

3D printer

Resources

- [hotend change](#)
 - mount heatbreak and nozzle touching together and with **0.5mm gap** between head and nozzle
 - preheat hotend at ABS temp
 - fix nozzle with 1nm torque
 - [E3D V6 assembly](#)
 - [temperature tower](#)
 - set combing mode to off



z offset: subtract 0.25 to A4 paper without friction and without warm up

Printing tips

- Initial Layer Speed: 20mm/s
- Combing mode: not in skin
- Maximum Comb Distance with No Retract: 10mm
- Initial Layer Line Width: 140%

PETG:

- first layer: 245
- other layer: 245
- bed: 80
- z-hop: 0.6

Anycubic 4max pro 2

- [fan duct](#)

[anycubic_4max_4maxpro2.0_petg_fast](#)

```
[general]
version = 4
name = 4MAXpro2.0 PETG fast
definition = anycubic_4max

[metadata]
```

```
type = quality_changes
quality_type = normal
intent_category = default
position = 0
setting_version = 19

[values]
cool_fan_enabled = True
cool_fan_speed = 50
infill_pattern = grid
infill_sparse_density = 20
initial_layer_line_width_factor = 140
material_initial_print_temperature = =max(-273.15,
material_print_temperature - 10)
material_print_temperature = 245
material_print_temperature_layer_0 = 245
optimize_wall_printing_order = True
raft_margin = 5
retraction_combing_max_distance = 10
retraction_hop = 0.6
retraction_hop_enabled = True
speed_layer_0 = 20
speed_print = 50
speed_print_layer_0 = =speed_layer_0
speed_travel = 100
speed_travel_layer_0 = =speed_layer_0 * speed_travel / speed_print
top_layers = =0 if infill_sparse_density == 100 else
math.ceil(round(top_thickness / resolveOrValue('layer_height'), 4))
travel_avoid_other_parts = False
wall_line_count = =1 if magic_spiralize else max(1,
round((wall_thickness - wall_line_width_0) / wall_line_width_x) + 1) if
wall_thickness != 0 else 0
```

[anycubic_4max_extruder_0_#2_4maxpro2.0_petg_fast](#)

```
[general]
version = 4
name = 4MAXpro2.0 PETG fast
definition = anycubic_4max

[metadata]
type = quality_changes
quality_type = normal
setting_version = 19

[values]
adaptive_layer_height_enabled = False
adhesion_type = skirt
default_material_bed_temperature = 60
layer_height = 0.3
```

```
material_bed_temperature = 80
material_bed_temperature_layer_0 = 80
retraction_combing = noskin
support_enable = False
support_type = buildplate
```

Flsun Super Racer

todo

Ender3 v2

- bed 70
- head 225
- Retraction Distance: 6.5mm.
- Retraction Speed: 25mm/s.
- Maximum Retraction Count: 10.
- Minimum Extrusion Distance Window: 10mm.
- Combing Mode: ON and set to "Within Infill" (no stringing).
- fan 100% for details or fan 0% for straight
- [bltouch](#)
- [jyers firmware settings in octoprint](#)

Geeetech A20



first layer speed
10mm/s



into start g-code
keep only first G28
as below

```
G28; auto home
G1 Z15 F300; linear move, 15mm vertical and set feedrate at 300
M107; turn fan off
G90 ; absolute positioning
M82 ; This command is used to override G91 and put the E axis into absolute
mode independent of the other axes.
G92 E0; set absolute position
```

```
M107 ; M107; turn fan off
G0 X10 Y20 F6000 ; move to X 10 mm Y 20 mm , feed rate 6000
G1 Z0.8 ; move Z to 0.8 mm [WHY MOVE VERTICALLY?]
G1 F300 X200 E40 ; push 40 mm of filament while moving at 300 mm/min to
position X=200
G1 F1200 Z2 ; move to position Z=2 at 1200 mm/min
G92 E0 ; set the extruder position as the new zeros
```

fetch marlin code and checkout same branch release on Marlin.git and Configurations.git

