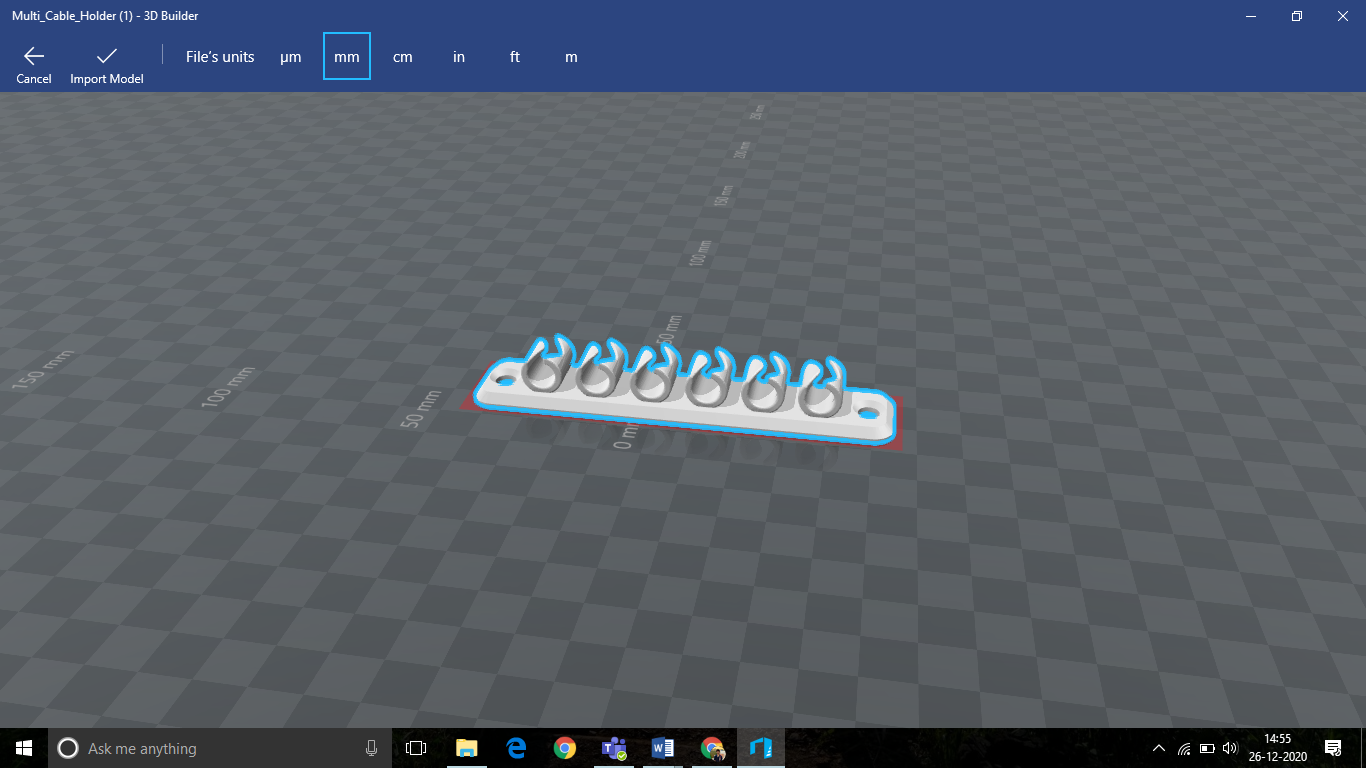
**MODULE 4 ASSIGNMENT 1**

1.Download a CAD Model from Thingiverse and perform slicing operation using Slicer. Screenshot the entire window with the sliced model preview and data showing estimated print time and material usage. Add your name and roll number on the screenshot using an image editing tool and submit the .gcode and as well as the screenshot in .jpg/.png file formats

NAME:

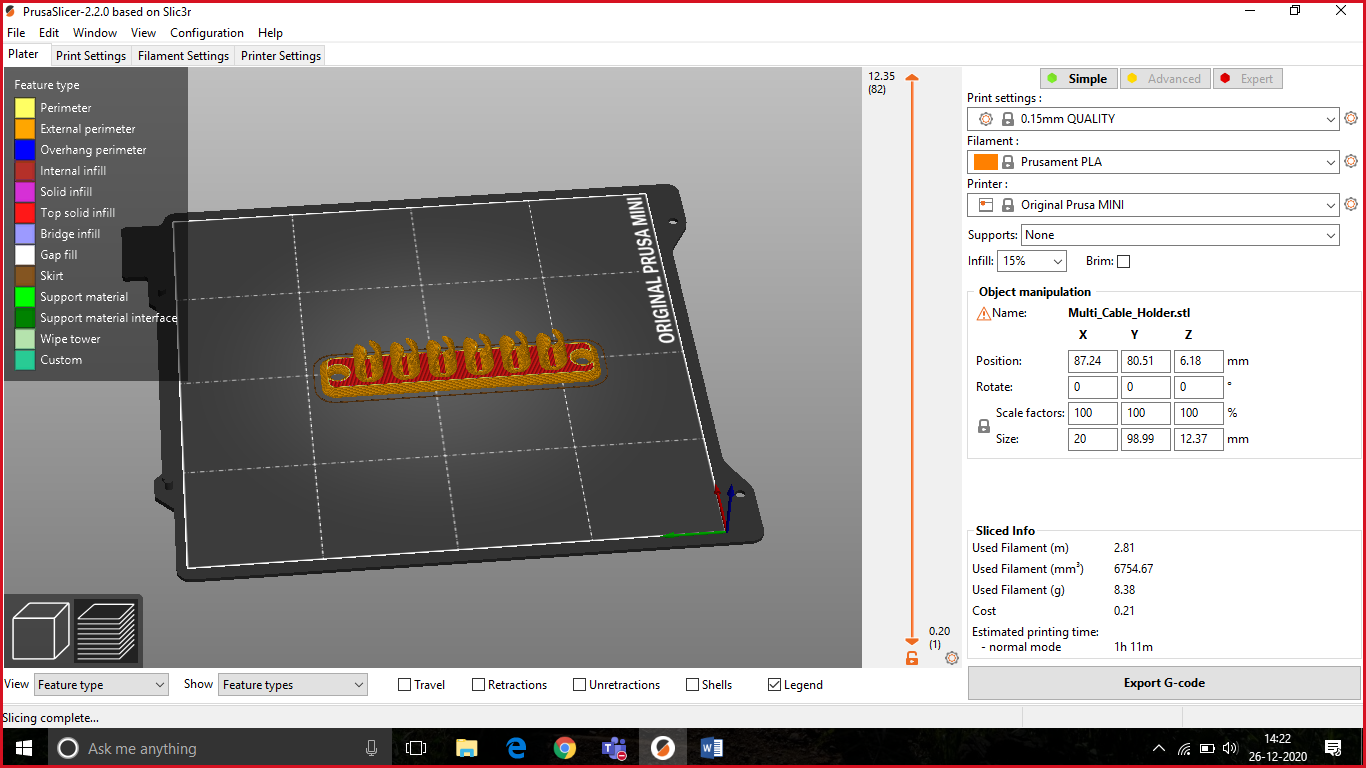
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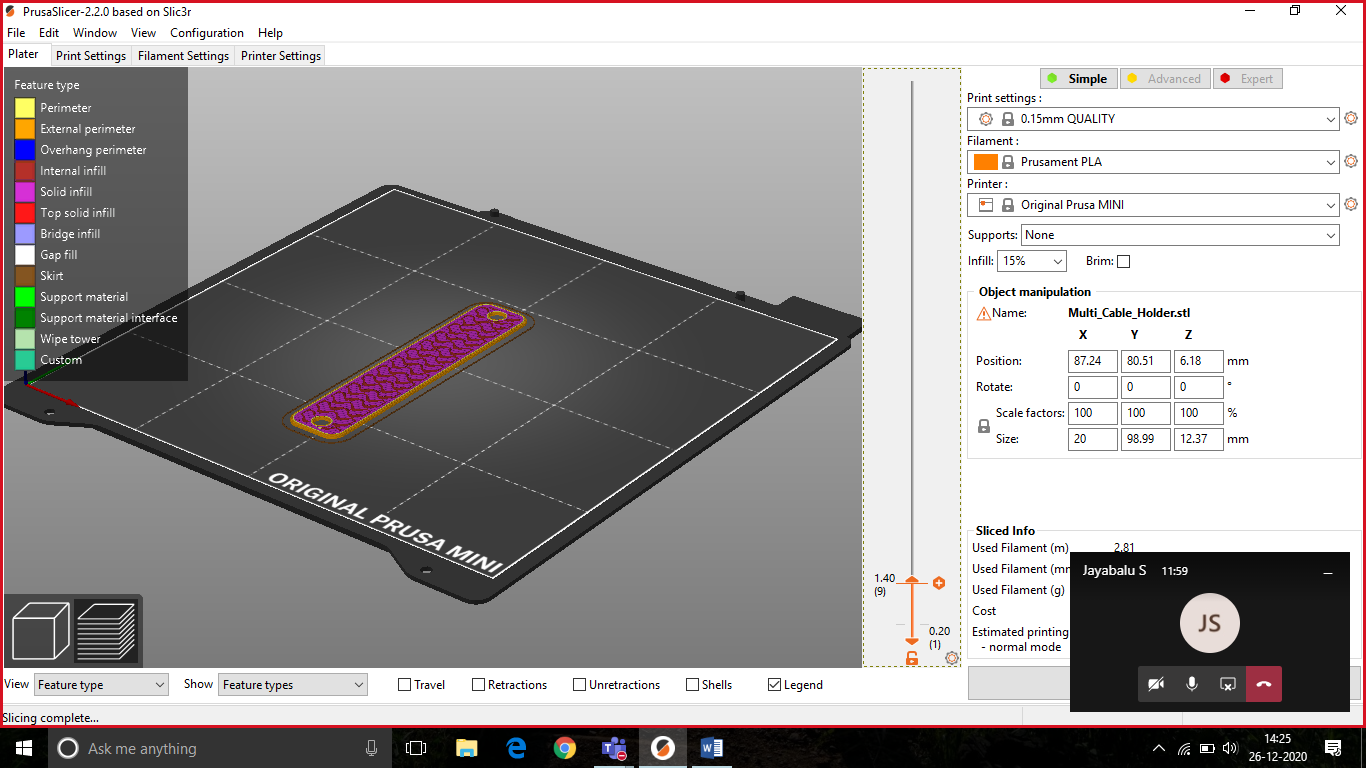
TEAM: C3\_TEAM07



CAD MODEL THINGIVERSE

SLICER





G CODES

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; GBpcMTX5O9FEiwrCTA8/7xnAjhw5osxy7pdfyJwqQ/or8+LqMRVsmJOjyxVwWt3w1zRwX/TP7CHH0C

; rnN9xvn9scS+USxfF0tzA/o4BNAccLchMI8+tvsEQ2bZhqFzV4TvAx4TCXucHk6/xC9zCBGPT9aHOc

; c2COkwpyMx+9fAZOn11DVZmYLp8TUzutbgCHus0AlxsD7st+Q+UoRtYqZw2MpBLu5zkIDRFXfc1WpQ

; sDNgUcJ9YTz/oCiSI2YZuZycCLAj4mEGYEqQ6+bJhcySKf2QJm2NflZAnwxatrY8OCzDr057qhIle1

; 1pzveF76ankz5qQFOL2ZI36cNivZ7ooVnGnVCaJqTr6a/hvTki8arpNzugGXCDQn2BRwJCv1SZ3Gww

; aeX/iAjUgs6QNustcI6MM6kr03voTOnz+vTG4/gHmBzK0EsLWyRKkdy5/TGUDDKd3d98ydUxmoGtX9

; NIyy+pfag2D5n2OwBQHNzVfj/7xvluVnKUe+gOzQBYEtpnCJojGZAi9d8HFjiVKRlzl16lRsgnkJDG

; QrjEGunYGqsU4ogbOoIbMO/Xn3li0VY6vmKfBoOJ0u/bNqMmVbYxaMnSh6QkG2Xo62CECzmo/8JErP

; wldsvcZ1BjEh44Czy2QU0EUNXhjw6cmqt/J1MjF/r4P3zdqg1u78qCFLVK1UV7FSNJcXi/ayfLF21R

; KxduVi0bIyb1aTaLL5lgps1sFrca2onBYnN+iSwVZSUhIPXDaDFyZ8bgACGorHNxvgOU3Ahwkm63D6

; kqGSiLVn+DZPBbBUIbOORHMkXaDZB+fmC4kNRnE9eI5f2Bj/H6t6WwYhIkV6AAAAAElFTkSuQmCC

; thumbnail end

;

;

; external perimeters extrusion width = 0.45mm

; perimeters extrusion width = 0.45mm

; infill extrusion width = 0.45mm

; solid infill extrusion width = 0.45mm

; top infill extrusion width = 0.40mm

; first layer extrusion width = 0.42mm

M73 P0 R71

M201 X1250 Y1250 Z400 E5000 ; sets maximum accelerations, mm/sec^2

M203 X180 Y180 Z12 E80 ; sets maximum feedrates, mm/sec

M204 P1250 R1250 T1250 ; sets acceleration (P, T) and retract acceleration (R), mm/sec^2

M205 X8.00 Y8.00 Z2.00 E10.00 ; sets the jerk limits, mm/sec

M205 S0 T0 ; sets the minimum extruding and travel feed rate, mm/sec

M107

G90 ; use absolute coordinates

M83 ; extruder relative mode

M104 S170 ; set extruder temp for bed leveling

M140 S60 ; set bed temp

M109 R170 ; wait for bed leveling temp

M190 S60 ; wait for bed temp

G28 ; home all without mesh bed level

G29 ; mesh bed leveling

M104 S215 ; set extruder temp

G92 E0.0

G1 Y-2.0 X179 F2400

G1 Z3 F720

M109 S215 ; wait for extruder temp

; intro line

G1 X170 F1000

G1 Z0.2 F720

G1 X110.0 E8.0 F900

M73 P0 R71

G1 X40.0 E10.0 F700

G92 E0.0

M221 S95 ; set flow

G21 ; set units to millimeters

G90 ; use absolute coordinates

M83 ; use relative distances for extrusion

M900 K0.2 ; Filament gcode

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;0.2

G1 Z0.200 F9000.000

;AFTER\_LAYER\_CHANGE

;0.2

G1 E-3.20000 F4200.00000

G1 Z0.400 F9000.000

G1 X75.433 Y33.187

G1 Z0.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1200.000

G1 X75.864 Y32.316 E0.03046

G1 X76.599 Y31.271 E0.04006

G1 X77.348 Y30.499 E0.03372

G1 X78.260 Y29.813 E0.03579

G1 X79.736 Y29.077 E0.05171

G1 X80.691 Y28.812 E0.03107

G1 X82.163 Y28.639 E0.04647

G1 X92.248 Y28.637 E0.31622

G1 X93.540 Y28.754 E0.04069

G1 X94.918 Y29.142 E0.04489

G1 X96.000 Y29.674 E0.03781

G1 X97.281 Y30.628 E0.05005

G1 X98.024 Y31.435 E0.03442

G1 X98.797 Y32.630 E0.04461

G1 X99.324 Y33.945 E0.04442

G1 X99.576 Y35.224 E0.04085

G1 X99.621 Y125.009 E2.81517

G1 X99.565 Y125.895 E0.02784

G1 X99.430 Y126.663 E0.02445

G1 X99.116 Y127.670 E0.03308

G1 X98.722 Y128.537 E0.02985

G1 X98.090 Y129.504 E0.03622

G1 X97.296 Y130.379 E0.03704

G1 X96.535 Y131.006 E0.03094

G1 X95.772 Y131.479 E0.02812

G1 X94.684 Y131.968 E0.03742

G1 X93.447 Y132.282 E0.04002

G1 X92.308 Y132.384 E0.03584

G1 X82.233 Y132.385 E0.31591

G1 X81.333 Y132.324 E0.02827

G1 X80.225 Y132.101 E0.03545

G1 X78.930 Y131.597 E0.04357

G1 X77.756 Y130.860 E0.04346

G1 X76.919 Y130.109 E0.03527

G1 X76.189 Y129.210 E0.03630

G1 X75.741 Y128.490 E0.02661

G1 X75.376 Y127.678 E0.02789

G1 X75.032 Y126.549 E0.03702

G1 X74.872 Y125.164 E0.04370

G1 X74.867 Y36.013 E2.79527

G1 X74.923 Y35.127 E0.02784

G1 X75.058 Y34.374 E0.02399

G1 X75.415 Y33.244 E0.03717

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X75.864 Y32.316 E-0.57116

G1 X76.218 Y31.813 E-0.34084

G1 E-0.04800 F4200.00000

G1 Z0.400 F9000.000

G1 X86.963 Y120.731

G1 Z0.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1200.000

G1 X87.553 Y120.732 E0.01848

G1 X87.885 Y120.781 E0.01053

G1 X88.198 Y120.859 E0.01012

G1 X88.504 Y120.968 E0.01018

G1 X88.796 Y121.106 E0.01013

G1 X89.072 Y121.272 E0.01011

G1 X89.331 Y121.465 E0.01011

G1 X89.571 Y121.681 E0.01014

G1 X89.788 Y121.921 E0.01014

G1 X89.980 Y122.180 E0.01011

G1 X90.146 Y122.457 E0.01011

G1 X90.284 Y122.749 E0.01013

G1 X90.394 Y123.054 E0.01018

G1 X90.471 Y123.368 E0.01012

G1 X90.518 Y123.686 E0.01010

G1 X90.534 Y124.008 E0.01011

G1 X90.518 Y124.330 E0.01011

G1 X90.471 Y124.649 E0.01010

G1 X90.394 Y124.962 E0.01012

G1 X90.284 Y125.268 E0.01018

G1 X90.146 Y125.560 E0.01013

G1 X89.980 Y125.836 E0.01011

G1 X89.788 Y126.095 E0.01011

G1 X89.571 Y126.336 E0.01014

G1 X89.331 Y126.552 E0.01014

G1 X89.072 Y126.744 E0.01011

G1 X88.796 Y126.910 E0.01011

G1 X88.504 Y127.048 E0.01013

G1 X88.198 Y127.158 E0.01018

G1 X87.885 Y127.235 E0.01011

G1 X87.568 Y127.282 E0.01005

G1 X87.244 Y127.299 E0.01016

G1 X86.920 Y127.282 E0.01016

G1 X86.603 Y127.235 E0.01005

G1 X86.290 Y127.158 E0.01012

G1 X85.985 Y127.048 E0.01018

G1 X85.692 Y126.910 E0.01013

G1 X85.416 Y126.744 E0.01011

G1 X85.157 Y126.552 E0.01011

G1 X84.917 Y126.336 E0.01014

G1 X84.700 Y126.095 E0.01014

G1 X84.508 Y125.836 E0.01011

G1 X84.342 Y125.560 E0.01011

G1 X84.204 Y125.268 E0.01013

G1 X84.095 Y124.962 E0.01018

G1 X84.017 Y124.649 E0.01011

G1 X83.970 Y124.332 E0.01005

G1 X83.953 Y124.008 E0.01016

G1 X83.970 Y123.685 E0.01016

G1 X84.017 Y123.368 E0.01005

G1 X84.095 Y123.054 E0.01012

G1 X84.204 Y122.749 E0.01018

G1 X84.342 Y122.457 E0.01013

G1 X84.508 Y122.180 E0.01011

G1 X84.700 Y121.921 E0.01011

G1 X84.917 Y121.681 E0.01014

G1 X85.157 Y121.465 E0.01014

G1 X85.416 Y121.272 E0.01011

G1 X85.692 Y121.106 E0.01011

G1 X85.985 Y120.968 E0.01013

G1 X86.290 Y120.859 E0.01018

G1 X86.606 Y120.781 E0.01019

G1 X86.904 Y120.739 E0.00944

M204 S1250

G1 X86.956 Y121.112 F9000.000

M204 S800

G1 F1200.000

G1 X87.524 Y121.109 E0.01782

G1 X87.812 Y121.152 E0.00910

G1 X88.089 Y121.220 E0.00895

G1 X88.359 Y121.317 E0.00900

G1 X88.618 Y121.439 E0.00897

G1 X88.862 Y121.586 E0.00895

G1 X89.092 Y121.757 E0.00897

G1 X89.304 Y121.948 E0.00896

G1 X89.496 Y122.160 E0.00896

G1 X89.666 Y122.390 E0.00897

G1 X89.813 Y122.635 E0.00895

G1 X89.935 Y122.893 E0.00897

G1 X90.032 Y123.164 E0.00900

G1 X90.101 Y123.441 E0.00895

G1 X90.143 Y123.723 E0.00895

G1 X90.157 Y124.008 E0.00895

G1 X90.143 Y124.293 E0.00895

G1 X90.101 Y124.576 E0.00895

G1 X90.032 Y124.853 E0.00895

G1 X89.935 Y125.123 E0.00900

G1 X89.813 Y125.382 E0.00897

G1 X89.666 Y125.627 E0.00895

G1 X89.496 Y125.856 E0.00897

G1 X89.304 Y126.069 E0.00896

G1 X89.092 Y126.260 E0.00896

G1 X88.862 Y126.430 E0.00897

G1 X88.618 Y126.577 E0.00895

G1 X88.359 Y126.700 E0.00897

G1 X88.089 Y126.796 E0.00900

G1 X87.812 Y126.865 E0.00895

G1 X87.530 Y126.907 E0.00892

G1 X87.244 Y126.922 E0.00898

G1 X86.958 Y126.907 E0.00898

G1 X86.677 Y126.865 E0.00892

G1 X86.399 Y126.796 E0.00895

G1 X86.129 Y126.700 E0.00900

G1 X85.871 Y126.577 E0.00897

G1 X85.626 Y126.430 E0.00895

G1 X85.396 Y126.260 E0.00897

G1 X85.184 Y126.069 E0.00896

G1 X84.992 Y125.856 E0.00896

G1 X84.822 Y125.626 E0.00897

G1 X84.675 Y125.382 E0.00895

G1 X84.553 Y125.123 E0.00897

G1 X84.456 Y124.853 E0.00900

G1 X84.387 Y124.576 E0.00895

G1 X84.346 Y124.294 E0.00892

G1 X84.331 Y124.008 E0.00898

G1 X84.346 Y123.722 E0.00898

G1 X84.387 Y123.441 E0.00892

G1 X84.456 Y123.164 E0.00895

G1 X84.553 Y122.893 E0.00900

G1 X84.675 Y122.635 E0.00897

G1 X84.822 Y122.390 E0.00895

G1 X84.992 Y122.160 E0.00897

G1 X85.184 Y121.948 E0.00896

G1 X85.396 Y121.757 E0.00896

G1 X85.626 Y121.586 E0.00897

G1 X85.871 Y121.439 E0.00895

G1 X86.129 Y121.317 E0.00897

G1 X86.399 Y121.220 E0.00900

G1 X86.677 Y121.151 E0.00898

G1 X86.897 Y121.121 E0.00694

M204 S1250

G1 X87.132 Y120.753 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.524 Y121.109 E-0.34801

G1 X87.812 Y121.152 E-0.16092

G1 X88.089 Y121.220 E-0.15824

G1 X88.359 Y121.317 E-0.15913

G1 X88.499 Y121.383 E-0.08570

G1 E-0.04800 F4200.00000

G1 Z0.400 F9000.000

G1 X87.244 Y40.298

G1 Z0.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1200.000

G1 X86.922 Y40.283 E0.01011

G1 X86.603 Y40.235 E0.01010

G1 X86.290 Y40.158 E0.01012

G1 X85.985 Y40.048 E0.01018

G1 X85.692 Y39.910 E0.01013

G1 X85.416 Y39.744 E0.01011

G1 X85.157 Y39.552 E0.01011

G1 X84.917 Y39.336 E0.01014

G1 X84.700 Y39.095 E0.01014

G1 X84.508 Y38.836 E0.01011

G1 X84.342 Y38.560 E0.01011

G1 X84.204 Y38.268 E0.01013

G1 X84.095 Y37.962 E0.01018

G1 X84.014 Y37.636 E0.01055

G1 X83.951 Y37.008 E0.01977

G1 X84.014 Y36.381 E0.01977

G1 X84.095 Y36.054 E0.01055

G1 X84.204 Y35.749 E0.01018

G1 X84.342 Y35.457 E0.01013

G1 X84.508 Y35.180 E0.01011

G1 X84.700 Y34.921 E0.01011

G1 X84.917 Y34.681 E0.01014

G1 X85.157 Y34.465 E0.01014

G1 X85.416 Y34.272 E0.01011

G1 X85.692 Y34.106 E0.01011

G1 X85.985 Y33.968 E0.01013

G1 X86.290 Y33.859 E0.01018

G1 X86.616 Y33.778 E0.01053

G1 X87.202 Y33.718 E0.01848

G1 X87.565 Y33.734 E0.01139

G1 X87.885 Y33.781 E0.01013

G1 X88.198 Y33.859 E0.01012

G1 X88.504 Y33.968 E0.01018

G1 X88.796 Y34.106 E0.01013

G1 X89.072 Y34.272 E0.01011

G1 X89.331 Y34.465 E0.01011

G1 X89.571 Y34.681 E0.01014

G1 X89.788 Y34.921 E0.01014

G1 X89.980 Y35.180 E0.01011

G1 X90.146 Y35.457 E0.01011

G1 X90.284 Y35.749 E0.01013

G1 X90.394 Y36.054 E0.01018

G1 X90.471 Y36.368 E0.01012

G1 X90.518 Y36.686 E0.01010

G1 X90.534 Y37.008 E0.01011

G1 X90.518 Y37.330 E0.01011

G1 X90.471 Y37.649 E0.01010

G1 X90.394 Y37.962 E0.01012

G1 X90.284 Y38.268 E0.01018

G1 X90.146 Y38.560 E0.01013

G1 X89.980 Y38.836 E0.01011

G1 X89.788 Y39.095 E0.01011

G1 X89.571 Y39.336 E0.01014

G1 X89.331 Y39.552 E0.01014

G1 X89.072 Y39.744 E0.01011

G1 X88.796 Y39.910 E0.01011

G1 X88.504 Y40.048 E0.01013

G1 X88.198 Y40.158 E0.01018

G1 X87.885 Y40.235 E0.01011

G1 X87.566 Y40.283 E0.01010

G1 X87.304 Y40.295 E0.00823

M204 S1250

G1 X87.286 Y39.919 F9000.000

M204 S800

G1 F1200.000

G1 X86.959 Y39.907 E0.01025

G1 X86.677 Y39.865 E0.00895

G1 X86.399 Y39.796 E0.00895

G1 X86.129 Y39.700 E0.00900

G1 X85.871 Y39.577 E0.00897

G1 X85.626 Y39.430 E0.00895

G1 X85.396 Y39.260 E0.00897

G1 X85.184 Y39.069 E0.00896

G1 X84.992 Y38.856 E0.00896

G1 X84.822 Y38.626 E0.00897

G1 X84.675 Y38.382 E0.00895

G1 X84.553 Y38.123 E0.00897

G1 X84.456 Y37.853 E0.00900

G1 X84.386 Y37.571 E0.00911

G1 X84.330 Y37.008 E0.01773

G1 X84.386 Y36.446 E0.01773

G1 X84.456 Y36.164 E0.00911

G1 X84.553 Y35.893 E0.00900

G1 X84.675 Y35.635 E0.00897

G1 X84.822 Y35.390 E0.00895

G1 X84.992 Y35.160 E0.00897

G1 X85.184 Y34.948 E0.00896

G1 X85.396 Y34.757 E0.00896

G1 X85.626 Y34.586 E0.00897

G1 X85.871 Y34.439 E0.00895

G1 X86.129 Y34.317 E0.00897

G1 X86.399 Y34.220 E0.00900

G1 X86.681 Y34.150 E0.00910

G1 X87.213 Y34.096 E0.01678

G1 X87.529 Y34.110 E0.00991

G1 X87.812 Y34.152 E0.00895

G1 X88.089 Y34.220 E0.00895

G1 X88.359 Y34.317 E0.00900

G1 X88.618 Y34.439 E0.00897

G1 X88.862 Y34.586 E0.00895

G1 X89.092 Y34.757 E0.00897

G1 X89.304 Y34.948 E0.00896

G1 X89.496 Y35.160 E0.00896

G1 X89.666 Y35.390 E0.00897

G1 X89.813 Y35.635 E0.00895

G1 X89.935 Y35.893 E0.00897

G1 X90.032 Y36.164 E0.00900

G1 X90.101 Y36.441 E0.00895

G1 X90.143 Y36.723 E0.00895

G1 X90.157 Y37.008 E0.00895

G1 X90.143 Y37.293 E0.00895

G1 X90.101 Y37.576 E0.00895

G1 X90.032 Y37.853 E0.00895

G1 X89.935 Y38.123 E0.00900

G1 X89.813 Y38.382 E0.00897

G1 X89.666 Y38.627 E0.00895

G1 X89.496 Y38.856 E0.00897

G1 X89.304 Y39.069 E0.00896

G1 X89.092 Y39.260 E0.00896

G1 X88.862 Y39.430 E0.00897

G1 X88.618 Y39.577 E0.00895

G1 X88.359 Y39.700 E0.00897

G1 X88.089 Y39.796 E0.00900

G1 X87.812 Y39.865 E0.00895

G1 X87.346 Y39.916 E0.01470

M204 S1250

G1 X87.130 Y40.206 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.959 Y39.907 E-0.21429

