



making printing easy, fun and productive!

G-codes for multi-media t-shirt video

Full video found here: <https://youtu.be/jvtBIAGROCs>

Relevant Gcode settings

- * Follow bold text for adding lines of code or uncommenting by adding “;”
- * Other code is shown for your reference of position.

1. Commands for Marker Settings

Printer Settings > Machine G-code > Machine start G-code G90, use absolute coordinate
M83; extruder relative mode

M302 P1 ; disable thermistor

;M104 S[nozzle temperature initial layer]; set extruder temp

M140 S[bed_temperature_initial_layer_single]; set bed temp

M190 S[bed_temperature_initial_layer_single]; wait for bed temp

;M109 S[nozzle temperature initial_layer_single]; wait for extruder temp

G28; home all

G1 X2 Y10 F3000

G1 Z0.28 F240

G92 E0

;G1 Y190 E15 F1500; intro line G1 X2.3 F5000

G92 E0

;G1 Y10 E15 F1200; intro line

G92 E0

Printer Settings > Machine G-code > Change filament G-code

G1 Z40; Move Head up

M0; pause to replace marker

Save Printer settings Profile with a name as: Marker Printing

2. Commands for TPU Settings

Printer Settings > Machine G-code > Machine start G-code

G1 X2 Y10 F3000

G1 Z0.28 F240

G92 E0

;G1 Y190 E15 F1500 ; intro line G1 X2.3 F5000

G92 E0

;G1 Y10 E15 F1200; intro line

G92 E0

Save Printer settings Profile with a name as: TPU on t-shirt