

**[profile]**

```
layer_height = 0.2
wall_thickness = 0.8
retraction_enable = True
solid_layer_thickness = 0.6
fill_density = 20
print_speed = 50
print_temperature = 210
print_temperature2 = 0
print_temperature3 = 0
print_temperature4 = 0
print_temperature5 = 0
print_bed_temperature = 65
support = None
platform_adhesion = None
support_dual_extrusion = Both
wipe_tower = False
wipe_tower_volume = 15
ooze_shield = False
filament_diameter = 1.77
filament_diameter2 = 0
filament_diameter3 = 0
filament_diameter4 = 0
filament_diameter5 = 0
filament_flow = 100.0
nozzle_size = 0.4
retraction_speed = 40.0
retraction_amount = 4.5
retraction_dual_amount = 16.5
retraction_min_travel = 1.5
retraction_combing = All
retraction_minimal_extrusion = 0.02
retraction_hop = 0.0
bottom_thickness = 0.3
layer0_width_factor = 150
object_sink = 0.0
overlap_dual = 0.15
travel_speed = 130
bottom_layer_speed = 20
infill_speed = 40.0
solidarea_speed = 15.0
inset0_speed = 30.0
insetx_speed = 0.0
cool_min_layer_time = 5
fan_enabled = True
skirt_line_count = 3
skirt_gap = 3.0
skirt_minimal_length = 150.0
fan_full_height = 0.5
fan_speed = 100
fan_speed_max = 100
cool_min_feedrate = 10
cool_head_lift = False
solid_top = True
solid_bottom = True
fill_overlap = 8
perimeter_before_infill = True
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support_type = Lines
support_angle = 60
support_fill_rate = 15
support_xy_distance = 0.7
support_z_distance = 0.15
spiralize = False
simple_mode = False
brim_line_count = 20
raft_margin = 5.0
raft_line_spacing = 3.0
raft_base_thickness = 0.3
raft_base_linewidth = 1.0
raft_interface_thickness = 0.27
raft_interface_linewidth = 0.4
raft_airgap_all = 0.0
raft_airgap = 0.22
raft_surface_layers = 2
raft_surface_thickness = 0.27
raft_surface_linewidth = 0.4
fix_horrible_union_all_type_a = True
fix_horrible_union_all_type_b = False
fix_horrible_use_open_bits = False
fix_horrible_extensive_stitching = False
plugin_config =
object_center_x = -1
object_center_y = -1

```

#### [alterations]

```

start.gcode = ;Sliced at: {day} {date} {time}
;Basic settings: Layer height: {layer_height} Walls: {wall_thickness} Fill: {fill_density}
;Print time: {print_time}
;Filament used: {filament_amount}m {filament_weight}g
;Filament cost: {filament_cost}
;M190 S{print_bed_temperature} ;Uncomment to add your own bed temperature line
;M109 S{print_temperature} ;Uncomment to add your own temperature line
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 Z15.0 F{travel_speed} ;move the platform down 15mm

G92 E0 ;zero the extruded length
G1 F200 E3 ;extrude 3mm of feed stock
G92 E0 ;zero the extruded length again
G1 F{travel_speed}
;Put printing message on LCD screen
M117 Printing...

end.gcode = ;End GCode
M104 S0 ;extruder heater off
M140 S0 ;heated bed heater off (if you have it)

G91 ;relative positioning

```

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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 F{travel_speed} ;move Z up a bit and retract filament even more
G28 X0 Y0 ;move X/Y to min endstops, so the head is out of
the way

M84 ;steppers off
G90 ;absolute positioning
;{profile_string}

```

```

start2.gcode = ;Sliced at: {day} {date} {time}
;Basic settings: Layer height: {layer_height} Walls: {wall_thickness} Fill: {fill_density}
;Print time: {print_time}
;Filament used: {filament_amount}m {filament_weight}g
;Filament cost: {filament_cost}
;M190 S{print_bed_temperature} ;Uncomment to add your own bed temperature line
;M104 S{print_temperature} ;Uncomment to add your own temperature line
;M109 T1 S{print_temperature2} ;Uncomment to add your own temperature line
;M109 T0 S{print_temperature} ;Uncomment to add your own temperature line
G21 ;metric values
G90 ;absolute positioning
M107 ;start with the fan off

G28 X0 Y0 ;move X/Y to min endstops
G28 Z0 ;move Z to min endstops

G1 Z15.0 F{travel_speed} ;move the platform down 15mm

T1 ;Switch to the 2nd extruder
G92 E0 ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0 ;zero the extruded length again
G1 F200 E-{retraction_dual_amount}

T0 ;Switch to the first extruder
G92 E0 ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0 ;zero the extruded length again
G1 F{travel_speed}
;Put printing message on LCD screen
M117 Printing...

```