G1 X86.677 Y39.865 E-0.15819

G1 X86.399 Y39.796 E-0.15824

G1 X86.129 Y39.700 E-0.15913

G1 X85.871 Y39.577 E-0.15847

G1 X85.772 Y39.518 E-0.06367

G1 E-0.04800 F4200.00000

G1 Z0.400 F9000.000

G1 X80.252 Y32.304

G1 Z0.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1200.000

G1 X80.844 Y32.042 E0.02030

G1 X81.176 Y31.942 E0.01086

G1 X81.956 Y31.814 E0.02479

G1 X82.260 Y31.801 E0.00955

G1 X92.228 Y31.801 E0.31254

G1 X92.515 Y31.813 E0.00901

G1 X92.960 Y31.866 E0.01405

G1 X93.504 Y31.997 E0.01753

G1 X93.748 Y32.082 E0.00812

G1 X94.253 Y32.315 E0.01742

G1 X94.730 Y32.617 E0.01771

G1 X95.148 Y32.967 E0.01709

G1 X95.471 Y33.313 E0.01483

G1 X95.682 Y33.584 E0.01079

G1 X95.972 Y34.057 E0.01740

G1 X96.165 Y34.481 E0.01459

G1 X96.297 Y34.876 E0.01306

G1 X96.423 Y35.505 E0.02012

G1 X96.457 Y36.038 E0.01675

G1 X96.457 Y124.981 E2.78873

G1 X96.419 Y125.552 E0.01794

G1 X96.359 Y125.896 E0.01094

G1 X96.181 Y126.487 E0.01937

G1 X95.952 Y127.002 E0.01766

G1 X95.605 Y127.543 E0.02017

G1 X95.303 Y127.900 E0.01465

G1 X95.053 Y128.145 E0.01097

G1 X94.680 Y128.441 E0.01494

G1 X94.387 Y128.632 E0.01096

G1 X93.964 Y128.851 E0.01494

G1 X93.716 Y128.951 E0.00837

G1 X93.180 Y129.112 E0.01754

G1 X92.810 Y129.177 E0.01178

G1 X92.215 Y129.221 E0.01871

G1 X82.273 Y129.221 E0.31173

G1 X81.677 Y129.177 E0.01875

G1 X81.132 Y129.068 E0.01743

G1 X80.672 Y128.911 E0.01523

G1 X80.358 Y128.772 E0.01076

G1 X79.871 Y128.486 E0.01771

G1 X79.663 Y128.334 E0.00807

G1 X79.250 Y127.968 E0.01730

G1 X78.836 Y127.476 E0.02015

G1 X78.537 Y127.004 E0.01755

G1 X78.311 Y126.494 E0.01748

G1 X78.129 Y125.893 E0.01970

G1 X78.069 Y125.552 E0.01085

G1 X78.031 Y124.981 E0.01794

G1 X78.031 Y36.042 E2.78863

G1 X78.070 Y35.464 E0.01814

G1 X78.109 Y35.212 E0.00799

G1 X78.249 Y34.687 E0.01704

G1 X78.372 Y34.365 E0.01081

G1 X78.586 Y33.930 E0.01520

G1 X78.721 Y33.709 E0.00814

G1 X79.057 Y33.264 E0.01746

G1 X79.429 Y32.885 E0.01667

G1 X80.200 Y32.333 E0.02971

M204 S1250

G1 X80.014 Y32.005 F9000.000

M204 S800

G1 F1200.000

G1 X80.713 Y31.688 E0.02406

G1 X81.090 Y31.574 E0.01235

G1 X81.917 Y31.438 E0.02629

G1 X82.252 Y31.424 E0.01052

G1 X92.236 Y31.424 E0.31302

G1 X92.545 Y31.437 E0.00971

G1 X93.027 Y31.494 E0.01521

G1 X93.610 Y31.635 E0.01882

G1 X93.890 Y31.732 E0.00928

G1 X94.433 Y31.983 E0.01876

G1 X94.953 Y32.312 E0.01929

G1 X95.408 Y32.692 E0.01860

G1 X95.758 Y33.068 E0.01610

G1 X95.992 Y33.369 E0.01198

G1 X96.305 Y33.880 E0.01878

G1 X96.516 Y34.343 E0.01593

G1 X96.662 Y34.779 E0.01442

G1 X96.798 Y35.456 E0.02165

G1 X96.834 Y36.026 E0.01793

G1 X96.834 Y124.993 E2.78950

G1 X96.794 Y125.597 E0.01896

G1 X96.727 Y125.981 E0.01223

G1 X96.533 Y126.623 E0.02103

G1 X96.285 Y127.181 E0.01914

G1 X95.909 Y127.768 E0.02185

G1 X95.579 Y128.157 E0.01599

G1 X95.303 Y128.428 E0.01213

G1 X94.901 Y128.748 E0.01610

G1 X94.577 Y128.959 E0.01212

G1 X94.121 Y129.194 E0.01610

G1 X93.841 Y129.307 E0.00946

G1 X93.268 Y129.479 E0.01878

G1 X92.857 Y129.552 E0.01307

G1 X92.229 Y129.598 E0.01975

G1 X82.259 Y129.598 E0.31260

G1 X81.633 Y129.552 E0.01970

G1 X81.026 Y129.431 E0.01940

G1 X80.534 Y129.263 E0.01630

G1 X80.186 Y129.108 E0.01196

G1 X79.664 Y128.802 E0.01896

G1 X79.426 Y128.629 E0.00923

G1 X78.980 Y128.232 E0.01873

G1 X78.531 Y127.700 E0.02181

G1 X78.203 Y127.182 E0.01923

G1 X77.957 Y126.625 E0.01908

G1 X77.761 Y125.980 E0.02115

G1 X77.694 Y125.597 E0.01219

G1 X77.654 Y124.993 E0.01896

G1 X77.654 Y36.029 E2.78942

G1 X77.695 Y35.422 E0.01907

G1 X77.740 Y35.134 E0.00913

G1 X77.890 Y34.571 E0.01829

G1 X78.027 Y34.214 E0.01197

G1 X78.255 Y33.748 E0.01628

G1 X78.409 Y33.496 E0.00926

G1 X78.771 Y33.018 E0.01880

G1 X79.182 Y32.599 E0.01840

G1 X79.962 Y32.034 E0.03019

M204 S1250

G1 X80.358 Y32.209 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.713 Y31.688 E-0.45842

G1 X81.090 Y31.574 E-0.21835

G1 X81.509 Y31.505 E-0.23523

G1 E-0.04800 F4200.00000

G1 Z0.400 F9000.000

G1 X95.841 Y34.061

G1 Z0.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1200.000

G1 X94.952 Y33.171 E0.03953

G1 X94.563 Y32.846 E0.01593

G1 X94.117 Y32.564 E0.01657

G1 X93.563 Y32.317 E0.01905

G1 X95.936 Y34.690 E0.10546

G1 X96.023 Y34.949 E0.00857

G1 X96.114 Y35.402 E0.01453

G1 X92.849 Y32.138 E0.14509

G1 X92.498 Y32.096 E0.01110

G1 X92.273 Y32.096 E0.00709

G1 X96.171 Y35.994 E0.17323

G1 X96.174 Y36.532 E0.01690

G1 X91.738 Y32.095 E0.19716

G1 X91.203 Y32.094 E0.01681

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G1 X96.174 Y37.600 E0.01679

G1 X90.667 Y32.094 E0.24472

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G1 X96.174 Y38.135 E0.26850

G1 X96.174 Y38.669 E0.01679

G1 X89.597 Y32.093 E0.29228

G1 X89.062 Y32.092 E0.01681

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G1 X96.174 Y39.738 E0.01679

G1 X88.527 Y32.091 E0.33983

G1 X87.992 Y32.091 E0.01681

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G1 X96.174 Y40.807 E0.01679

G1 X87.457 Y32.090 E0.38739

G1 X86.922 Y32.089 E0.01681

G1 X88.499 Y33.666 E0.07006

G1 X88.280 Y33.588 E0.00730

G1 X87.778 Y33.479 E0.01615

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G1 X87.198 Y33.435 E0.05983

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G1 X84.782 Y32.087 E0.01681

G1 X86.268 Y33.573 E0.06604

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G1 X83.712 Y32.086 E0.01681

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G1 X85.184 Y34.092 E0.01217

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G1 X82.642 Y32.085 E0.01681

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G1 X81.640 Y32.152 E0.01498

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G1 X81.187 Y32.234 E0.13217

G1 X80.945 Y32.307 E0.00796

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G1 X79.499 Y33.218 E0.00521

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G1 X83.842 Y38.095 E0.01335

G1 X79.239 Y33.492 E0.20454

G1 X79.009 Y33.797 E0.01199

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G1 X96.174 Y50.427 E0.01679

G1 X86.157 Y40.410 E0.44515

G1 X86.549 Y40.513 E0.01271

G1 X86.837 Y40.556 E0.00917

G1 X96.174 Y49.893 E0.41494

M73 P1 R70

G1 X96.174 Y49.358 E0.01679

G1 X87.390 Y40.574 E0.39037

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G1 X90.367 Y38.741 E0.01217

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G1 X90.543 Y38.382 E0.25026

G1 X90.679 Y37.985 E0.01322

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G1 X96.174 Y42.945 E0.01679

G1 X90.773 Y37.543 E0.24004

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G1 X96.174 Y42.411 E0.23816

G1 X96.174 Y41.876 E0.01679

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G1 X90.586 Y35.754 E0.00730

G1 X96.344 Y41.511 E0.25587

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.04800 F4200.00000

G1 Z0.400 F9000.000

G1 X96.344 Y51.666

G1 Z0.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1200.000

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M73 P3 R69

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M73 P4 R68

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M73 P5 R67

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G1 X90.651 Y122.934 E0.20422

G1 X90.749 Y123.313 E0.01229

G1 X90.793 Y123.611 E0.00947

G1 X94.992 Y127.809 E0.18658

G1 X94.866 Y127.932 E0.00554

G1 X94.707 Y128.059 E0.00638

G1 X90.810 Y124.162 E0.17318

G1 X90.758 Y124.644 E0.01525

G1 X94.400 Y128.287 E0.16186

G1 X94.061 Y128.482 E0.01229

G1 X90.654 Y125.075 E0.15144

G1 X90.506 Y125.461 E0.01300

G1 X93.698 Y128.653 E0.14186

G1 X93.293 Y128.783 E0.01336

G1 X90.324 Y125.814 E0.13195

G1 X90.111 Y126.135 E0.01212

G1 X92.857 Y128.882 E0.12207

G1 X92.368 Y128.926 E0.01546

G1 X89.869 Y126.428 E0.11104

G1 X89.599 Y126.692 E0.01188

G1 X91.845 Y128.938 E0.09984

G1 X91.311 Y128.938 E0.01679

G1 X89.300 Y126.928 E0.08936

G1 X88.972 Y127.134 E0.01218

G1 X90.776 Y128.938 E0.08018

G1 X90.242 Y128.938 E0.01679

G1 X88.613 Y127.309 E0.07239

G1 X88.214 Y127.445 E0.01324

G1 X89.707 Y128.938 E0.06636

G1 X89.173 Y128.938 E0.01679

G1 X87.772 Y127.538 E0.06224

G1 X87.281 Y127.581 E0.01551

G1 X88.638 Y128.938 E0.06034

G1 X88.104 Y128.938 E0.01679

G1 X86.701 Y127.536 E0.06234

G1 X86.208 Y127.429 E0.01585

G1 X85.977 Y127.346 E0.00772

G1 X87.569 Y128.938 E0.07077

G1 X87.035 Y128.938 E0.01679

G1 X78.314 Y120.217 E0.38756

G1 X78.314 Y119.683 E0.01679

G1 X83.906 Y125.275 E0.24852

G1 X83.824 Y125.044 E0.00772

G1 X83.717 Y124.551 E0.01585

G1 X78.314 Y119.148 E0.24010

G1 X78.314 Y118.614 E0.01679

G1 X83.672 Y123.972 E0.23810

G1 X83.715 Y123.480 E0.01551

G1 X78.314 Y118.080 E0.24000

G1 X78.314 Y117.545 E0.01679

G1 X83.807 Y123.038 E0.24412

G1 X83.943 Y122.639 E0.01324

G1 X78.314 Y117.011 E0.25015

G1 X78.314 Y116.476 E0.01679

G1 X84.118 Y122.280 E0.25794

G1 X84.325 Y121.953 E0.01218

G1 X78.314 Y115.942 E0.26712

G1 X78.314 Y115.407 E0.01679

G1 X84.561 Y121.654 E0.27760

G1 X84.825 Y121.383 E0.01188

G1 X78.314 Y114.873 E0.28933

G1 X78.314 Y114.338 E0.01679

G1 X85.117 Y121.142 E0.30234

G1 X85.439 Y120.929 E0.01212

G1 X78.314 Y113.804 E0.31663

G1 X78.314 Y113.269 E0.01679

G1 X85.791 Y120.747 E0.33229

G1 X86.178 Y120.599 E0.01300

G1 X78.314 Y112.735 E0.34946

G1 X78.314 Y112.201 E0.01679

G1 X86.608 Y120.495 E0.36859

G1 X86.944 Y120.448 E0.01065

G1 X87.096 Y120.448 E0.00479

G1 X78.314 Y111.666 E0.39027

G1 X78.314 Y111.132 E0.01679

G1 X87.642 Y120.459 E0.41452

G1 X87.940 Y120.503 E0.00947

G1 X88.318 Y120.602 E0.01229

G1 X78.144 Y110.427 E0.45214

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X79.308 Y111.591 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z0.400 F9000.000

G1 X78.306 Y126.088

G1 Z0.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1200.000

G1 X80.912 Y128.694 E0.11582

G1 X81.205 Y128.795 E0.00974

G1 X81.632 Y128.880 E0.01367

G1 X78.367 Y125.615 E0.14508

G1 X78.318 Y125.031 E0.01841

G1 X82.220 Y128.934 E0.17342

G1 X82.759 Y128.938 E0.01694

G1 X78.314 Y124.493 E0.19756

G1 X78.314 Y123.958 E0.01679

G1 X83.294 Y128.938 E0.22131

G1 X83.828 Y128.938 E0.01679

G1 X78.314 Y123.424 E0.24506

G1 X78.314 Y122.890 E0.01679

G1 X84.363 Y128.938 E0.26881

G1 X84.897 Y128.938 E0.01679

G1 X78.314 Y122.355 E0.29256

G1 X78.314 Y121.821 E0.01679

G1 X85.432 Y128.938 E0.31631

G1 X85.966 Y128.938 E0.01679

G1 X78.314 Y121.286 E0.34006

G1 X78.314 Y120.752 E0.01679

G1 X86.670 Y129.108 E0.37135

M204 S1250

M106 S255

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;0.35

G1 Z0.350 F9000.000

;AFTER\_LAYER\_CHANGE

;0.35

G1 E-3.20000 F4200.00000

G1 Z0.550 F9000.000

G1 X78.930 Y131.597

G1 Z0.350

G1 E3.20000 F2400.00000

G1 X77.756 Y130.860 E0.03352

G1 X76.919 Y130.109 E0.02720

G1 X76.189 Y129.210 E0.02800

G1 X75.741 Y128.490 E0.02052

G1 X75.376 Y127.678 E0.02151

G1 X75.032 Y126.549 E0.02856

G1 X74.872 Y125.164 E0.03371

G1 X74.867 Y36.013 E2.15611

G1 X74.923 Y35.127 E0.02147

G1 X75.058 Y34.374 E0.01851

G1 X75.433 Y33.187 E0.03012

G1 X75.864 Y32.316 E0.02349

G1 X76.599 Y31.271 E0.03090

G1 X77.348 Y30.499 E0.02601

G1 X78.260 Y29.813 E0.02761

G1 X79.736 Y29.077 E0.03988

G1 X80.691 Y28.812 E0.02397

G1 X82.163 Y28.639 E0.03584

G1 X92.248 Y28.637 E0.24391

G1 X93.540 Y28.754 E0.03138

G1 X94.918 Y29.142 E0.03463

G1 X96.000 Y29.674 E0.02916

G1 X97.281 Y30.628 E0.03861

G1 X98.024 Y31.435 E0.02655

G1 X98.797 Y32.630 E0.03441

G1 X99.324 Y33.945 E0.03426

G1 X99.576 Y35.224 E0.03151

G1 X99.621 Y125.009 E2.17146

G1 X99.565 Y125.895 E0.02147

G1 X99.430 Y126.663 E0.01886

G1 X99.116 Y127.670 E0.02551

G1 X98.722 Y128.537 E0.02302

G1 X98.090 Y129.504 E0.02794

G1 X97.296 Y130.379 E0.02857

G1 X96.535 Y131.006 E0.02386

G1 X95.772 Y131.479 E0.02169

G1 X94.684 Y131.968 E0.02886

G1 X93.447 Y132.282 E0.03087

G1 X92.308 Y132.384 E0.02764

G1 X82.233 Y132.385 E0.24368

G1 X81.333 Y132.324 E0.02180

G1 X80.225 Y132.101 E0.02734

G1 X78.986 Y131.618 E0.03216

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X77.756 Y130.860 E-0.80076

G1 X77.607 Y130.726 E-0.11124

G1 E-0.04800 F4200.00000

G1 Z0.550 F9000.000

G1 X84.467 Y125.493

G1 Z0.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.231 Y124.921 E0.01612

G1 X84.115 Y124.333 E0.01563

G1 X84.097 Y124.008 E0.00847

G1 X84.115 Y123.684 E0.00847

G1 X84.231 Y123.095 E0.01563

G1 X84.468 Y122.524 E0.01612

G1 X84.802 Y122.024 E0.01565

G1 X85.019 Y121.783 E0.00846

G1 X85.260 Y121.566 E0.00846

G1 X85.759 Y121.232 E0.01565

G1 X86.317 Y121.001 E0.01571

G1 X86.636 Y120.922 E0.00856

G1 X86.996 Y120.873 E0.00947

G1 X87.553 Y120.876 E0.01453

G1 X88.157 Y120.995 E0.01604

G1 X88.729 Y121.232 E0.01612

G1 X89.228 Y121.566 E0.01565

G1 X89.469 Y121.783 E0.00846

G1 X89.687 Y122.024 E0.00846

G1 X90.021 Y122.524 E0.01565

G1 X90.257 Y123.095 E0.01612

G1 X90.377 Y123.700 E0.01607

G1 X90.377 Y124.316 E0.01604

G1 X90.257 Y124.921 E0.01608

G1 X90.021 Y125.493 E0.01612

G1 X89.687 Y125.992 E0.01565

G1 X89.469 Y126.233 E0.00846

G1 X89.228 Y126.451 E0.00846

G1 X88.729 Y126.785 E0.01565

G1 X88.157 Y127.022 E0.01612

G1 X87.569 Y127.138 E0.01563

G1 X87.244 Y127.155 E0.00847

G1 X86.919 Y127.138 E0.00847

G1 X86.331 Y127.022 E0.01563

G1 X85.759 Y126.785 E0.01612

G1 X85.260 Y126.451 E0.01565

G1 X85.019 Y126.233 E0.00846

G1 X84.802 Y125.992 E0.00846

G1 X84.501 Y125.543 E0.01409

M204 S1250

G1 X84.848 Y125.310 F9000.000

M204 S800

G1 F1500.000

G1 X84.633 Y124.800 E0.01444

G1 X84.530 Y124.281 E0.01377

G1 X84.516 Y124.008 E0.00712

G1 X84.530 Y123.735 E0.00712

G1 X84.633 Y123.217 E0.01377

G1 X84.838 Y122.722 E0.01396

G1 X85.132 Y122.282 E0.01379

G1 X85.315 Y122.079 E0.00711

G1 X85.518 Y121.896 E0.00711

G1 X85.958 Y121.602 E0.01379

G1 X86.448 Y121.399 E0.01382

G1 X86.714 Y121.333 E0.00715

G1 X87.023 Y121.291 E0.00813

G1 X87.512 Y121.293 E0.01273

G1 X88.036 Y121.397 E0.01392

G1 X88.531 Y121.602 E0.01396

G1 X88.971 Y121.896 E0.01379

G1 X89.173 Y122.079 E0.00711

G1 X89.356 Y122.282 E0.00711

G1 X89.650 Y122.722 E0.01379

G1 X89.856 Y123.217 E0.01396

G1 X89.959 Y123.741 E0.01393

G1 X89.959 Y124.275 E0.01391

G1 X89.855 Y124.800 E0.01393

G1 X89.650 Y125.295 E0.01396

G1 X89.356 Y125.735 E0.01379

G1 X89.173 Y125.938 E0.00711

G1 X88.971 Y126.120 E0.00711

G1 X88.531 Y126.415 E0.01379

G1 X88.036 Y126.620 E0.01396

G1 X87.517 Y126.722 E0.01377

G1 X87.244 Y126.737 E0.00712

G1 X86.971 Y126.722 E0.00712

G1 X86.453 Y126.620 E0.01377

G1 X85.957 Y126.415 E0.01396

G1 X85.518 Y126.120 E0.01379

G1 X85.315 Y125.938 E0.00711

G1 X85.132 Y125.735 E0.00711

G1 X84.881 Y125.360 E0.01174

M204 S1250

G1 X84.448 Y125.293 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.633 Y124.800 E-0.33985

G1 X84.530 Y124.281 E-0.29293

G1 X84.516 Y124.008 E-0.15144

G1 X84.528 Y123.778 E-0.12778

G1 E-0.04800 F4200.00000

G1 Z0.550 F9000.000

G1 X87.244 Y40.156

G1 Z0.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.630 Y40.096 E0.01607

G1 X86.039 Y39.917 E0.01609

G1 X85.496 Y39.626 E0.01606

G1 X85.017 Y39.235 E0.01610

G1 X84.626 Y38.757 E0.01610

G1 X84.335 Y38.213 E0.01606

G1 X84.157 Y37.623 E0.01608

G1 X84.095 Y37.008 E0.01608

G1 X84.157 Y36.394 E0.01609

G1 X84.335 Y35.803 E0.01608

G1 X84.626 Y35.260 E0.01606

G1 X85.017 Y34.781 E0.01610

G1 X85.496 Y34.390 E0.01610

G1 X86.039 Y34.099 E0.01606

G1 X86.629 Y33.921 E0.01604

G1 X87.185 Y33.863 E0.01456

G1 X87.549 Y33.877 E0.00950

G1 X87.873 Y33.925 E0.00854

G1 X88.449 Y34.099 E0.01568

G1 X88.993 Y34.390 E0.01606

G1 X89.471 Y34.781 E0.01610

G1 X89.862 Y35.260 E0.01610

G1 X90.153 Y35.803 E0.01606

G1 X90.332 Y36.395 E0.01609

G1 X90.392 Y37.008 E0.01607

G1 X90.332 Y37.622 E0.01607

G1 X90.153 Y38.213 E0.01609

G1 X89.862 Y38.757 E0.01606

G1 X89.471 Y39.235 E0.01610

G1 X88.993 Y39.627 E0.01610

G1 X88.449 Y39.917 E0.01606

G1 X87.858 Y40.096 E0.01609

G1 X87.304 Y40.150 E0.01450

M204 S1250

G1 X87.263 Y39.734 F9000.000

M204 S800

G1 F1500.000

G1 X86.712 Y39.684 E0.01441

G1 X86.200 Y39.529 E0.01395

G1 X85.729 Y39.277 E0.01392

G1 X85.314 Y38.938 E0.01395

G1 X84.975 Y38.524 E0.01395

G1 X84.723 Y38.053 E0.01392

G1 X84.568 Y37.540 E0.01394

G1 X84.515 Y37.008 E0.01394

G1 X84.568 Y36.476 E0.01394

G1 X84.723 Y35.964 E0.01394

G1 X84.975 Y35.493 E0.01392

G1 X85.314 Y35.078 E0.01395

G1 X85.729 Y34.739 E0.01395

G1 X86.200 Y34.487 E0.01392

G1 X86.711 Y34.333 E0.01393

G1 X87.198 Y34.282 E0.01275

G1 X87.510 Y34.294 E0.00813

G1 X87.781 Y34.334 E0.00715

G1 X88.289 Y34.487 E0.01380

G1 X88.760 Y34.739 E0.01392

G1 X89.174 Y35.078 E0.01395

G1 X89.513 Y35.493 E0.01395

G1 X89.765 Y35.964 E0.01392

G1 X89.920 Y36.476 E0.01395

G1 X89.972 Y37.008 E0.01393

G1 X89.920 Y37.540 E0.01393

G1 X89.765 Y38.053 E0.01395

G1 X89.513 Y38.524 E0.01392

G1 X89.174 Y38.938 E0.01395

G1 X88.760 Y39.277 E0.01395

G1 X88.288 Y39.529 E0.01392

G1 X87.776 Y39.684 E0.01395

G1 X87.323 Y39.729 E0.01187

M204 S1250

G1 X87.065 Y40.082 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X86.200 Y39.529 E-0.29666

G1 X85.760 Y39.294 E-0.27612

G1 E-0.04800 F4200.00000

G1 Z0.550 F9000.000

G1 X92.984 Y31.725

G1 Z0.350

G1 E3.20000 F2400.00000

M204 S800

G1 X93.605 Y31.881 E0.01668

G1 X93.798 Y31.948 E0.00533

G1 X94.377 Y32.221 E0.01667

G1 X94.761 Y32.465 E0.01184

G1 X95.249 Y32.865 E0.01645

G1 X95.507 Y33.142 E0.00986

G1 X95.801 Y33.506 E0.01220

G1 X96.126 Y34.048 E0.01647

G1 X96.283 Y34.393 E0.00986

G1 X96.431 Y34.818 E0.01173

G1 X96.566 Y35.486 E0.01776

G1 X96.601 Y36.034 E0.01430

G1 X96.601 Y124.986 E2.31772

G1 X96.556 Y125.609 E0.01628

G1 X96.511 Y125.872 E0.00695

G1 X96.360 Y126.289 E0.01156

G1 X96.291 Y126.556 E0.00718

G1 X96.070 Y127.085 E0.01493

G1 X95.679 Y127.679 E0.01853

G1 X95.438 Y127.965 E0.00974

G1 X95.099 Y128.293 E0.01231

G1 X94.800 Y128.531 E0.00994

G1 X94.403 Y128.787 E0.01231

G1 X94.062 Y128.963 E0.01000

G1 X93.846 Y129.050 E0.00606

G1 X93.627 Y129.135 E0.00614

G1 X93.264 Y129.239 E0.00984

G1 X92.701 Y129.330 E0.01485

G1 X92.220 Y129.365 E0.01255

G1 X82.268 Y129.365 E0.25933

G1 X81.784 Y129.330 E0.01264

G1 X81.295 Y129.255 E0.01288

G1 X81.091 Y129.206 E0.00547

G1 X80.720 Y129.079 E0.01022

G1 X80.289 Y128.897 E0.01218

G1 X79.740 Y128.568 E0.01668

G1 X79.576 Y128.448 E0.00529

G1 X79.102 Y128.019 E0.01666

G1 X78.800 Y127.669 E0.01204

G1 X78.672 Y127.487 E0.00578

G1 X78.421 Y127.090 E0.01226

G1 X78.242 Y126.687 E0.01149

G1 X78.126 Y126.281 E0.01099

G1 X77.978 Y125.872 E0.01134

G1 X77.932 Y125.609 E0.00695

G1 X77.887 Y124.986 E0.01628

G1 X77.887 Y36.036 E2.31765

G1 X77.932 Y35.408 E0.01642

G1 X77.964 Y35.204 E0.00538

G1 X78.111 Y34.649 E0.01494

G1 X78.288 Y34.213 E0.01228

G1 X78.460 Y33.861 E0.01020

G1 X78.569 Y33.683 E0.00543

G1 X78.949 Y33.171 E0.01661

G1 X79.386 Y32.734 E0.01612

G1 X79.899 Y32.353 E0.01665

G1 X80.206 Y32.167 E0.00935

G1 X80.815 Y31.900 E0.01732

G1 X81.081 Y31.820 E0.00724

G1 X81.944 Y31.670 E0.02284

G1 X82.257 Y31.657 E0.00815

G1 X92.475 Y31.668 E0.26623

G1 X92.925 Y31.718 E0.01180

M204 S1250

G1 X92.971 Y31.303 F9000.000

M204 S800

G1 F1800.000

G1 X93.726 Y31.480 E0.02019

G1 X93.957 Y31.561 E0.00639

G1 X94.579 Y31.855 E0.01791

G1 X95.006 Y32.125 E0.01319

G1 X95.536 Y32.560 E0.01784

G1 X95.823 Y32.868 E0.01097

G1 X96.145 Y33.266 E0.01334

G1 X96.497 Y33.854 E0.01784

G1 X96.671 Y34.237 E0.01098

G1 X96.835 Y34.707 E0.01297

G1 X96.982 Y35.431 E0.01924

G1 X97.019 Y36.020 E0.01539

G1 X97.019 Y125.001 E2.31846

G1 X96.972 Y125.660 E0.01722

G1 X96.916 Y125.980 E0.00845

G1 X96.759 Y126.413 E0.01200

G1 X96.692 Y126.674 E0.00703

G1 X96.438 Y127.286 E0.01725

G1 X96.015 Y127.930 E0.02008

G1 X95.744 Y128.250 E0.01094

G1 X95.375 Y128.608 E0.01338

G1 X95.044 Y128.871 E0.01101

G1 X94.613 Y129.149 E0.01338

G1 X94.236 Y129.343 E0.01103

G1 X94.000 Y129.438 E0.00665

G1 X93.760 Y129.531 E0.00671

G1 X93.355 Y129.647 E0.01097

G1 X92.750 Y129.745 E0.01597

G1 X92.236 Y129.783 E0.01343

G1 X82.252 Y129.783 E0.26013

G1 X81.737 Y129.745 E0.01346

G1 X81.215 Y129.666 E0.01378

G1 X80.974 Y129.607 E0.00644

G1 X80.571 Y129.470 E0.01110

G1 X80.100 Y129.271 E0.01333

G1 X79.510 Y128.917 E0.01793

G1 X79.312 Y128.773 E0.00636

G1 X78.802 Y128.311 E0.01792

G1 X78.471 Y127.926 E0.01324

G1 X78.325 Y127.720 E0.00658

G1 X78.051 Y127.287 E0.01333

G1 X77.848 Y126.830 E0.01305

G1 X77.728 Y126.410 E0.01137

G1 X77.572 Y125.980 E0.01192

G1 X77.517 Y125.660 E0.00845

G1 X77.469 Y125.001 E0.01722

G1 X77.469 Y36.021 E2.31844

G1 X77.517 Y35.360 E0.01727

G1 X77.555 Y35.118 E0.00639

G1 X77.714 Y34.517 E0.01619

G1 X77.906 Y34.042 E0.01336

G1 X78.094 Y33.660 E0.01109

G1 X78.222 Y33.449 E0.00642

G1 X78.631 Y32.898 E0.01789

G1 X79.112 Y32.417 E0.01772

G1 X79.663 Y32.008 E0.01786

G1 X79.878 Y31.872 E0.00665

G1 X80.019 Y31.792 E0.00420

G1 X80.670 Y31.507 E0.01852

G1 X80.984 Y31.412 E0.00855

G1 X81.900 Y31.253 E0.02422

G1 X82.249 Y31.239 E0.00909

G1 X92.498 Y31.250 E0.26706

G1 X92.912 Y31.296 E0.01084

M204 S1250

G1 X93.115 Y31.676 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.726 Y31.480 E-0.46237

