How to set up IdeaMaker

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

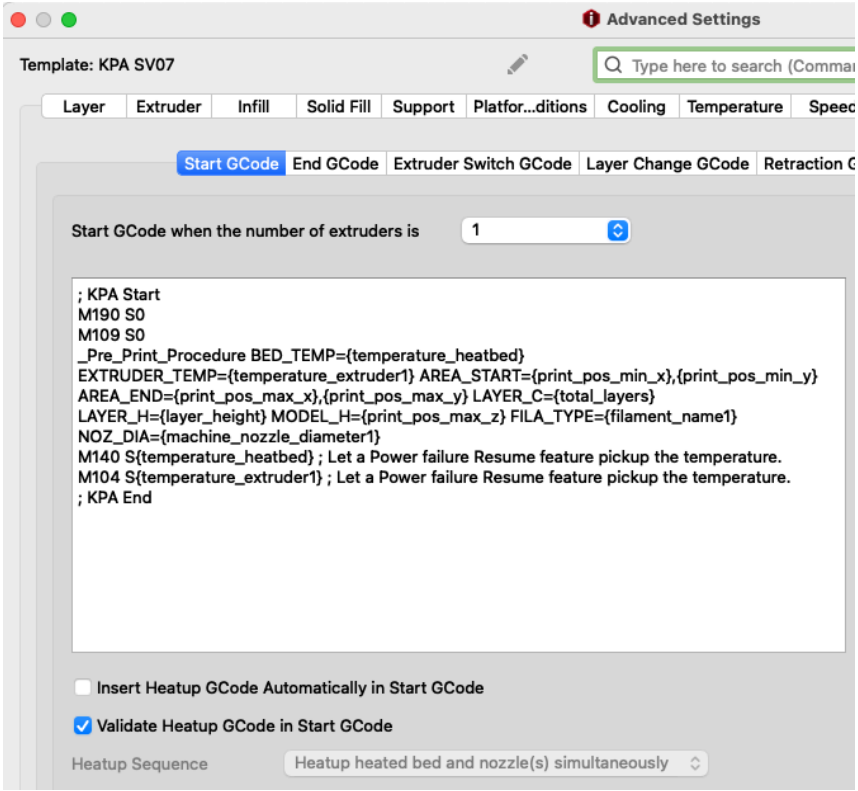
Start-G-Code

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.

