

Configuring a Slicer for the Emergence PRO™

STEP ONE

Set the firmware type to **RepRap**.

STEP TWO

Set the build volume to rectangular and input the build area.

X-Axis: 480 mm
Y-Axis: 330 mm
Z-Axis: 635 mm

STEP FOUR

Set the Z offset to **-0.20 mm** to account for the 0.20 mm shim that is typically used to gap the nozzle.

STEP THREE

Set the hardware for a single extruder and heated bed.

If configurable, the extruder should be set to **Tool 0**.

STEP FIVE

Set the starting G-code:

```

;EP V2.0 START GCODE
M291 P"PRINT STARTED. PREHEATING BED AND NOZZLE" S1 T10
G21 ; SET UNITS TO MILLIMETERS
G90 ; USE ABSOLUTE COORDINATES
M82 ; USE ABSOLUTE DISTANCES FOR EXTRUSION
M140 S[FIRST_LAYER_BED_TEMPERATURE] ;SET BED TEMP
M104 S[FIRST_LAYER_TEMPERATURE] ;SET EXTRUDER TEMP
M190 S[FIRST_LAYER_BED_TEMPERATURE] ;WAIT FOR BED TEMP
M109 S[FIRST_LAYER_TEMPERATURE] ;WAIT FOR EXTRUDER TEMP
G90 ; EXPLICITLY FORCE ABSOLUTE POSITIONING IN CASE IT WAS
NOT RESET PREVIOUSLY.
G28 ; HOME ALL AXES
G1 X-14 Y35 F9000 ; MOVE TO WIPE POSITION
G1 Z5 F4000 ; LOWER Z
G1 Y5 F2000 ; WIPE NOZZLE
G1 Z10 F4000
G1 X35 F9000 ; MOVE CLEAR OF BRUSH
G1 Z5 F4000
;M557 X80:330 Y80:225 P8:7 ; UNCOMMENT TO DEFINE CUSTOM
POBE AREA
G29 ; RUN BED PROBE
G1 X15 Y10 F9000 ; MOVE TO THE FRONT-LEFT PART OF THE BED.
G1 Z0.15 F4000 ; RAISE Z
G92 E0 ; ZERO THE EXTRUDER.
G1 X75 E50 F500 ; EXTRUDE A FAT LINE OF FILAMENT TO PRIME
AND CLEAN THE NOZZLE.
G92 E0 ; ZERO THE EXTRUDER.
G1 E-2 F2000 ; RETRACT 2 MM.
G1 X90 F9000 ; SWEEP RIGHT TO CUT ANY STRING

```

Note: The variables used for the bed and nozzle temperatures will be slicer specific.

STEP SIX

Set the ending script:

```

G92 E0 ; ZERO THE EXTRUDER.
G1 E-5 F3000 ; RETRACT FILAMENT
G91 ; RELATIVE MODE
G1 Z10 ; RAISE Z 10MM
G90 ; ABSOLUTE MODE
M107 ; FAN OFF
M104 S0 T0 ; SET HEAT TO 0
M140 S0 ; SET BED TO 0
G28 X0 Y0 ; HOME X Y
M18 S10 X Y E0 ; TURN OFF X Y
EXTRUDER

```