G1 X93.957 Y31.561 E-0.13596

G1 X94.469 Y31.803 E-0.31367

G1 E-0.04800 F4200.00000

G1 Z0.550 F9000.000

G1 X95.390 Y33.199

G1 Z0.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.526 Y38.063 E0.18003

G1 X90.641 Y37.683 E0.01039

G1 X90.676 Y37.319 E0.00957

G1 X94.961 Y33.034 E0.15860

G1 X94.635 Y32.767 E0.01104

G1 X90.679 Y36.723 E0.14644

G1 X90.641 Y36.333 E0.01025

G1 X90.602 Y36.206 E0.00348

G1 X94.279 Y32.530 E0.13608

G1 X93.881 Y32.334 E0.01160

G1 X90.464 Y35.750 E0.12646

G1 X90.268 Y35.354 E0.01159

G1 X93.455 Y32.166 E0.11798

G1 X92.981 Y32.047 E0.01281

G1 X90.043 Y34.985 E0.10875

G1 X89.775 Y34.659 E0.01104

G1 X92.453 Y31.981 E0.09911

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G1 X89.467 Y34.374 E0.08857

G1 X89.136 Y34.111 E0.01106

G1 X91.267 Y31.980 E0.07889

G1 X90.674 Y31.979 E0.01552

G1 X88.749 Y33.905 E0.07126

G1 X88.569 Y33.808 E0.00534

G1 X88.326 Y33.735 E0.00667

G1 X90.082 Y31.979 E0.06499

G1 X89.489 Y31.978 E0.01552

G1 X87.860 Y33.607 E0.06028

G1 X87.578 Y33.565 E0.00747

G1 X87.318 Y33.555 E0.00680

G1 X88.896 Y31.977 E0.05838

G1 X88.303 Y31.977 E0.01552

G1 X86.679 Y33.601 E0.06011

G1 X86.566 Y33.613 E0.00295

G1 X85.919 Y33.808 E0.01771

G1 X85.831 Y33.856 E0.00262

G1 X87.710 Y31.976 E0.06956

G1 X87.117 Y31.976 E0.01552

G1 X78.200 Y40.892 E0.33004

G1 X78.200 Y41.486 E0.01553

G1 X84.091 Y35.595 E0.21805

G1 X84.044 Y35.683 E0.00262

G1 X83.848 Y36.332 E0.01776

G1 X83.837 Y36.443 E0.00290

G1 X78.200 Y42.079 E0.20863

M73 P7 R66

G1 X78.200 Y42.673 E0.01553

G1 X83.788 Y37.085 E0.20682

G1 X83.842 Y37.625 E0.01419

G1 X78.200 Y43.266 E0.20882

G1 X78.200 Y43.860 E0.01553

G1 X83.971 Y38.090 E0.21358

G1 X84.044 Y38.333 E0.00667

G1 X84.140 Y38.513 E0.00534

G1 X78.200 Y44.453 E0.21986

G1 X78.200 Y45.047 E0.01553

G1 X84.347 Y38.900 E0.22752

G1 X84.609 Y39.231 E0.01106

G1 X78.200 Y45.641 E0.23722

G1 X78.200 Y46.234 E0.01553

G1 X84.895 Y39.540 E0.24778

G1 X85.221 Y39.807 E0.01104

G1 X78.200 Y46.828 E0.25986

G1 X78.200 Y47.421 E0.01553

G1 X85.589 Y40.032 E0.27349

G1 X85.986 Y40.229 E0.01159

G1 X78.200 Y48.015 E0.28819

G1 X78.200 Y48.608 E0.01553

G1 X86.442 Y40.366 E0.30506

G1 X86.569 Y40.405 E0.00348

G1 X86.959 Y40.443 E0.01025

G1 X78.200 Y49.202 E0.32419

G1 X78.200 Y49.795 E0.01553

G1 X87.555 Y40.440 E0.34625

G1 X87.919 Y40.405 E0.00957

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G1 X95.951 Y34.419 E0.65701

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G1 X96.111 Y34.852 E0.00950

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G1 X78.213 Y125.158 E0.66899

G1 X78.266 Y125.700 E0.01424

G1 X96.288 Y107.677 E0.66707

G1 X96.288 Y108.271 E0.01553

G1 X78.411 Y126.148 E0.66170

G1 X78.548 Y126.604 E0.01247

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M204 S1250

G1 E-2.24000 F4200.00000

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G1 E-0.04800 F4200.00000

G1 Z0.550 F9000.000

G1 X94.215 Y128.743

G1 Z0.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X95.993 Y126.456 E0.01365

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G1 X96.248 Y125.522 E0.12877

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G1 X88.248 Y127.323 E0.01278

G1 X87.838 Y127.404 E0.01094

G1 X86.190 Y129.052 E0.06100

G1 X85.597 Y129.052 E0.01553

G1 X87.183 Y127.466 E0.05872

M73 P8 R65

G1 X86.880 Y127.449 E0.00793

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G1 X86.168 Y127.293 E0.06510

G1 X85.749 Y127.120 E0.01189

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G1 X85.372 Y126.903 E0.07956

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G1 X81.521 Y128.973 E0.10861

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G1 X84.218 Y125.683 E0.11752

G1 X84.036 Y125.271 E0.01179

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G1 X80.432 Y128.617 E0.00516

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G1 X83.892 Y124.822 E0.13582

G1 X83.800 Y124.320 E0.01335

G1 X79.856 Y128.264 E0.14600

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G1 X89.421 Y121.318 E0.00462

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G1 X96.288 Y116.580 E0.01553

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G1 X96.288 Y118.361 E0.20719

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G1 X90.640 Y124.602 E0.20906

G1 X90.559 Y125.013 E0.01094

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G1 X96.476 Y119.360 E0.22593

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.04800 F4200.00000

G1 Z0.550 F9000.000

G1 X78.012 Y40.487

G1 Z0.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X86.524 Y31.975 E0.31505

G1 X85.931 Y31.974 E0.01552

G1 X78.200 Y39.705 E0.28615

G1 X78.200 Y39.112 E0.01553

G1 X85.338 Y31.974 E0.26421

G1 X84.746 Y31.973 E0.01552

G1 X78.200 Y38.518 E0.24226

G1 X78.200 Y37.925 E0.01553

G1 X84.153 Y31.972 E0.22032

G1 X83.560 Y31.972 E0.01552

G1 X78.200 Y37.331 E0.19837

G1 X78.200 Y36.738 E0.01553

G1 X82.967 Y31.971 E0.17643

G1 X82.374 Y31.971 E0.01552

G1 X78.200 Y36.144 E0.15448

G1 X78.239 Y35.512 E0.01657

G1 X81.725 Y32.026 E0.12904

G1 X81.153 Y32.125 E0.01520

G1 X80.980 Y32.177 E0.00473

G1 X78.409 Y34.749 E0.09518

G1 X78.574 Y34.341 E0.01153

G1 X78.735 Y34.012 E0.00957

G1 X79.184 Y33.380 E0.02028

G1 X80.303 Y32.261 E0.04144

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;0.5

G1 Z0.500 F9000.000

;AFTER\_LAYER\_CHANGE

;0.5

G1 E-3.20000 F4200.00000

G1 Z0.700 F9000.000

G1 X79.736 Y29.077

G1 Z0.500

G1 E3.20000 F2400.00000

G1 X80.691 Y28.812 E0.02397

G1 X82.163 Y28.639 E0.03584

G1 X92.248 Y28.637 E0.24391

G1 X93.540 Y28.754 E0.03138

G1 X94.918 Y29.142 E0.03463

G1 X96.000 Y29.674 E0.02916

G1 X97.281 Y30.628 E0.03861

G1 X98.024 Y31.435 E0.02655

G1 X98.797 Y32.630 E0.03441

G1 X99.324 Y33.945 E0.03426

G1 X99.576 Y35.224 E0.03151

G1 X99.621 Y125.009 E2.17146

G1 X99.565 Y125.895 E0.02147

G1 X99.430 Y126.663 E0.01886

G1 X99.116 Y127.670 E0.02551

G1 X98.722 Y128.537 E0.02302

G1 X98.090 Y129.504 E0.02794

G1 X97.296 Y130.379 E0.02857

G1 X96.535 Y131.006 E0.02386

G1 X95.772 Y131.479 E0.02169

G1 X94.684 Y131.968 E0.02886

G1 X93.447 Y132.282 E0.03087

G1 X92.308 Y132.384 E0.02764

G1 X82.233 Y132.385 E0.24368

G1 X81.333 Y132.324 E0.02180

G1 X80.225 Y132.101 E0.02734

G1 X78.930 Y131.597 E0.03361

G1 X77.756 Y130.860 E0.03352

G1 X76.919 Y130.109 E0.02720

G1 X76.189 Y129.210 E0.02800

G1 X75.741 Y128.490 E0.02052

G1 X75.376 Y127.678 E0.02151

G1 X75.032 Y126.549 E0.02856

G1 X74.872 Y125.164 E0.03371

G1 X74.867 Y36.013 E2.15611

G1 X74.923 Y35.127 E0.02147

G1 X75.058 Y34.374 E0.01851

G1 X75.433 Y33.187 E0.03012

G1 X75.864 Y32.316 E0.02349

G1 X76.599 Y31.271 E0.03090

G1 X77.348 Y30.499 E0.02601

G1 X78.260 Y29.813 E0.02761

G1 X79.682 Y29.104 E0.03843

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.691 Y28.812 E-0.58186

G1 X81.282 Y28.742 E-0.33014

G1 E-0.04800 F4200.00000

G1 Z0.700 F9000.000

G1 X87.554 Y120.876

G1 Z0.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.157 Y120.995 E0.01602

G1 X88.729 Y121.232 E0.01612

G1 X89.228 Y121.566 E0.01565

G1 X89.469 Y121.783 E0.00846

G1 X89.687 Y122.024 E0.00846

G1 X90.021 Y122.524 E0.01565

G1 X90.257 Y123.095 E0.01612

G1 X90.377 Y123.700 E0.01607

G1 X90.377 Y124.316 E0.01604

G1 X90.257 Y124.921 E0.01608

G1 X90.021 Y125.493 E0.01612

G1 X89.687 Y125.992 E0.01565

G1 X89.469 Y126.233 E0.00846

G1 X89.228 Y126.451 E0.00846

G1 X88.729 Y126.785 E0.01565

G1 X88.157 Y127.022 E0.01612

G1 X87.569 Y127.138 E0.01563

G1 X87.244 Y127.155 E0.00847

G1 X86.919 Y127.138 E0.00847

G1 X86.331 Y127.021 E0.01563

G1 X85.759 Y126.785 E0.01612

G1 X85.260 Y126.451 E0.01565

G1 X85.019 Y126.233 E0.00846

G1 X84.802 Y125.992 E0.00846

G1 X84.467 Y125.493 E0.01565

G1 X84.231 Y124.921 E0.01612

G1 X84.115 Y124.333 E0.01563

G1 X84.097 Y124.008 E0.00847

G1 X84.115 Y123.684 E0.00847

G1 X84.231 Y123.095 E0.01563

G1 X84.468 Y122.524 E0.01612

G1 X84.802 Y122.024 E0.01565

G1 X85.019 Y121.783 E0.00846

G1 X85.260 Y121.566 E0.00846

G1 X85.760 Y121.232 E0.01565

G1 X86.317 Y121.001 E0.01571

G1 X86.637 Y120.921 E0.00861

G1 X87.020 Y120.872 E0.01004

G1 X87.494 Y120.875 E0.01237

M204 S1250

G1 X87.491 Y121.293 F9000.000

M204 S800

G1 F1500.000

G1 X88.036 Y121.397 E0.01444

G1 X88.531 Y121.602 E0.01396

G1 X88.971 Y121.896 E0.01379

G1 X89.173 Y122.079 E0.00711

G1 X89.356 Y122.282 E0.00711

G1 X89.651 Y122.722 E0.01379

G1 X89.856 Y123.217 E0.01396

G1 X89.959 Y123.741 E0.01393

G1 X89.959 Y124.275 E0.01392

G1 X89.855 Y124.800 E0.01393

G1 X89.650 Y125.295 E0.01396

G1 X89.356 Y125.735 E0.01379

G1 X89.173 Y125.938 E0.00711

G1 X88.971 Y126.120 E0.00711

G1 X88.531 Y126.415 E0.01379

G1 X88.036 Y126.620 E0.01396

G1 X87.517 Y126.722 E0.01377

G1 X87.244 Y126.737 E0.00712

G1 X86.971 Y126.722 E0.00712

G1 X86.452 Y126.620 E0.01378

G1 X85.957 Y126.415 E0.01396

G1 X85.518 Y126.120 E0.01379

G1 X85.315 Y125.938 E0.00711

G1 X85.132 Y125.735 E0.00711

G1 X84.838 Y125.295 E0.01379

G1 X84.633 Y124.800 E0.01396

G1 X84.530 Y124.281 E0.01377

G1 X84.516 Y124.008 E0.00712

G1 X84.530 Y123.735 E0.00712

G1 X84.633 Y123.217 E0.01378

G1 X84.838 Y122.722 E0.01396

G1 X85.132 Y122.282 E0.01379

G1 X85.315 Y122.079 E0.00711

G1 X85.518 Y121.896 E0.00711

G1 X85.958 Y121.602 E0.01379

G1 X86.448 Y121.399 E0.01382

G1 X86.715 Y121.333 E0.00717

G1 X87.045 Y121.290 E0.00868

G1 X87.431 Y121.293 E0.01007

M204 S1250

G1 X87.728 Y120.971 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.036 Y121.397 E-0.33985

G1 X88.531 Y121.602 E-0.29692

G1 X88.944 Y121.878 E-0.27524

G1 E-0.04800 F4200.00000

G1 Z0.700 F9000.000

G1 X87.244 Y40.156

G1 Z0.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.630 Y40.096 E0.01607

G1 X86.039 Y39.917 E0.01609

G1 X85.496 Y39.626 E0.01606

G1 X85.017 Y39.235 E0.01610

G1 X84.626 Y38.757 E0.01610

G1 X84.335 Y38.213 E0.01606

G1 X84.157 Y37.623 E0.01608

G1 X84.095 Y37.008 E0.01608

G1 X84.157 Y36.394 E0.01609

G1 X84.335 Y35.803 E0.01608

G1 X84.626 Y35.260 E0.01606

G1 X85.017 Y34.781 E0.01610

G1 X85.496 Y34.390 E0.01610

G1 X86.039 Y34.099 E0.01606

G1 X86.628 Y33.922 E0.01602

G1 X87.161 Y33.865 E0.01396

G1 X87.547 Y33.877 E0.01007

G1 X87.873 Y33.925 E0.00859

G1 X88.449 Y34.099 E0.01568

G1 X88.993 Y34.390 E0.01606

G1 X89.471 Y34.781 E0.01610

G1 X89.862 Y35.260 E0.01610

G1 X90.153 Y35.803 E0.01606

G1 X90.332 Y36.395 E0.01609

G1 X90.392 Y37.008 E0.01607

G1 X90.332 Y37.622 E0.01607

G1 X90.153 Y38.213 E0.01609

G1 X89.862 Y38.757 E0.01606

G1 X89.471 Y39.235 E0.01610

G1 X88.993 Y39.627 E0.01610

G1 X88.449 Y39.917 E0.01606

G1 X87.858 Y40.096 E0.01609

G1 X87.304 Y40.150 E0.01450

M204 S1250

G1 X87.263 Y39.734 F9000.000

M204 S800

G1 F1500.000

G1 X86.712 Y39.684 E0.01441

G1 X86.200 Y39.529 E0.01395

G1 X85.729 Y39.277 E0.01392

G1 X85.314 Y38.938 E0.01395

G1 X84.975 Y38.524 E0.01395

G1 X84.723 Y38.053 E0.01392

G1 X84.568 Y37.540 E0.01394

G1 X84.515 Y37.008 E0.01394

G1 X84.568 Y36.476 E0.01394

G1 X84.723 Y35.964 E0.01394

G1 X84.975 Y35.493 E0.01392

G1 X85.314 Y35.078 E0.01395

G1 X85.729 Y34.739 E0.01395

G1 X86.200 Y34.487 E0.01392

G1 X86.711 Y34.333 E0.01392

G1 X87.176 Y34.283 E0.01219

G1 X87.509 Y34.294 E0.00868

G1 X87.781 Y34.334 E0.00717

G1 X88.289 Y34.487 E0.01380

G1 X88.760 Y34.739 E0.01392

G1 X89.174 Y35.078 E0.01395

G1 X89.513 Y35.493 E0.01395

G1 X89.765 Y35.964 E0.01392

G1 X89.920 Y36.476 E0.01395

G1 X89.972 Y37.008 E0.01393

G1 X89.920 Y37.540 E0.01393

G1 X89.765 Y38.053 E0.01395

G1 X89.513 Y38.524 E0.01392

G1 X89.174 Y38.938 E0.01395

G1 X88.760 Y39.277 E0.01395

G1 X88.288 Y39.529 E0.01392

G1 X87.776 Y39.684 E0.01395

G1 X87.323 Y39.729 E0.01187

M204 S1250

G1 X87.065 Y40.082 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.712 Y39.684 E-0.33922

G1 X86.200 Y39.529 E-0.29666

G1 X85.760 Y39.294 E-0.27612

G1 E-0.04800 F4200.00000

G1 Z0.700 F9000.000

G1 X93.796 Y31.948

G1 Z0.500

G1 E3.20000 F2400.00000

M204 S800

G1 X94.422 Y32.249 E0.01810

G1 X94.717 Y32.435 E0.00908

G1 X95.250 Y32.867 E0.01788

G1 X95.801 Y33.508 E0.02201

G1 X96.149 Y34.096 E0.01781

G1 X96.269 Y34.361 E0.00758

G1 X96.427 Y34.803 E0.01223

G1 X96.566 Y35.486 E0.01817

G1 X96.601 Y36.034 E0.01429

G1 X96.601 Y124.985 E2.31769

G1 X96.551 Y125.645 E0.01724

G1 X96.518 Y125.836 E0.00507

G1 X96.283 Y126.486 E0.01801

G1 X96.192 Y126.803 E0.00859

G1 X96.061 Y127.098 E0.00841

G1 X95.646 Y127.720 E0.01947

G1 X95.462 Y127.936 E0.00739

G1 X95.056 Y128.327 E0.01470

G1 X94.830 Y128.508 E0.00754

G1 X94.365 Y128.806 E0.01441

G1 X93.913 Y129.019 E0.01300

G1 X93.574 Y129.150 E0.00948

G1 X93.301 Y129.228 E0.00739

G1 X92.593 Y129.338 E0.01867

G1 X92.220 Y129.365 E0.00974

G1 X82.268 Y129.365 E0.25933

G1 X81.893 Y129.338 E0.00979

G1 X81.092 Y129.205 E0.02116

G1 X80.289 Y128.895 E0.02242

G1 X79.578 Y128.449 E0.02187

G1 X79.067 Y127.979 E0.01809

G1 X78.836 Y127.711 E0.00922

G1 X78.623 Y127.410 E0.00961

G1 X78.431 Y127.106 E0.00938

G1 X78.296 Y126.803 E0.00862

G1 X78.206 Y126.486 E0.00859

G1 X77.970 Y125.836 E0.01801

G1 X77.937 Y125.645 E0.00507

G1 X77.887 Y124.985 E0.01724

G1 X77.887 Y36.038 E2.31759

G1 X77.937 Y35.373 E0.01737

G1 X78.111 Y34.653 E0.01930

G1 X78.323 Y34.144 E0.01437

G1 X78.553 Y33.714 E0.01270

G1 X78.950 Y33.172 E0.01750

G1 X79.427 Y32.700 E0.01749

G1 X79.821 Y32.408 E0.01277

G1 X80.233 Y32.155 E0.01260

G1 X80.831 Y31.895 E0.01701

G1 X81.030 Y31.835 E0.00539

G1 X81.946 Y31.670 E0.02427

G1 X82.257 Y31.657 E0.00810

G1 X92.421 Y31.666 E0.26483

G1 X92.984 Y31.726 E0.01474

G1 X93.739 Y31.928 E0.02039

M204 S1250

G1 X93.878 Y31.534 F9000.000

M204 S800

G1 F1800.000

G1 X94.625 Y31.883 E0.02150

G1 X94.961 Y32.095 E0.01035

G1 X95.536 Y32.561 E0.01927

G1 X95.761 Y32.802 E0.00859

G1 X96.144 Y33.267 E0.01571

G1 X96.520 Y33.903 E0.01924

G1 X96.657 Y34.204 E0.00862

G1 X96.830 Y34.691 E0.01346

G1 X96.982 Y35.431 E0.01969

G1 X97.019 Y36.020 E0.01539

G1 X97.019 Y125.001 E2.31845

G1 X96.966 Y125.696 E0.01817

G1 X96.923 Y125.944 E0.00655

G1 X96.680 Y126.615 E0.01860

G1 X96.585 Y126.946 E0.00897

G1 X96.428 Y127.301 E0.01010

G1 X95.980 Y127.972 E0.02103

G1 X95.768 Y128.222 E0.00856

G1 X95.332 Y128.642 E0.01576

G1 X95.073 Y128.848 E0.00861

G1 X94.567 Y129.172 E0.01566

G1 X94.078 Y129.403 E0.01410

G1 X93.707 Y129.547 E0.01036

G1 X93.391 Y129.637 E0.00855

G1 X92.641 Y129.753 E0.01980

G1 X92.236 Y129.783 E0.01058

G1 X82.252 Y129.783 E0.26013

G1 X81.847 Y129.753 E0.01059

G1 X81.161 Y129.652 E0.01808

G1 X80.975 Y129.606 E0.00499

G1 X80.657 Y129.498 E0.00874

G1 X80.100 Y129.269 E0.01570

G1 X79.313 Y128.773 E0.02424

G1 X78.766 Y128.271 E0.01934

G1 X78.506 Y127.969 E0.01039

G1 X78.276 Y127.642 E0.01041

G1 X78.061 Y127.303 E0.01045

G1 X77.903 Y126.946 E0.01018

G1 X77.808 Y126.615 E0.00897

G1 X77.565 Y125.944 E0.01860

G1 X77.522 Y125.696 E0.00655

G1 X77.469 Y125.001 E0.01817

G1 X77.469 Y36.022 E2.31841

G1 X77.522 Y35.324 E0.01822

G1 X77.552 Y35.136 E0.00497

G1 X77.714 Y34.518 E0.01664

G1 X77.945 Y33.964 E0.01564

G1 X78.199 Y33.491 E0.01399

G1 X78.632 Y32.898 E0.01913

G1 X79.154 Y32.382 E0.01913

G1 X79.586 Y32.062 E0.01401

G1 X80.039 Y31.783 E0.01385

G1 X80.687 Y31.502 E0.01841

G1 X80.932 Y31.428 E0.00666

G1 X81.901 Y31.253 E0.02565

G1 X82.249 Y31.239 E0.00907

G1 X92.444 Y31.248 E0.26564

G1 X93.058 Y31.314 E0.01611

G1 X93.821 Y31.514 E0.02054

M204 S1250

G1 X93.944 Y31.929 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X94.625 Y31.883 E-0.49031

G1 X94.961 Y32.095 E-0.22008

G1 X95.244 Y32.324 E-0.20161

G1 E-0.04800 F4200.00000

G1 Z0.700 F9000.000

G1 X95.959 Y34.021

G1 Z0.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X95.030 Y33.092 E0.03440

G1 X94.534 Y32.690 E0.01670

G1 X94.270 Y32.524 E0.00816

G1 X93.686 Y32.243 E0.01696

G1 X93.550 Y32.206 E0.00370

G1 X96.065 Y34.721 E0.09310

G1 X96.124 Y34.888 E0.00464

G1 X96.249 Y35.499 E0.01633

G1 X92.768 Y32.018 E0.12884

G1 X92.404 Y31.979 E0.00959

G1 X92.136 Y31.979 E0.00703

G1 X96.288 Y36.131 E0.15371

G1 X96.288 Y36.725 E0.01554

G1 X91.542 Y31.978 E0.17570

G1 X90.947 Y31.978 E0.01555

G1 X96.288 Y37.318 E0.19769

G1 X96.288 Y37.912 E0.01554

G1 X90.353 Y31.977 E0.21968

G1 X89.759 Y31.977 E0.01555

G1 X96.288 Y38.505 E0.24167

G1 X96.288 Y39.099 E0.01554

G1 X89.165 Y31.976 E0.26366

G1 X88.571 Y31.976 E0.01555

G1 X96.288 Y39.693 E0.28565

G1 X96.288 Y40.286 E0.01554

G1 X87.977 Y31.975 E0.30764

G1 X87.383 Y31.975 E0.01555

G1 X96.288 Y40.880 E0.32964

G1 X96.288 Y41.473 E0.01554

G1 X90.382 Y35.568 E0.21861

G1 X90.444 Y35.683 E0.00342

G1 X90.641 Y36.333 E0.01778

G1 X90.650 Y36.429 E0.00251

G1 X96.288 Y42.067 E0.20870

G1 X96.288 Y42.660 E0.01554

G1 X90.701 Y37.073 E0.20683

G1 X90.647 Y37.613 E0.01421

G1 X96.288 Y43.254 E0.20880

G1 X96.288 Y43.848 E0.01554

G1 X90.521 Y38.080 E0.21349

G1 X90.444 Y38.334 E0.00693

G1 X90.352 Y38.505 E0.00510

G1 X96.288 Y44.441 E0.21973

G1 X96.288 Y45.035 E0.01554

G1 X90.145 Y38.892 E0.22738

G1 X89.884 Y39.225 E0.01107

G1 X96.288 Y45.628 E0.23704

G1 X96.288 Y46.222 E0.01554

G1 X89.600 Y39.534 E0.24756

G1 X89.274 Y39.801 E0.01104

G1 X96.288 Y46.815 E0.25964

G1 X96.288 Y47.409 E0.01554

G1 X88.907 Y40.028 E0.27323

G1 X88.511 Y40.226 E0.01158

G1 X96.288 Y48.003 E0.28788

G1 X96.288 Y48.596 E0.01554

G1 X88.055 Y40.363 E0.30475

G1 X87.919 Y40.405 E0.00373

G1 X87.540 Y40.442 E0.00996

G1 X96.288 Y49.190 E0.32382

G1 X96.288 Y49.783 E0.01554

G1 X86.946 Y40.442 E0.34580

G1 X86.569 Y40.405 E0.00992

G1 X86.206 Y40.295 E0.00994

G1 X96.288 Y50.377 E0.37321

G1 X96.288 Y50.971 E0.01554

G1 X78.979 Y33.662 E0.64071

G1 X79.238 Y33.327 E0.01108

G1 X83.957 Y38.046 E0.17469

G1 X83.848 Y37.684 E0.00991

G1 X83.810 Y37.305 E0.00996

G1 X79.537 Y33.032 E0.15818

G1 X79.632 Y32.939 E0.00349

G1 X79.864 Y32.766 E0.00758

G1 X83.810 Y36.712 E0.14606

G1 X83.848 Y36.332 E0.00998

G1 X83.889 Y36.197 E0.00370

G1 X80.221 Y32.530 E0.13576

G1 X80.378 Y32.433 E0.00481

G1 X80.615 Y32.330 E0.00678

G1 X84.027 Y35.741 E0.12627

G1 X84.225 Y35.346 E0.01158

G1 X81.038 Y32.159 E0.11795

G1 X81.535 Y32.062 E0.01324

G1 X84.451 Y34.979 E0.10796

G1 X84.718 Y34.652 E0.01104

G1 X82.045 Y31.979 E0.09894

G1 X82.630 Y31.971 E0.01531

G1 X85.028 Y34.368 E0.08874

G1 X85.360 Y34.107 E0.01107

G1 X83.224 Y31.971 E0.07906

G1 X83.819 Y31.972 E0.01555

G1 X85.747 Y33.900 E0.07139

G1 X85.919 Y33.808 E0.00510

G1 X86.172 Y33.732 E0.00693

G1 X84.413 Y31.972 E0.06513

G1 X85.007 Y31.973 E0.01555

G1 X86.639 Y33.605 E0.06043

G1 X87.179 Y33.552 E0.01420

G1 X85.601 Y31.973 E0.05842

G1 X86.195 Y31.974 E0.01555

G1 X87.822 Y33.601 E0.06024

G1 X87.942 Y33.619 E0.00316

G1 X88.569 Y33.808 E0.01717

G1 X88.685 Y33.870 E0.00342

G1 X86.601 Y31.786 E0.07714

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.764 Y32.950 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z0.700 F9000.000

G1 X96.476 Y51.752

G1 Z0.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X78.745 Y34.021 E0.65637

G1 X78.548 Y34.418 E0.01160

G1 X96.288 Y52.158 E0.65667

G1 X96.288 Y52.751 E0.01554

G1 X78.386 Y34.849 E0.66268

G1 X78.271 Y35.328 E0.01288

G1 X96.288 Y53.345 E0.66695

G1 X96.288 Y53.938 E0.01554

G1 X78.214 Y35.865 E0.66903

G1 X78.200 Y36.444 E0.01517

G1 X96.288 Y54.532 E0.66955

G1 X96.288 Y55.126 E0.01554

G1 X78.200 Y37.038 E0.66955

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G1 X96.288 Y58.687 E0.01554

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G1 X78.200 Y41.193 E0.01554

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G1 X78.200 Y48.316 E0.01554

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G1 X96.288 Y66.997 E0.01554

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M73 P10 R64

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G1 X96.274 Y125.154 E0.01518

G1 X78.200 Y107.080 E0.66904

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G1 X96.224 Y125.697 E0.66718

G1 X96.074 Y126.141 E0.01226

G1 X78.200 Y108.267 E0.66164

G1 X78.200 Y108.861 E0.01554

G1 X95.928 Y126.588 E0.65621

G1 X95.897 Y126.696 E0.00294

G1 X95.748 Y127.002 E0.00891

G1 X78.200 Y109.454 E0.64957

G1 X78.200 Y110.048 E0.01554

G1 X95.510 Y127.358 E0.64077

G1 X95.255 Y127.696 E0.01109

G1 X90.556 Y122.997 E0.17395

G1 X90.690 Y123.725 E0.01938

G1 X94.955 Y127.990 E0.15787

G1 X94.633 Y128.262 E0.01103

G1 X90.690 Y124.319 E0.14596

G1 X90.597 Y124.819 E0.01332

G1 X94.272 Y128.493 E0.13602

G1 X93.875 Y128.691 E0.01159

G1 X90.453 Y125.268 E0.12668

G1 X90.272 Y125.681 E0.01179

G1 X93.450 Y128.859 E0.11766

G1 X93.234 Y128.922 E0.00590

G1 X92.961 Y128.964 E0.00722

G1 X90.034 Y126.037 E0.10836

G1 X89.935 Y126.185 E0.00468

G1 X89.771 Y126.367 E0.00640

G1 X92.439 Y129.035 E0.09877

G1 X91.862 Y129.052 E0.01510

G1 X89.467 Y126.657 E0.08866

G1 X89.118 Y126.901 E0.01116

G1 X91.269 Y129.052 E0.07961

G1 X90.675 Y129.052 E0.01554

G1 X88.742 Y127.119 E0.07157

G1 X88.322 Y127.292 E0.01189

G1 X90.082 Y129.052 E0.06514

G1 X89.488 Y129.052 E0.01554

G1 X87.840 Y127.404 E0.06102

G1 X87.608 Y127.449 E0.00619

G1 X87.308 Y127.465 E0.00786

G1 X88.894 Y129.052 E0.05874

G1 X88.301 Y129.052 E0.01554

G1 X86.653 Y127.405 E0.06098

G1 X86.240 Y127.323 E0.01104

G1 X85.793 Y127.138 E0.01265

G1 X87.707 Y129.052 E0.07085

G1 X87.114 Y129.052 E0.01554

G1 X78.200 Y120.139 E0.32995

G1 X78.200 Y119.545 E0.01554

G1 X84.114 Y125.459 E0.21892

G1 X83.929 Y125.013 E0.01265

G1 X83.848 Y124.599 E0.01103

G1 X78.200 Y118.951 E0.20905

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G1 X83.787 Y123.945 E0.20680

G1 X83.803 Y123.645 E0.00786

G1 X83.849 Y123.413 E0.00619

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G1 X83.960 Y122.930 E0.21321

G1 X84.134 Y122.511 E0.01189

G1 X78.200 Y116.577 E0.21964

G1 X78.200 Y115.984 E0.01554

G1 X84.351 Y122.134 E0.22768

G1 X84.595 Y121.785 E0.01116

G1 X78.200 Y115.390 E0.23673

G1 X78.200 Y114.796 E0.01554

G1 X84.885 Y121.482 E0.24747

G1 X85.067 Y121.318 E0.00641

G1 X85.216 Y121.218 E0.00468

G1 X78.200 Y114.203 E0.25970

G1 X78.200 Y113.609 E0.01554

G1 X85.571 Y120.980 E0.27286

G1 X85.984 Y120.799 E0.01179

G1 X78.200 Y113.016 E0.28813

G1 X78.200 Y112.422 E0.01554

G1 X86.429 Y120.650 E0.30459

G1 X86.579 Y120.613 E0.00407

G1 X86.938 Y120.567 E0.00947

G1 X78.200 Y111.829 E0.32346

G1 X78.200 Y111.235 E0.01554

G1 X87.528 Y120.562 E0.34527

G1 X88.255 Y120.696 E0.01937

G1 X78.012 Y110.453 E0.37917

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X79.176 Y111.617 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z0.700 F9000.000

