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[profile]
filament_diameter = 1.75
nozzle_size = 0.4
wall_thickness = 0.8
retraction_enable = True
layer_height = 0.1
solid_layer_thickness = 0.6
fill_density = 30
print_speed = 50
print_temperature = 220
support = None
enable_raft = False
filament_density = 1.00
skirt_line_count = 1
skirt_gap = 6.0
retraction_min_travel = 5.0
retraction_speed = 90.0
retraction_amount = 7
retraction_extra = 0.0
travel_speed = 150
max_z_speed = 3.0
bottom_layer_speed = 15
cool_min_layer_time = 10
fan_enabled = True
bottom_thickness = 0.2
enable_skin = False
plugin_config =
flip_x = False
flip_y = False
flip_z = False
swap_xz = False
swap_yz = False
model_scale = 1.0
model_rotate_base = 0
extra_base_wall_thickness = 0.0
cool_min_feedrate = 5
fan_layer = 1
fan_speed = 100
fan_speed_max = 100
raft_margin = 5
raft_base_material_amount = 100
raft_interface_material_amount = 100
support_rate = 50
support_distance = 0.5
infill_type = Line
solid_top = True
fill_overlap = 15
bridge_speed = 100
sequence = Loops > Perimeter > Infill
force_first_layer_sequence = True
joris = False
retract_on_jumps_only = True
hop_on_move = False
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[alterations]
start.gcode = ;Sliced {filename} at: {day} {date} {time}
    ;Basic settings: Layer height: {layer_height} Walls:
{wall_thickness} Fill: {fill_density}
    ;Print time: {print_time}
    ;Filament used: {filament_amount}m {filament_weight}g
    ;Filament cost: {filament_cost}
G21          ;metric values
G90          ;absolute positioning
M107        ;start with the fan off
G28 X0 Y0   ;move X/Y to min endstops
G28 Z0      ;move Z to min endstops
G92 X0 Y0 Z0 E0      ;reset software position to front/
left/z=0.0
    G1 Z15.0 F{max_z_speed} ;move the platform down 15mm
    G92 E0                  ;zero the extruded length
    G1 F200 E3              ;extrude 3mm of feed stock
    G92 E0                  ;zero the extruded length again
    G1 F{travel_speed}
end.gcode = ;End GCode
    M104 S0                 ;extruder heater off
    M140 S0                 ;heated bed heater off (if you
have it)
    G91                    ;relative
positioning
    G1 E-1 F300             ;retract the
filament a bit before lifting the nozzle, to release some of the
pressure
    G1 Z+0.5 E-5 X-20 Y-20 F{travel_speed} ;move Z up a bit and
retract filament even more
    G28 X0 Y0              ;move X/Y to min
endstops, so the head is out of the way
    M84                    ;steppers off
    G90                    ;absolute positioning
nextobject.gcode = ;Move to next object on the platform. clear_z is
the minimal z height we need to make sure we do not hit any objects.
    G92 E0
    G91                    ;relative
positioning
    G1 E-1 F300             ;retract the
filament a bit before lifting the nozzle, to release some of the
pressure
    G1 Z+0.5 E-5 F{travel_speed} ;move Z up a bit and
retract filament even more
    G90                    ;absolute
positioning
    G1 Z{clear_z} F{max_z_speed}
    G92 E0
    G1 X{object_center_x} Y{object_center_x} F{travel_speed}
    G1 F200 E6
    G92 E0
replace.csv =

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