

# Extruder gets cooled down before end of print #2918

Edit New issue

Open MB3Y opened this issue on 5 Dec 2017 · 7 comments



MB3Y commented on 5 Dec 2017

Hi,  
I have a diamond hotend, taking 3 filaments in.  
On the last layer Cura generates "M104 T2 S0" before the end of the print, i.e. the print is finalising last skin with T0.  
On diamond hotend setup though M104 controls the temp for THE extruder, so heating is shut down completely :(  
I can surely upload project and gcode if you require it and tell me where to put it.  
Cherio,  
Mikael

### Assignees

No one assigned

### Labels

3rd party only

### Projects

None yet

### Milestone

No milestone

### Notifications

4 participants



nallath commented on 15 Dec 2017

Contributor

We don't have a diamond hotend, so this is almost impossible for us to test. We can't provide any support for this unfortunately.

ChrisTerBeke added the 3rd party only label on 15 Dec 2017



ChrisTerBeke commented on 15 Dec 2017

Member

I think the firmware should actually handle this, Cura is not aware that all hot-ends are on the same extruder (T). The firmware should prevent using T1 or T2 to disable the heating.



Ghostkeeper commented 12 days ago

Owner

You could also (as a workaround) add a Search-and-Replace post-processing script that replaces M104 S\d+ T with ;<removed M104>



MB3Y commented 12 days ago

I'd love that.. but don't know how to couple a post processor directly into Cura? Is there a user guide as of how to make and couple such yourself?



Ghostkeeper commented 12 days ago

Owner

It's under Extensions -> Post-Processing -> Modify G-Code.



MB3Y commented 12 days ago

@Ghostkeeper : that was the part I already figured out :) - my questions are about where to put a script, having an example script, how to couple it such that it appears in this list, etc. I assume these scripts are in Python? Are there other alternatives?

MB3Y referenced this issue 2 hours ago

Dual extruder - one nozzle temp question #3019

Open

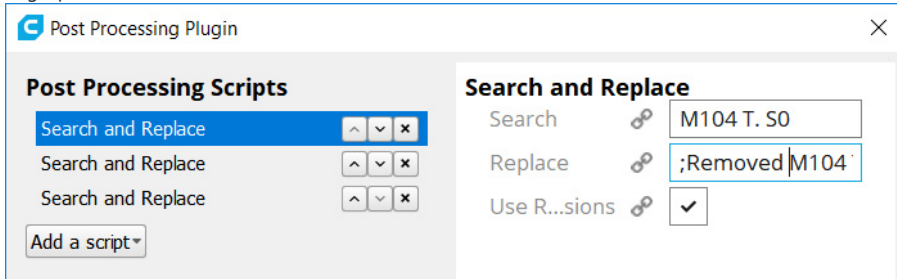


MB3Y commented an hour ago • edited

Ha... figured @Ghostkeeper 's suggestion out - I thought I had to make myself a plugin to do such thing... Which I still would like, such that I can group and process more Geeetech Rostock 301 "misbehaviors" and "shortcuts".

Goto Extensions -> Post-Processing -> Modify G-Code and select "Search And Replace" as modification. Next one can do the following for correct replacement:

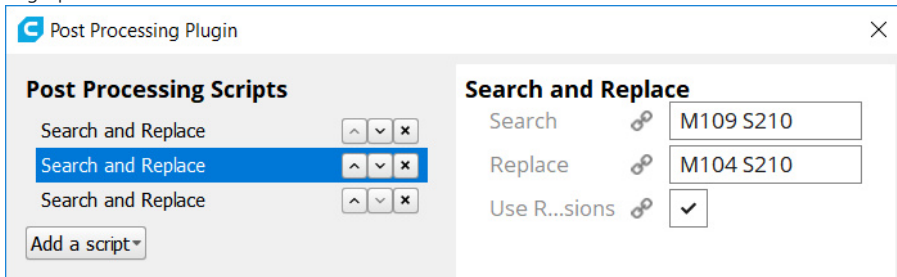
- Search: "M104 T. S0"
- Replace ";Removed M104 T. S0"
- RegExp: "Yes"



Another pretty annoying one on the Diamonds hotend is all the M109's during the print. If for any reason your temp drops, or your hotend can't fully keep up, then you'll get pauses, oozing and blobs on the location of that pause.

The following replacement can help - without interfering too much in the code

- Search: "M109"
- Replace "M104"
- RegExp: "No"



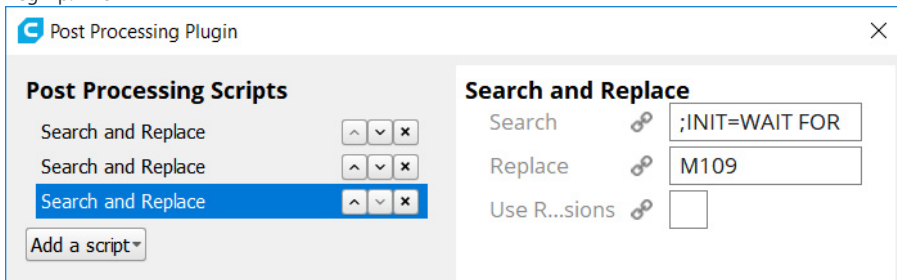
As this also removes your initial heating up of the nozzle, one should update the start script to include a ";INIT=WAIT FOR S{material\_print\_temperature\_layer\_0}" and next a third replacement

**Start Code**

```
G28
M140 S{material_bed_temperature_layer_0}
M109 S{material_print_temperature_layer_0}
;INIT=WAIT FOR S{material_print_temperature_layer_0}
```

So the following replacement makes such that you keep the necessary command

- Search: ";INIT=WAIT FOR "
- Replace "M109"
- RegExp: "No"



I didn't want to remove the original M109 S{material\_print\_temperature\_layer\_0} as this could have unwanted side-effects as I got pointed out lately that Cura does check if the start script contains the necessary temp preparation commands - else inserts them him/her-self after your own start script.

...Now I hope Cura will remember my favorit replacement throughtout sessions, reboots etc...

MB3Y referenced this issue 29 seconds ago

Feature Suggestion: Keep Selected Post-Processing rules in place after shutdown and restart of Cura #3133 [Open](#)