G1 X78.512 Y126.979

G1 Z0.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X79.304 Y127.772 E0.02932

G1 X79.769 Y128.199 E0.01653

G1 X80.430 Y128.614 E0.02043

G1 X80.934 Y128.808 E0.01415

G1 X78.497 Y126.371 E0.09022

G1 X78.274 Y125.755 E0.01714

G1 X78.242 Y125.523 E0.00615

G1 X81.709 Y128.990 E0.12835

G1 X81.930 Y129.026 E0.00586

G1 X82.365 Y129.052 E0.01141

G1 X78.200 Y124.887 E0.15417

G1 X78.200 Y124.294 E0.01554

G1 X82.959 Y129.052 E0.17614

G1 X83.552 Y129.052 E0.01554

G1 X78.200 Y123.700 E0.19812

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G1 X84.146 Y129.052 E0.22009

G1 X84.739 Y129.052 E0.01554

G1 X78.200 Y122.513 E0.24206

G1 X78.200 Y121.919 E0.01554

G1 X85.333 Y129.052 E0.26403

G1 X85.927 Y129.052 E0.01554

G1 X78.200 Y121.326 E0.28601

G1 X78.200 Y120.732 E0.01554

G1 X86.708 Y129.240 E0.31494

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;0.65

G1 Z0.650 F9000.000

;AFTER\_LAYER\_CHANGE

;0.65

G1 E-3.20000 F4200.00000

G1 Z0.850 F9000.000

G1 X86.331 Y127.021

G1 Z0.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.759 Y126.785 E0.01611

G1 X85.260 Y126.451 E0.01565

G1 X85.019 Y126.233 E0.00846

G1 X84.801 Y125.992 E0.00847

G1 X84.467 Y125.493 E0.01565

G1 X84.231 Y124.921 E0.01612

G1 X84.115 Y124.333 E0.01563

G1 X84.097 Y124.008 E0.00847

G1 X84.115 Y123.683 E0.00847

G1 X84.231 Y123.095 E0.01563

G1 X84.468 Y122.524 E0.01611

G1 X84.802 Y122.024 E0.01565

G1 X85.019 Y121.783 E0.00846

G1 X85.260 Y121.566 E0.00847

G1 X85.760 Y121.232 E0.01565

G1 X86.317 Y121.001 E0.01571

G1 X86.639 Y120.921 E0.00865

G1 X87.043 Y120.871 E0.01061

G1 X87.555 Y120.876 E0.01334

G1 X88.157 Y120.995 E0.01600

G1 X88.729 Y121.232 E0.01611

G1 X89.228 Y121.566 E0.01565

G1 X89.469 Y121.783 E0.00846

G1 X89.687 Y122.025 E0.00847

G1 X90.021 Y122.524 E0.01565

G1 X90.257 Y123.095 E0.01612

G1 X90.377 Y123.700 E0.01607

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G1 X90.257 Y124.922 E0.01608

G1 X90.021 Y125.493 E0.01611

G1 X89.687 Y125.992 E0.01565

G1 X89.469 Y126.233 E0.00846

G1 X89.228 Y126.451 E0.00847

G1 X88.729 Y126.785 E0.01565

G1 X88.157 Y127.022 E0.01612

G1 X87.569 Y127.138 E0.01563

G1 X87.244 Y127.155 E0.00847

G1 X86.919 Y127.138 E0.00847

G1 X86.390 Y127.033 E0.01407

M204 S1250

G1 X86.471 Y126.623 F9000.000

M204 S800

G1 F1500.000

G1 X85.957 Y126.415 E0.01443

G1 X85.518 Y126.120 E0.01379

G1 X85.315 Y125.938 E0.00711

G1 X85.132 Y125.735 E0.00712

G1 X84.838 Y125.295 E0.01379

G1 X84.633 Y124.800 E0.01396

G1 X84.530 Y124.281 E0.01377

G1 X84.516 Y124.008 E0.00712

G1 X84.530 Y123.735 E0.00712

G1 X84.633 Y123.217 E0.01378

G1 X84.838 Y122.722 E0.01396

G1 X85.132 Y122.282 E0.01379

G1 X85.315 Y122.079 E0.00711

G1 X85.518 Y121.896 E0.00711

G1 X85.958 Y121.602 E0.01379

G1 X86.448 Y121.399 E0.01382

G1 X86.715 Y121.333 E0.00718

G1 X87.067 Y121.289 E0.00923

G1 X87.512 Y121.293 E0.01161

G1 X88.036 Y121.397 E0.01390

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G1 X89.959 Y123.741 E0.01393

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G1 X89.356 Y125.735 E0.01379

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G1 X88.971 Y126.120 E0.00712

G1 X88.531 Y126.415 E0.01379

G1 X88.036 Y126.620 E0.01396

G1 X87.517 Y126.722 E0.01377

G1 X87.244 Y126.737 E0.00712

G1 X86.971 Y126.722 E0.00712

G1 X86.530 Y126.635 E0.01173

M204 S1250

G1 X86.176 Y126.893 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.957 Y126.415 E-0.33970

G1 X85.518 Y126.120 E-0.29335

G1 X85.315 Y125.938 E-0.15123

G1 X85.161 Y125.766 E-0.12772

G1 E-0.04800 F4200.00000

G1 Z0.850 F9000.000

G1 X87.244 Y40.156

G1 Z0.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.630 Y40.096 E0.01607

G1 X86.039 Y39.917 E0.01609

G1 X85.495 Y39.626 E0.01606

G1 X85.017 Y39.235 E0.01610

G1 X84.626 Y38.757 E0.01610

G1 X84.335 Y38.213 E0.01606

G1 X84.157 Y37.623 E0.01608

G1 X84.095 Y37.008 E0.01608

G1 X84.157 Y36.394 E0.01609

G1 X84.335 Y35.803 E0.01608

G1 X84.626 Y35.260 E0.01606

G1 X85.017 Y34.781 E0.01610

G1 X85.496 Y34.390 E0.01610

G1 X86.039 Y34.099 E0.01606

G1 X86.627 Y33.922 E0.01600

G1 X87.137 Y33.866 E0.01337

G1 X87.545 Y33.877 E0.01064

G1 X87.873 Y33.925 E0.00864

G1 X88.449 Y34.099 E0.01568

G1 X88.993 Y34.390 E0.01606

G1 X89.471 Y34.781 E0.01610

G1 X89.862 Y35.260 E0.01610

G1 X90.153 Y35.803 E0.01606

G1 X90.332 Y36.395 E0.01609

G1 X90.392 Y37.008 E0.01607

G1 X90.332 Y37.622 E0.01607

G1 X90.153 Y38.213 E0.01609

G1 X89.862 Y38.757 E0.01606

G1 X89.471 Y39.235 E0.01610

G1 X88.993 Y39.627 E0.01610

G1 X88.449 Y39.917 E0.01606

G1 X87.858 Y40.096 E0.01609

G1 X87.304 Y40.150 E0.01450

M204 S1250

G1 X87.263 Y39.735 F9000.000

M204 S800

G1 F1500.000

G1 X86.712 Y39.684 E0.01441

G1 X86.200 Y39.529 E0.01395

G1 X85.729 Y39.277 E0.01392

G1 X85.314 Y38.938 E0.01395

G1 X84.975 Y38.524 E0.01395

G1 X84.723 Y38.053 E0.01392

G1 X84.568 Y37.540 E0.01394

G1 X84.515 Y37.008 E0.01394

G1 X84.568 Y36.476 E0.01394

G1 X84.723 Y35.964 E0.01394

G1 X84.975 Y35.493 E0.01392

G1 X85.314 Y35.078 E0.01395

G1 X85.729 Y34.739 E0.01395

G1 X86.200 Y34.487 E0.01392

G1 X86.711 Y34.333 E0.01391

G1 X87.154 Y34.284 E0.01162

G1 X87.509 Y34.294 E0.00924

G1 X87.781 Y34.334 E0.00718

G1 X88.289 Y34.487 E0.01380

G1 X88.760 Y34.739 E0.01392

G1 X89.174 Y35.078 E0.01395

G1 X89.513 Y35.493 E0.01395

G1 X89.765 Y35.964 E0.01392

G1 X89.920 Y36.476 E0.01395

G1 X89.972 Y37.008 E0.01393

G1 X89.920 Y37.540 E0.01393

G1 X89.765 Y38.053 E0.01395

G1 X89.513 Y38.524 E0.01392

G1 X89.174 Y38.938 E0.01395

G1 X88.760 Y39.277 E0.01395

G1 X88.288 Y39.529 E0.01392

G1 X87.776 Y39.684 E0.01395

G1 X87.323 Y39.729 E0.01187

M204 S1250

G1 X87.065 Y40.082 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.712 Y39.684 E-0.33922

G1 X86.200 Y39.529 E-0.29666

G1 X85.760 Y39.294 E-0.27612

G1 E-0.04800 F4200.00000

G1 Z0.850 F9000.000

G1 X80.848 Y31.889

G1 Z0.650

G1 E3.20000 F2400.00000

M204 S800

G1 X80.978 Y31.850 E0.00355

G1 X81.948 Y31.670 E0.02570

G1 X82.257 Y31.657 E0.00805

G1 X92.367 Y31.663 E0.26343

G1 X92.979 Y31.727 E0.01602

G1 X93.813 Y31.958 E0.02256

G1 X94.468 Y32.277 E0.01897

G1 X94.672 Y32.406 E0.00630

G1 X95.241 Y32.861 E0.01898

G1 X95.803 Y33.513 E0.02242

G1 X96.171 Y34.145 E0.01905

G1 X96.423 Y34.788 E0.01801

G1 X96.566 Y35.487 E0.01858

G1 X96.601 Y36.034 E0.01428

G1 X96.601 Y124.984 E2.31766

G1 X96.525 Y125.800 E0.02136

G1 X96.203 Y126.691 E0.02469

G1 X96.137 Y126.919 E0.00620

G1 X96.052 Y127.112 E0.00548

G1 X95.612 Y127.760 E0.02042

G1 X95.487 Y127.908 E0.00503

G1 X95.014 Y128.362 E0.01708

G1 X94.860 Y128.485 E0.00514

G1 X94.316 Y128.831 E0.01679

G1 X93.997 Y128.982 E0.00919

G1 X93.338 Y129.218 E0.01824

G1 X92.485 Y129.346 E0.02250

G1 X92.220 Y129.365 E0.00690

G1 X82.268 Y129.365 E0.25933

G1 X82.007 Y129.346 E0.00682

G1 X81.080 Y129.198 E0.02446

G1 X80.288 Y128.893 E0.02210

G1 X79.565 Y128.435 E0.02231

G1 X79.031 Y127.939 E0.01897

G1 X78.871 Y127.753 E0.00640

G1 X78.440 Y127.121 E0.01993

G1 X78.351 Y126.919 E0.00575

G1 X78.285 Y126.691 E0.00620

G1 X77.963 Y125.800 E0.02469

G1 X77.942 Y125.680 E0.00318

G1 X77.887 Y124.984 E0.01819

G1 X77.887 Y36.039 E2.31753

G1 X77.958 Y35.240 E0.02091

G1 X78.111 Y34.655 E0.01574

G1 X78.363 Y34.064 E0.01675

G1 X78.526 Y33.760 E0.00898

G1 X78.951 Y33.173 E0.01888

G1 X79.469 Y32.667 E0.01887

G1 X79.747 Y32.460 E0.00903

G1 X80.250 Y32.147 E0.01544

G1 X80.793 Y31.913 E0.01540

M204 S1250

G1 X80.704 Y31.496 F9000.000

M204 S800

G1 F1800.000

G1 X80.879 Y31.443 E0.00477

G1 X81.901 Y31.253 E0.02708

G1 X82.249 Y31.239 E0.00906

G1 X92.389 Y31.246 E0.26421

G1 X93.057 Y31.315 E0.01749

G1 X93.962 Y31.565 E0.02448

G1 X94.672 Y31.911 E0.02058

G1 X94.915 Y32.066 E0.00750

G1 X95.532 Y32.559 E0.02059

G1 X96.144 Y33.269 E0.02443

G1 X96.543 Y33.952 E0.02060

G1 X96.642 Y34.171 E0.00627

G1 X96.826 Y34.674 E0.01395

G1 X96.982 Y35.431 E0.02014

G1 X97.019 Y36.020 E0.01538

G1 X97.019 Y125.000 E2.31844

G1 X96.961 Y125.732 E0.01913

G1 X96.930 Y125.908 E0.00464

G1 X96.600 Y126.820 E0.02527

G1 X96.531 Y127.062 E0.00658

G1 X96.419 Y127.315 E0.00721

G1 X95.945 Y128.013 E0.02198

G1 X95.792 Y128.194 E0.00617

G1 X95.289 Y128.677 E0.01815

G1 X95.103 Y128.825 E0.00621

G1 X94.519 Y129.198 E0.01805

G1 X94.162 Y129.366 E0.01028

G1 X93.654 Y129.562 E0.01419

G1 X93.427 Y129.627 E0.00614

G1 X92.531 Y129.762 E0.02362

G1 X92.236 Y129.783 E0.00771

G1 X82.252 Y129.783 E0.26013

G1 X81.958 Y129.762 E0.00768

M73 P11 R63

G1 X80.971 Y129.603 E0.02606

G1 X80.100 Y129.268 E0.02431

G1 X79.309 Y128.767 E0.02439

G1 X78.730 Y128.230 E0.02058

G1 X78.541 Y128.011 E0.00753

G1 X78.071 Y127.319 E0.02180

G1 X77.957 Y127.062 E0.00730

G1 X77.888 Y126.820 E0.00658

G1 X77.558 Y125.908 E0.02527

G1 X77.527 Y125.732 E0.00464

G1 X77.469 Y125.000 E0.01913

G1 X77.469 Y36.022 E2.31839

G1 X77.549 Y35.154 E0.02272

G1 X77.715 Y34.519 E0.01709

G1 X77.986 Y33.883 E0.01803

G1 X78.171 Y33.538 E0.01019

G1 X78.633 Y32.899 E0.02055

G1 X79.197 Y32.348 E0.02054

G1 X79.512 Y32.114 E0.01021

G1 X80.056 Y31.776 E0.01670

G1 X80.649 Y31.520 E0.01683

M204 S1250

G1 X80.845 Y31.613 F9000.000

G1 X80.310 Y32.258

M204 S1000

G1 F4800.000

G1 X79.186 Y33.382 E0.04161

G1 X78.792 Y33.926 E0.01758

G1 X78.646 Y34.199 E0.00810

G1 X78.412 Y34.750 E0.01566

G1 X80.987 Y32.174 E0.09533

G1 X81.725 Y32.030 E0.01968

G1 X78.243 Y35.512 E0.12887

G1 X78.200 Y36.148 E0.01669

G1 X82.378 Y31.971 E0.15461

G1 X82.971 Y31.971 E0.01552

G1 X78.200 Y36.742 E0.17656

G1 X78.200 Y37.335 E0.01553

G1 X83.564 Y31.971 E0.19851

G1 X84.157 Y31.972 E0.01552

G1 X78.200 Y37.929 E0.22046

G1 X78.200 Y38.522 E0.01553

G1 X84.750 Y31.972 E0.24241

G1 X85.343 Y31.972 E0.01552

G1 X78.200 Y39.115 E0.26436

G1 X78.200 Y39.709 E0.01553

G1 X85.936 Y31.973 E0.28631

G1 X86.530 Y31.973 E0.01552

G1 X78.012 Y40.490 E0.31522

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X79.176 Y39.327 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z0.850 F9000.000

G1 X95.378 Y33.213

G1 Z0.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.525 Y38.067 E0.17964

G1 X90.640 Y37.683 E0.01049

G1 X90.676 Y37.322 E0.00950

G1 X94.960 Y33.038 E0.15854

G1 X94.630 Y32.774 E0.01105

G1 X90.679 Y36.725 E0.14623

G1 X90.641 Y36.333 E0.01031

G1 X90.603 Y36.208 E0.00342

G1 X94.278 Y32.533 E0.13602

G1 X93.879 Y32.338 E0.01162

G1 X90.465 Y35.753 E0.12635

G1 X90.269 Y35.355 E0.01159

G1 X93.444 Y32.181 E0.11750

G1 X92.979 Y32.052 E0.01262

G1 X90.044 Y34.987 E0.10862

G1 X89.777 Y34.660 E0.01104

G1 X92.450 Y31.987 E0.09894

G1 X91.867 Y31.976 E0.01526

G1 X89.469 Y34.375 E0.08876

G1 X89.138 Y34.112 E0.01105

G1 X91.274 Y31.976 E0.07906

G1 X90.681 Y31.976 E0.01552

G1 X88.751 Y33.906 E0.07142

G1 X88.569 Y33.808 E0.00540

G1 X88.328 Y33.735 E0.00660

G1 X90.088 Y31.975 E0.06514

G1 X89.495 Y31.975 E0.01552

G1 X87.863 Y33.607 E0.06040

G1 X87.572 Y33.564 E0.00769

G1 X87.319 Y33.557 E0.00663

G1 X88.902 Y31.975 E0.05857

G1 X88.309 Y31.974 E0.01552

G1 X86.683 Y33.600 E0.06018

G1 X86.564 Y33.613 E0.00312

G1 X85.919 Y33.808 E0.01764

G1 X85.838 Y33.852 E0.00241

G1 X87.716 Y31.974 E0.06950

G1 X87.123 Y31.973 E0.01552

G1 X78.200 Y40.896 E0.33021

G1 X78.200 Y41.489 E0.01553

G1 X84.088 Y35.602 E0.21788

G1 X84.044 Y35.683 E0.00240

G1 X83.848 Y36.332 E0.01776

G1 X83.837 Y36.446 E0.00300

G1 X78.200 Y42.083 E0.20859

G1 X78.200 Y42.676 E0.01553

G1 X83.788 Y37.088 E0.20680

G1 X83.842 Y37.628 E0.01418

G1 X78.200 Y43.270 E0.20881

G1 X78.200 Y43.863 E0.01553

G1 X83.971 Y38.092 E0.21358

G1 X84.044 Y38.333 E0.00660

G1 X84.141 Y38.515 E0.00540

G1 X78.200 Y44.457 E0.21988

G1 X78.200 Y45.050 E0.01553

G1 X84.348 Y38.902 E0.22753

G1 X84.611 Y39.233 E0.01105

G1 X78.200 Y45.643 E0.23724

G1 X78.200 Y46.237 E0.01553

G1 X84.896 Y39.541 E0.24781

G1 X85.223 Y39.808 E0.01104

G1 X78.200 Y46.830 E0.25989

G1 X78.200 Y47.424 E0.01553

G1 X85.591 Y40.033 E0.27353

G1 X85.988 Y40.229 E0.01159

G1 X78.200 Y48.017 E0.28823

G1 X78.200 Y48.611 E0.01553

G1 X86.444 Y40.367 E0.30510

G1 X86.569 Y40.405 E0.00342

G1 X86.961 Y40.443 E0.01031

G1 X78.200 Y49.204 E0.32423

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G1 X87.558 Y40.440 E0.34631

G1 X87.919 Y40.405 E0.00950

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G1 X78.200 Y50.391 E0.37388

G1 X78.200 Y50.984 E0.01553

G1 X95.520 Y33.665 E0.64099

G1 X95.744 Y34.034 E0.01131

G1 X78.200 Y51.578 E0.64928

G1 X78.200 Y52.171 E0.01553

G1 X95.952 Y34.420 E0.65698

G1 X96.113 Y34.853 E0.01208

G1 X78.200 Y52.765 E0.66292

G1 X78.200 Y53.358 E0.01553

G1 X96.217 Y35.342 E0.66677

G1 X96.255 Y35.529 E0.00499

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G1 X96.288 Y36.458 E0.66941

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G1 X96.288 Y80.966 E0.01553

G1 X78.200 Y99.054 E0.66941

G1 X78.200 Y99.647 E0.01553

G1 X96.288 Y81.560 E0.66941

G1 X96.288 Y82.153 E0.01553

G1 X78.200 Y100.241 E0.66941

G1 X78.200 Y100.834 E0.01553

G1 X96.288 Y82.747 E0.66941

G1 X96.288 Y83.340 E0.01553

G1 X78.200 Y101.428 E0.66941

G1 X78.200 Y102.021 E0.01553

G1 X96.288 Y83.934 E0.66941

G1 X96.288 Y84.527 E0.01553

G1 X78.200 Y102.615 E0.66941

G1 X78.200 Y103.208 E0.01553

G1 X96.288 Y85.120 E0.66941

G1 X96.288 Y85.714 E0.01553

G1 X78.200 Y103.802 E0.66941

G1 X78.200 Y104.395 E0.01553

G1 X96.288 Y86.307 E0.66941

G1 X96.288 Y86.901 E0.01553

G1 X78.200 Y104.988 E0.66941

G1 X78.200 Y105.582 E0.01553

G1 X96.288 Y87.494 E0.66941

G1 X96.288 Y88.088 E0.01553

G1 X78.200 Y106.175 E0.66941

G1 X78.200 Y106.769 E0.01553

G1 X96.288 Y88.681 E0.66941

G1 X96.288 Y89.275 E0.01553

G1 X78.200 Y107.362 E0.66941

G1 X78.200 Y107.956 E0.01553

G1 X96.288 Y89.868 E0.66941

G1 X96.288 Y90.462 E0.01553

G1 X78.200 Y108.549 E0.66941

G1 X78.200 Y109.143 E0.01553

G1 X96.288 Y91.055 E0.66941

G1 X96.288 Y91.648 E0.01553

G1 X78.200 Y109.736 E0.66941

G1 X78.200 Y110.330 E0.01553

G1 X96.288 Y92.242 E0.66941

G1 X96.288 Y92.835 E0.01553

G1 X78.200 Y110.923 E0.66941

G1 X78.200 Y111.516 E0.01553

G1 X96.288 Y93.429 E0.66941

G1 X96.288 Y94.022 E0.01553

G1 X78.200 Y112.110 E0.66941

G1 X78.200 Y112.703 E0.01553

G1 X96.288 Y94.616 E0.66941

G1 X96.288 Y95.209 E0.01553

G1 X78.200 Y113.297 E0.66941

G1 X78.200 Y113.890 E0.01553

G1 X96.288 Y95.803 E0.66941

G1 X96.288 Y96.396 E0.01553

G1 X78.200 Y114.484 E0.66941

G1 X78.200 Y115.077 E0.01553

G1 X96.288 Y96.989 E0.66941

G1 X96.288 Y97.583 E0.01553

G1 X78.200 Y115.671 E0.66941

G1 X78.200 Y116.264 E0.01553

G1 X96.288 Y98.176 E0.66941

G1 X96.288 Y98.770 E0.01553

G1 X78.200 Y116.857 E0.66941

G1 X78.200 Y117.451 E0.01553

G1 X96.288 Y99.363 E0.66941

G1 X96.288 Y99.957 E0.01553

G1 X78.200 Y118.044 E0.66941

G1 X78.200 Y118.638 E0.01553

G1 X96.288 Y100.550 E0.66941

G1 X96.288 Y101.144 E0.01553

G1 X78.200 Y119.231 E0.66941

G1 X78.200 Y119.825 E0.01553

G1 X96.288 Y101.737 E0.66941

M73 P13 R62

G1 X96.288 Y102.331 E0.01553

G1 X78.200 Y120.418 E0.66941

G1 X78.200 Y121.012 E0.01553

G1 X96.288 Y102.924 E0.66941

G1 X96.288 Y103.517 E0.01553

G1 X78.200 Y121.605 E0.66941

G1 X78.200 Y122.199 E0.01553

G1 X96.288 Y104.111 E0.66941

G1 X96.288 Y104.704 E0.01553

G1 X78.200 Y122.792 E0.66941

G1 X78.200 Y123.385 E0.01553

G1 X96.288 Y105.298 E0.66941

G1 X96.288 Y105.891 E0.01553

G1 X78.200 Y123.979 E0.66941

G1 X78.200 Y124.572 E0.01553

G1 X96.288 Y106.485 E0.66941

G1 X96.288 Y107.078 E0.01553

G1 X78.217 Y125.149 E0.66879

G1 X78.268 Y125.692 E0.01427

G1 X96.288 Y107.672 E0.66691

G1 X96.288 Y108.265 E0.01553

G1 X78.418 Y126.135 E0.66136

G1 X78.575 Y126.571 E0.01213

G1 X96.288 Y108.858 E0.65553

G1 X96.288 Y109.452 E0.01553

G1 X78.600 Y127.139 E0.65460

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X79.764 Y125.976 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z0.850 F9000.000

G1 X94.205 Y128.745

G1 Z0.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X95.362 Y127.570 E0.04315

G1 X95.777 Y126.959 E0.01934

G1 X95.985 Y126.371 E0.01632

G1 X93.546 Y128.811 E0.09028

G1 X93.262 Y128.913 E0.00790

G1 X92.778 Y128.985 E0.01280

G1 X96.244 Y125.519 E0.12829

G1 X96.288 Y124.882 E0.01671

G1 X92.117 Y129.052 E0.15434

G1 X91.524 Y129.052 E0.01553

G1 X96.288 Y124.288 E0.17631

G1 X96.288 Y123.695 E0.01553

G1 X90.931 Y129.052 E0.19827

G1 X90.337 Y129.052 E0.01553

G1 X96.288 Y123.101 E0.22023

G1 X96.288 Y122.508 E0.01553

G1 X89.744 Y129.052 E0.24220

G1 X89.150 Y129.052 E0.01553

G1 X96.288 Y121.914 E0.26416

G1 X96.288 Y121.321 E0.01553

G1 X88.557 Y129.052 E0.28612

G1 X87.963 Y129.052 E0.01553

G1 X96.288 Y120.727 E0.30809

G1 X96.288 Y120.134 E0.01553

G1 X87.370 Y129.052 E0.33005

G1 X86.776 Y129.052 E0.01553

G1 X88.687 Y127.141 E0.07072

G1 X88.248 Y127.323 E0.01244

G1 X87.829 Y127.406 E0.01118

G1 X86.183 Y129.052 E0.06093

G1 X85.590 Y129.052 E0.01553

G1 X87.176 Y127.465 E0.05873

G1 X86.880 Y127.449 E0.00776

G1 X86.645 Y127.403 E0.00628

G1 X84.996 Y129.052 E0.06103

G1 X84.403 Y129.052 E0.01553

G1 X86.163 Y127.291 E0.06517

G1 X85.744 Y127.118 E0.01189

G1 X83.809 Y129.052 E0.07160

G1 X83.216 Y129.052 E0.01553

G1 X85.368 Y126.900 E0.07965

G1 X85.019 Y126.655 E0.01115

G1 X82.622 Y129.052 E0.08870

G1 X82.046 Y129.035 E0.01509

G1 X84.716 Y126.365 E0.09881

G1 X84.554 Y126.185 E0.00634

G1 X84.453 Y126.035 E0.00474

G1 X81.534 Y128.953 E0.10802

G1 X81.162 Y128.894 E0.00987

G1 X81.045 Y128.849 E0.00327

G1 X84.215 Y125.679 E0.11731

G1 X84.034 Y125.266 E0.01179

G1 X80.617 Y128.684 E0.12648

G1 X80.430 Y128.611 E0.00525

G1 X80.225 Y128.482 E0.00634

G1 X83.891 Y124.816 E0.13566

G1 X83.800 Y124.314 E0.01337

G1 X79.862 Y128.252 E0.14575

G1 X79.757 Y128.186 E0.00325

G1 X79.538 Y127.982 E0.00782

G1 X83.799 Y123.721 E0.15769

G1 X83.934 Y122.993 E0.01940

G1 X79.233 Y127.694 E0.17398

G1 X78.976 Y127.358 E0.01108

G1 X96.288 Y110.045 E0.64072

G1 X96.288 Y110.639 E0.01553

G1 X86.226 Y120.700 E0.37237

G1 X86.582 Y120.612 E0.00959

G1 X86.954 Y120.566 E0.00981

G1 X96.288 Y111.232 E0.34545

G1 X96.288 Y111.826 E0.01553

G1 X87.551 Y120.563 E0.32335

G1 X88.052 Y120.655 E0.01334

G1 X96.288 Y112.419 E0.30480

G1 X96.288 Y113.013 E0.01553

G1 X88.502 Y120.799 E0.28815

G1 X88.915 Y120.979 E0.01179

G1 X96.288 Y113.606 E0.27287

G1 X96.288 Y114.200 E0.01553

G1 X89.270 Y121.217 E0.25971

G1 X89.421 Y121.318 E0.00474

G1 X89.601 Y121.480 E0.00634

G1 X96.288 Y114.793 E0.24748

G1 X96.288 Y115.386 E0.01553

G1 X89.891 Y121.783 E0.23674

G1 X90.136 Y122.132 E0.01115

G1 X96.288 Y115.980 E0.22769

G1 X96.288 Y116.573 E0.01553

G1 X90.353 Y122.508 E0.21963

G1 X90.527 Y122.928 E0.01189

G1 X96.288 Y117.167 E0.21320

G1 X96.288 Y117.760 E0.01553

G1 X90.639 Y123.409 E0.20907

G1 X90.690 Y123.670 E0.00695

G1 X90.690 Y123.951 E0.00737

G1 X96.288 Y118.354 E0.20717

G1 X96.288 Y118.947 E0.01553

G1 X90.642 Y124.594 E0.20897

G1 X90.559 Y125.013 E0.01118

G1 X90.377 Y125.452 E0.01243

G1 X96.476 Y119.353 E0.22572

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;0.8

G1 Z0.800 F9000.000

;AFTER\_LAYER\_CHANGE

;0.8

G1 E-3.20000 F4200.00000

G1 Z1.000 F9000.000

G1 X90.021 Y122.524

G1 Z0.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.257 Y123.095 E0.01612

