

How to set up other Slicer Apps for the Klipper Printer Additions

If you successfully setup a slicer app for which no guide exists, please let me know so I can create one. Thank you!

Start-G-Code

- In your slicer app, open the "**Start-G-Code**" section. You find it usually in the printer-settings.

Put a [macro-call](#) into the **Start-G-Code** section. The macro-name is "[_Pre_Print_Procedure](#)". Note the underscore at the beginning.

The following two **parameters** are required:

- Parameter **BED_TEMP** is the bed temperature.
- Parameter **EXTRUDER_TEMP** is the extruder (nozzle) temperature.

Optional - if you want to use an adaptive mesh / adaptive priming:

- Parameter **AREA_START** is a list of two values - the minimum X and Y of the print model on the bed.
- Parameter **AREA_END** is a list of two values - the maximum X and Y of the print model on the bed.

Optional - if you want to use the feature "Print Slow In Height" more comfortable:

- Parameter **LAYER_C** is the total count of layers.
- Parameter **LAYER_H** is the layer height.

Alternative, if your slicer has a variable for the model's height:

- Parameter **MODEL_H**

Optional - to get automatic flow reduction on priming:

- Parameter **FILA_TYPE** is the type of the filament.
- Parameter **NOZ_DIA** is the diameter of the nozzle.

End-G-Code

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

[_End_Print](#)

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.

Slicer Modes

- In your slicer, set the **g-code mode** to "Klipper", if available. Otherwise chose "Marlin".
- In your slicer, make sure the **Extruder mode** is set to "Relative". Otherwise your extruder will spin like crazy.

The naming of these options may differ from slicer to slicer.

Object Exclusion

- In your slicer, look for a "Label Objects" setting and enable it.
- In your slicer, look for a "Exclude Objects" setting and enable it.

It might be that the naming is different, or that only **one** or **none** of such setting exists. Object Exclusion may still work. Or not.

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Thank you!

Christian 😊