

## Cura setup (for v3.1)

Install Cura from <https://ultimaker.com/en/products/ultimaker-cura-software>.

Start up Cura and add each printer manually, from Settings->Printer->Add Printer... Since Cura is made by Ultimaker they don't include any other machines than their own, therefore they have to be added as "Custom FDM Printer". Name the machine accordingly, the small ones are called 2040, the medium 4070 and the big one 3MT. The following settings are for the 2040:

### Machine Settings

Printer Extrude...

#### Printer Settings

X (Width) 200 mm  
Y (Depth) 200 mm  
Z (Height) 400 mm

Build plate shape Elliptic

- Origin at center
- Heated bed

Gcode flavor Marlin

#### Start Gcode

```
G28 ;Home  
G1 Z15.0 F6000 ;Move the platform down 15mm  
;Prime the extruder  
G92 E0  
G1 F200 E3  
G92 E0
```

#### Printhead Settings

X min 20 mm  
Y min 10 mm  
X max 10 mm  
Y max 10 mm

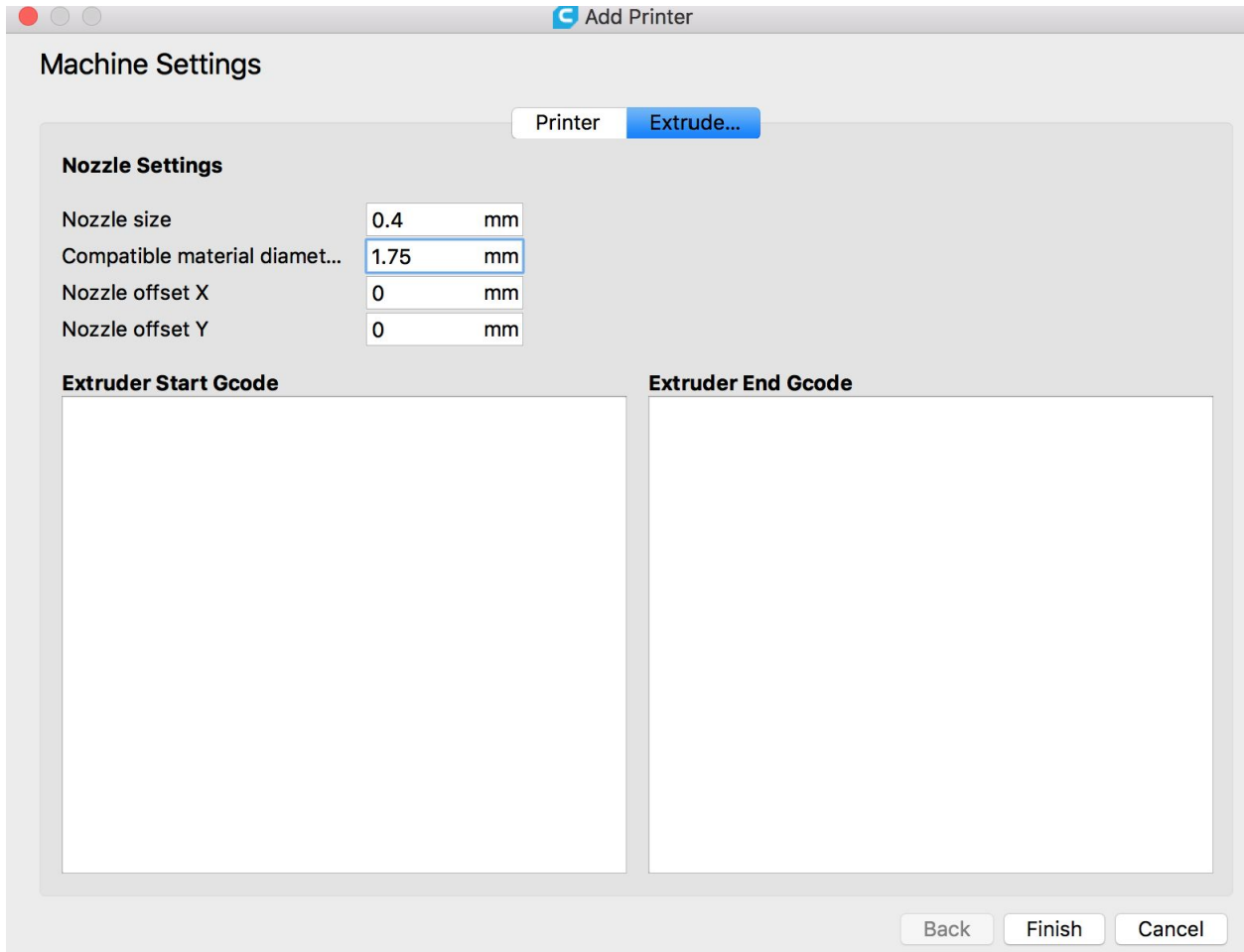
Gantry height 999999999999

Number of Extruders 1

#### End Gcode

```
M104 S0  
M140 S0  
;Retract the filament  
G92 E1  
G1 E-1 F300  
G28 X0 Y0  
M84
```

Back Finish Cancel



The setup with the other machines are the same, but with the following variations:

### **2040 Clay**

X (Width): 200 mm  
Y (Depth): 200 mm  
Z (Height): 400 mm  
Nozzle size: 1.5 mm

### **4070 Industrial**

X (Width): 400 mm  
Y (Depth): 400 mm  
Z (Height): 700 mm  
Nozzle size: 0.7 mm

### **3MT Pellet**

X (Width): 1000 mm  
Y (Depth): 1000 mm

Z (Height): 1000 mm  
Nozzle size: 3 mm

### 3MT Clay

X (Width): 1000 mm  
Y (Depth): 1000 mm  
Z (Height): 1000 mm  
Nozzle size: 5 mm

After that a profile can be imported from Settings->Profile->Manage Profiles...