G1 X90.377 Y123.700 E0.01607

G1 X90.377 Y124.316 E0.01605

G1 X90.257 Y124.922 E0.01608

G1 X90.021 Y125.493 E0.01611

G1 X89.687 Y125.992 E0.01565

G1 X89.469 Y126.233 E0.00846

G1 X89.228 Y126.451 E0.00847

G1 X88.729 Y126.785 E0.01565

G1 X88.157 Y127.022 E0.01612

G1 X87.569 Y127.138 E0.01563

G1 X87.244 Y127.155 E0.00847

G1 X86.919 Y127.138 E0.00847

G1 X86.331 Y127.021 E0.01563

G1 X85.759 Y126.785 E0.01611

G1 X85.260 Y126.451 E0.01565

G1 X85.019 Y126.233 E0.00846

G1 X84.801 Y125.992 E0.00847

G1 X84.467 Y125.493 E0.01565

G1 X84.231 Y124.921 E0.01612

G1 X84.115 Y124.333 E0.01563

G1 X84.097 Y124.008 E0.00847

G1 X84.115 Y123.683 E0.00847

G1 X84.231 Y123.095 E0.01563

G1 X84.468 Y122.524 E0.01611

G1 X84.802 Y122.024 E0.01565

G1 X85.019 Y121.783 E0.00846

G1 X85.260 Y121.566 E0.00847

G1 X85.760 Y121.232 E0.01565

G1 X86.317 Y121.001 E0.01571

G1 X86.640 Y120.921 E0.00869

G1 X87.067 Y120.870 E0.01118

G1 X87.556 Y120.876 E0.01276

G1 X88.157 Y120.995 E0.01597

G1 X88.729 Y121.232 E0.01611

G1 X89.228 Y121.566 E0.01565

G1 X89.469 Y121.783 E0.00846

G1 X89.687 Y122.025 E0.00847

G1 X89.987 Y122.474 E0.01409

M204 S1250

G1 X89.640 Y122.706 F9000.000

M204 S800

G1 F1500.000

G1 X89.856 Y123.217 E0.01444

G1 X89.959 Y123.741 E0.01393

G1 X89.959 Y124.275 E0.01392

G1 X89.855 Y124.800 E0.01393

G1 X89.650 Y125.295 E0.01396

G1 X89.356 Y125.735 E0.01379

G1 X89.173 Y125.938 E0.00711

G1 X88.971 Y126.120 E0.00712

G1 X88.531 Y126.415 E0.01379

G1 X88.036 Y126.620 E0.01396

G1 X87.517 Y126.722 E0.01377

G1 X87.244 Y126.737 E0.00712

G1 X86.971 Y126.722 E0.00712

G1 X86.452 Y126.620 E0.01378

G1 X85.957 Y126.415 E0.01396

G1 X85.518 Y126.120 E0.01379

G1 X85.315 Y125.938 E0.00711

G1 X85.132 Y125.735 E0.00712

G1 X84.838 Y125.295 E0.01379

G1 X84.633 Y124.800 E0.01396

G1 X84.530 Y124.281 E0.01377

G1 X84.516 Y124.008 E0.00712

G1 X84.530 Y123.735 E0.00712

G1 X84.633 Y123.217 E0.01378

G1 X84.838 Y122.722 E0.01396

G1 X85.132 Y122.282 E0.01379

G1 X85.315 Y122.079 E0.00711

G1 X85.518 Y121.896 E0.00712

G1 X85.958 Y121.602 E0.01379

G1 X86.448 Y121.399 E0.01382

G1 X86.716 Y121.332 E0.00719

G1 X87.089 Y121.288 E0.00979

G1 X87.513 Y121.294 E0.01105

G1 X88.036 Y121.397 E0.01390

G1 X88.531 Y121.602 E0.01396

G1 X88.971 Y121.896 E0.01379

G1 X89.173 Y122.079 E0.00711

G1 X89.356 Y122.282 E0.00712

G1 X89.607 Y122.656 E0.01174

M204 S1250

G1 X90.040 Y122.724 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.856 Y123.217 E-0.33981

G1 X89.959 Y123.741 E-0.29626

G1 X89.959 Y124.239 E-0.27593

G1 E-0.04800 F4200.00000

G1 Z1.000 F9000.000

G1 X87.244 Y40.156

G1 Z0.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.630 Y40.096 E0.01607

G1 X86.039 Y39.917 E0.01609

G1 X85.495 Y39.626 E0.01607

G1 X85.017 Y39.235 E0.01610

G1 X84.626 Y38.757 E0.01610

G1 X84.335 Y38.213 E0.01606

G1 X84.157 Y37.623 E0.01607

G1 X84.095 Y37.008 E0.01608

G1 X84.157 Y36.394 E0.01609

G1 X84.335 Y35.803 E0.01608

G1 X84.626 Y35.260 E0.01607

G1 X85.017 Y34.781 E0.01610

G1 X85.496 Y34.390 E0.01610

G1 X86.039 Y34.099 E0.01606

G1 X86.626 Y33.922 E0.01597

G1 X87.113 Y33.867 E0.01278

G1 X87.544 Y33.877 E0.01121

G1 X87.873 Y33.925 E0.00868

G1 X88.449 Y34.099 E0.01568

G1 X88.993 Y34.390 E0.01607

G1 X89.471 Y34.781 E0.01610

G1 X89.862 Y35.260 E0.01610

G1 X90.153 Y35.803 E0.01606

G1 X90.332 Y36.395 E0.01609

G1 X90.392 Y37.008 E0.01607

G1 X90.332 Y37.622 E0.01607

G1 X90.153 Y38.213 E0.01609

G1 X89.862 Y38.757 E0.01607

G1 X89.471 Y39.235 E0.01610

G1 X88.993 Y39.627 E0.01610

G1 X88.449 Y39.917 E0.01606

G1 X87.858 Y40.096 E0.01609

G1 X87.304 Y40.150 E0.01450

M204 S1250

G1 X87.263 Y39.734 F9000.000

M204 S800

G1 F1500.000

G1 X86.712 Y39.684 E0.01441

G1 X86.200 Y39.529 E0.01395

G1 X85.728 Y39.277 E0.01392

G1 X85.314 Y38.938 E0.01395

G1 X84.975 Y38.524 E0.01395

G1 X84.723 Y38.053 E0.01392

G1 X84.568 Y37.540 E0.01394

G1 X84.515 Y37.008 E0.01394

G1 X84.568 Y36.476 E0.01394

G1 X84.723 Y35.964 E0.01394

G1 X84.975 Y35.493 E0.01392

G1 X85.314 Y35.078 E0.01395

G1 X85.729 Y34.739 E0.01395

G1 X86.200 Y34.487 E0.01392

G1 X86.711 Y34.333 E0.01390

G1 X87.132 Y34.285 E0.01106

G1 X87.508 Y34.294 E0.00979

G1 X87.781 Y34.334 E0.00720

G1 X88.289 Y34.487 E0.01380

G1 X88.760 Y34.739 E0.01392

G1 X89.174 Y35.078 E0.01395

G1 X89.513 Y35.493 E0.01395

G1 X89.765 Y35.964 E0.01392

G1 X89.920 Y36.476 E0.01395

G1 X89.972 Y37.008 E0.01393

G1 X89.920 Y37.540 E0.01393

G1 X89.765 Y38.053 E0.01395

G1 X89.513 Y38.524 E0.01392

G1 X89.174 Y38.938 E0.01395

G1 X88.760 Y39.277 E0.01395

G1 X88.288 Y39.529 E0.01392

G1 X87.776 Y39.684 E0.01395

G1 X87.323 Y39.729 E0.01187

M204 S1250

G1 X87.065 Y40.082 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.712 Y39.684 E-0.33922

G1 X86.200 Y39.529 E-0.29666

G1 X85.760 Y39.294 E-0.27612

G1 E-0.04800 F4200.00000

G1 Z1.000 F9000.000

G1 X80.865 Y31.884

G1 Z0.800

G1 E3.20000 F2400.00000

M204 S800

G1 X81.950 Y31.670 E0.02882

G1 X82.257 Y31.657 E0.00801

G1 X92.313 Y31.661 E0.26202

G1 X92.980 Y31.728 E0.01746

G1 X93.812 Y31.958 E0.02249

G1 X94.514 Y32.305 E0.02040

G1 X95.241 Y32.863 E0.02390

G1 X95.801 Y33.512 E0.02233

G1 X96.193 Y34.193 E0.02048

G1 X96.418 Y34.773 E0.01622

G1 X96.566 Y35.487 E0.01900

G1 X96.601 Y36.034 E0.01426

G1 X96.601 Y124.983 E2.31763

G1 X96.532 Y125.766 E0.02050

G1 X96.090 Y127.018 E0.03459

G1 X96.043 Y127.125 E0.00305

G1 X95.511 Y127.879 E0.02404

G1 X94.889 Y128.462 E0.02220

G1 X94.268 Y128.856 E0.01918

G1 X94.087 Y128.942 E0.00523

G1 X93.356 Y129.210 E0.02028

G1 X92.201 Y129.365 E0.03036

G1 X82.268 Y129.365 E0.25882

G1 X81.078 Y129.196 E0.03132

G1 X80.289 Y128.892 E0.02204

G1 X79.567 Y128.435 E0.02226

G1 X78.996 Y127.899 E0.02039

G1 X78.450 Y127.137 E0.02443

G1 X77.965 Y125.790 E0.03730

G1 X77.887 Y124.979 E0.02124

G1 X77.887 Y36.040 E2.31737

G1 X77.946 Y35.330 E0.01855

G1 X78.113 Y34.653 E0.01818

G1 X78.404 Y33.984 E0.01902

G1 X78.499 Y33.806 E0.00524

G1 X78.952 Y33.174 E0.02027

G1 X79.510 Y32.633 E0.02026

G1 X80.267 Y32.140 E0.02354

G1 X80.810 Y31.907 E0.01537

M204 S1250

G1 X80.645 Y31.523 F9000.000

M204 S800

G1 F1800.000

G1 X80.827 Y31.458 E0.00504

G1 X81.902 Y31.253 E0.02851

G1 X82.249 Y31.239 E0.00904

G1 X92.334 Y31.243 E0.26278

G1 X93.057 Y31.316 E0.01893

G1 X93.961 Y31.566 E0.02445

G1 X94.718 Y31.940 E0.02201

G1 X94.869 Y32.036 E0.00466

G1 X95.532 Y32.560 E0.02202

G1 X96.143 Y33.269 E0.02439

G1 X96.565 Y34.002 E0.02203

G1 X96.821 Y34.657 E0.01833

G1 X96.982 Y35.431 E0.02060

G1 X97.019 Y36.020 E0.01538

G1 X97.019 Y125.000 E2.31843

G1 X96.937 Y125.872 E0.02283

G1 X96.479 Y127.173 E0.03592

G1 X96.409 Y127.330 E0.00449

G1 X95.816 Y128.166 E0.02670

G1 X95.132 Y128.802 E0.02434

G1 X94.470 Y129.223 E0.02044

G1 X94.248 Y129.328 E0.00640

G1 X93.457 Y129.618 E0.02196

G1 X92.229 Y129.783 E0.03227

G1 X82.252 Y129.783 E0.25995

G1 X80.970 Y129.602 E0.03375

G1 X80.100 Y129.267 E0.02429

G1 X79.310 Y128.767 E0.02437

G1 X78.694 Y128.189 E0.02200

G1 X78.577 Y128.053 E0.00467

G1 X78.081 Y127.334 E0.02275

G1 X77.554 Y125.881 E0.04029

G1 X77.469 Y124.999 E0.02309

G1 X77.469 Y36.023 E2.31834

G1 X77.532 Y35.262 E0.01987

G1 X77.716 Y34.519 E0.01996

G1 X78.027 Y33.802 E0.02037

G1 X78.143 Y33.585 E0.00640

G1 X78.634 Y32.900 E0.02197

G1 X79.239 Y32.314 E0.02196

G1 X79.437 Y32.167 E0.00641

G1 X80.073 Y31.769 E0.01956

G1 X80.590 Y31.547 E0.01465

M204 S1250

G1 X80.798 Y31.641 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.827 Y31.458 E-0.14033

G1 X81.902 Y31.253 E-0.60641

G1 X82.200 Y31.241 E-0.16525

G1 E-0.04800 F4200.00000

G1 Z1.000 F9000.000

G1 X96.337 Y34.998

G1 Z0.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X93.550 Y32.211 E0.10314

G1 X92.922 Y32.037 E0.01706

G1 X92.767 Y32.021 E0.00407

G1 X96.250 Y35.504 E0.12890

G1 X96.288 Y36.136 E0.01656

G1 X92.127 Y31.974 E0.15401

G1 X91.533 Y31.974 E0.01554

G1 X96.288 Y36.729 E0.17599

G1 X96.288 Y37.323 E0.01553

G1 X90.939 Y31.974 E0.19797

G1 X90.346 Y31.974 E0.01554

G1 X96.288 Y37.916 E0.21994

G1 X96.288 Y38.510 E0.01553

G1 X89.752 Y31.973 E0.24192

G1 X89.158 Y31.973 E0.01554

G1 X96.288 Y39.103 E0.26389

G1 X96.288 Y39.697 E0.01553

G1 X88.564 Y31.973 E0.28587

G1 X87.971 Y31.973 E0.01554

G1 X96.288 Y40.290 E0.30785

G1 X96.288 Y40.884 E0.01553

G1 X87.377 Y31.973 E0.32982

G1 X86.783 Y31.972 E0.01554

G1 X88.676 Y33.866 E0.07008

G1 X88.569 Y33.808 E0.00318

G1 X87.942 Y33.619 E0.01716

G1 X87.818 Y33.600 E0.00328

G1 X86.189 Y31.972 E0.06027

G1 X85.596 Y31.972 E0.01554

G1 X87.179 Y33.555 E0.05860

G1 X86.636 Y33.606 E0.01427

G1 X85.002 Y31.972 E0.06048

G1 X84.408 Y31.971 E0.01554

G1 X86.169 Y33.733 E0.06519

G1 X85.919 Y33.808 E0.00685

G1 X85.745 Y33.901 E0.00517

G1 X83.814 Y31.971 E0.07145

G1 X83.221 Y31.971 E0.01554

G1 X85.358 Y34.108 E0.07911

G1 X85.026 Y34.370 E0.01106

G1 X82.627 Y31.971 E0.08879

G1 X82.042 Y31.979 E0.01530

G1 X84.717 Y34.654 E0.09899

G1 X84.450 Y34.980 E0.01104

G1 X81.537 Y32.067 E0.10781

G1 X81.038 Y32.162 E0.01328

G1 X84.223 Y35.348 E0.11789

G1 X84.026 Y35.744 E0.01158

G1 X80.616 Y32.334 E0.12620

G1 X80.412 Y32.419 E0.00579

G1 X80.225 Y32.536 E0.00577

G1 X83.888 Y36.199 E0.13558

G1 X83.848 Y36.332 E0.00364

G1 X83.810 Y36.714 E0.01005

G1 X79.860 Y32.765 E0.14618

G1 X79.713 Y32.872 E0.00476

G1 X79.541 Y33.039 E0.00628

G1 X83.810 Y37.309 E0.15802

G1 X83.848 Y37.684 E0.00988

G1 X83.959 Y38.050 E0.01002

G1 X79.239 Y33.331 E0.17467

G1 X78.983 Y33.668 E0.01108

G1 X96.288 Y50.973 E0.64050

G1 X96.288 Y50.380 E0.01553

G1 X86.202 Y40.294 E0.37331

G1 X86.569 Y40.405 E0.01004

G1 X86.943 Y40.441 E0.00983

G1 X96.288 Y49.786 E0.34587

G1 X96.288 Y49.193 E0.01553

G1 X87.537 Y40.442 E0.32388

G1 X87.919 Y40.405 E0.01003

G1 X88.053 Y40.364 E0.00366

G1 X96.288 Y48.599 E0.30480

G1 X96.288 Y48.006 E0.01553

G1 X88.509 Y40.226 E0.28793

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G1 X96.288 Y47.412 E0.27327

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G1 X89.598 Y39.536 E0.01104

G1 X96.288 Y46.225 E0.24760

G1 X96.288 Y45.632 E0.01553

G1 X89.883 Y39.227 E0.23707

G1 X90.144 Y38.894 E0.01106

G1 X96.288 Y45.038 E0.22740

G1 X96.288 Y44.445 E0.01553

G1 X90.351 Y38.508 E0.21974

G1 X90.444 Y38.334 E0.00517

G1 X90.520 Y38.083 E0.00685

G1 X96.288 Y43.851 E0.21350

G1 X96.288 Y43.258 E0.01553

G1 X90.647 Y37.617 E0.20878

G1 X90.700 Y37.076 E0.01421

G1 X96.288 Y42.664 E0.20682

G1 X96.288 Y42.071 E0.01553

G1 X90.650 Y36.433 E0.20866

G1 X90.641 Y36.333 E0.00262

G1 X90.444 Y35.683 E0.01778

G1 X90.387 Y35.576 E0.00318

G1 X96.476 Y41.665 E0.22538

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X95.312 Y40.501 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.000 F9000.000

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G1 Z0.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X96.288 Y52.160 E0.65639

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G1 X96.288 Y53.941 E0.01553

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M73 P14 R61

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G1 X96.273 Y125.146 E0.01516

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G1 X96.219 Y125.685 E0.66691

G1 X96.064 Y126.124 E0.01217

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G1 X95.909 Y126.563 E0.65545

G1 X95.750 Y126.997 E0.01211

G1 X78.200 Y109.447 E0.64956

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G1 X95.505 Y127.345 E0.64047

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G1 X95.255 Y127.690 E0.00065

G1 X90.551 Y122.985 E0.17413

G1 X90.690 Y123.718 E0.01952

G1 X94.949 Y127.977 E0.15762

G1 X94.632 Y128.254 E0.01101

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G1 X90.598 Y124.813 E0.01334

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G1 X93.877 Y128.685 E0.00683

G1 X90.455 Y125.263 E0.12666

G1 X90.275 Y125.677 E0.01180

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G1 X88.327 Y127.290 E0.01189

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G1 X88.899 Y129.048 E0.05861

G1 X88.305 Y129.048 E0.01555

G1 X86.663 Y127.407 E0.06074

G1 X86.240 Y127.323 E0.01131

G1 X85.807 Y127.144 E0.01225

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G1 X86.584 Y120.612 E0.00404

G1 X86.947 Y120.569 E0.00958

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G1 X78.200 Y111.228 E0.01553

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M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.04800 F4200.00000

G1 Z1.000 F9000.000

G1 X78.518 Y126.976

G1 Z0.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X78.254 Y125.526 E0.00515

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G1 X82.138 Y129.041 E0.01154

G1 X82.363 Y129.041 E0.00588

G1 X78.200 Y124.878 E0.15407

G1 X78.200 Y124.285 E0.01553

G1 X82.957 Y129.042 E0.17606

G1 X83.551 Y129.042 E0.01555

G1 X78.200 Y123.691 E0.19805

G1 X78.200 Y123.098 E0.01553

G1 X84.145 Y129.043 E0.22004

G1 X84.740 Y129.044 E0.01555

G1 X78.200 Y122.504 E0.24204

G1 X78.200 Y121.911 E0.01553

G1 X85.334 Y129.044 E0.26403

G1 X85.928 Y129.045 E0.01555

G1 X78.200 Y121.317 E0.28602

G1 X78.200 Y120.724 E0.01553

G1 X86.710 Y129.234 E0.31498

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;0.95

G1 Z0.950 F9000.000

;AFTER\_LAYER\_CHANGE

;0.95

G1 E-3.20000 F4200.00000

G1 Z1.150 F9000.000

G1 X87.244 Y127.157

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.630 Y127.096 E0.01609

G1 X86.039 Y126.917 E0.01608

G1 X85.495 Y126.626 E0.01607

G1 X85.017 Y126.235 E0.01610

G1 X84.626 Y125.757 E0.01610

G1 X84.335 Y125.213 E0.01606

G1 X84.157 Y124.623 E0.01607

G1 X84.095 Y124.008 E0.01608

G1 X84.157 Y123.394 E0.01609

G1 X84.335 Y122.803 E0.01608

G1 X84.626 Y122.260 E0.01607

G1 X85.017 Y121.781 E0.01610

G1 X85.496 Y121.390 E0.01610

G1 X86.039 Y121.099 E0.01606

G1 X86.625 Y120.922 E0.01595

G1 X87.090 Y120.869 E0.01219

G1 X87.542 Y120.876 E0.01177

G1 X87.873 Y120.925 E0.00872

G1 X88.449 Y121.099 E0.01568

G1 X88.993 Y121.390 E0.01607

G1 X89.471 Y121.781 E0.01610

G1 X89.862 Y122.260 E0.01610

G1 X90.153 Y122.803 E0.01606

G1 X90.332 Y123.395 E0.01609

G1 X90.392 Y124.008 E0.01607

G1 X90.332 Y124.622 E0.01607

G1 X90.153 Y125.213 E0.01609

G1 X89.862 Y125.757 E0.01607

G1 X89.471 Y126.235 E0.01610

G1 X88.993 Y126.627 E0.01610

G1 X88.449 Y126.917 E0.01606

G1 X87.858 Y127.096 E0.01607

G1 X87.304 Y127.151 E0.01452

M204 S1250

G1 X87.262 Y126.736 F9000.000

M204 S800

G1 F1500.000

G1 X86.712 Y126.684 E0.01440

G1 X86.200 Y126.529 E0.01394

G1 X85.728 Y126.277 E0.01392

G1 X85.314 Y125.938 E0.01395

G1 X84.975 Y125.524 E0.01395

G1 X84.723 Y125.053 E0.01392

G1 X84.568 Y124.540 E0.01394

G1 X84.515 Y124.008 E0.01394

G1 X84.568 Y123.476 E0.01394

G1 X84.723 Y122.964 E0.01394

G1 X84.975 Y122.493 E0.01392

G1 X85.314 Y122.078 E0.01395

G1 X85.729 Y121.739 E0.01395

G1 X86.200 Y121.487 E0.01392

G1 X86.710 Y121.333 E0.01390

G1 X87.111 Y121.287 E0.01050

G1 X87.508 Y121.294 E0.01035

G1 X87.781 Y121.334 E0.00721

G1 X88.289 Y121.487 E0.01380

G1 X88.760 Y121.739 E0.01392

G1 X89.174 Y122.078 E0.01395

G1 X89.513 Y122.493 E0.01395

G1 X89.765 Y122.964 E0.01392

G1 X89.920 Y123.476 E0.01395

G1 X89.972 Y124.008 E0.01393

G1 X89.920 Y124.540 E0.01393

G1 X89.765 Y125.053 E0.01395

G1 X89.513 Y125.524 E0.01392

G1 X89.174 Y125.938 E0.01395

G1 X88.760 Y126.277 E0.01395

G1 X88.288 Y126.529 E0.01392

G1 X87.776 Y126.684 E0.01394

G1 X87.322 Y126.730 E0.01190

M204 S1250

G1 X87.063 Y127.083 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.712 Y126.684 E-0.33891

G1 X86.200 Y126.529 E-0.29653

G1 X85.760 Y126.294 E-0.27656

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X87.552 Y40.141

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.936 Y40.141 E0.01605

G1 X86.331 Y40.022 E0.01607

G1 X85.759 Y39.785 E0.01612

G1 X85.260 Y39.451 E0.01565

G1 X85.019 Y39.233 E0.00846

G1 X84.802 Y38.992 E0.00846

G1 X84.467 Y38.493 E0.01566

G1 X84.231 Y37.921 E0.01612

G1 X84.115 Y37.333 E0.01563

G1 X84.097 Y37.008 E0.00847

G1 X84.115 Y36.683 E0.00847

G1 X84.231 Y36.095 E0.01562

G1 X84.468 Y35.524 E0.01612

G1 X84.802 Y35.024 E0.01565

G1 X85.019 Y34.783 E0.00846

G1 X85.260 Y34.566 E0.00846

G1 X85.760 Y34.232 E0.01566

G1 X86.317 Y34.001 E0.01571

G1 X86.641 Y33.920 E0.00871

G1 X87.090 Y33.868 E0.01177

G1 X87.558 Y33.877 E0.01219

G1 X88.157 Y33.995 E0.01592

G1 X88.729 Y34.232 E0.01612

G1 X89.228 Y34.566 E0.01565

G1 X89.469 Y34.783 E0.00846

G1 X89.687 Y35.024 E0.00846

G1 X90.021 Y35.524 E0.01566

G1 X90.257 Y36.095 E0.01612

G1 X90.377 Y36.700 E0.01607

G1 X90.377 Y37.316 E0.01605

G1 X90.257 Y37.921 E0.01607

G1 X90.021 Y38.493 E0.01612

G1 X89.687 Y38.992 E0.01565

G1 X89.469 Y39.233 E0.00846

G1 X89.228 Y39.451 E0.00846

G1 X88.729 Y39.785 E0.01566

G1 X88.157 Y40.022 E0.01612

G1 X87.611 Y40.129 E0.01451

M204 S1250

G1 X87.530 Y39.720 F9000.000

M204 S800

G1 F1500.000

G1 X86.977 Y39.723 E0.01441

G1 X86.453 Y39.620 E0.01393

G1 X85.957 Y39.415 E0.01396

G1 X85.518 Y39.120 E0.01379

G1 X85.315 Y38.938 E0.00711

G1 X85.132 Y38.735 E0.00711

G1 X84.838 Y38.295 E0.01380

G1 X84.633 Y37.800 E0.01396

G1 X84.530 Y37.281 E0.01377

G1 X84.516 Y37.008 E0.00712

G1 X84.530 Y36.735 E0.00712

G1 X84.633 Y36.217 E0.01377

G1 X84.838 Y35.722 E0.01396

G1 X85.132 Y35.282 E0.01379

G1 X85.315 Y35.079 E0.00711

G1 X85.518 Y34.896 E0.00711

G1 X85.958 Y34.602 E0.01380

G1 X86.448 Y34.399 E0.01382

G1 X86.716 Y34.332 E0.00720

G1 X87.111 Y34.287 E0.01035

G1 X87.513 Y34.294 E0.01049

G1 X88.036 Y34.397 E0.01387

G1 X88.531 Y34.602 E0.01396

G1 X88.971 Y34.896 E0.01379

G1 X89.173 Y35.079 E0.00711

G1 X89.356 Y35.282 E0.00711

G1 X89.651 Y35.722 E0.01380

G1 X89.856 Y36.217 E0.01396

G1 X89.959 Y36.741 E0.01393

G1 X89.959 Y37.275 E0.01392

G1 X89.856 Y37.800 E0.01393

G1 X89.650 Y38.295 E0.01396

G1 X89.356 Y38.735 E0.01379

G1 X89.173 Y38.938 E0.00711

G1 X88.971 Y39.120 E0.00711

G1 X88.531 Y39.415 E0.01380

G1 X88.036 Y39.620 E0.01396

G1 X87.589 Y39.708 E0.01187

M204 S1250

G1 X87.367 Y40.085 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.977 Y39.723 E-0.33910

G1 X86.453 Y39.620 E-0.29622

G1 X85.991 Y39.429 E-0.27668

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X80.907 Y31.874

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S800

G1 X81.951 Y31.670 E0.02772

G1 X82.257 Y31.657 E0.00798

G1 X92.259 Y31.659 E0.26060

G1 X92.981 Y31.729 E0.01889

G1 X93.810 Y31.959 E0.02242

G1 X94.533 Y32.320 E0.02106

G1 X95.243 Y32.867 E0.02337

G1 X95.798 Y33.510 E0.02212

G1 X96.237 Y34.292 E0.02336

G1 X96.414 Y34.758 E0.01301

G1 X96.567 Y35.488 E0.01942

G1 X96.601 Y36.034 E0.01425

G1 X96.601 Y124.982 E2.31761

G1 X96.540 Y125.696 E0.01867

G1 X96.020 Y127.157 E0.04042

G1 X95.517 Y127.869 E0.02271

G1 X94.896 Y128.453 E0.02222

G1 X94.239 Y128.869 E0.02027

G1 X93.384 Y129.201 E0.02389

G1 X92.200 Y129.365 E0.03114

G1 X82.199 Y129.359 E0.26057

G1 X81.076 Y129.194 E0.02958

G1 X80.289 Y128.891 E0.02198

G1 X79.568 Y128.435 E0.02222

G1 X78.981 Y127.879 E0.02108

G1 X78.444 Y127.111 E0.02442

G1 X77.958 Y125.754 E0.03757

G1 X77.887 Y124.980 E0.02024

G1 X77.887 Y36.041 E2.31738

G1 X77.951 Y35.297 E0.01945

G1 X78.113 Y34.657 E0.01721

G1 X78.471 Y33.853 E0.02294

G1 X78.952 Y33.174 E0.02167

G1 X79.598 Y32.565 E0.02313

G1 X80.282 Y32.134 E0.02106

G1 X80.852 Y31.897 E0.01609

M204 S1250

G1 X80.691 Y31.511 F9000.000

M204 S800

G1 F1800.000

G1 X80.786 Y31.472 E0.00266

G1 X81.902 Y31.253 E0.02965

G1 X82.249 Y31.239 E0.00903

G1 X92.279 Y31.241 E0.26135

G1 X93.057 Y31.317 E0.02036

G1 X93.960 Y31.567 E0.02442

G1 X94.756 Y31.964 E0.02317

G1 X95.532 Y32.562 E0.02554

G1 X96.142 Y33.269 E0.02432

G1 X96.616 Y34.114 E0.02526

G1 X96.816 Y34.640 E0.01467

G1 X96.982 Y35.432 E0.02106

G1 X97.019 Y36.020 E0.01537

G1 X97.019 Y125.000 E2.31842

G1 X96.952 Y125.785 E0.02054

G1 X96.395 Y127.352 E0.04332

G1 X95.833 Y128.144 E0.02530

G1 X95.153 Y128.785 E0.02434

G1 X94.428 Y129.244 E0.02237

G1 X93.490 Y129.608 E0.02623

G1 X92.229 Y129.783 E0.03317

G1 X82.169 Y129.777 E0.26212

G1 X80.969 Y129.601 E0.03158

G1 X80.100 Y129.266 E0.02427

G1 X79.311 Y128.766 E0.02435

G1 X78.665 Y128.155 E0.02317

G1 X78.132 Y127.415 E0.02376

G1 X78.061 Y127.281 E0.00396

G1 X77.547 Y125.844 E0.03975

G1 X77.469 Y124.999 E0.02212

G1 X77.469 Y36.023 E2.31834

M73 P15 R60

G1 X77.537 Y35.227 E0.02081

G1 X77.717 Y34.520 E0.01900

G1 X78.115 Y33.632 E0.02536

G1 X78.635 Y32.900 E0.02339

G1 X79.282 Y32.279 E0.02337

G1 X80.089 Y31.762 E0.02498

G1 X80.636 Y31.534 E0.01544

M204 S1250

G1 X80.775 Y31.570 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.786 Y31.472 E-0.08991

