**CONFIG.G**

; Configuration file for My Printer

; Communication and general

M111 S0 ; Debug off

M550 PRailCore ; Machine name and Netbios name (can be anything you like)

;M551 Pmyrap ; Machine password (used for FTP)

;\*\*\* If you have more than one Duet on your network, they must all have different MAC addresses, so change the last digits

;M540 P0xBE:0xEF:0xDE:0xAD:0xFE:0xEE ; Uncomment and change if you want to set a MAC address

;\*\*\* Wifi Networking

M552 S1 ; Enable WiFi

M555 P2 ; Set output to look like Marlin

M575 P1 B57600 S1 ; Comms parameters for PanelDue

G21 ; Work in millimetres

G90 ; Send absolute coordinates...

M83 ; ...but relative extruder moves

; Axis and motor configuration

M669 K1 ; CoreXY mode

M584 X0 Y1 Z5:6:7 E3:4:8:9 ; Map Z to drivers 5, 6, 7. Define unused drivers 3,4,8 and 9 as extruders

M569 P0 S0 ; Drive 0 goes forwards (change to S0 to reverse it) X stepper (Rear)

M569 P1 S1 ; Drive 1 goes backwards Y Stepper (Front)

M569 P2 S1 ; Drive 2 goes forwards Unused

M569 P3 S0 ; Drive 3 goes forwards Extruder

M569 P4 S1 ; Drive 4 goes forwards Extruder (unused)

M569 P5 S0 ; Drive 5 goes backwards Front Left Z

M569 P6 S0 ; Drive 6 goes backwards Rear Left Z

M569 P7 S0 ; Drive 7 goes backwards

;Leadscrew locations

M671 X-10:-10:333 Y22.5:277.5:150 S7.5 ;Front left, Rear Left, Right S7.5 is the max correction - measure your own offsets, to the bolt for the yoke of each leadscrew

M350 X16 Y16 Z16 E16 I1 ; set 16x microstepping for axes& extruder, with interpolation

M574 X1 Y1 Z0 S1 ; set homing switch configuration (x,y at min, z at max) IF YOU NEED TO REVERSE YOUR HOMING SWITCHES CHANGE S1 to S0

M906 X1400 Y1400 Z1000 E800 I60 ; Set motor currents (mA)

M201 X3000 Y3000 Z100 E1500 ; Accelerations (mm/s^2)

M203 X24000 Y24000 Z900 E3600 ; Maximum speeds (mm/min)

M566 X1000 Y1000 Z100 E1500 ; Maximum jerk speeds mm/minute

M208 X290 Y290 Z280 ; set axis maxima and high homing switch positions (adjust to suit your machine)

M208 X0 Y0 Z-0.5 S1 ; set axis minima and low homing switch positions (adjust to make X=0 and Y=0 the edges of the bed)

M92 X200 Y200 Z1600 E837 ; steps/mm

; Thermistors

M305 P0 T100000 B3950 R4700 H0 L0 ; Put your own H and/or L values here to set the bed thermistor ADC correction

;If you have a Slice Engineering thermistor, comment out the next line

M305 P1 T100000 B4725 R4700 H0 L0 C7.06e-8 ; Put your own H and/or L values here to set the first nozzle thermistor ADC correction

;If you have a Slice Engineering thermistor, uncomment the next lines. KITS DO NOT SHIP WITH A SLICE THERMISTOR - ONLY UNCOMMENT IF YOU ORDERED ONE

;M305 P1 T500000 B4723 C1.196220e-7 ; Set thermistor + ADC parameters for slice thermistor

M307 H0 A240.3 C608.7 D8.2 V24.1 B0 ; Bed Heaters

M307 H1 A270.7 C90.4 D6.7 V24.0 B0 ;Heater 1 model

M570 S360 ; Hot end may be a little slow to heat up so allow it 180 seconds

M143 S285

; Fans

M106 P0 H-1 ; disable thermostatic mode for fan 0

M106 P1 H-1 ; disable thermostatic mode for fan 1

M106 P2 H-1

M106 P0 S0 ; turn off fans

M106 P1 S0

M106 P2 S0

; Tool definitions

M563 P0 D0 H1 ; Define tool 0

G10 P0 S0 R0 ; Set tool 0 operating and standby temperatures

;\*\*\* If you have a single-nozzle build, comment the next 2 lines

;M563 P1 D1 H2 ; Define tool 1

;G10 P1 S0 R0 X0 Y17 ; Set tool 1 operating and standby temperatures

; Z probe and compensation definition

;\*\*\* If you have a switch instead of an IR probe, change P1 to P4 in the following M558 command

; IR PRobe - uncomment the following 2 lines if you have a and IR Probe, and comment out the BLTouch section below

;M558 P1 X0 Y0 Z1 ; Z probe is an IR probe and is not used for homing any axes

;G31 X0 Y30 Z1.0 P500 ; Set the zprobe height and threshold (put your own values here)

;BLTouch - comment out the following 3 lines if using a IR Probe

M307 H3 A-1 C-1 D-1

M558 P9 X0 Y0 Z1 H5 F150 T6000 A5 S0.02

G31 X-4 Y42 Z1.0 P25 ; Customize your offsets appropriately - do a paper test, and put the probed value in the Z value here

;

T0 ; select first hot end

**HOMEALL.G**

M98 P"homex.g"

M98 P"homey.g"

M98 P"homez.g"

**HOMEZ.G**

G91

G1 Z5 F800 H2

G90

G1 X150 Y150 F2400

G30

G1 Z10 F200

Circuit: Duet WiFi 1.02 or later + DueX5

Firmware: RepRapFirmware for Duet 2 WiFi/Ethernet

Firmware Version: 2.05.1 (2020-02-09b1)

Duet WiFi Server Version: 1.23

Web Interface Version: 1.22.6