; Configuration file for Duet WiFi (firmware version 1.21)

; executed by the firmware on start-up

;

; generated by RepRapFirmware Configuration Tool v2 on Wed May 22 2019 18:55:37 GMT-0500 (Central Daylight Time)

; General preferences

G90 ; Send absolute coordinates...

M83 ; ...but relative extruder moves

; Network

M550 P"PlastiBot" ; Set machine name

M551 P"HARKNESS4" ; Set password

M552 S1 ; Enable network

M587 S"Tortuga" P"jackson5" ; Configure access point. You can delete this line once connected

M586 P0 S1 ; Enable HTTP

M586 P1 S1 ; Enable FTP

M586 P2 S1 ; Enable Telnet

; Drives

M569 P0 S1 ; Physical drive 0 goes forwards

M569 P1 S1 ; Physical drive 1 goes forwards

M569 P2 S1 ; Physical drive 2 goes forwards

M569 P3 S1 ; Physical drive 3 goes forwards

M350 X16 Y16 Z16 E16 I1 ; Configure microstepping with interpolation

M92 X80.00 Y80.00 Z4000.00 E420.00 ; Set steps per mm

M566 X900.00 Y900.00 Z12.00 E120.00 ; Set maximum instantaneous speed changes (mm/min)

M203 X6000.00 Y6000.00 Z180.00 E1200.00 ; Set maximum speeds (mm/min)

M201 X500.00 Y500.00 Z20.00 E250.00 ; Set accelerations (mm/s^2)

M906 X1600.00 Y800.00 Z800.00 E800.00 I30 ; Set motor currents (mA) and motor idle factor in per cent

M84 S30 ; Set idle timeout

; Axis Limits

M208 X0 Y0 Z0 S1 ; Set axis minima

M208 X260 Y280 Z230 S0 ; Set axis maxima

; Endstops

M574 X1 Y1 Z1 S1 ; Set active high endstops

; Z-Probe

M558 P0 H5 F120 T6000 ; Disable Z probe but set dive height, probe speed and travel speed

M557 X15:245 Y15:195 S20 ; Define mesh grid

; Heaters

M140 H1 ; Remap heated bed to heater 1

M307 H1 B1 S1.0 ; Enable bang-bang mode for the bed heater and set PWM limit

M141 H2 ; Assign chamber heater to heater 1

M307 H2 B0 S1.0 ; Enable bang-bang mode for the bed heater and set PWM limit

M305 P0 T100000 B4138 R4700 ; Set thermistor + ADC parameters for heater 0

M143 H0 S500 ; Set temperature limit for heater 0 to 500C

M305 P1 T100000 B4138 R4700 ; Set thermistor + ADC parameters for heater 1

M143 H1 S280 ; Set temperature limit for heater 1 to 280C

M305 P2 T100000 B4138 R4700 ; Set thermistor + ADC parameters for heater 2

M143 H2 S160 ; Set temperature limit for heater 2 to 160C

; Fans

M106 P0 S0 I0 F500 H T45 ; Set fan 0 value, PWM signal inversion and frequency. Thermostatic control is turned on

M106 P1 S1 I0 F500 H1 T45 ; Set fan 1 value, PWM signal inversion and frequency. Thermostatic control is turned on

; Tools

M563 P0 S"PlastiBot" D0 ; Define tool 0

G10 P0 X0 Y0 Z0 ; Set tool 0 axis offsets

G10 P0 R0 S0 ; Set initial tool 0 active and standby temperatures to 0C

; Automatic power saving

M911 S10 R11 P"M913 X0 Y0 G91 M83 G1 Z3 E-5 F1000" ; Set voltage thresholds and actions to run on power loss

; Custom settings are not configured

; Miscellaneous

T0 ; Select first tool