

BIBO Startup code	Cura 5.6.0 – Model on E2, Adhesion Extruder Not overridden
<pre> M104 T0 165 M104 T1 165 M109 T{initial_extruder_nr} S{material_print_temperature_layer_0, initial_extruder_nr} G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T{initial_extruder_nr} M117 BIBO Printing... </pre>	<pre> ;Generated with Cura_SteamEngine 5.6.0 T1 M140 S60 M105 M190 S60 M82 ;absolute extrusion mode M104 T0 165 M104 T1 165 M109 T0 S(200, 0) ; T0 and S(200, 0) are incorrect G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T0 ; T0 is incorrect M117 BIBO Printing... G92 E0 G92 E0 G1 F1500 E-6.5 ;LAYER_COUNT:125 ;LAYER:0 M107 G0 F3600 X-21.656 Y7.689 Z0.3 ;TYPE:SKIRT G1 F1500 E0 </pre>

Model is assigned to E2, no supports. Cura starts with T1, but the substitutions for initial_extruder_nr are incorrect. Cura never goes back to T1, but instead tries to print the model on T0.

BIBO Startup code	Cura 5.6.0 – Model on E2, Adhesion type is None
<pre> M104 T0 165 M104 T1 165 M109 T{initial_extruder_nr} S{material_print_temperature_layer_0, initial_extruder_nr} G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T{initial_extruder_nr} M117 BIBO Printing... </pre>	<pre> ;Generated with Cura_SteamEngine 5.6.0 T1 M140 S60 M105 M190 S60 M82 ;absolute extrusion mode M104 T0 165 M104 T1 165 M109 T1 S(200, 1) ; T1 is correct, S(200, 1) is incorrect G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T1 ; T1 is correct M117 BIBO Printing... G92 E0 G92 E0 G1 F1500 E-6.5 ;LAYER_COUNT:125 ;LAYER:0 M107 ;MESH:Old English V.stl G0 F3600 X-12.327 Y-3.6 Z0.3 ;TYPE:WALL-INNER G1 F1500 E0 </pre>

Model is assigned to E2, no supports, build plate adhesion is None. Initial_extruder_nr substitutes correctly. Cura never tries to use T0.

BIBO Startup code	Cura 5.6.0 – Model on E2, Adhesion Extruder E2
<pre> M104 T0 165 M104 T1 165 M109 T{initial_extruder_nr} S{material_print_temperature_layer_0, initial_extruder_nr} G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T{initial_extruder_nr} M117 BIBO Printing... </pre>	<pre> ;Generated with Cura_SteamEngine 5.6.0 T1 M140 S60 M105 M190 S60 M82 ;absolute extrusion mode M104 T0 165 M104 T1 165 M109 T1 S(200, 1) ; T1 is correct S(200, 1) is incorrect G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T1 ; T1 is correct M117 BIBO Printing... G92 E0 G92 E0 G1 F1500 E-6.5 ;LAYER_COUNT:125 ;LAYER:0 M107 G0 F3600 X-21.656 Y7.689 Z0.3 ;TYPE:SKIRT G1 F1500 E0 </pre>

Model is assigned to E2, no supports, build plate adhesion is Brim, adhesion and skirt/brim extruders are E2. Initial_extruder_nr substitutes correctly. Cura never tries to use T0.

BIBO Startup code	Cura 5.1.0 – Model on E2, Adhesion Extruder E2
<pre> M104 T0 165 M104 T1 165 M109 T{initial_extruder_nr} S{material_print_temperature_layer_0, initial_extruder_nr} G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T{initial_extruder_nr} M117 BIBO Printing... </pre>	<pre> ;Generated with Cura_SteamEngine main T1 M140 S60 M105 M190 S60 M82 ;absolute extrusion mode M104 T0 165 M104 T1 165 M109 T1 S200 G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T1 M117 BIBO Printing... G92 E0 G92 E0 G1 F1500 E-6.5 ;LAYER_COUNT:125 ;LAYER:0 M107 G0 F3600 X-21.664 Y7.717 Z0.3 G0 X-34.982 Y13.691 ;TYPE:SKIRT G1 F1500 E0 </pre>

Model assigned to E2, brim adhesion, adhesion and skirt/brim extruders set to E2. Everything is correct. Cura never tries to use T0.

BIBO Startup code	Cura 5.1.0 – Model on E2, Adhesion E2, skirt/brim E1
<pre> M104 T0 165 M104 T1 165 M109 T{initial_extruder_nr} S{material_print_temperature_layer_0, initial_extruder_nr} G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T{initial_extruder_nr} M117 BIBO Printing... </pre>	<pre> ;Generated with Cura_SteamEngine main T0 M140 S60 M105 M190 S60 M82 ;absolute extrusion mode M104 T0 165 M104 T1 165 M109 T0 S200 ; note no S(200, 0) G21 ;metric values G90 ;absolute positioning M107 ;start with the fan off G28 X0 Y0 ;move X/Y to min endstops G28 Z0 ;move Z to min endstops G1 Z2.0 F400 ;move the platform down 2mm T0 G92 E0 G28 G1 Y0 F1200 E0 G92 E0 T0 M117 BIBO Printing... G92 E0 G92 E0 G1 F1500 E-6.5 ;LAYER_COUNT:125 ;LAYER:0 M107 M104 T1 S175 ; E2 is sent to the standby temperature G0 F3600 X-21.664 Y7.717 Z0.3 G0 X-34.982 Y13.691 ;TYPE:SKIRT G1 F1500 E0 </pre>

Model assigned to E2, brim adhesion, adhesion extruder is E2, skirt/brim extruder is E1. Cura interprets skirt/brim extruder to be the one to use to print the brim and starts with E1; E2 is sent to its standby temperature. Cura start using T1 after the brim is printed. This is perfectly reasonable.