G1 X81.902 Y31.253 E-0.63055

G1 X82.248 Y31.239 E-0.19154

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X80.593 Y33.370

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.968 Y33.520 E0.01051

G1 X81.416 Y33.604 E0.01189

G1 X81.865 Y33.403 E0.01281

G1 X82.122 Y32.892 E0.01490

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.865 Y33.403 E-0.31693

G1 X81.416 Y33.604 E-0.27242

G1 X80.968 Y33.520 E-0.25282

G1 X80.851 Y33.473 E-0.06983

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X84.341 Y35.148

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.106 Y34.910 E0.00872

G1 X83.658 Y34.616 E0.01397

G1 X82.761 Y34.259 E0.02515

G1 X82.313 Y34.174 E0.01189

G1 X81.865 Y34.376 E0.01281

G1 X81.416 Y35.265 E0.02593

G1 X80.968 Y36.001 E0.02247

G1 X80.520 Y36.455 E0.01662

G1 X80.071 Y36.749 E0.01397

G1 X79.107 Y37.119 E0.02692

G1 X79.107 Y39.476 E0.06140

G1 X79.175 Y39.587 E0.00341

G1 X79.623 Y40.041 E0.01662

G1 X80.071 Y40.335 E0.01397

G1 X80.968 Y40.692 E0.02515

G1 X81.416 Y40.777 E0.01189

G1 X81.865 Y40.575 E0.01281

G1 X82.313 Y39.687 E0.02593

G1 X82.761 Y38.950 E0.02247

G1 X83.210 Y38.497 E0.01662

G1 X83.658 Y38.202 E0.01397

G1 X83.958 Y38.083 E0.00843

G1 X84.190 Y38.641 E0.01575

G1 X84.554 Y39.185 E0.01705

G1 X84.797 Y39.455 E0.00947

G1 X85.067 Y39.699 E0.00947

G1 X85.611 Y40.063 E0.01705

G1 X86.240 Y40.323 E0.01774

G1 X86.905 Y40.454 E0.01768

G1 X87.544 Y40.454 E0.01663

G1 X88.141 Y40.692 E0.01675

G1 X88.589 Y40.777 E0.01189

G1 X89.037 Y40.575 E0.01281

G1 X89.548 Y39.584 E0.02904

G1 X89.691 Y39.455 E0.00503

G1 X89.935 Y39.185 E0.00947

G1 X90.382 Y38.497 E0.02140

G1 X90.830 Y38.202 E0.01397

G1 X91.727 Y37.845 E0.02515

G1 X92.175 Y37.760 E0.01189

G1 X92.624 Y37.962 E0.01281

G1 X93.072 Y38.851 E0.02593

G1 X93.520 Y39.587 E0.02247

G1 X93.968 Y40.041 E0.01662

G1 X94.417 Y40.335 E0.01397

G1 X95.381 Y40.705 E0.02692

G1 X95.381 Y43.062 E0.06141

G1 X95.313 Y43.174 E0.00341

G1 X94.865 Y43.627 E0.01662

G1 X94.417 Y43.921 E0.01397

G1 X93.520 Y44.279 E0.02515

G1 X93.072 Y44.363 E0.01189

G1 X92.624 Y44.162 E0.01281

G1 X92.175 Y43.273 E0.02593

G1 X91.727 Y42.536 E0.02247

G1 X91.279 Y42.083 E0.01662

G1 X90.830 Y41.789 E0.01397

G1 X89.934 Y41.431 E0.02515

G1 X89.486 Y41.347 E0.01189

G1 X89.037 Y41.549 E0.01281

G1 X88.589 Y42.437 E0.02593

G1 X88.141 Y43.174 E0.02247

G1 X87.692 Y43.627 E0.01662

G1 X87.244 Y43.921 E0.01397

G1 X86.348 Y44.279 E0.02515

G1 X85.899 Y44.363 E0.01189

G1 X85.451 Y44.162 E0.01281

G1 X85.003 Y43.273 E0.02593

G1 X84.554 Y42.536 E0.02247

G1 X84.106 Y42.083 E0.01662

G1 X83.658 Y41.789 E0.01397

G1 X82.761 Y41.431 E0.02515

G1 X82.313 Y41.347 E0.01189

G1 X81.865 Y41.549 E0.01281

G1 X81.416 Y42.437 E0.02593

G1 X80.968 Y43.174 E0.02247

G1 X80.520 Y43.627 E0.01662

G1 X80.071 Y43.921 E0.01397

G1 X79.107 Y44.292 E0.02692

G1 X79.107 Y46.648 E0.06140

G1 X79.175 Y46.760 E0.00341

G1 X79.623 Y47.213 E0.01662

G1 X80.071 Y47.508 E0.01397

G1 X80.968 Y47.865 E0.02515

G1 X81.416 Y47.950 E0.01189

G1 X81.865 Y47.748 E0.01281

G1 X82.313 Y46.859 E0.02593

G1 X82.761 Y46.123 E0.02247

G1 X83.210 Y45.669 E0.01662

G1 X83.658 Y45.375 E0.01397

G1 X84.554 Y45.018 E0.02515

G1 X85.003 Y44.933 E0.01189

G1 X85.451 Y45.135 E0.01281

G1 X85.899 Y46.023 E0.02593

G1 X86.348 Y46.760 E0.02247

G1 X86.796 Y47.213 E0.01662

G1 X87.244 Y47.508 E0.01397

G1 X88.141 Y47.865 E0.02515

G1 X88.589 Y47.950 E0.01189

G1 X89.037 Y47.748 E0.01281

G1 X89.486 Y46.859 E0.02593

G1 X89.934 Y46.123 E0.02247

G1 X90.382 Y45.669 E0.01662

G1 X90.830 Y45.375 E0.01397

G1 X91.727 Y45.018 E0.02515

G1 X92.175 Y44.933 E0.01189

G1 X92.624 Y45.135 E0.01281

G1 X93.072 Y46.023 E0.02593

G1 X93.520 Y46.760 E0.02247

G1 X93.968 Y47.213 E0.01662

G1 X94.417 Y47.508 E0.01397

G1 X95.381 Y47.878 E0.02692

G1 X95.381 Y50.235 E0.06141

G1 X95.313 Y50.346 E0.00341

G1 X94.865 Y50.800 E0.01662

G1 X94.417 Y51.094 E0.01397

G1 X93.520 Y51.451 E0.02515

G1 X93.072 Y51.536 E0.01189

G1 X92.624 Y51.334 E0.01281

G1 X92.175 Y50.446 E0.02593

G1 X91.727 Y49.709 E0.02247

G1 X91.279 Y49.256 E0.01662

G1 X90.830 Y48.961 E0.01397

G1 X89.934 Y48.604 E0.02515

G1 X89.486 Y48.519 E0.01189

G1 X89.037 Y48.721 E0.01281

G1 X88.589 Y49.610 E0.02593

G1 X88.141 Y50.346 E0.02247

G1 X87.692 Y50.800 E0.01662

G1 X87.244 Y51.094 E0.01397

G1 X86.348 Y51.451 E0.02515

G1 X85.899 Y51.536 E0.01189

G1 X85.451 Y51.334 E0.01281

G1 X85.003 Y50.446 E0.02593

G1 X84.554 Y49.709 E0.02247

G1 X84.106 Y49.256 E0.01662

G1 X83.658 Y48.961 E0.01397

G1 X82.761 Y48.604 E0.02515

G1 X82.313 Y48.519 E0.01189

G1 X81.865 Y48.721 E0.01281

G1 X81.416 Y49.610 E0.02593

G1 X80.968 Y50.346 E0.02247

G1 X80.520 Y50.800 E0.01662

G1 X80.071 Y51.094 E0.01397

G1 X79.107 Y51.464 E0.02692

G1 X79.107 Y53.821 E0.06140

G1 X79.175 Y53.933 E0.00341

G1 X79.623 Y54.386 E0.01662

G1 X80.071 Y54.680 E0.01397

G1 X80.968 Y55.038 E0.02515

G1 X81.416 Y55.122 E0.01189

G1 X81.865 Y54.921 E0.01281

G1 X82.313 Y54.032 E0.02593

G1 X82.761 Y53.295 E0.02247

G1 X83.210 Y52.842 E0.01662

G1 X83.658 Y52.548 E0.01397

G1 X84.554 Y52.190 E0.02515

G1 X85.003 Y52.106 E0.01189

G1 X85.451 Y52.307 E0.01281

G1 X85.899 Y53.196 E0.02593

G1 X86.348 Y53.933 E0.02247

G1 X86.796 Y54.386 E0.01662

G1 X87.244 Y54.680 E0.01397

G1 X88.141 Y55.038 E0.02515

G1 X88.589 Y55.122 E0.01189

G1 X89.037 Y54.921 E0.01281

G1 X89.486 Y54.032 E0.02593

G1 X89.934 Y53.295 E0.02247

G1 X90.382 Y52.842 E0.01662

G1 X90.830 Y52.548 E0.01397

G1 X91.727 Y52.190 E0.02515

G1 X92.175 Y52.106 E0.01189

G1 X92.624 Y52.307 E0.01281

G1 X93.072 Y53.196 E0.02593

G1 X93.520 Y53.933 E0.02247

G1 X93.968 Y54.386 E0.01662

G1 X94.417 Y54.680 E0.01397

G1 X95.381 Y55.050 E0.02692

G1 X95.381 Y57.407 E0.06141

G1 X95.313 Y57.519 E0.00341

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G1 X89.037 Y106.102 E0.01281

G1 X88.589 Y106.991 E0.02593

G1 X88.141 Y107.727 E0.02247

G1 X87.692 Y108.181 E0.01662

G1 X87.244 Y108.475 E0.01397

G1 X86.348 Y108.832 E0.02515

G1 X85.899 Y108.917 E0.01189

G1 X85.451 Y108.715 E0.01281

G1 X85.003 Y107.826 E0.02593

G1 X84.554 Y107.090 E0.02247

G1 X84.106 Y106.636 E0.01662

G1 X83.658 Y106.342 E0.01397

G1 X82.761 Y105.985 E0.02515

G1 X82.313 Y105.900 E0.01189

G1 X81.865 Y106.102 E0.01281

G1 X81.416 Y106.991 E0.02593

G1 X80.968 Y107.727 E0.02247

G1 X80.520 Y108.181 E0.01662

G1 X80.071 Y108.475 E0.01397

G1 X79.107 Y108.845 E0.02692

G1 X79.107 Y111.202 E0.06140

G1 X79.175 Y111.313 E0.00341

G1 X79.623 Y111.767 E0.01662

G1 X80.071 Y112.061 E0.01397

G1 X80.968 Y112.418 E0.02515

G1 X81.416 Y112.503 E0.01189

G1 X81.865 Y112.301 E0.01281

G1 X82.313 Y111.413 E0.02593

G1 X82.761 Y110.676 E0.02247

G1 X83.210 Y110.223 E0.01662

G1 X83.658 Y109.929 E0.01397

G1 X84.554 Y109.571 E0.02515

G1 X85.003 Y109.487 E0.01189

G1 X85.451 Y109.688 E0.01281

G1 X85.899 Y110.577 E0.02593

G1 X86.348 Y111.313 E0.02247

G1 X86.796 Y111.767 E0.01662

G1 X87.244 Y112.061 E0.01397

G1 X88.141 Y112.418 E0.02515

G1 X88.589 Y112.503 E0.01189

G1 X89.037 Y112.301 E0.01281

G1 X89.486 Y111.413 E0.02593

G1 X89.934 Y110.676 E0.02247

G1 X90.382 Y110.223 E0.01662

G1 X90.830 Y109.929 E0.01397

G1 X91.727 Y109.571 E0.02515

G1 X92.175 Y109.487 E0.01189

G1 X92.624 Y109.688 E0.01281

G1 X93.072 Y110.577 E0.02593

G1 X93.520 Y111.313 E0.02247

G1 X93.968 Y111.767 E0.01662

G1 X94.417 Y112.061 E0.01397

G1 X95.381 Y112.431 E0.02692

G1 X95.381 Y114.788 E0.06141

G1 X95.313 Y114.900 E0.00341

G1 X94.865 Y115.353 E0.01662

G1 X94.417 Y115.648 E0.01397

G1 X93.520 Y116.005 E0.02515

G1 X93.072 Y116.089 E0.01189

G1 X92.624 Y115.888 E0.01281

G1 X92.175 Y114.999 E0.02593

G1 X91.727 Y114.263 E0.02247

G1 X91.279 Y113.809 E0.01662

G1 X90.830 Y113.515 E0.01397

G1 X89.934 Y113.158 E0.02515

G1 X89.486 Y113.073 E0.01189

G1 X89.037 Y113.275 E0.01281

G1 X88.589 Y114.163 E0.02593

G1 X88.141 Y114.900 E0.02247

G1 X87.692 Y115.353 E0.01662

G1 X87.244 Y115.648 E0.01397

G1 X86.348 Y116.005 E0.02515

G1 X85.899 Y116.089 E0.01189

G1 X85.451 Y115.888 E0.01281

G1 X85.003 Y114.999 E0.02593

G1 X84.554 Y114.263 E0.02247

G1 X84.106 Y113.809 E0.01662

G1 X83.658 Y113.515 E0.01397

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G1 X82.313 Y113.073 E0.01189

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G1 X80.071 Y115.648 E0.01397

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G1 X79.107 Y118.374 E0.06140

G1 X79.175 Y118.486 E0.00341

G1 X79.623 Y118.940 E0.01662

G1 X80.071 Y119.234 E0.01397

G1 X80.968 Y119.591 E0.02515

G1 X81.416 Y119.676 E0.01189

G1 X81.865 Y119.474 E0.01281

G1 X82.313 Y118.585 E0.02593

G1 X82.761 Y117.849 E0.02247

G1 X83.210 Y117.395 E0.01662

G1 X83.658 Y117.101 E0.01397

G1 X84.554 Y116.744 E0.02515

G1 X85.003 Y116.659 E0.01189

G1 X85.451 Y116.861 E0.01281

G1 X85.899 Y117.750 E0.02593

G1 X86.348 Y118.486 E0.02247

G1 X86.796 Y118.940 E0.01662

G1 X87.244 Y119.234 E0.01397

G1 X88.141 Y119.591 E0.02515

G1 X88.589 Y119.676 E0.01189

G1 X89.037 Y119.474 E0.01281

G1 X89.486 Y118.585 E0.02593

G1 X89.934 Y117.849 E0.02247

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G1 X90.830 Y117.101 E0.01397

G1 X91.727 Y116.744 E0.02515

G1 X92.175 Y116.659 E0.01189

G1 X92.624 Y116.861 E0.01281

G1 X93.072 Y117.750 E0.02593

G1 X93.520 Y118.486 E0.02247

G1 X93.968 Y118.940 E0.01662

G1 X94.417 Y119.234 E0.01397

G1 X95.381 Y119.604 E0.02692

G1 X95.381 Y121.961 E0.06141

G1 X95.313 Y122.072 E0.00341

G1 X94.865 Y122.526 E0.01662

G1 X94.417 Y122.820 E0.01397

G1 X93.520 Y123.177 E0.02515

G1 X93.072 Y123.262 E0.01189

G1 X92.624 Y123.060 E0.01281

G1 X92.175 Y122.172 E0.02593

G1 X91.727 Y121.435 E0.02247

G1 X91.279 Y120.982 E0.01662

G1 X90.830 Y120.687 E0.01397

G1 X89.934 Y120.330 E0.02515

G1 X89.486 Y120.246 E0.01189

G1 X89.037 Y120.447 E0.01281

G1 X88.794 Y120.929 E0.01405

G1 X88.569 Y120.808 E0.00665

G1 X87.942 Y120.619 E0.01709

G1 X87.567 Y120.563 E0.00986

G1 X87.075 Y120.555 E0.01284

G1 X86.562 Y120.614 E0.01345

G1 X85.919 Y120.808 E0.01749

G1 X85.321 Y121.128 E0.01767

G1 X84.795 Y121.559 E0.01772

G1 X84.700 Y121.674 E0.00389

G1 X84.554 Y121.435 E0.00730

G1 X84.106 Y120.982 E0.01662

G1 X83.658 Y120.687 E0.01397

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G1 X82.313 Y120.246 E0.01189

G1 X81.865 Y120.447 E0.01281

G1 X81.416 Y121.336 E0.02593

G1 X80.968 Y122.072 E0.02247

G1 X80.520 Y122.526 E0.01662

G1 X80.071 Y122.820 E0.01397

G1 X79.107 Y123.190 E0.02692

G1 X79.107 Y124.957 E0.04604

G1 X79.164 Y125.549 E0.01550

G1 X79.218 Y125.702 E0.00421

G1 X79.623 Y126.112 E0.01504

G1 X80.071 Y126.406 E0.01397

G1 X80.968 Y126.764 E0.02515

G1 X81.416 Y126.848 E0.01189

G1 X81.865 Y126.647 E0.01281

G1 X82.313 Y125.758 E0.02593

G1 X82.761 Y125.022 E0.02247

G1 X83.210 Y124.568 E0.01662

G1 X83.658 Y124.274 E0.01397

G1 X83.801 Y124.217 E0.00402

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.658 Y124.274 E-0.08546

G1 X83.210 Y124.568 E-0.29715

G1 X82.761 Y125.022 E-0.35339

G1 X82.596 Y125.293 E-0.17600

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X84.093 Y128.145

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.658 Y127.860 E0.01355

G1 X82.761 Y127.503 E0.02515

G1 X82.313 Y127.418 E0.01189

G1 X81.865 Y127.620 E0.01281

G1 X81.635 Y128.059 E0.01290

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.865 Y127.620 E-0.27436

G1 X82.313 Y127.418 E-0.27242

G1 X82.761 Y127.503 E-0.25282

G1 X82.950 Y127.578 E-0.11240

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X88.762 Y128.145

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X89.486 Y127.418 E0.01281

G1 X89.934 Y127.503 E0.01189

G1 X90.830 Y127.860 E0.02515

G1 X91.265 Y128.145 E0.01355

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.830 Y127.860 E-0.28824

G1 X89.934 Y127.503 E-0.53484

G1 X89.776 Y127.473 E-0.08892

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X94.186 Y128.755

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X95.280 Y127.660 E0.04051

G1 X95.740 Y127.011 E0.02079

G1 X95.963 Y126.384 E0.01742

G1 X93.544 Y128.803 E0.08950

G1 X93.305 Y128.896 E0.00672

G1 X92.786 Y128.968 E0.01370

G1 X93.428 Y128.326 E0.02375

G1 X93.133 Y128.440 E0.00828

G1 X92.657 Y128.503 E0.01255

G1 X92.108 Y129.052 E0.02032

G1 X91.515 Y129.052 E0.01552

G1 X92.004 Y128.563 E0.01807

G1 X91.410 Y128.563 E0.01553

G1 X90.922 Y129.051 E0.01806

G1 X90.329 Y129.051 E0.01552

G1 X90.817 Y128.563 E0.01804

G1 X90.223 Y128.563 E0.01553

G1 X89.736 Y129.050 E0.01803

G1 X89.143 Y129.050 E0.01552

G1 X89.630 Y128.563 E0.01801

G1 X89.037 Y128.563 E0.01553

G1 X88.550 Y129.050 E0.01800

G1 X87.957 Y129.049 E0.01552

G1 X88.443 Y128.563 E0.01798

G1 X87.850 Y128.563 E0.01553

G1 X87.364 Y129.049 E0.01797

G1 X86.771 Y129.048 E0.01552

G1 X87.257 Y128.563 E0.01795

G1 X86.663 Y128.563 E0.01553

G1 X86.178 Y129.048 E0.01794

G1 X85.585 Y129.048 E0.01552

G1 X86.070 Y128.563 E0.01792

G1 X85.476 Y128.563 E0.01553

G1 X84.992 Y129.047 E0.01791

G1 X84.399 Y129.047 E0.01552

G1 X84.883 Y128.563 E0.01789

G1 X84.290 Y128.563 E0.01553

G1 X83.806 Y129.046 E0.01788

G1 X83.213 Y129.046 E0.01552

G1 X83.696 Y128.563 E0.01786

G1 X83.103 Y128.563 E0.01553

G1 X82.620 Y129.046 E0.01785

G1 X82.222 Y129.045 E0.01042

G1 X82.052 Y129.021 E0.00450

G1 X82.509 Y128.563 E0.01692

G1 X82.276 Y128.563 E0.00612

G1 X81.954 Y128.526 E0.00848

G1 X81.535 Y128.945 E0.01551

G1 X81.156 Y128.889 E0.01001

G1 X81.041 Y128.845 E0.00323

G1 X81.434 Y128.452 E0.01454

G1 X80.989 Y128.304 E0.01228

G1 X80.613 Y128.680 E0.01391

G1 X80.430 Y128.610 E0.00511

G1 X80.222 Y128.478 E0.00647

G1 X80.575 Y128.124 E0.01309

G1 X80.206 Y127.900 E0.01130

G1 X79.858 Y128.248 E0.01288

G1 X79.762 Y128.187 E0.00299

G1 X79.538 Y127.975 E0.00806

G1 X79.877 Y127.636 E0.01255

G1 X79.577 Y127.342 E0.01098

G1 X79.233 Y127.686 E0.01272

G1 X78.986 Y127.340 E0.01113

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G1 X79.201 Y126.827 E0.00558

G1 X79.102 Y126.630 E0.00576

G1 X78.742 Y126.990 E0.01332

G1 X78.725 Y126.966 E0.00079

G1 X78.579 Y126.560 E0.01129

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G1 X78.423 Y126.123 E0.01368

G1 X78.266 Y125.686 E0.01214

G1 X78.714 Y125.238 E0.01657

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G1 X78.689 Y124.670 E0.00804

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G1 X96.288 Y117.158 E0.01809

G1 X96.288 Y117.752 E0.01553

G1 X95.799 Y118.241 E0.01809

G1 X95.799 Y118.834 E0.01553

G1 X96.288 Y118.345 E0.01809

G1 X96.288 Y118.938 E0.01553

G1 X95.799 Y119.427 E0.01809

G1 X95.799 Y120.021 E0.01553

G1 X96.288 Y119.532 E0.01809

G1 X96.288 Y120.125 E0.01553

G1 X95.799 Y120.614 E0.01809

G1 X95.799 Y121.207 E0.01553

G1 X96.288 Y120.719 E0.01809

G1 X96.288 Y121.312 E0.01553

G1 X95.799 Y121.801 E0.01809

G1 X95.799 Y122.394 E0.01553

G1 X96.288 Y121.905 E0.01809

G1 X96.288 Y122.499 E0.01553

G1 X95.799 Y122.988 E0.01809

G1 X95.799 Y123.581 E0.01553

G1 X96.288 Y123.092 E0.01809

G1 X96.288 Y123.686 E0.01553

G1 X95.799 Y124.174 E0.01809

G1 X95.799 Y124.768 E0.01553

G1 X96.288 Y124.279 E0.01809

G1 X96.288 Y124.872 E0.01553

G1 X95.762 Y125.398 E0.01945

G1 X95.737 Y125.635 E0.00623

G1 X95.521 Y126.232 E0.01662

G1 X96.448 Y125.306 E0.03428

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X95.521 Y126.232 E-0.72593

G1 X95.636 Y125.916 E-0.18607

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X94.922 Y126.608

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.417 Y126.406 E0.01418

G1 X93.968 Y126.112 E0.01397

G1 X93.520 Y125.659 E0.01662

G1 X93.072 Y124.922 E0.02247

G1 X92.624 Y124.034 E0.02593

G1 X92.175 Y123.832 E0.01281

G1 X91.727 Y123.917 E0.01189

G1 X90.830 Y124.274 E0.02515

G1 X90.670 Y124.379 E0.00499

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.830 Y124.274 E-0.10604

G1 X91.727 Y123.917 E-0.53484

G1 X92.175 Y123.832 E-0.25282

G1 X92.205 Y123.845 E-0.01829

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X95.372 Y35.904

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X95.313 Y36.001 E0.00295

G1 X94.865 Y36.455 E0.01662

G1 X94.417 Y36.749 E0.01397

G1 X93.520 Y37.106 E0.02515

G1 X93.072 Y37.191 E0.01189

G1 X92.624 Y36.989 E0.01281

G1 X92.175 Y36.100 E0.02593

G1 X91.727 Y35.364 E0.02247

G1 X91.279 Y34.910 E0.01662

G1 X90.830 Y34.616 E0.01397

G1 X89.934 Y34.259 E0.02515

G1 X89.486 Y34.174 E0.01189

G1 X89.319 Y34.249 E0.00477

M204 S1250

G1 X89.302 Y32.877 F9000.000

M204 S1000

G1 F4800.000

G1 X89.037 Y33.403 E0.01534

G1 X88.589 Y33.604 E0.01281

G1 X88.141 Y33.520 E0.01189

G1 X87.244 Y33.162 E0.02515

G1 X86.809 Y32.877 E0.01355

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.244 Y33.162 E-0.28827

G1 X88.141 Y33.520 E-0.53484

G1 X88.298 Y33.550 E-0.08888

G1 E-0.04800 F4200.00000

G1 Z1.150 F9000.000

G1 X78.513 Y34.059

G1 Z0.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X79.201 Y33.371 E0.02546

G1 X79.791 Y32.814 E0.02124

G1 X80.427 Y32.413 E0.01966

G1 X80.984 Y32.181 E0.01579

G1 X78.152 Y35.013 E0.10479

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;1.1

G1 Z1.100 F9000.000

;AFTER\_LAYER\_CHANGE

;1.1

G1 E-3.20000 F4200.00000

G1 Z1.300 F9000.000

G1 X86.627 Y120.922

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.113 Y120.868 E0.01277

G1 X87.543 Y120.876 E0.01120

G1 X87.873 Y120.925 E0.00869

G1 X88.449 Y121.099 E0.01568

G1 X88.993 Y121.390 E0.01607

G1 X89.471 Y121.781 E0.01610

G1 X89.862 Y122.260 E0.01610

G1 X90.153 Y122.804 E0.01607

G1 X90.332 Y123.395 E0.01609

G1 X90.392 Y124.008 E0.01607

G1 X90.332 Y124.622 E0.01607

G1 X90.153 Y125.213 E0.01609

G1 X89.862 Y125.757 E0.01607

G1 X89.471 Y126.235 E0.01610

G1 X88.993 Y126.627 E0.01610

G1 X88.449 Y126.917 E0.01607

G1 X87.858 Y127.096 E0.01607

G1 X87.244 Y127.157 E0.01609

G1 X86.630 Y127.096 E0.01609

G1 X86.039 Y126.917 E0.01608

G1 X85.495 Y126.626 E0.01607

G1 X85.017 Y126.235 E0.01610

G1 X84.626 Y125.757 E0.01610

G1 X84.335 Y125.213 E0.01607

G1 X84.157 Y124.623 E0.01607

G1 X84.095 Y124.008 E0.01608

G1 X84.157 Y123.394 E0.01609

G1 X84.335 Y122.803 E0.01608

G1 X84.626 Y122.260 E0.01607

G1 X85.017 Y121.781 E0.01610

G1 X85.496 Y121.390 E0.01610

G1 X86.039 Y121.099 E0.01607

G1 X86.569 Y120.939 E0.01442

M204 S1250

G1 X86.690 Y121.339 F9000.000

M204 S800

G1 F1500.000

G1 X87.132 Y121.286 E0.01161

G1 X87.508 Y121.294 E0.00979

G1 X87.781 Y121.334 E0.00720

G1 X88.289 Y121.487 E0.01380

G1 X88.760 Y121.739 E0.01392

G1 X89.174 Y122.078 E0.01395

G1 X89.513 Y122.493 E0.01395

G1 X89.765 Y122.964 E0.01392

G1 X89.920 Y123.476 E0.01394

G1 X89.972 Y124.008 E0.01393

G1 X89.920 Y124.540 E0.01393

G1 X89.765 Y125.053 E0.01395

G1 X89.513 Y125.524 E0.01392

G1 X89.174 Y125.938 E0.01395

G1 X88.760 Y126.277 E0.01395

G1 X88.288 Y126.529 E0.01392

G1 X87.776 Y126.684 E0.01394

G1 X87.244 Y126.737 E0.01394

G1 X86.712 Y126.684 E0.01394

G1 X86.200 Y126.529 E0.01394

G1 X85.728 Y126.277 E0.01392

G1 X85.314 Y125.938 E0.01395

G1 X84.975 Y125.524 E0.01395

G1 X84.723 Y125.053 E0.01392

G1 X84.568 Y124.540 E0.01394

G1 X84.515 Y124.008 E0.01394

G1 X84.568 Y123.476 E0.01394

G1 X84.723 Y122.964 E0.01394

G1 X84.975 Y122.493 E0.01392

G1 X85.314 Y122.078 E0.01395

G1 X85.729 Y121.739 E0.01395

G1 X86.200 Y121.487 E0.01392

G1 X86.632 Y121.357 E0.01178

M204 S1250

G1 X86.813 Y120.959 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.132 Y121.286 E-0.27979

G1 X87.508 Y121.294 E-0.20821

G1 X87.781 Y121.334 E-0.15315

G1 X88.249 Y121.475 E-0.27085

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X86.936 Y40.141

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.331 Y40.022 E0.01607

G1 X85.759 Y39.785 E0.01612

G1 X85.260 Y39.451 E0.01565

G1 X85.019 Y39.233 E0.00846

G1 X84.802 Y38.992 E0.00846

G1 X84.467 Y38.493 E0.01566

G1 X84.231 Y37.921 E0.01612

G1 X84.115 Y37.333 E0.01563

G1 X84.097 Y37.008 E0.00847

G1 X84.115 Y36.683 E0.00847

G1 X84.231 Y36.095 E0.01562

G1 X84.468 Y35.524 E0.01612

G1 X84.802 Y35.024 E0.01565

G1 X85.019 Y34.783 E0.00846

G1 X85.260 Y34.566 E0.00846

G1 X85.760 Y34.232 E0.01566

G1 X86.317 Y34.001 E0.01571

G1 X86.640 Y33.921 E0.00868

G1 X87.067 Y33.870 E0.01119

G1 X87.556 Y33.876 E0.01277

G1 X88.157 Y33.995 E0.01595

G1 X88.729 Y34.232 E0.01612

G1 X89.228 Y34.566 E0.01565

G1 X89.469 Y34.783 E0.00846

G1 X89.687 Y35.024 E0.00846

G1 X90.021 Y35.524 E0.01566

G1 X90.257 Y36.095 E0.01612

G1 X90.377 Y36.700 E0.01607

G1 X90.377 Y37.316 E0.01605

G1 X90.257 Y37.921 E0.01607

G1 X90.021 Y38.493 E0.01612

G1 X89.687 Y38.992 E0.01565

G1 X89.469 Y39.233 E0.00846

G1 X89.228 Y39.451 E0.00846

G1 X88.729 Y39.785 E0.01566

G1 X88.157 Y40.022 E0.01611

G1 X87.552 Y40.141 E0.01607

G1 X86.996 Y40.141 E0.01448

M204 S1250

G1 X86.996 Y39.723 F9000.000

M204 S800

G1 F1500.000

G1 X86.453 Y39.620 E0.01442

G1 X85.957 Y39.415 E0.01396

G1 X85.518 Y39.120 E0.01379

G1 X85.315 Y38.938 E0.00711

G1 X85.132 Y38.735 E0.00711

G1 X84.838 Y38.295 E0.01380

G1 X84.633 Y37.800 E0.01396

G1 X84.530 Y37.281 E0.01377

G1 X84.516 Y37.008 E0.00712

G1 X84.530 Y36.735 E0.00712

G1 X84.633 Y36.217 E0.01377

G1 X84.838 Y35.722 E0.01396

G1 X85.132 Y35.282 E0.01379

G1 X85.315 Y35.079 E0.00711

G1 X85.518 Y34.896 E0.00711

G1 X85.958 Y34.602 E0.01380

G1 X86.448 Y34.399 E0.01382

G1 X86.715 Y34.333 E0.00719

G1 X87.089 Y34.288 E0.00979

G1 X87.513 Y34.294 E0.01105

G1 X88.036 Y34.397 E0.01389

G1 X88.531 Y34.602 E0.01396

G1 X88.971 Y34.896 E0.01379

G1 X89.173 Y35.079 E0.00711

G1 X89.356 Y35.282 E0.00711

G1 X89.651 Y35.722 E0.01380

G1 X89.856 Y36.217 E0.01396

G1 X89.959 Y36.741 E0.01393

G1 X89.959 Y37.275 E0.01392

G1 X89.856 Y37.800 E0.01393

G1 X89.650 Y38.295 E0.01396

G1 X89.356 Y38.735 E0.01379

G1 X89.173 Y38.938 E0.00711

G1 X88.971 Y39.120 E0.00711

G1 X88.531 Y39.415 E0.01380

G1 X88.036 Y39.620 E0.01396

G1 X87.511 Y39.723 E0.01393

G1 X87.056 Y39.723 E0.01185

M204 S1250

G1 X86.765 Y40.050 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.453 Y39.620 E-0.33935

