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(*IMPORT AND COLOR CONVERT, LOOK AT THE BOTTOM FOR EXAMPLE*)
Img = Import["C:\\picture\\furby.jpg"]
ImgRS = ImageResize[Img, 80]; (* ONLY USED IN SECTION 5.3 *)
ImgGrayscale = ColorConvert[Img, "Grayscale"]
(* COLOR CONVERT IS DIFFERENT WHEN USED UNDER SECTION 5.3,
Img IS REPLACED BY ImgRS *)

(*EDGE DETECT*)
ImgEdge = EdgeDetect[ImgGrayscale]

(*PIXEL COORDINATES OF THE EDGE DETECT IMAGE*)
PixelsCoordinates = PixelValuePositions[ImgEdge, White];

(*SCALING AND MIN MAX FROM (-50,-50) to (50,50) *)
ImgDi = ImageDimensions[Img] * 0.01;
(* SCALING IS DIFFERENT WHEN USED UNDER SECTION 5.3, Img IS REPLACED BY ImgRS *)
CoordinatesLayer1 = DeleteDuplicates[
  Round[N[(PixelsCoordinates / Table[Max[ImgDi], Length[PixelsCoordinates]]) - 50]]];

(*SHORTEST TOUR*)
CoordinatesShortTour = FindShortestTour[CoordinatesLayer1];
Coordinates = CoordinatesLayer1[[Last[CoordinatesShortTour]]];

(*TABLES WITH G00, G01 AND G98*)
G00 = Table[" G00 " <> "X" <> ToString[Coordinates[[i]][[1]]] <>
  " Y" <> ToString[Coordinates[[i]][[2]]] <> " Z", {i, Length[Coordinates] }];
G01 = Table[" G01 " <> "X" <> ToString[Coordinates[[i]][[1]]] <> " Y" <>
  ToString[Coordinates[[i]][[2]]] <> " Z", {i, Length[Coordinates] }];
G98 = Table[" G98" <> " Z", Length[Coordinates]];

(*G98 WITH VARYING Z COORDINATE*)
G98Zvar = Table[-1 * i, {i, 13, Length[G98], 0.2}];
G98real = Table[ToString[G98[[i]]] <> ToString[G98Zvar[[i]]], {i, Length[Coordinates] }];

(*COMBINING G00 AND G01 TO A BIG TABLE,
SO THERE IS G00 G01 G00 FOR EVERY COORDINATE*)
G00G01 = Riffle[G00, G01];
G00G01G00 = Riffle[G00G01, G00, 3];

(*VALUE OF Z, HEIGHT OF PENCIL FOR G01 AND G00*)
Zvar = Flatten[Table[{32, 20, 32}, Length[G00G01G00]]];

(*IMPLEMETING VARRYING Z COORDINATES*)
T0 = Table[0, 2399];
T1 = Table[0.2, 2399];
T2 = Table[0.4, 2399];
T3 = Table[0.6, 2399];
T4 = Table[0.8, 2399];
T5 = Table[1, 2399];
T6 = Table[1.2, 2399];

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T7 = Table[1.4, 2399];
T8 = Table[1.6, 2399];
T9 = Table[1.8, 2399];
T10 = Table[2, 2399];
T11 = Table[2.2, 2399];
T12 = Table[2.4, 2399];
T13 = Table[2.6, 2399];
T14 = Table[2.8, 2399];
T15 = Table[3, 2399];
T16 = Table[3.2, 2399];
T17 = Table[3.4, 2399];
T18 = Table[3.6, 2399];
T19 = Table[3.8, 2399];
T20 = Table[4, 2399];
T21 = Table[4.2, 2399];
T22 = Table[4.4, 2399];
T23 = Table[4.6, 2399];
T24 = Table[4.8, 2399];
T25 = Table[5, 2399];
T26 = Table[5.2, 2399];
T27 = Table[5.4, 2399];
T28 = Table[5.6, 2399];
T29 = Table[5.8, 2399];
T30 = Table[6, 2399];
T31 = Table[6.2, 2399];
T32 = Table[6.4, 2399];
T33 = Table[6.6, 2399];
T34 = Table[6.8, 2399];
T35 = Table[7, 2399];
T36 = Table[7.2, 2399];
T37 = Table[7.4, 2399];
T38 = Table[7.6, 2399];
T39 = Table[7.8, 2399];
T40 = Table[8, 2399];
T41 = Table[8.2, 2399];
T42 = Table[8.4, 2399];
T43 = Table[8.6, 2399];
T44 = Table[8.8, 2399];
T45 = Table[9, 2399];
T46 = Table[9.2, 2399];
T47 = Table[9.4, 2399];
T48 = Table[9.6, 2399];
T49 = Table[9.8, 2399];
T50 = Table[10, 2399];
T51 = Table[10.2, 2399];
T52 = Table[10.4, 2399];
T53 = Table[10.6, 2399];
T54 = Table[10.8, 2399];
T55 = Table[11, 2399];
T56 = Table[11.2, 2399];
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T57 = Table[11.4, 2399];
T58 = Table[11.6, 2399];
T59 = Table[11.8, 2399];
T60 = Table[12, 2399];
T61 = Table[12.2, 2399];
T62 = Table[12.4, 2399];
T63 = Table[12.6, 2399];
T64 = Table[12.8, 2399];
T65 = Table[13, 2399];