[apply this](#)

patch

```
git clone https://github.com/MarlinFirmware/Marlin.git
#git clone https://github.com/Jyers/Marlin.git

cd Marlin
check out latest release branch, for example 2.0.9.2
git clone https://github.com/MarlinFirmware/Configurations.git
cd Configurations
check out latest release branch, for example 2.0.9.2
#git clone https://github.com/Jyers/Configurations.git

# copy Configuration.h and Configuration_adv.h from examples
cd ..
rsync -av Configurations/config/examples/Geeetech/A20/ Marlin/

code .
// select default shell to bash Terminal: Select Default Profile

// change MOTHERBOARD
#define MOTHERBOARD BOARD_GT2560_V4_A20

// enable bltouch if present
// comment PROBE_MANUALLY and uncomment BLTOUCH
//#define PROBE_MANUALLY
#define BLTOUCH
#define Z_MIN_ENDSTOP_INVERTING false // Set to true to invert the logic of
the endstop.
#define Z_MIN_PROBE_ENDSTOP_INVERTING false // Set to true to invert the
logic of the probe.
#define Z_SAFE_HOMING

// temporary
#define X_BED_SIZE 200
#define Y_BED_SIZE 200
#define X_MIN_POS -10
```

```
// original plate 260x260
//#define X_BED_SIZE 255
//#define Y_BED_SIZE 255
//#define Y_MIN_POS -5
```

install marlin auto build extension

change vscode settings.json

javascript

```
{
  "terminal.integrated.defaultProfile.linux": "bash"
}
```

To upload firmware add a **custom FFF** (no geeetech A20 model) printer and use upload firmware menu

- [z offset wizard](#)
- [pid tuning](#)

Anycubic Predator

[manual silicone 039](#)

- [recensione 1](#)
- [customizzazioni](#)
- [cura profile](#)
 - rename *predatorimage.png.stl* to *predatorimage.png*

custom spare parts:

- [enclosure](#)
- [Fan Duct](#)
- [sensor holder](#)
- [smoothers holder](#)
- [Filament Sensor Relocation](#)

Marlin firmware predator

clone this [repository](#)

add to Marlin/Configuration.h

```
#define LCD_SCREEN_ROT_180
```

change

```
#define TEMP_SENSOR_0 11
```

decomment in Marlin/Configurationadv.h `<code> Enable for M105 to include ADC values read from temperature sensors. #define SHOWTEMPADC_VALUES </code> build project <code> scp .pio/build/trigorilla_pro/firmware.bin root@octoprint:/root </code> remove jumper jp1 and change other jumper to USB video getting info <code> stm32flash /dev/ttyUSB0 stm32flash 0.5 http://stm32flash.sourceforge.net/ Interface serial_posix: 57600 8E1 Version : 0x22 Option 1 : 0x00 Option 2 : 0x00 Device ID : 0x0414 (STM32F10xxx High-density) - RAM : 64KiB (512b reserved by bootloader) - Flash : 512KiB (size first sector: 2x2048) - Option RAM : 16b - System RAM : 2KiB </code> make backup <code> stm32flash -r predator-original.bin /dev/ttyUSB0 </code> write firmware <code> stm32flash -v -R -b 57600 -g 0x8000000 -w firmware.bin /dev/ttyUSB0 </code> platformio.ini <code> [env:trigorillapro] platform = ststm32 board = genericSTM32F103ZE buildflags = !python Marlin/src/HAL/STM32F1/build_flags.py </code> === Auto calibration === * configuration → delta calibration → auto → enter → wait → enter * configuration → store === z offset === Disable software endstops (M211 S0), preheat and with motion z to grab paper: get deltax (positive or negative, for example 0.3) * configuration → runout sensors → off * temperature → preheat PLA → preheat PLA * motion → z adjust probe z-offest adding deltax: * configuration → probe z-offest → =z-offest+deltax enable software endstops (M211 S1) store settings === z babysteps === <code> M290 Z0.25 ; move up 0.25mm on the Z axis ... M500 ; store </code> ===== PID autotune ===== start pid autotune at 220C and 8 cycles <code> M303 S220 C8 </code> wait and store proposed values with M301 <code> M301 P13.83 I0.76 D63.18 </code> save settings <code> M500 </code> ===== Thermocouple tuning ===== Get actual extruder thermocouple from Menu → About → Thermistors and from Configuration.h get actual thermistor_xx.h utilized set hotend to 200C from control and check in terminal ADC value (138.06 in example) <code> Recv: T:200.47 /200.00 (138.06) B:21.64 /0.00 (982.37) @:47 B@:0 </code>`

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