G1 X85.957 Y39.415 E-0.29698

G1 X85.544 Y39.138 E-0.27566

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X80.877 Y31.909

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S800

G1 X81.948 Y31.695 E0.02848

G1 X82.258 Y31.682 E0.00807

G1 X92.214 Y31.682 E0.25940

G1 X92.979 Y31.755 E0.02005

G1 X93.802 Y31.983 E0.02224

G1 X94.552 Y32.361 E0.02189

G1 X95.228 Y32.887 E0.02232

G1 X95.776 Y33.523 E0.02188

G1 X96.202 Y34.274 E0.02250

G1 X96.387 Y34.753 E0.01336

G1 X96.542 Y35.496 E0.01977

G1 X96.576 Y36.034 E0.01405

G1 X96.576 Y124.981 E2.31759

G1 X96.512 Y125.713 E0.01915

G1 X95.991 Y127.157 E0.03999

G1 X95.514 Y127.833 E0.02156

G1 X94.907 Y128.413 E0.02188

G1 X94.190 Y128.867 E0.02211

G1 X93.404 Y129.170 E0.02195

G1 X92.199 Y129.340 E0.03171

G1 X82.282 Y129.340 E0.25838

G1 X81.084 Y129.170 E0.03153

G1 X80.302 Y128.869 E0.02183

G1 X79.582 Y128.412 E0.02223

G1 X78.974 Y127.833 E0.02186

G1 X78.494 Y127.151 E0.02175

G1 X77.977 Y125.721 E0.03961

G1 X77.912 Y124.981 E0.01935

G1 X77.912 Y36.041 E2.31739

G1 X77.979 Y35.279 E0.01993

G1 X78.138 Y34.663 E0.01659

G1 X78.482 Y33.887 E0.02213

G1 X78.974 Y33.190 E0.02222

G1 X79.589 Y32.605 E0.02211

G1 X80.307 Y32.150 E0.02216

G1 X80.821 Y31.932 E0.01455

M204 S1250

G1 X80.658 Y31.548 F9000.000

M204 S800

G1 F1800.000

G1 X80.753 Y31.507 E0.00268

G1 X81.898 Y31.279 E0.03043

G1 X82.249 Y31.264 E0.00914

G1 X92.233 Y31.264 E0.26015

G1 X93.056 Y31.343 E0.02152

G1 X93.953 Y31.591 E0.02427

G1 X94.777 Y32.006 E0.02403

G1 X95.517 Y32.583 E0.02446

G1 X96.119 Y33.281 E0.02402

G1 X96.581 Y34.095 E0.02437

G1 X96.789 Y34.634 E0.01505

G1 X96.957 Y35.439 E0.02144

G1 X96.994 Y36.020 E0.01517

G1 X96.994 Y124.999 E2.31842

M73 P17 R58

G1 X96.923 Y125.804 E0.02104

G1 X96.365 Y127.352 E0.04287

G1 X95.832 Y128.107 E0.02410

G1 X95.165 Y128.743 E0.02402

G1 X94.378 Y129.242 E0.02426

G1 X93.510 Y129.577 E0.02427

G1 X92.228 Y129.758 E0.03372

G1 X82.253 Y129.758 E0.25991

G1 X80.979 Y129.577 E0.03354

G1 X80.114 Y129.244 E0.02415

G1 X79.323 Y128.743 E0.02438

G1 X78.656 Y128.107 E0.02401

G1 X78.120 Y127.345 E0.02428

G1 X77.566 Y125.812 E0.04249

G1 X77.494 Y124.999 E0.02125

G1 X77.494 Y36.023 E2.31834

G1 X77.566 Y35.208 E0.02131

G1 X77.743 Y34.525 E0.01839

G1 X78.117 Y33.680 E0.02410

G1 X78.656 Y32.915 E0.02436

G1 X79.330 Y32.274 E0.02426

G1 X80.113 Y31.779 E0.02412

G1 X80.603 Y31.571 E0.01387

M204 S1250

G1 X80.742 Y31.607 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.753 Y31.507 E-0.09023

G1 X81.898 Y31.279 E-0.64720

G1 X82.213 Y31.266 E-0.17457

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X84.352 Y35.133

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.106 Y34.922 E0.00845

G1 X83.658 Y34.674 E0.01334

G1 X82.761 Y34.436 E0.02417

G1 X82.313 Y34.476 E0.01173

G1 X81.865 Y34.806 E0.01450

G1 X80.968 Y36.058 E0.04014

G1 X80.520 Y36.443 E0.01540

G1 X80.071 Y36.691 E0.01334

G1 X79.257 Y36.908 E0.02196

G1 X79.257 Y39.715 E0.07315

G1 X79.623 Y40.030 E0.01258

G1 X80.071 Y40.277 E0.01334

G1 X80.968 Y40.516 E0.02417

G1 X81.416 Y40.475 E0.01173

G1 X81.865 Y40.146 E0.01450

G1 X82.761 Y38.893 E0.04014

G1 X83.210 Y38.508 E0.01540

G1 X83.658 Y38.261 E0.01334

G1 X83.995 Y38.171 E0.00909

G1 X84.190 Y38.641 E0.01327

G1 X84.554 Y39.185 E0.01705

G1 X84.797 Y39.455 E0.00947

G1 X85.067 Y39.699 E0.00947

G1 X85.611 Y40.063 E0.01705

G1 X86.240 Y40.323 E0.01774

G1 X86.905 Y40.454 E0.01768

G1 X87.583 Y40.454 E0.01764

G1 X87.771 Y40.417 E0.00500

G1 X88.141 Y40.516 E0.00997

G1 X88.589 Y40.475 E0.01173

G1 X89.037 Y40.146 E0.01450

G1 X89.298 Y39.781 E0.01169

G1 X89.421 Y39.699 E0.00385

G1 X89.691 Y39.455 E0.00947

G1 X89.935 Y39.185 E0.00947

G1 X90.298 Y38.641 E0.01705

G1 X90.338 Y38.546 E0.00270

G1 X90.382 Y38.508 E0.00152

G1 X90.830 Y38.261 E0.01334

G1 X91.727 Y38.022 E0.02417

G1 X92.175 Y38.062 E0.01173

G1 X92.624 Y38.392 E0.01450

G1 X93.520 Y39.645 E0.04014

G1 X93.968 Y40.030 E0.01540

G1 X94.417 Y40.277 E0.01334

G1 X95.231 Y40.494 E0.02196

G1 X95.231 Y43.301 E0.07315

G1 X94.865 Y43.616 E0.01258

G1 X94.417 Y43.863 E0.01334

G1 X93.520 Y44.102 E0.02417

G1 X93.072 Y44.062 E0.01173

G1 X92.624 Y43.732 E0.01450

G1 X91.727 Y42.479 E0.04014

G1 X91.279 Y42.094 E0.01540

G1 X90.830 Y41.847 E0.01334

G1 X89.934 Y41.608 E0.02417

G1 X89.486 Y41.648 E0.01173

G1 X89.037 Y41.978 E0.01450

G1 X88.141 Y43.231 E0.04014

G1 X87.692 Y43.616 E0.01540

G1 X87.244 Y43.863 E0.01334

G1 X86.348 Y44.102 E0.02417

G1 X85.899 Y44.062 E0.01173

G1 X85.451 Y43.732 E0.01450

G1 X84.554 Y42.479 E0.04014

G1 X84.106 Y42.094 E0.01540

G1 X83.658 Y41.847 E0.01334

G1 X82.761 Y41.608 E0.02417

G1 X82.313 Y41.648 E0.01173

G1 X81.865 Y41.978 E0.01450

G1 X80.968 Y43.231 E0.04014

G1 X80.520 Y43.616 E0.01540

G1 X80.071 Y43.863 E0.01334

G1 X79.257 Y44.080 E0.02196

G1 X79.257 Y46.888 E0.07315

G1 X79.623 Y47.202 E0.01258

G1 X80.071 Y47.450 E0.01334

G1 X80.968 Y47.688 E0.02417

G1 X81.416 Y47.648 E0.01173

G1 X81.865 Y47.318 E0.01450

G1 X82.761 Y46.065 E0.04014

G1 X83.210 Y45.680 E0.01540

G1 X83.658 Y45.433 E0.01334

G1 X84.554 Y45.194 E0.02417

G1 X85.003 Y45.235 E0.01173

G1 X85.451 Y45.565 E0.01450

G1 X86.348 Y46.817 E0.04014

G1 X86.796 Y47.202 E0.01540

G1 X87.244 Y47.450 E0.01334

G1 X88.141 Y47.688 E0.02417

G1 X88.589 Y47.648 E0.01173

G1 X89.037 Y47.318 E0.01450

G1 X89.934 Y46.065 E0.04014

G1 X90.382 Y45.680 E0.01540

G1 X90.830 Y45.433 E0.01334

G1 X91.727 Y45.194 E0.02417

G1 X92.175 Y45.235 E0.01173

G1 X92.624 Y45.565 E0.01450

G1 X93.520 Y46.817 E0.04014

G1 X93.968 Y47.202 E0.01540

G1 X94.417 Y47.450 E0.01334

G1 X95.231 Y47.667 E0.02196

G1 X95.231 Y50.474 E0.07315

G1 X94.865 Y50.789 E0.01258

G1 X94.417 Y51.036 E0.01334

G1 X93.520 Y51.275 E0.02417

G1 X93.072 Y51.234 E0.01173

G1 X92.624 Y50.905 E0.01450

G1 X91.727 Y49.652 E0.04014

G1 X91.279 Y49.267 E0.01540

G1 X90.830 Y49.019 E0.01334

G1 X89.934 Y48.781 E0.02417

G1 X89.486 Y48.821 E0.01173

G1 X89.037 Y49.151 E0.01450

G1 X88.141 Y50.404 E0.04014

G1 X87.692 Y50.789 E0.01540

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G1 X85.899 Y51.234 E0.01173

G1 X85.451 Y50.905 E0.01450

G1 X84.554 Y49.652 E0.04014

G1 X84.106 Y49.267 E0.01540

G1 X83.658 Y49.019 E0.01334

G1 X82.761 Y48.781 E0.02417

G1 X82.313 Y48.821 E0.01173

G1 X81.865 Y49.151 E0.01450

G1 X80.968 Y50.404 E0.04014

G1 X80.520 Y50.789 E0.01540

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G1 X79.257 Y51.253 E0.02196

G1 X79.257 Y54.060 E0.07315

G1 X79.623 Y54.375 E0.01258

G1 X80.071 Y54.622 E0.01334

G1 X80.968 Y54.861 E0.02417

G1 X81.416 Y54.821 E0.01173

G1 X81.865 Y54.491 E0.01450

G1 X82.761 Y53.238 E0.04014

G1 X83.210 Y52.853 E0.01540

G1 X83.658 Y52.606 E0.01334

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G1 X85.003 Y52.407 E0.01173

G1 X85.451 Y52.737 E0.01450

G1 X86.348 Y53.990 E0.04014

G1 X86.796 Y54.375 E0.01540

G1 X87.244 Y54.622 E0.01334

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G1 X88.589 Y54.821 E0.01173

G1 X89.037 Y54.491 E0.01450

G1 X89.934 Y53.238 E0.04014

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G1 X90.830 Y52.606 E0.01334

G1 X91.727 Y52.367 E0.02417

G1 X92.175 Y52.407 E0.01173

G1 X92.624 Y52.737 E0.01450

G1 X93.520 Y53.990 E0.04014

G1 X93.968 Y54.375 E0.01540

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G1 X95.231 Y57.647 E0.07315

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G1 X94.417 Y58.209 E0.01334

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G1 X83.658 Y56.192 E0.01334

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G1 X82.313 Y55.994 E0.01173

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G1 X79.257 Y58.425 E0.02196

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G1 X85.451 Y59.910 E0.01450

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G1 X87.244 Y61.795 E0.01334

G1 X88.141 Y62.034 E0.02417

G1 X88.589 Y61.993 E0.01173

G1 X89.037 Y61.663 E0.01450

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G1 X92.624 Y59.910 E0.01450

G1 X93.520 Y61.163 E0.04014

G1 X93.968 Y61.548 E0.01540

G1 X94.417 Y61.795 E0.01334

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G1 X94.417 Y65.381 E0.01334

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G1 X85.451 Y67.082 E0.01450

G1 X86.348 Y68.335 E0.04014

G1 X86.796 Y68.720 E0.01540

G1 X87.244 Y68.967 E0.01334

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G1 X88.589 Y69.166 E0.01173

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G1 X85.451 Y74.255 E0.01450

G1 X86.348 Y75.508 E0.04014

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G1 X88.589 Y76.338 E0.01173

G1 X89.037 Y76.009 E0.01450

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G1 X83.658 Y109.987 E0.01334

G1 X84.554 Y109.748 E0.02417

G1 X85.003 Y109.788 E0.01173

G1 X85.451 Y110.118 E0.01450

G1 X86.348 Y111.371 E0.04014

G1 X86.796 Y111.756 E0.01540

G1 X87.244 Y112.003 E0.01334

G1 X88.141 Y112.242 E0.02417

G1 X88.589 Y112.202 E0.01173

G1 X89.037 Y111.872 E0.01450

G1 X89.934 Y110.619 E0.04014

G1 X90.382 Y110.234 E0.01540

G1 X90.830 Y109.987 E0.01334

G1 X91.727 Y109.748 E0.02417

G1 X92.175 Y109.788 E0.01173

G1 X92.624 Y110.118 E0.01450

G1 X93.520 Y111.371 E0.04014

G1 X93.968 Y111.756 E0.01540

G1 X94.417 Y112.003 E0.01334

G1 X95.231 Y112.220 E0.02196

G1 X95.231 Y115.028 E0.07315

G1 X94.865 Y115.342 E0.01258

G1 X94.417 Y115.589 E0.01334

G1 X93.520 Y115.828 E0.02417

G1 X93.072 Y115.788 E0.01173

G1 X92.624 Y115.458 E0.01450

G1 X91.727 Y114.205 E0.04014

G1 X91.279 Y113.820 E0.01540

G1 X90.830 Y113.573 E0.01334

G1 X89.934 Y113.334 E0.02417

G1 X89.486 Y113.375 E0.01173

G1 X89.037 Y113.704 E0.01450

G1 X88.141 Y114.957 E0.04014

G1 X87.692 Y115.342 E0.01540

G1 X87.244 Y115.589 E0.01334

G1 X86.348 Y115.828 E0.02417

G1 X85.899 Y115.788 E0.01173

G1 X85.451 Y115.458 E0.01450

G1 X84.554 Y114.205 E0.04014

G1 X84.106 Y113.820 E0.01540

G1 X83.658 Y113.573 E0.01334

G1 X82.761 Y113.334 E0.02417

G1 X82.313 Y113.375 E0.01173

G1 X81.865 Y113.704 E0.01450

G1 X80.968 Y114.957 E0.04014

G1 X80.520 Y115.342 E0.01540

G1 X80.071 Y115.589 E0.01334

G1 X79.257 Y115.806 E0.02196

G1 X79.257 Y118.614 E0.07315

G1 X79.623 Y118.928 E0.01258

G1 X80.071 Y119.176 E0.01334

G1 X80.968 Y119.414 E0.02417

G1 X81.416 Y119.374 E0.01173

G1 X81.865 Y119.044 E0.01450

G1 X82.761 Y117.791 E0.04014

G1 X83.210 Y117.407 E0.01540

G1 X83.658 Y117.159 E0.01334

G1 X84.554 Y116.921 E0.02417

G1 X85.003 Y116.961 E0.01173

G1 X85.451 Y117.291 E0.01450

G1 X86.348 Y118.544 E0.04014

G1 X86.796 Y118.928 E0.01540

G1 X87.244 Y119.176 E0.01334

G1 X88.141 Y119.414 E0.02417

G1 X88.589 Y119.374 E0.01173

G1 X89.037 Y119.044 E0.01450

G1 X89.934 Y117.791 E0.04014

G1 X90.382 Y117.407 E0.01540

G1 X90.830 Y117.159 E0.01334

G1 X91.727 Y116.921 E0.02417

G1 X92.175 Y116.961 E0.01173

G1 X92.624 Y117.291 E0.01450

G1 X93.520 Y118.544 E0.04014

G1 X93.968 Y118.928 E0.01540

G1 X94.417 Y119.176 E0.01334

G1 X95.231 Y119.393 E0.02196

G1 X95.231 Y122.200 E0.07315

G1 X94.865 Y122.515 E0.01258

G1 X94.417 Y122.762 E0.01334

G1 X93.520 Y123.001 E0.02417

G1 X93.072 Y122.960 E0.01173

G1 X92.624 Y122.631 E0.01450

G1 X91.727 Y121.378 E0.04014

G1 X91.279 Y120.993 E0.01540

G1 X90.830 Y120.746 E0.01334

G1 X89.934 Y120.507 E0.02417

G1 X89.486 Y120.547 E0.01173

G1 X89.037 Y120.877 E0.01450

G1 X88.943 Y121.008 E0.00421

G1 X88.569 Y120.808 E0.01105

G1 X87.942 Y120.619 E0.01709

G1 X87.569 Y120.564 E0.00981

G1 X87.099 Y120.554 E0.01225

G1 X86.563 Y120.614 E0.01405

G1 X85.919 Y120.808 E0.01754

G1 X85.321 Y121.128 E0.01767

G1 X84.795 Y121.559 E0.01772

G1 X84.736 Y121.631 E0.00243

G1 X84.554 Y121.378 E0.00811

G1 X84.106 Y120.993 E0.01540

G1 X83.658 Y120.746 E0.01334

G1 X82.761 Y120.507 E0.02417

G1 X82.313 Y120.547 E0.01173

G1 X81.865 Y120.877 E0.01450

G1 X80.968 Y122.130 E0.04014

G1 X80.520 Y122.515 E0.01540

G1 X80.071 Y122.762 E0.01334

G1 X79.257 Y122.979 E0.02196

G1 X79.257 Y124.956 E0.05152

G1 X79.314 Y125.535 E0.01515

G1 X79.464 Y125.964 E0.01185

G1 X79.623 Y126.101 E0.00548

G1 X80.071 Y126.348 E0.01334

G1 X80.968 Y126.587 E0.02417

G1 X81.416 Y126.547 E0.01173

G1 X81.865 Y126.217 E0.01450

G1 X82.761 Y124.964 E0.04014

G1 X83.210 Y124.579 E0.01540

G1 X83.658 Y124.332 E0.01334

G1 X83.809 Y124.292 E0.00407

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.658 Y124.332 E-0.08647

G1 X83.210 Y124.579 E-0.28373

G1 X82.761 Y124.964 E-0.32744

G1 X82.536 Y125.279 E-0.21436

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X83.798 Y127.995

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.658 Y127.918 E0.00417

G1 X82.761 Y127.679 E0.02417

G1 X82.313 Y127.720 E0.01173

G1 X81.986 Y127.960 E0.01058

M204 S1250

G1 X81.244 Y129.066 F9000.000

M204 S1000

G1 F4800.000

G1 X78.543 Y126.364 E0.09991

G1 X78.774 Y127.005 E0.01780

G1 X79.211 Y127.626 E0.01986

G1 X80.312 Y128.727 E0.04071

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X79.211 Y127.626 E-0.86254

G1 X79.160 Y127.553 E-0.04946

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X89.111 Y127.995

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.486 Y127.720 E0.01212

G1 X89.934 Y127.679 E0.01173

G1 X90.830 Y127.918 E0.02417

G1 X90.971 Y127.995 E0.00417

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.830 Y127.918 E-0.08870

G1 X89.934 Y127.679 E-0.51416

G1 X89.486 Y127.720 E-0.24943

G1 X89.399 Y127.784 E-0.05971

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X90.666 Y124.422

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.830 Y124.332 E0.00489

G1 X91.727 Y124.093 E0.02417

G1 X92.175 Y124.133 E0.01173

G1 X92.624 Y124.463 E0.01450

G1 X93.520 Y125.716 E0.04014

G1 X93.968 Y126.101 E0.01540

G1 X94.417 Y126.348 E0.01334

G1 X94.839 Y126.461 E0.01137

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X94.417 Y126.348 E-0.24191

G1 X93.968 Y126.101 E-0.28373

G1 X93.520 Y125.716 E-0.32744

G1 X93.458 Y125.630 E-0.05893

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X96.313 Y35.010

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X93.537 Y32.235 E0.10266

G1 X92.922 Y32.064 E0.01668

G1 X92.758 Y32.049 E0.00432

G1 X93.626 Y32.917 E0.03212

G1 X93.536 Y32.872 E0.00264

G1 X92.922 Y32.686 E0.01679

G1 X92.788 Y32.672 E0.00351

G1 X92.111 Y31.995 E0.02502

G1 X91.518 Y31.995 E0.01551

G1 X92.132 Y32.609 E0.02270

G1 X91.539 Y32.609 E0.01551

G1 X90.925 Y31.995 E0.02270

G1 X90.332 Y31.995 E0.01551

G1 X90.946 Y32.609 E0.02270

G1 X90.353 Y32.609 E0.01551

G1 X89.739 Y31.995 E0.02270

G1 X89.146 Y31.995 E0.01551

G1 X89.760 Y32.609 E0.02270

G1 X89.167 Y32.609 E0.01551

G1 X88.553 Y31.995 E0.02270

G1 X87.960 Y31.995 E0.01551

G1 X88.574 Y32.609 E0.02270

G1 X87.981 Y32.609 E0.01551

G1 X87.367 Y31.995 E0.02270

G1 X86.774 Y31.995 E0.01551

G1 X87.388 Y32.609 E0.02270

G1 X86.795 Y32.609 E0.01551

G1 X86.181 Y31.995 E0.02270

G1 X85.588 Y31.995 E0.01551

G1 X86.202 Y32.609 E0.02270

G1 X85.609 Y32.609 E0.01551

G1 X84.995 Y31.995 E0.02270

G1 X84.402 Y31.995 E0.01551

G1 X85.015 Y32.609 E0.02270

G1 X84.422 Y32.609 E0.01551

G1 X83.809 Y31.995 E0.02270

G1 X83.215 Y31.995 E0.01551

G1 X83.829 Y32.609 E0.02270

G1 X83.236 Y32.609 E0.01551

G1 X82.622 Y31.995 E0.02270

G1 X82.265 Y31.995 E0.00936

G1 X82.039 Y32.005 E0.00590

G1 X82.643 Y32.609 E0.02234

G1 X82.276 Y32.609 E0.00961

G1 X82.070 Y32.629 E0.00541

G1 X81.538 Y32.097 E0.01968

G1 X81.043 Y32.195 E0.01319

G1 X81.552 Y32.704 E0.01881

G1 X81.254 Y32.763 E0.00795

G1 X81.088 Y32.833 E0.00471

G1 X80.615 Y32.360 E0.01749

G1 X80.453 Y32.429 E0.00459

G1 X80.231 Y32.569 E0.00688

G1 X80.670 Y33.008 E0.01624

G1 X80.303 Y33.235 E0.01127

G1 X79.868 Y32.799 E0.01611

G1 X79.782 Y32.853 E0.00264

G1 X79.550 Y33.074 E0.00839

G1 X79.976 Y33.500 E0.01577

G1 X79.680 Y33.797 E0.01097

G1 X79.246 Y33.363 E0.01605

G1 X78.994 Y33.705 E0.01109

G1 X79.430 Y34.140 E0.01611

G1 X79.250 Y34.408 E0.00843

G1 X79.206 Y34.509 E0.00289

G1 X78.751 Y34.054 E0.01682

G1 X78.569 Y34.465 E0.01176

G1 X79.035 Y34.931 E0.01723

G1 X78.902 Y35.392 E0.01253

G1 X78.403 Y34.893 E0.01847

G1 X78.289 Y35.333 E0.01189

G1 X78.286 Y35.368 E0.00094

G1 X78.849 Y35.932 E0.02083

G1 X78.839 Y36.515 E0.01526

G1 X78.238 Y35.914 E0.02224

G1 X78.225 Y36.055 E0.00372

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M204 S1000

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G1 X94.417 Y36.691 E0.01334

G1 X93.520 Y36.929 E0.02417

G1 X93.072 Y36.889 E0.01173

G1 X92.624 Y36.559 E0.01450

G1 X91.727 Y35.306 E0.04014

G1 X91.279 Y34.922 E0.01540

G1 X90.830 Y34.674 E0.01334

G1 X89.934 Y34.436 E0.02417

G1 X89.586 Y34.467 E0.00909

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.934 Y34.436 E-0.19338

G1 X90.830 Y34.674 E-0.51416

G1 X91.153 Y34.852 E-0.20446

G1 E-0.04800 F4200.00000

G1 Z1.300 F9000.000

G1 X88.964 Y33.027

G1 Z1.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.589 Y33.303 E0.01212

G1 X88.141 Y33.343 E0.01173

G1 X87.244 Y33.104 E0.02417

G1 X87.104 Y33.027 E0.00417

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;1.25

G1 Z1.250 F9000.000

;AFTER\_LAYER\_CHANGE

;1.25

G1 E-3.20000 F4200.00000

G1 Z1.450 F9000.000

G1 X86.628 Y120.922

G1 Z1.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.137 Y120.867 E0.01335

G1 X87.544 Y120.877 E0.01062

G1 X87.873 Y120.925 E0.00865

G1 X88.449 Y121.099 E0.01568

G1 X88.993 Y121.390 E0.01607

G1 X89.471 Y121.781 E0.01610

G1 X89.862 Y122.260 E0.01610

G1 X90.153 Y122.804 E0.01607

G1 X90.332 Y123.395 E0.01609

G1 X90.392 Y124.008 E0.01607

G1 X90.332 Y124.622 E0.01607

G1 X90.153 Y125.213 E0.01609

G1 X89.862 Y125.757 E0.01607

G1 X89.471 Y126.235 E0.01610

G1 X88.993 Y126.627 E0.01610

G1 X88.449 Y126.917 E0.01607

G1 X87.858 Y127.096 E0.01607

G1 X87.244 Y127.157 E0.01608

G1 X86.630 Y127.096 E0.01609

G1 X86.039 Y126.917 E0.01608

G1 X85.495 Y126.626 E0.01607

G1 X85.017 Y126.235 E0.01610

G1 X84.626 Y125.757 E0.01610

G1 X84.335 Y125.213 E0.01607

G1 X84.157 Y124.623 E0.01607

G1 X84.095 Y124.008 E0.01608

G1 X84.157 Y123.394 E0.01609

G1 X84.335 Y122.803 E0.01608

G1 X84.626 Y122.260 E0.01607

G1 X85.017 Y121.781 E0.01610

G1 X85.496 Y121.390 E0.01610

G1 X86.039 Y121.099 E0.01607

G1 X86.570 Y120.939 E0.01444

M204 S1250

G1 X86.691 Y121.339 F9000.000

M204 S800

G1 F1500.000

G1 X87.154 Y121.285 E0.01215

G1 X87.509 Y121.294 E0.00923

G1 X87.781 Y121.334 E0.00719

G1 X88.289 Y121.487 E0.01380

G1 X88.760 Y121.739 E0.01392

G1 X89.174 Y122.078 E0.01395

G1 X89.513 Y122.493 E0.01395

G1 X89.765 Y122.964 E0.01392

G1 X89.920 Y123.476 E0.01394

G1 X89.972 Y124.008 E0.01393

G1 X89.920 Y124.540 E0.01393

G1 X89.765 Y125.053 E0.01395

G1 X89.513 Y125.524 E0.01392

G1 X89.174 Y125.938 E0.01395

G1 X88.760 Y126.277 E0.01395

G1 X88.288 Y126.529 E0.01392

G1 X87.776 Y126.684 E0.01394

G1 X87.244 Y126.737 E0.01394

G1 X86.712 Y126.684 E0.01394

G1 X86.200 Y126.529 E0.01394

G1 X85.728 Y126.277 E0.01392

G1 X85.314 Y125.938 E0.01395

G1 X84.975 Y125.524 E0.01395

G1 X84.723 Y125.053 E0.01392

G1 X84.568 Y124.540 E0.01394

G1 X84.515 Y124.008 E0.01394

G1 X84.568 Y123.476 E0.01394

G1 X84.723 Y122.964 E0.01394

G1 X84.975 Y122.493 E0.01392

G1 X85.314 Y122.078 E0.01395

G1 X85.729 Y121.739 E0.01395

G1 X86.200 Y121.487 E0.01392

G1 X86.633 Y121.356 E0.01180

M204 S1250

G1 X86.815 Y120.959 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.154 Y121.285 E-0.29131

G1 X87.509 Y121.294 E-0.19640

G1 X87.781 Y121.334 E-0.15287

G1 X88.250 Y121.476 E-0.27143

G1 E-0.04800 F4200.00000

G1 Z1.450 F9000.000

G1 X86.936 Y40.141

G1 Z1.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.331 Y40.022 E0.01607

G1 X85.759 Y39.785 E0.01612

G1 X85.260 Y39.451 E0.01565

G1 X85.019 Y39.233 E0.00846

G1 X84.802 Y38.992 E0.00846

G1 X84.467 Y38.493 E0.01566

G1 X84.231 Y37.921 E0.01611

G1 X84.115 Y37.333 E0.01563

G1 X84.097 Y37.008 E0.00847

G1 X84.115 Y36.683 E0.00848

G1 X84.231 Y36.095 E0.01562

G1 X84.468 Y35.524 E0.01612

G1 X84.802 Y35.024 E0.01565

G1 X85.019 Y34.783 E0.00846

G1 X85.260 Y34.566 E0.00846

G1 X85.760 Y34.232 E0.01566

G1 X86.317 Y34.001 E0.01571

G1 X86.639 Y33.921 E0.00864

G1 X87.043 Y33.871 E0.01062

G1 X87.555 Y33.876 E0.01335

G1 X88.157 Y33.995 E0.01598

G1 X88.729 Y34.232 E0.01612

G1 X89.228 Y34.566 E0.01565

G1 X89.469 Y34.783 E0.00846

G1 X89.687 Y35.024 E0.00846

G1 X90.021 Y35.524 E0.01566

G1 X90.257 Y36.095 E0.01611

G1 X90.377 Y36.700 E0.01607

G1 X90.377 Y37.316 E0.01605

G1 X90.257 Y37.921 E0.01607

G1 X90.021 Y38.493 E0.01612

G1 X89.687 Y38.992 E0.01565

G1 X89.469 Y39.233 E0.00846

G1 X89.228 Y39.451 E0.00846

G1 X88.729 Y39.785 E0.01566

G1 X88.157 Y40.022 E0.01611

G1 X87.552 Y40.141 E0.01607

G1 X86.996 Y40.141 E0.01448

M204 S1250

G1 X86.996 Y39.723 F9000.000

M204 S800

G1 F1500.000

G1 X86.453 Y39.620 E0.01442

G1 X85.957 Y39.415 E0.01396

G1 X85.518 Y39.120 E0.01379

G1 X85.315 Y38.938 E0.00711

G1 X85.132 Y38.735 E0.00711

G1 X84.838 Y38.295 E0.01380

G1 X84.633 Y37.800 E0.01396

G1 X84.530 Y37.281 E0.01377

G1 X84.516 Y37.008 E0.00712

G1 X84.530 Y36.735 E0.00712

G1 X84.633 Y36.217 E0.01377

G1 X84.838 Y35.722 E0.01396

G1 X85.132 Y35.282 E0.01379

G1 X85.315 Y35.079 E0.00711

G1 X85.518 Y34.896 E0.00711

G1 X85.958 Y34.602 E0.01380

G1 X86.448 Y34.399 E0.01382

G1 X86.715 Y34.333 E0.00718

G1 X87.067 Y34.289 E0.00924

G1 X87.512 Y34.294 E0.01161

G1 X88.036 Y34.397 E0.01390

G1 X88.531 Y34.602 E0.01396

G1 X88.971 Y34.896 E0.01379

G1 X89.173 Y35.079 E0.00711

G1 X89.356 Y35.282 E0.00711

G1 X89.651 Y35.722 E0.01380

G1 X89.856 Y36.217 E0.01396

G1 X89.959 Y36.741 E0.01393

G1 X89.959 Y37.275 E0.01392

G1 X89.856 Y37.800 E0.01393

G1 X89.650 Y38.295 E0.01396

G1 X89.356 Y38.735 E0.01379

G1 X89.173 Y38.938 E0.00711

G1 X88.971 Y39.120 E0.00711

G1 X88.531 Y39.415 E0.01380

G1 X88.036 Y39.620 E0.01396

G1 X87.511 Y39.723 E0.01393

G1 X87.056 Y39.723 E0.01185

M204 S1250

G1 X86.765 Y40.050 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.453 Y39.620 E-0.33935