minusT = Join[T0, T1, T2, T3, T4, T5, T6, T7, T8, T9, T10, T11, T12, T13, T14, T15, T16, T17,
  T18, T19, T20, T21, T22, T23, T24, T25, T26, T27, T28, T29, T30, T31, T32, T33,
  T34, T35, T36, T37, T38, T39, T40, T41, T42, T43, T44, T45, T46, T47, T48, T49,
  T50, T51, T52, T53, T54, T55, T56, T57, T58, T59, T60, T61, T62, T63, T64, T65];
minusTreal = Extract[minusT, Partition[Range[Length[Zvar]], 1]];

(*Z VARRIATION*)
Zvarreal = Zvar - minusTreal;

(*IMPLEMETING THE VARIATION OF Z IN THE ORIGINAL G00G01G00 TABLE*)
G00G01G00z =
  Table[ToString[G00G01G00[[i]]] <> ToString[Zvarreal[[i]]], {i, Length[G00G01G00]}}];

(*COMBINING G00G01G00 WITH G98 EVERY
  2400 LINES WHICH IS 800 POINTS MADE ON A DRAWING*)
GcodeLayer = Riffle[G00G01G00z, G98real, 2400];

(*NUMBERS N OF G-CODE LINES AND G-CODE*)
Nnum = ToString["N" <> #] & /@ Table[ToString[i], {i, Length[GcodeLayer]}}];
Gcode = Table[ToString[Nnum[[i]]] <> ToString[GcodeLayer[[i]]], {i, Length[GcodeLayer]}}]

(*EXPORTING IN .TXT FILE*)
Export["C:\\G-code files\\G-Code.txt", Gcode];

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(*IMPORTED IMAGE*)

Out[]=



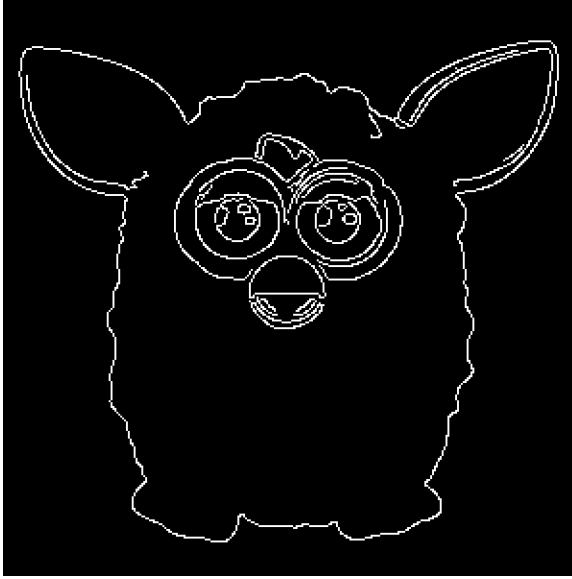
(*COLOR CONVERTED IMAGE*)

Out[]=



(*EDGE DETECT OF COLOR CONVERTED IMAGE*)

Out[*]=



(*EXPORTED G-CODE*)

Out[*]=

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{N1 G00 X41 Y43 Z32, N2 G01 X41 Y43 Z20, N3 G00 X41 Y43 Z32, N4 G00 X40 Y41 Z32,
N5 G01 X40 Y41 Z20, N6 G00 X40 Y41 Z32, N7 G00 X41 Y41 Z32, N8 G01 X41 Y41 Z20,
N9 G00 X41 Y41 Z32, N10 G00 X42 Y41 Z32, N11 G01 X42 Y41 Z20, N12 G00 X42 Y41 Z32,
N13 G00 X43 Y41 Z32, N14 G01 X43 Y41 Z20, N15 G00 X43 Y41 Z32, N16 G00 X44 Y42 Z32,
N17 G01 X44 Y42 Z20, N18 G00 X44 Y42 Z32, N19 G00 X43 Y42 Z32, N20 G01 X43 Y42 Z20,
N21 G00 X43 Y42 Z32, N22 G00 X42 Y43 Z32, N23 G01 X42 Y43 Z20, N24 G00 X42 Y43 Z32,
N25 G00 X43 Y43 Z32, N26 G01 X43 Y43 Z20, N27 G00 X43 Y43 Z32, N28 G00 X44 Y43 Z32,
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