```

end2.gcode = ;End GCode
M104 T0 S0 ;extruder heater off
M104 T1 S0 ;extruder heater off
M140 S0 ;heated bed heater off (if you have it)

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 F{travel_speed} ;move Z up a bit and retract filament even more
G28 X0 Y0 ;move X/Y to min endstops, so the head is out of
the way

M84 ;steppers off
G90 ;absolute positioning
;{profile_string}

```

```

start3.gcode = ;Sliced at: {day} {date} {time}
;Basic settings: Layer height: {layer_height} Walls: {wall_thickness} Fill: {fill_density}
;Print time: {print_time}
;Filament used: {filament_amount}m {filament_weight}g
;Filament cost: {filament_cost}
;M190 S{print_bed_temperature} ;Uncomment to add your own bed temperature line
;M104 S{print_temperature} ;Uncomment to add your own temperature line
;M109 T1 S{print_temperature2} ;Uncomment to add your own temperature line
;M109 T0 S{print_temperature} ;Uncomment to add your own temperature line
G21 ;metric values
G90 ;absolute positioning
M107 ;start with the fan off

G28 X0 Y0 ;move X/Y to min endstops
G28 Z0 ;move Z to min endstops

G1 Z15.0 F{travel_speed} ;move the platform down 15mm

T2 ;Switch to the 3rd extruder
G92 E0 ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0 ;zero the extruded length again
G1 F200 E-{retraction_dual_amount}

T1 ;Switch to the 2nd extruder
G92 E0 ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0 ;zero the extruded length again
G1 F200 E-{retraction_dual_amount}

T0 ;Switch to the first extruder
G92 E0 ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0 ;zero the extruded length again
G1 F{travel_speed}
;Put printing message on LCD screen
M117 Printing...

end3.gcode = ;End GCode
M104 T0 S0 ;extruder heater off
M104 T1 S0 ;extruder heater off
M104 T2 S0 ;extruder heater off
M140 S0 ;heated bed heater off (if you have it)

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 F{travel_speed} ;move Z up a bit and retract filament even more
G28 X0 Y0 ;move X/Y to min endstops, so the head is out of
the way

M84 ;steppers off
G90 ;absolute positioning
;{profile_string}

start4.gcode = ;Sliced at: {day} {date} {time}

```

```

;Basic settings: Layer height: {layer_height} Walls: {wall_thickness} Fill: {fill_density}
;Print time: {print_time}
;Filament used: {filament_amount}m {filament_weight}g
;Filament cost: {filament_cost}
;M190 S{print_bed_temperature} ;Uncomment to add your own bed temperature line
;M104 S{print_temperature} ;Uncomment to add your own temperature line
;M109 T2 S{print_temperature2} ;Uncomment to add your own temperature line
;M109 T1 S{print_temperature2} ;Uncomment to add your own temperature line
;M109 T0 S{print_temperature} ;Uncomment to add your own temperature line
G21          ;metric values
G90          ;absolute positioning
M107        ;start with the fan off

G28 X0 Y0   ;move X/Y to min endstops
G28 Z0      ;move Z to min endstops

G1 Z15.0 F{travel_speed} ;move the platform down 15mm

T3          ;Switch to the 4th extruder
G92 E0      ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0      ;zero the extruded length again
G1 F200 E-{retraction_dual_amount}

T2          ;Switch to the 3rd extruder
G92 E0      ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0      ;zero the extruded length again
G1 F200 E-{retraction_dual_amount}

T1          ;Switch to the 2nd extruder
G92 E0      ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0      ;zero the extruded length again
G1 F200 E-{retraction_dual_amount}

T0          ;Switch to the first extruder
G92 E0      ;zero the extruded length
G1 F200 E10 ;extrude 10mm of feed stock
G92 E0      ;zero the extruded length again
G1 F{travel_speed}
;Put printing message on LCD screen
M117 Printing...

end4.gcode = ;End GCode
M104 T0 S0          ;extruder heater off
M104 T1 S0          ;extruder heater off
M104 T2 S0          ;extruder heater off
M104 T3 S0          ;extruder heater off
M140 S0            ;heated bed heater off (if you have it)

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 F{travel_speed} ;move Z up a bit and retract filament even more
G28 X0 Y0          ;move X/Y to min endstops, so the head is out of
the way

```

```
M84                ;steppers off
G90                ;absolute positioning
;{profile_string}
```

```
support_start.gcode =
```

```
support_end.gcode =
```

```
cool_start.gcode =
```

```
cool_end.gcode =
```

```
replace.csv =
```

```
preswitchextruder.gcode = ;Switch between the current extruder and the next extruder, when
printing with multiple extruders.
```

```
    ;This code is added before the T(n)
```

```
postswitchextruder.gcode = ;Switch between the current extruder and the next extruder, when
printing with multiple extruders.
```

```
    ;This code is added after the T(n)
```