

ORIGINAL gcode AS PER CURA 5.2.1

1. G21 ;metric values
2. G90; ;absolute positioning
3. M82; ;set extruder to absolute mode
4. M107 ;start with fan off
5. G28 Z0 ;home Z
6. G1 Z15.0 F840
7. G92 E0 ;zero the extruded length
8. G1 F200 E3 ;extrude 3mm of feed sto
9. G92 E0 ;zero the extruded length
10. G1 F840
11. ;Put printing on LCD screen
12. M117 Printing...

MY MODDED gcode

1. G21 ;metric values
2. G90; ;absolute positioning
3. M82; ;set extruder to absolute mode
4. M107 ;start with fan off
5. M109; Set extruder temperature and Wait
6. M140; Set bed temperature
7. M190; Wait for bed temperature
8. G28 X160 Y160 ;home Z
9. G1 Z15.0 F840
10. G92 E0 ;zero the extruded length
11. G1 F200 E3 ;extrude 3mm of feed sto
12. G92 E0 ;zero the extruded length
13. G1 F840
14. ;Put printing on LCD screen
15. M117 Printing...

ISSUES PRINTING

First Print - 1_Print Test Cube_25x25x25 G-code.gcode

As I tried to print, the print head would start with absolute 0 of 160,160. It ran print routine until I killed it as the Z axis remained constant.

Second Print - 1_30x30x0.20.gcode

Removed filament to avoid mess on print bed. Print head would start with absolute 0 of 160,160, about 25 mm above print bed. It ran print routine until complete as it was a low print. Throughout the print the Z axis remained constant.

1. Is it possible line 9 in **MY MODDED gcode** "G1 Z15.0 F840" is the potential issue?
2. Do you have any suggestions/critiques regarding my altered gcode