; Configurat; Configuration file for Duet WiFi / Ethernet

; executed by the firmware on start-up

; General preferences

M111 S0 ; Debugging off

G21 ; Work in millimetres

G90 ; Send absolute coordinates...

M83 ; ...but relative extruder moves

M555 P2 ; Set firmware compatibility to look like Marlin

; Network

M550 P"ToolChanger" ; Set machine name

;M587 S"Ziggo5687440" P"117WilmaAd117" ; WiFi Settings

;M552 S1 P"Ziggo5687440" ; Enable WiFi Networking

M552 S1 ; Enable Networking

M586 P0 S1 ; Enable HTTP

M586 P1 S0 ; Disable FTP

M586 P2 S0 ; Disable Telnet

M667 S1 ; Select CoreXY mode

; Endstops

M574 X1 Y1 S3 ; Set X / Y endstop stall detection

M574 Z1 S2 ; Set Z endstop probe

M558 P7 X0 Y0 Z2 H3 F360 I0 T20000 ; Set Z probe type to switch, the axes for which it is used and the dive height + speeds

G31 P200 X0 Y0 Z0 ; Set Z probe trigger value, offset and trigger height

M557 X10:290 Y20:180 S40 ; Define mesh grid

; Drive direction

M569 P0 S0 ; Drive 0 X

M569 P1 S0 ; Drive 1 Y

M569 P2 S1 ; Drive 2 Z

M569 P3 S0 ; Drive 3 E0

M569 P4 S0 ; Drive 4 E1

M569 P5 S1 ; Drive 5 E2

M569 P6 S1 ; Drive 6 E3

M569 P7 S0 ; Drive 7 COUPLER

M569 P8 S0 ; Drive 8 UNUSED

M569 P9 S0 ; Drive 9 UNUSED

M584 X0 Y1 Z2 C7 E3:4:5:6 ; Apply custom drive mapping

M208 X-35:328.5 Y-49:243 Z0:300 C0:500 S0 ; Set axis maxima & minima

M350 E8:8:8:8 C8 I0 ; Configure microstepping without interpolation

M350 X16 Y16 Z16 I1 ; Configure microstepping with interpolation

M92 X100 Y100 Z1600 C100 E417:417:417:417 ; Set steps per mm

M566 X900 Y900 Z30 C2 E3000:3000:3000:3000 ; Set maximum instantaneous speed changes (mm/min)

M203 X35000 Y35000 Z1200 C5000 E5000:5000:5000:5000 ; Set maximum speeds (mm/min)

M201 X6000 Y6000 Z400 C500 E2500:2500:2500:2500 ; Set accelerations (mm/s^2)

M906 X2000 Y2000 Z1330 C400 E1680:1680:1680:1680 I30 ; Set motor currents (mA) and motor idle factor in percent

M84 S120 ; Set idle timeout

;Stall Detection

M915 C S5 F0 H200 R4700 ; Coupler

;Stall Detection

M915 X Y S5 F0 H400 R4700 ; X / Y Axes

; Heaters

M305 P0 T100000 B4138 C0 ; Set thermistor

M143 H0 S225 ; Set temperature limit for heater 0 to 225C

M305 S"T0" P1 R4700 T100000 B4388 ; Set thermistor

M143 H1 S300 ; Set temperature limit for heater 1 to 300C

M305 S"T1" P2 R4700 T100000 B4388 ; Set thermistor

M143 H2 S300 ; Set temperature limit for heater 2 to 300C

M305 S"T2" P3 R4700 T100000 B4388 ;Set thermistor

M143 H3 S300 ; Set temperature limit for heater 3 to 300C

M305 S"T3" P4 R4700 T100000 B4388 ; Set thermistor

M143 H4 S300 ; Set temperature limit for heater 4 to 300C

; Tools

M563 P0 S"T0" D0 H1 ; Define tool 0

G10 P0 X0 Y0 Z0 ; Reset tool 0 axis offsets

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

M563 P1 S"T1" D1 H2 ; Define tool 1

G10 P1 X0 Y0 Z0 ; Reset tool 1 axis offsets

G10 P1 R0 S0 ; Reset initial tool 1 active and standby temperatures to 0C

M563 P2 S"T2" D2 H3 F3 ; Define tool 2

G10 P2 X0 Y0 Z0 ; Reset tool 2 axis offsets

G10 P2 R0 S0 ; Reset initial tool 2 active and standby temperatures to 0C

M563 P3 S"T3" D3 H4 ; Define tool 3

G10 P3 X0 Y0 Z0 ; Reset tool 3 axis offsets

G10 P3 R0 S0 ; Reset initial tool 3 active and standby temperatures to 0C

; Fans

M106 P0 S0 ; UNUSED

M106 P1 S255 H1 T70 ; T0 HE

M106 P2 S0 ; T0 PCF

M106 P3 S255 H2 T70 ; T1 HE

M106 P4 S0 ; T1 PCF

M106 P5 S255 H3 T70 ; T2 HE

M106 P6 S0 ; T2 PCF

M106 P7 S255 H4 T70 ; T3 HE

M106 P8 S0 ; T3 PCF

M593 F50 ; cancel ringing at 50Hz (https://forum.e3d-online.com/threads/accelerometer-and-resonance-measurements-of-the-motion-system.3445/)

;M376 H15 ; bed compensation taper

;tool offsets

G10 P0 X-9 Y39 Z-4.470 ; T0

G10 P1 X-8.75 Y38.85 Z-4.84 ; T1

G10 P2 X-9.25 Y39.1 Z-4.510 ; T2

G10 P3 X-8.7 Y38.9 Z-4.625 ; T3

;deselect tools

T-1

;M572 D0 S0.2 ; pressure advance T0

;M572 D1 S0.2 ; pressure advance T1

;M572 D2 S0.2 ; pressure advance T2

;M572 D3 S0.2 ; pressure advance T3