLUE=0 SYNC=0 TRANSMIT=1
```

```
NOTIFY_PRINT_DONE
```

```
#####
```

```
## Prime Line macro (not in use)
```

```
#####
```

```
[gcode_macro _PRIME_LINE]
```

```
gcode:
```

```
G90 ; Absolute Position
G1 E10 F2000
G1 Z0.3 F3000 ; put down hotend
G1 X5 Y5 F2200
G1 X5 Y5 Z0.2 F3000 ; get ready to prime
G92 E0 ; reset extrusion distance
G1 X110 E15 F600 ; prime nozzle
G1 X140 F5000 ; quick wipe
```

```
#####
```

```
## Mesh probe macro (not in use)
```

```
#####
```

```
[gcode_macro probe_mesh]
```

```
gcode:
```

```
# Set extruder and bed temperature
M190 S60
# Home all axis
G28
# Start probing
BED_MESH_CALIBRATE PROFILE=mesh1 METHOD=automatic
```

```
# Turn off heaters afterward
```

```
TURN_OFF_HEATERS
```

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