

## Table

To make the table move we use the motorslot for the second extruder. We plugged in a stepper driver and the motor of the table. We had to upgrade the firmware of our arduino to be dual extruding compatible. Next we had to shut off the temperature safety limiter with G-code *M302*(Allow cold extrudes, or set the minimum extruder's temperature.) This is because due to the limiter it will not allow motor movements if the temperature of the extruder is too low.

Now we can by selecting the motor, and using the "feed" function move the table.

*T1*

*G1 F1000 E100*

*T0*

## Splitting the STL file

We will have to split the file into four segments, two segments for each Ultimaker. This means we must have two G-code files. We will split the 3D file into segments with space between the two segments (like in the picture of a simple cylinder). We transpose this file to G-code with Cura. In the G-code we look for the feed from the first segment to the second segment. That must look like:

*G1 F[high] [no E]*

We will erase this code and put the table slide in its place.

We still have to find a solution to print the other segment at the same place, this could be done by making the coordinate system relative but we are currently working on this problem.