

SOVOL SV01

Ultimaker CURA / Creality Slicer

[start.gcode](#)

```
M201 X500.00 Y500.00 Z100.00 E5000.00 ;Setup machine max acceleration
M203 X500.00 Y500.00 Z10.00 E50.00 ;Setup machine max feedrate
M204 P500.00 R1000.00 T500.00 ;Setup Print/Retract/Travel acceleration
M205 X8.00 Y8.00 Z0.40 E5.00 ;Setup Jerk
M220 S100 ;Reset Feedrate
M221 S100 ;Reset Flowrate

G28 ;Home
G29 A; to turn leveling on
G29 L1 ;Load mesh
G29 J2 ;Four point level

;Sound Check
M300 S1108 P150
M300 S1174 P150

G92 E0 ;Reset Extruder
G1 Z2.0 F3000 ;Move Z Axis up
G1 X10.1 Y20 Z0.28 F5000.0 ;Move to start position
G1 X10.1 Y200.0 Z0.28 F1500.0 E15 ;Draw the first line
G1 X10.4 Y200.0 Z0.28 F5000.0 ;Move to side a little
G1 X10.4 Y20 Z0.28 F1500.0 E30 ;Draw the second line
G92 E0 ;Reset Extruder
G1 Z2.0 F3000 ;Move Z Axis up
```

[end.gcode](#)

```
G91 ;Relative positioning
G1 E-2 F2700 ;Retract a bit
G1 E-2 Z0.2 F2400 ;Retract and raise Z
G1 X0 Y240 F3000 ;Wipe out
G1 Z10 ;Raise Z more
G90 ;Absolute positioning

M106 S0 ;Turn-off fan
M104 S0 ;Turn-off hotend
M140 S0 ;Turn-off bed

G1 X0 Y{machine_depth} ;Present print
```

```
G1 Z300 F150 ;Move Z Axis up

M84 X Y E ;Disable all steppers but Z

;Sound Check
M300 S1174 P150
M300 S1108 P150
```

Общие настройки

- Relative Extrusion - ON. Формирует G-Code с относительными значениями выдавливания филамента. Теоритически будет точнее чем абсолютные значения и проще GCode.

Travel

- Combing - Off
- Z Hop When Retracted - On
- Z Hop only over printed parts - on
- Z Hop height - 0.2mm

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