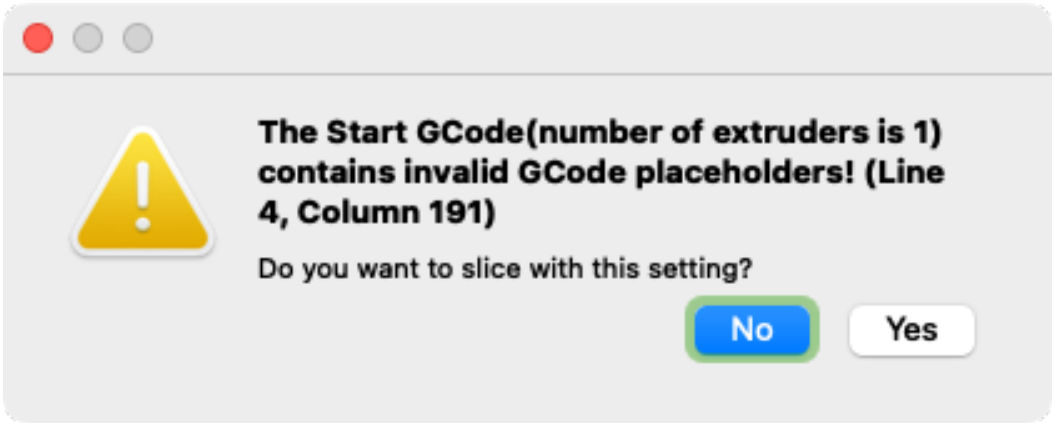
- The following text block contains **minimized text lines**, so it has no line breaks on copy & paste, which would later lead to error messages.
- **Select** the following **ENTIRE** text block. Do not copy line-per-line! Copy & Paste the **entire** text block into the **Start-G-Code**:

```
; 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

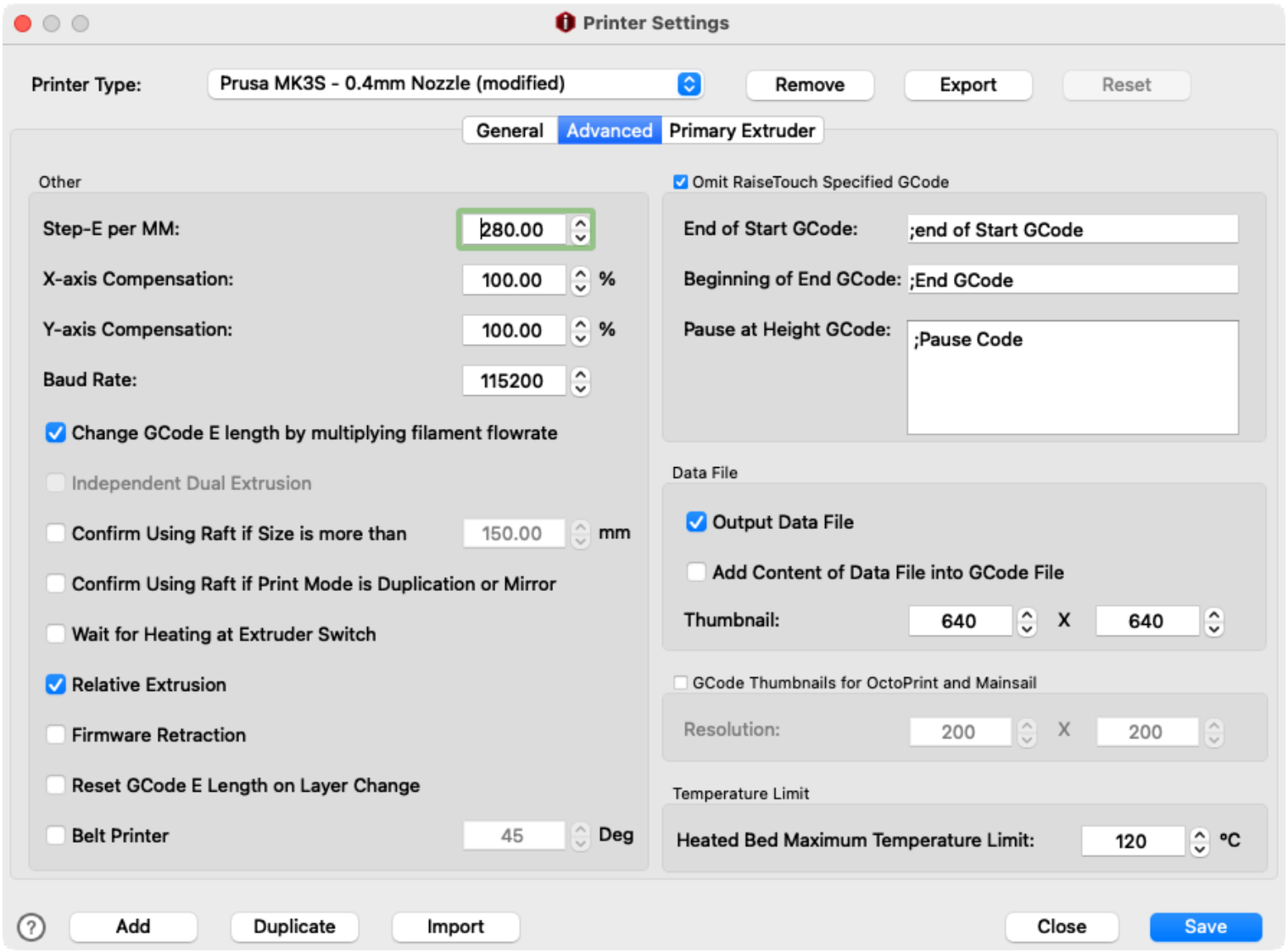
☑ Validate Printing Priority before Slicing

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:



Object Exclusion

• Object Exclusion should work without any settings change.

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Thank you!

Christian 🙂