

**\*These are the Factory Default settings for STACKER 500KS Printers**

Access your EEPROM Settings in STACKER RUN by pressing Alt+E

Firmware EEPROM Settings			
Language	0		
Baudrate	250000		
Filament Printed	0		
Printer Active	0		
Max. inactive time	0		
Stop stepper after inactivity	360000		
X-axis steps per mm	73.45		
Y-axis steps per mm	73.45		
Z-axis steps per mm	257.37		
X-axis max. feedrate	200		
Y-axis max. feedrate	200		
Z-axis max. feedrate	80		
X-axis homing feedrate	40		
Y-axis homing feedrate	40		
Z-axis homing feedrate	10		
Max. jerk	25		
Max. Z-jerk	0.3		
X min pos	0		
Y min pos	0		
Z min pos	0		
X max length	418		
Y max length	235		
Z max length	210	for Desktop	600 for Full Height
X backlash	0		
Y backlash	0		
Z backlash	0		
X-axis acceleration	1000		
Y-axis acceleration	1000		
Z-axis acceleration	50		
X-axis travel acceleration	1000		
Y-axis travel acceleration	1000		
Z-axis travel acceleration	50		
Autolevel active (1/0)	0		
Bed Heat Manager	1		
Bed PID drive max	255		
Bed PID drive min	80		
Bed PID P-gain	196		
Bed PID I-gain	33		
Bed PID D-gain	290		
Bed PID max value	255		

Enable retraction conversion	0		
Retraction length	2.5		
Retraction length extruder switch	2.5		
Retraction speed	50		
Retraction z-lift	0		
Extra extrusion on undo retract	0		
Extra extrusion on undo switch retract	0		
Retraction undo speed	40		
Extr. 1 steps per mm	255		
Extr. 1 max. feedrate	50		
Extr. 1 acceleration	5000		
Extr. 1 heat manager	1		
Extr. 1 PID drive max	255		
Extr. 1 PID drive min	40		
Extr. 1 PID P-gain/dead-time	8.94		
Extr. 1 PID I-gain	0.51		
Extr. 1 PID D-gain	20		
Extr. 1 PID max value	255		
Extr. 1 PID X-offset	0		
Extr. 1 X-offset	0		
Extr. 1 Y-offset	0		
Extr. 1 Z-offset	0		
Extr. 1 temp. stabilize time	1		
Extr. 1 temp. for retraction when heating	150		
Extr. 1 distance to retract when heating	0		
Extr. 1 extruder cooler speed	255		
Extr. 2 steps per mm	257		
Extr. 2 max. feedrate	100		
Extr. 2 acceleration	5000		
Extr. 2 heat manager	1		
Extr. 2 PID drive max	255		
Extr. 2 PID drive min	40		
Extr. 2 PID P-gain/dead-time	8.94		
Extr. 2 PID I-gain	0.51		
Extr. 2 PID D-gain	20		
Extr. 2 PID max value	255		
Extr. 2 PID X-offset	0		
Extr. 2 X-offset	0		
Extr. 2 Y-offset	0		
Extr. 2 Z-offset	0		
Extr. 2 temp. stabilize time	1		
Extr. 2 temp. for retraction when heating	150		
Extr. 2 distance to retract when heating	0		
Extr. 2 extruder cooler speed	255		
Extr. 3 steps per mm	255		
Extr. 3 max. feedrate	100		
Extr. 3 acceleration	5000		

Extr. 3 heat manager	1		
Extr. 3 PID drive max	255		
Extr. 3 PID dirve min	40		
Extr. 3 PID P-gain/dead-time	8.94		
Extr. 3 PID I-gain	0.51		
Extr. 3 PID D-gain	20		
Extr. 3 PID max value	255		
Extr. 3 PID X-offset	0		
Extr. 3 X-offset	0		
Extr. 3 Y-offset	0		
Extr. 3 Z-offset	0		
Extr. 3 temp. stablize time	1		
Extr. 3 temp. for retraction when heating	150		
Extr. 3 distance to retract when heating	0		
Extr. 3 extruder cooler speed	255		
Extr. 4 steps per mm	255		
Extr. 4 max. feedrate	100		
Extr. 4 acceleration	5000		
Extr. 4 heat manager	1		
Extr. 4 PID drive max	255		
Extr. 4 PID dirve min	40		
Extr. 4 PID P-gain/dead-time	8.94		
Extr. 4 PID I-gain	0.51		
Extr. 4 PID D-gain	20		
Extr. 4 PID max value	255		
Extr. 4 PID X-offset	0		
Extr. 4 X-offset	0		
Extr. 4 Y-offset	0		
Extr. 4 Z-offset	0		
Extr. 4 temp. stablize time	1		
Extr. 4 temp. for retraction when heating	150		
Extr. 4 distance to retract when heating	0		
Extr. 4 extruder cooler speed	255		