

How to set up IdeaMaker

This will setup IdeaMaker for the **Klipper Printer Additions**. I made this guide with IdeaMaker 4.4.0.

Start-G-Code

There doesn't seem to be a variable for filament type ("FILA_TYPE" parameter). As a workaround "filament_name1" is used. If the filament name contains "TPU", it will be recognized by the KPA as TPU-Filament.

- The following text block contains **minimized text lines**, so it has no line breaks on copy & paste, which would later lead to error messages.
- **Select** the following **ENTIRE** text block. **Do not copy line-per-line!** Copy & Paste the **entire** text block into the **Start-G-Code**:

; This is a text block with minimized lines.

;;; KPA Start

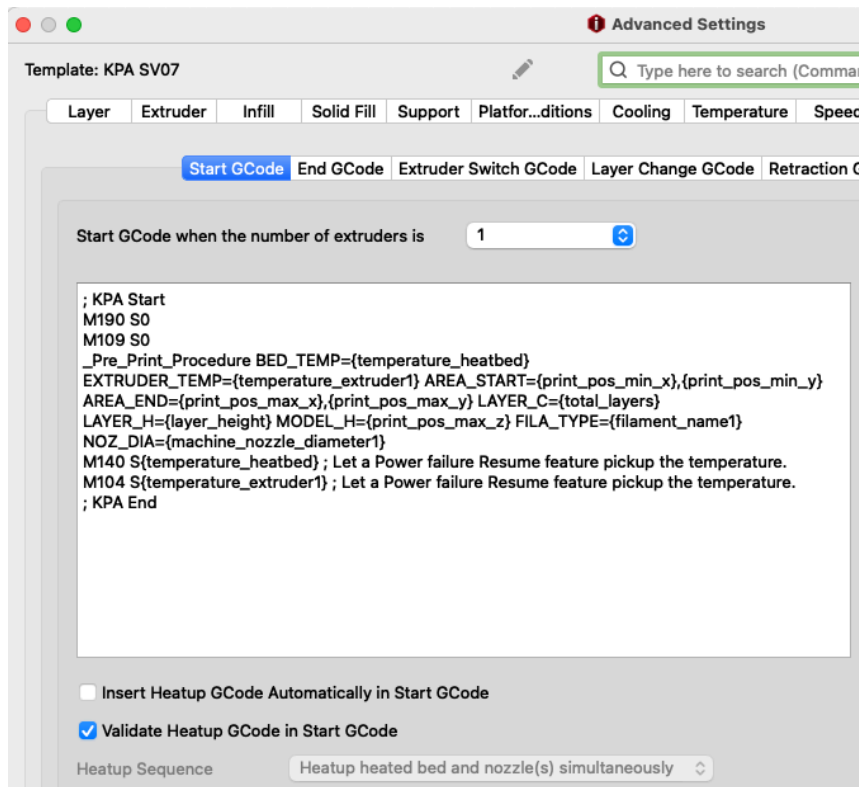
M190 S0

M109 S0

;;_Pre_Print_Procedure BED_TEMP={temperature_heatbed} EXTRUDER_TEMP={temperature_extruder1} AREA_START={print_pos_min_x},{print_pos_min_y} AREA_END={print_pos_max_x},{print_pos_max_y} LAYER_C={total_layers} LAYER_H={layer_height} MODEL_H={print_pos_max_z} FILA_TYPE={filament_name1} NOZ_DIA={machine_nozzle_diameter1}
M140 S{temperature_heatbed} ; Let a Power failure Resume feature pickup the temperature.
M104 S{temperature_extruder1} ; Let a Power failure Resume feature pickup the temperature.

;;; KPA End

- You don't need anything else in your **Start-G-Code**. If you have G-Code commands in there, comment them out, or delete them.



You may get this false error message, which you can ignore:



End-G-Code

- For the **End-G-Code** section, copy & paste this text line:

```
; KPA Start  
_End_Print  
; KPA End
```

- This is a macro of the Printer Additions which cleans up state, lifts up the extruder a bit higher, retracts a bit more, and turns off the heaters, motors, fans.
- You don't need anything else in your **End-G-Code**. If you have G-Code commands in there, comment them out, or delete them.

Slicer Modes

- In the **Printer Settings**, under **General**, set the **Firmware** to "**Klipper**", if available. Otherwise chose "**Marlin**":

Printer Settings

Printer Type:

Prusa MK3S - 0.4mm Nozzle

Remove

Export

Reset

General

Advanced

Primary Extruder

Printer Settings

Printer Type Abbreviation:

MK3S-04_

Nozzle Diameter:

0.40

mm

Build Width:

250.00

mm

Build Depth:

210.00

mm

Build Height:

210.00

mm

☒ Use Heated Bed

☒ Enable Fan Speed Control (Use PWM-Controllable Fans)

Distance From Border of Build Plate:

1.00

mm

Build Plate Shape:

Rectangle

☐ Bed origin at the center

Firmware:

Marlin

Extruders

Extruder Count:

1

Primary Extruder:

FormFutura - Tough PLA

Clearance Settings for Sequential Printing

Gantry Height:

55.00

mm

☐ Allow Custom Printing Priority in Sequential Printing

☒ Validate Printing Priority before Slicing

GCode Export

Default Action:

Export to Local Disk

?

Add

Duplicate

Import

Close

Save

- In the **Printer Settings**, under **Advanced**, tick the checkbox for **Relative Extrusion**:

Printer Settings

Printer Type: Prusa MK3S - 0.4mm Nozzle (modified) [Remove] [Export] [Reset]

General **Advanced** Primary Extruder

Other

Step-E per MM: 280.00

X-axis Compensation: 100.00 %

Y-axis Compensation: 100.00 %

Baud Rate: 115200

☒ Change GCode E length by multiplying filament flowrate

☐ Independent Dual Extrusion

☐ Confirm Using Raft if Size is more than 150.00 mm

☐ Confirm Using Raft if Print Mode is Duplication or Mirror

☐ Wait for Heating at Extruder Switch

☒ **Relative Extrusion**

☐ Firmware Retraction

☐ Reset GCode E Length on Layer Change

☐ Belt Printer 45 Deg

☒ Omit RaiseTouch Specified GCode

End of Start GCode: ;end of Start GCode

Beginning of End GCode: ;End GCode

Pause at Height GCode: ;Pause Code

Data File

☒ Output Data File

☐ Add Content of Data File into GCode File

Thumbnail: 640 X 640

☐ GCode Thumbnails for OctoPrint and Mainsail

Resolution: 200 X 200

Temperature Limit

Heated Bed Maximum Temperature Limit: 120 °C

[?] [Add] [Duplicate] [Import] [Close] [Save]

Object Exclusion

- Object Exclusion should work without any settings change.

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- Amazon: <https://amzn.to/3L35OX2>

Thank you!

Christian 😊