G1 X85.957 Y39.415 E-0.29698

G1 X85.544 Y39.138 E-0.27567

G1 E-0.04800 F4200.00000

G1 Z1.450 F9000.000

G1 X80.938 Y32.047

G1 Z1.250

G1 E3.20000 F2400.00000

M204 S800

G1 X81.924 Y31.851 E0.02619

G1 X82.262 Y31.832 E0.00882

G1 X92.213 Y31.832 E0.25929

G1 X92.970 Y31.906 E0.01981

G1 X93.760 Y32.128 E0.02139

G1 X94.500 Y32.506 E0.02166

G1 X95.141 Y33.014 E0.02131

G1 X95.644 Y33.596 E0.02005

G1 X96.060 Y34.325 E0.02187

G1 X96.243 Y34.798 E0.01320

G1 X96.395 Y35.540 E0.01975

G1 X96.426 Y36.034 E0.01289

G1 X96.426 Y124.981 E2.31759

G1 X96.363 Y125.701 E0.01882

G1 X95.863 Y127.080 E0.03822

G1 X95.390 Y127.747 E0.02131

G1 X94.834 Y128.278 E0.02003

G1 X94.134 Y128.727 E0.02166

G1 X93.347 Y129.030 E0.02199

G1 X92.199 Y129.190 E0.03018

G1 X82.240 Y129.186 E0.25949

G1 X81.141 Y129.030 E0.02893

G1 X80.381 Y128.741 E0.02118

G1 X79.654 Y128.277 E0.02248

G1 X79.100 Y127.749 E0.01992

G1 X78.607 Y127.038 E0.02256

G1 X78.127 Y125.706 E0.03689

M73 P18 R57

G1 X78.062 Y124.981 E0.01898

G1 X78.062 Y36.041 E2.31738

G1 X78.123 Y35.342 E0.01829

G1 X78.291 Y34.683 E0.01771

G1 X78.605 Y33.974 E0.02022

G1 X79.072 Y33.306 E0.02124

G1 X79.704 Y32.707 E0.02270

G1 X80.361 Y32.291 E0.02025

G1 X80.883 Y32.070 E0.01476

M204 S1250

G1 X80.720 Y31.685 F9000.000

M204 S800

G1 F1800.000

G1 X80.815 Y31.645 E0.00268

G1 X81.871 Y31.435 E0.02808

G1 X82.250 Y31.414 E0.00989

G1 X92.233 Y31.414 E0.26012

G1 X93.047 Y31.493 E0.02130

G1 X93.913 Y31.737 E0.02344

G1 X94.727 Y32.153 E0.02381

G1 X95.432 Y32.710 E0.02342

G1 X95.987 Y33.354 E0.02214

G1 X96.439 Y34.145 E0.02374

G1 X96.645 Y34.680 E0.01493

G1 X96.810 Y35.485 E0.02141

G1 X96.844 Y36.020 E0.01399

G1 X96.844 Y124.999 E2.31842

G1 X96.774 Y125.794 E0.02079

G1 X96.237 Y127.275 E0.04105

G1 X95.708 Y128.022 E0.02384

G1 X95.093 Y128.608 E0.02213

G1 X94.324 Y129.101 E0.02381

G1 X93.452 Y129.437 E0.02435

G1 X92.228 Y129.608 E0.03219

G1 X82.211 Y129.604 E0.26102

G1 X81.036 Y129.437 E0.03091

G1 X80.193 Y129.116 E0.02351

G1 X79.395 Y128.607 E0.02466

G1 X78.781 Y128.023 E0.02209

G1 X78.232 Y127.231 E0.02510

G1 X77.716 Y125.797 E0.03972

G1 X77.644 Y124.999 E0.02087

G1 X77.644 Y36.023 E2.31834

G1 X77.710 Y35.272 E0.01965

G1 X77.895 Y34.546 E0.01951

G1 X78.240 Y33.768 E0.02219

G1 X78.754 Y33.032 E0.02339

G1 X79.446 Y32.375 E0.02486

G1 X80.167 Y31.920 E0.02221

G1 X80.665 Y31.709 E0.01409

M204 S1250

G1 X80.804 Y31.745 F9000.000

G1 X80.421 Y32.402

M204 S1000

G1 F4800.000

G1 X78.658 Y34.165 E0.06532

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X79.821 Y33.002 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.450 F9000.000

G1 X84.367 Y35.110

G1 Z1.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.106 Y34.920 E0.00841

G1 X83.658 Y34.719 E0.01281

G1 X83.210 Y34.607 E0.01204

G1 X82.761 Y34.585 E0.01169

G1 X82.313 Y34.702 E0.01207

G1 X81.865 Y35.064 E0.01502

G1 X80.968 Y36.119 E0.03607

G1 X80.520 Y36.444 E0.01443

G1 X80.071 Y36.646 E0.01281

G1 X79.623 Y36.758 E0.01204

G1 X79.407 Y36.768 E0.00564

G1 X79.407 Y39.874 E0.08092

G1 X79.623 Y40.031 E0.00696

G1 X80.071 Y40.232 E0.01281

G1 X80.520 Y40.344 E0.01204

G1 X80.968 Y40.366 E0.01169

G1 X81.416 Y40.249 E0.01207

G1 X81.865 Y39.887 E0.01502

G1 X82.761 Y38.832 E0.03607

G1 X83.210 Y38.507 E0.01443

G1 X83.658 Y38.305 E0.01281

G1 X84.014 Y38.217 E0.00956

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.658 Y38.305 E-0.20336

G1 X83.210 Y38.507 E-0.27239

G1 X82.761 Y38.832 E-0.30685

G1 X82.610 Y39.010 E-0.12940

G1 E-0.04800 F4200.00000

G1 Z1.450 F9000.000

G1 X95.081 Y36.288

G1 Z1.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.865 Y36.444 E0.00696

G1 X94.417 Y36.646 E0.01281

G1 X93.968 Y36.758 E0.01204

G1 X93.520 Y36.780 E0.01169

G1 X93.072 Y36.663 E0.01207

G1 X92.624 Y36.300 E0.01502

G1 X91.727 Y35.245 E0.03607

G1 X91.279 Y34.920 E0.01443

G1 X90.830 Y34.719 E0.01281

G1 X90.382 Y34.607 E0.01204

G1 X89.934 Y34.585 E0.01169

G1 X89.755 Y34.632 E0.00482

G1 X89.935 Y34.831 E0.00700

G1 X90.298 Y35.375 E0.01705

G1 X90.559 Y36.004 E0.01773

G1 X90.690 Y36.670 E0.01768

G1 X90.690 Y37.347 E0.01764

G1 X90.559 Y38.013 E0.01768

G1 X90.342 Y38.536 E0.01476

G1 X90.830 Y38.305 E0.01407

G1 X91.279 Y38.194 E0.01204

G1 X91.727 Y38.172 E0.01169

G1 X92.175 Y38.288 E0.01207

G1 X92.624 Y38.651 E0.01502

G1 X93.520 Y39.706 E0.03607

G1 X93.968 Y40.031 E0.01443

G1 X94.417 Y40.232 E0.01281

G1 X94.865 Y40.344 E0.01204

G1 X95.081 Y40.355 E0.00564

G1 X95.081 Y43.460 E0.08092

G1 X94.865 Y43.617 E0.00696

G1 X94.417 Y43.819 E0.01281

G1 X93.968 Y43.930 E0.01204

G1 X93.520 Y43.952 E0.01169

G1 X93.072 Y43.836 E0.01207

G1 X92.624 Y43.473 E0.01502

G1 X91.727 Y42.418 E0.03607

G1 X91.279 Y42.093 E0.01443

G1 X90.830 Y41.891 E0.01281

G1 X90.382 Y41.780 E0.01204

G1 X89.934 Y41.758 E0.01169

G1 X89.486 Y41.874 E0.01207

G1 X89.037 Y42.237 E0.01502

G1 X88.141 Y43.292 E0.03607

G1 X87.692 Y43.617 E0.01443

G1 X87.244 Y43.819 E0.01281

G1 X86.796 Y43.930 E0.01204

G1 X86.348 Y43.952 E0.01169

G1 X85.899 Y43.836 E0.01207

G1 X85.451 Y43.473 E0.01502

G1 X84.554 Y42.418 E0.03607

G1 X84.106 Y42.093 E0.01443

G1 X83.658 Y41.891 E0.01281

G1 X83.210 Y41.780 E0.01204

G1 X82.761 Y41.758 E0.01169

G1 X82.313 Y41.874 E0.01207

G1 X81.865 Y42.237 E0.01502

G1 X80.968 Y43.292 E0.03607

G1 X80.520 Y43.617 E0.01443

G1 X80.071 Y43.819 E0.01281

G1 X79.623 Y43.930 E0.01204

G1 X79.407 Y43.941 E0.00564

G1 X79.407 Y47.047 E0.08092

G1 X79.623 Y47.203 E0.00696

G1 X80.071 Y47.405 E0.01281

G1 X80.520 Y47.517 E0.01204

G1 X80.968 Y47.539 E0.01169

G1 X81.416 Y47.422 E0.01207

G1 X81.865 Y47.059 E0.01502

G1 X82.761 Y46.004 E0.03607

G1 X83.210 Y45.679 E0.01443

G1 X83.658 Y45.478 E0.01281

G1 X84.106 Y45.366 E0.01204

G1 X84.554 Y45.344 E0.01169

G1 X85.003 Y45.461 E0.01207

G1 X85.451 Y45.823 E0.01502

G1 X86.348 Y46.878 E0.03607

G1 X86.796 Y47.203 E0.01443

G1 X87.244 Y47.405 E0.01281

G1 X87.692 Y47.517 E0.01204

G1 X88.141 Y47.539 E0.01169

G1 X88.589 Y47.422 E0.01207

G1 X89.037 Y47.059 E0.01502

G1 X89.934 Y46.004 E0.03607

G1 X90.382 Y45.679 E0.01443

G1 X90.830 Y45.478 E0.01281

G1 X91.279 Y45.366 E0.01204

G1 X91.727 Y45.344 E0.01169

G1 X92.175 Y45.461 E0.01207

G1 X92.624 Y45.823 E0.01502

G1 X93.520 Y46.878 E0.03607

G1 X93.968 Y47.203 E0.01443

G1 X94.417 Y47.405 E0.01281

G1 X94.865 Y47.517 E0.01204

G1 X95.081 Y47.527 E0.00564

G1 X95.081 Y50.633 E0.08092

G1 X94.865 Y50.790 E0.00696

G1 X94.417 Y50.991 E0.01281

G1 X93.968 Y51.103 E0.01204

G1 X93.520 Y51.125 E0.01169

G1 X93.072 Y51.008 E0.01207

G1 X92.624 Y50.646 E0.01502

G1 X91.727 Y49.591 E0.03607

G1 X91.279 Y49.266 E0.01443

G1 X90.830 Y49.064 E0.01281

G1 X90.382 Y48.953 E0.01204

G1 X89.934 Y48.931 E0.01169

G1 X89.486 Y49.047 E0.01207

G1 X89.037 Y49.410 E0.01503

G1 X88.141 Y50.465 E0.03607

G1 X87.692 Y50.790 E0.01443

G1 X87.244 Y50.991 E0.01281

G1 X86.796 Y51.103 E0.01204

G1 X86.348 Y51.125 E0.01169

G1 X85.899 Y51.008 E0.01207

G1 X85.451 Y50.646 E0.01502

G1 X84.554 Y49.591 E0.03607

G1 X84.106 Y49.266 E0.01443

G1 X83.658 Y49.064 E0.01281

G1 X83.210 Y48.953 E0.01204

G1 X82.761 Y48.931 E0.01169

G1 X82.313 Y49.047 E0.01207

G1 X81.865 Y49.410 E0.01502

G1 X80.968 Y50.465 E0.03607

G1 X80.520 Y50.790 E0.01443

G1 X80.071 Y50.991 E0.01281

G1 X79.623 Y51.103 E0.01204

G1 X79.407 Y51.113 E0.00564

G1 X79.407 Y54.219 E0.08092

G1 X79.623 Y54.376 E0.00696

G1 X80.071 Y54.578 E0.01281

G1 X80.520 Y54.689 E0.01204

G1 X80.968 Y54.711 E0.01169

G1 X81.416 Y54.595 E0.01207

G1 X81.865 Y54.232 E0.01502

G1 X82.761 Y53.177 E0.03607

G1 X83.210 Y52.852 E0.01443

G1 X83.658 Y52.650 E0.01281

G1 X84.106 Y52.539 E0.01204

G1 X84.554 Y52.517 E0.01169

G1 X85.003 Y52.633 E0.01207

G1 X85.451 Y52.996 E0.01502

G1 X86.348 Y54.051 E0.03607

G1 X86.796 Y54.376 E0.01443

G1 X87.244 Y54.578 E0.01281

G1 X87.692 Y54.689 E0.01204

G1 X88.141 Y54.711 E0.01169

G1 X88.589 Y54.595 E0.01207

G1 X89.037 Y54.232 E0.01502

G1 X89.934 Y53.177 E0.03607

G1 X90.382 Y52.852 E0.01443

G1 X90.830 Y52.650 E0.01281

G1 X91.279 Y52.539 E0.01204

G1 X91.727 Y52.517 E0.01169

G1 X92.175 Y52.633 E0.01207

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G1 X95.777 Y34.460 E0.00817

G1 X95.707 Y34.339 E0.00366

G1 X95.247 Y34.798 E0.01703

G1 X95.184 Y34.633 E0.00463

G1 X95.046 Y34.405 E0.00697

G1 X95.491 Y33.961 E0.01647

G1 X95.387 Y33.778 E0.00551

G1 X95.245 Y33.613 E0.00570

G1 X94.819 Y34.039 E0.01577

G1 X94.535 Y33.729 E0.01101

G1 X94.970 Y33.294 E0.01609

G1 X94.924 Y33.241 E0.00185

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G1 X93.019 Y32.870 E0.01244

G1 X93.506 Y32.382 E0.01807

G1 X93.043 Y32.252 E0.01261

G1 X92.503 Y32.792 E0.02001

G1 X92.208 Y32.759 E0.00778

G1 X91.941 Y32.759 E0.00697

G1 X92.524 Y32.177 E0.02156

G1 X92.198 Y32.145 E0.00857

G1 X91.961 Y32.145 E0.00619

G1 X91.348 Y32.759 E0.02273

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G1 X91.368 Y32.145 E0.02273

G1 X90.774 Y32.145 E0.01555

G1 X90.160 Y32.759 E0.02273

G1 X89.566 Y32.759 E0.01555

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G1 X89.586 Y32.145 E0.01555

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G1 X84.835 Y32.145 E0.01555

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G1 X83.627 Y32.759 E0.01555

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G1 X81.820 Y32.191 E0.03182

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G1 Z1.250

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M204 S1000

G1 F4800.000

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G1 X82.313 Y120.773 E0.01502

G1 X82.761 Y120.657 E0.01207

G1 X83.210 Y120.679 E0.01169

G1 X83.658 Y120.790 E0.01204

G1 X84.106 Y120.992 E0.01281

G1 X84.554 Y121.317 E0.01443

G1 X84.778 Y121.580 E0.00898

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;1.4

G1 Z1.400 F9000.000

;AFTER\_LAYER\_CHANGE

;1.4

G1 X85.017 Y121.781

M204 S800

G1 F1500.000

G1 X85.496 Y121.390 E0.01610

G1 X86.039 Y121.099 E0.01607

G1 X86.628 Y120.921 E0.01603

G1 X87.160 Y120.865 E0.01394

G1 X87.546 Y120.877 E0.01005

G1 X87.873 Y120.925 E0.00861

G1 X88.449 Y121.099 E0.01568

G1 X88.993 Y121.390 E0.01606

G1 X89.471 Y121.781 E0.01610

G1 X89.862 Y122.260 E0.01610

G1 X90.153 Y122.804 E0.01607

G1 X90.332 Y123.395 E0.01609

G1 X90.392 Y124.008 E0.01607

G1 X90.332 Y124.622 E0.01607

G1 X90.153 Y125.213 E0.01609

G1 X89.862 Y125.757 E0.01606

G1 X89.471 Y126.235 E0.01610

G1 X88.993 Y126.627 E0.01611

G1 X88.449 Y126.917 E0.01607

G1 X87.858 Y127.096 E0.01607

G1 X87.244 Y127.157 E0.01608

G1 X86.630 Y127.096 E0.01609

G1 X86.039 Y126.917 E0.01608

G1 X85.496 Y126.627 E0.01606

G1 X85.017 Y126.235 E0.01611

G1 X84.626 Y125.757 E0.01610

G1 X84.335 Y125.213 E0.01607

G1 X84.157 Y124.623 E0.01607

G1 X84.095 Y124.008 E0.01608

G1 X84.157 Y123.394 E0.01609

G1 X84.335 Y122.803 E0.01608

G1 X84.626 Y122.260 E0.01606

G1 X84.979 Y121.828 E0.01454

M204 S1250

G1 X85.303 Y122.093 F9000.000

M204 S800

G1 F1500.000

G1 X85.729 Y121.739 E0.01442

G1 X86.200 Y121.487 E0.01392

G1 X86.711 Y121.333 E0.01392

G1 X87.176 Y121.284 E0.01218

G1 X87.509 Y121.294 E0.00868

G1 X87.781 Y121.334 E0.00717

G1 X88.289 Y121.487 E0.01380

G1 X88.760 Y121.739 E0.01392

G1 X89.174 Y122.078 E0.01395

G1 X89.513 Y122.493 E0.01395

G1 X89.765 Y122.964 E0.01392

G1 X89.920 Y123.476 E0.01394

G1 X89.972 Y124.008 E0.01393

G1 X89.920 Y124.540 E0.01393

G1 X89.765 Y125.053 E0.01395

G1 X89.513 Y125.524 E0.01392

G1 X89.174 Y125.938 E0.01395

G1 X88.760 Y126.277 E0.01395

G1 X88.288 Y126.529 E0.01392

G1 X87.776 Y126.684 E0.01394

G1 X87.244 Y126.737 E0.01394

G1 X86.712 Y126.684 E0.01394

G1 X86.200 Y126.529 E0.01394

G1 X85.729 Y126.277 E0.01392

G1 X85.314 Y125.938 E0.01395

G1 X84.975 Y125.524 E0.01395

G1 X84.723 Y125.052 E0.01392

G1 X84.568 Y124.540 E0.01394

G1 X84.515 Y124.008 E0.01394

G1 X84.568 Y123.476 E0.01394

G1 X84.723 Y122.964 E0.01394

G1 X84.975 Y122.493 E0.01392

G1 X85.265 Y122.139 E0.01191

M204 S1250

G1 X85.197 Y121.707 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.729 Y121.739 E-0.33938

G1 X86.200 Y121.487 E-0.29614

G1 X86.677 Y121.343 E-0.27648

G1 E-0.04800 F4200.00000

G1 Z1.600 F9000.000

G1 X86.936 Y40.141

G1 Z1.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.331 Y40.022 E0.01607

G1 X85.759 Y39.785 E0.01612

G1 X85.260 Y39.451 E0.01565

G1 X85.019 Y39.233 E0.00846

G1 X84.802 Y38.992 E0.00846

G1 X84.467 Y38.493 E0.01566

G1 X84.231 Y37.921 E0.01611

G1 X84.115 Y37.333 E0.01563

G1 X84.097 Y37.008 E0.00847

G1 X84.115 Y36.683 E0.00848

G1 X84.231 Y36.095 E0.01562

G1 X84.468 Y35.524 E0.01612

G1 X84.802 Y35.024 E0.01565

G1 X85.019 Y34.783 E0.00846

G1 X85.260 Y34.566 E0.00846

G1 X85.760 Y34.232 E0.01566

G1 X86.317 Y34.001 E0.01571

G1 X86.637 Y33.921 E0.00860

G1 X87.020 Y33.872 E0.01005

G1 X87.554 Y33.876 E0.01394

G1 X88.157 Y33.995 E0.01601

G1 X88.729 Y34.232 E0.01612

G1 X89.228 Y34.566 E0.01565

G1 X89.469 Y34.783 E0.00846

G1 X89.687 Y35.024 E0.00846

G1 X90.021 Y35.524 E0.01566

G1 X90.257 Y36.095 E0.01611

G1 X90.377 Y36.700 E0.01607

G1 X90.377 Y37.316 E0.01605

G1 X90.257 Y37.921 E0.01607

G1 X90.021 Y38.493 E0.01612

G1 X89.687 Y38.992 E0.01565

G1 X89.469 Y39.233 E0.00846

G1 X89.228 Y39.451 E0.00846

G1 X88.729 Y39.785 E0.01566

G1 X88.157 Y40.022 E0.01611

G1 X87.552 Y40.141 E0.01607

G1 X86.996 Y40.141 E0.01448

M204 S1250

G1 X86.996 Y39.723 F9000.000

M204 S800

G1 F1500.000

G1 X86.453 Y39.620 E0.01442

G1 X85.957 Y39.415 E0.01396

G1 X85.518 Y39.120 E0.01379

G1 X85.315 Y38.938 E0.00711

G1 X85.132 Y38.735 E0.00711

G1 X84.838 Y38.295 E0.01380

G1 X84.633 Y37.800 E0.01396

G1 X84.530 Y37.281 E0.01377

G1 X84.516 Y37.008 E0.00712

G1 X84.530 Y36.735 E0.00712

G1 X84.633 Y36.217 E0.01377

G1 X84.838 Y35.722 E0.01396

G1 X85.132 Y35.282 E0.01379

G1 X85.315 Y35.079 E0.00711

G1 X85.518 Y34.896 E0.00711

G1 X85.958 Y34.602 E0.01380

G1 X86.448 Y34.399 E0.01382

G1 X86.714 Y34.333 E0.00716

G1 X87.045 Y34.290 E0.00868

G1 X87.512 Y34.293 E0.01217

G1 X88.036 Y34.397 E0.01390

G1 X88.531 Y34.602 E0.01396

G1 X88.971 Y34.896 E0.01379

G1 X89.173 Y35.079 E0.00711

G1 X89.356 Y35.282 E0.00711

G1 X89.651 Y35.722 E0.01380

G1 X89.856 Y36.217 E0.01396

G1 X89.959 Y36.741 E0.01393

G1 X89.959 Y37.275 E0.01392

G1 X89.856 Y37.800 E0.01393

G1 X89.650 Y38.295 E0.01396

G1 X89.356 Y38.735 E0.01379

G1 X89.173 Y38.938 E0.00711

G1 X88.971 Y39.120 E0.00711

G1 X88.531 Y39.415 E0.01380

G1 X88.036 Y39.620 E0.01396

G1 X87.511 Y39.723 E0.01393

G1 X87.056 Y39.723 E0.01186

M204 S1250

G1 X86.765 Y40.050 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.453 Y39.620 E-0.33934

G1 X85.957 Y39.415 E-0.29698

G1 X85.544 Y39.138 E-0.27568

G1 E-0.04800 F4200.00000

G1 Z1.600 F9000.000

G1 X81.000 Y32.185

G1 Z1.400

G1 E3.20000 F2400.00000

M204 S800

G1 X81.899 Y32.006 E0.02389

G1 X82.265 Y31.982 E0.00956

G1 X92.212 Y31.982 E0.25919

G1 X92.960 Y32.056 E0.01957

G1 X93.718 Y32.272 E0.02054

G1 X94.439 Y32.647 E0.02119

G1 X95.055 Y33.140 E0.02055

G1 X95.512 Y33.669 E0.01821

G1 X95.919 Y34.376 E0.02124

G1 X96.099 Y34.842 E0.01304

G1 X96.248 Y35.585 E0.01972

G1 X96.276 Y36.034 E0.01172

G1 X96.276 Y124.981 E2.31759

M73 P20 R56

G1 X96.214 Y125.683 E0.01836

G1 X95.735 Y127.003 E0.03659

G1 X95.266 Y127.661 E0.02106

G1 X94.761 Y128.143 E0.01819

G1 X94.079 Y128.586 E0.02120

G1 X93.289 Y128.890 E0.02203

G1 X92.200 Y129.040 E0.02865

G1 X82.198 Y129.032 E0.26060

G1 X81.198 Y128.890 E0.02633

G1 X80.457 Y128.611 E0.02064

G1 X79.816 Y128.211 E0.01968

G1 X79.219 Y127.657 E0.02122

G1 X78.734 Y126.965 E0.02202

G1 X78.277 Y125.691 E0.03526

G1 X78.212 Y124.980 E0.01859

G1 X78.212 Y36.041 E2.31737

G1 X78.277 Y35.313 E0.01906

G1 X78.441 Y34.710 E0.01628

G1 X78.728 Y34.062 E0.01847

G1 X79.174 Y33.418 E0.02041

G1 X79.819 Y32.809 E0.02313

G1 X80.415 Y32.432 E0.01836

G1 X80.944 Y32.208 E0.01497

M204 S1250

G1 X80.782 Y31.823 F9000.000

M204 S800

G1 F1800.000

G1 X80.876 Y31.783 E0.00267

G1 X81.844 Y31.591 E0.02572

G1 X82.251 Y31.564 E0.01063

G1 X92.233 Y31.564 E0.26008

G1 X93.038 Y31.644 E0.02108

G1 X93.873 Y31.882 E0.02262

G1 X94.668 Y32.295 E0.02336

G1 X95.347 Y32.838 E0.02262

G1 X95.854 Y33.426 E0.02025

G1 X96.297 Y34.195 E0.02312

G1 X96.502 Y34.725 E0.01481

G1 X96.663 Y35.530 E0.02138

G1 X96.694 Y36.020 E0.01280

G1 X96.694 Y124.999 E2.31842

G1 X96.624 Y125.779 E0.02040

G1 X96.108 Y127.199 E0.03935

G1 X95.584 Y127.936 E0.02358

G1 X95.021 Y128.472 E0.02024

G1 X94.270 Y128.960 E0.02336

G1 X93.394 Y129.297 E0.02443

G1 X92.229 Y129.458 E0.03066

G1 X82.169 Y129.450 E0.26212

G1 X81.094 Y129.297 E0.02830

G1 X80.271 Y128.987 E0.02291

G1 X79.561 Y128.545 E0.02180

G1 X78.904 Y127.935 E0.02336

G1 X78.404 Y127.239 E0.02232

G1 X78.349 Y127.131 E0.00316

G1 X77.865 Y125.782 E0.03734

G1 X77.794 Y124.999 E0.02048

G1 X77.794 Y36.023 E2.31834

G1 X77.866 Y35.234 E0.02064

G1 X78.046 Y34.570 E0.01794

G1 X78.362 Y33.856 E0.02033

G1 X78.855 Y33.144 E0.02257

G1 X79.562 Y32.477 E0.02532

G1 X80.221 Y32.060 E0.02031

G1 X80.726 Y31.847 E0.01430

M204 S1250

G1 X80.865 Y31.883 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.876 Y31.783 E-0.09011

G1 X81.844 Y31.591 E-0.54693

G1 X82.251 Y31.564 E-0.22617

G1 X82.339 Y31.564 E-0.04879

G1 E-0.04800 F4200.00000

G1 Z1.600 F9000.000

G1 X83.827 Y34.811

G1 Z1.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.658 Y34.751 E0.00466

G1 X83.210 Y34.685 E0.01181

G1 X82.761 Y34.714 E0.01171

G1 X82.313 Y34.885 E0.01251

G1 X81.865 Y35.264 E0.01528

G1 X80.968 Y36.185 E0.03349

G1 X80.520 Y36.456 E0.01366

G1 X80.071 Y36.614 E0.01238

G1 X79.557 Y36.676 E0.01351

G1 X79.557 Y40.003 E0.08667

G1 X79.623 Y40.043 E0.00202

G1 X80.071 Y40.200 E0.01238

G1 X80.520 Y40.267 E0.01181

G1 X80.968 Y40.237 E0.01171

G1 X81.416 Y40.066 E0.01251

G1 X81.865 Y39.688 E0.01528

G1 X82.761 Y38.766 E0.03349

G1 X83.210 Y38.495 E0.01366

G1 X83.434 Y38.416 E0.00621

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.210 Y38.495 E-0.13210

G1 X82.761 Y38.766 E-0.29045

G1 X82.145 Y39.399 E-0.48945

G1 E-0.04800 F4200.00000

G1 Z1.600 F9000.000

G1 X86.000 Y33.996

G1 Z1.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X85.708 Y33.704 E0.01077

G1 X85.324 Y33.912 E0.01140

G1 X85.464 Y34.052 E0.00519

G1 X85.110 Y34.289 E0.01113

G1 X84.975 Y34.155 E0.00496

G1 X84.667 Y34.427 E0.01072

G1 X84.794 Y34.565 E0.00489

G1 X84.520 Y34.882 E0.01095

G1 X84.385 Y34.748 E0.00498

G1 X84.142 Y35.097 E0.01109

G1 X84.282 Y35.237 E0.00517

G1 X84.190 Y35.375 E0.00434

G1 X84.084 Y35.630 E0.00721

G1 X83.936 Y35.482 E0.00548

G1 X83.873 Y35.615 E0.00384

G1 X83.769 Y35.907 E0.00808

G1 X83.919 Y36.057 E0.00555

G1 X83.821 Y36.551 E0.01314

G1 X83.654 Y36.383 E0.00619

G1 X83.615 Y36.647 E0.00697

G1 X83.601 Y36.922 E0.00718

G1 X83.789 Y37.110 E0.00695

G1 X83.803 Y37.372 E0.00683

G1 X83.888 Y37.801 E0.01141

G1 X83.642 Y37.555 E0.00906

G1 X83.752 Y38.064 E0.01358

G1 X83.860 Y38.365 E0.00834

G1 X86.189 Y40.694 E0.08594

M204 S1250

G1 X86.183 Y40.096 F9000.000

M204 S1000

G1 F4800.000

G1 X86.697 Y40.610 E0.01898

G1 X86.890 Y40.639 E0.00509

G1 X87.330 Y40.652 E0.01149

G1 X87.133 Y40.454 E0.00728

G1 X87.583 Y40.454 E0.01173

G1 X87.701 Y40.431 E0.00316

G1 X87.869 Y40.599 E0.00619

G1 X87.959 Y40.585 E0.00237

G1 X88.346 Y40.484 E0.01044

G1 X88.195 Y40.333 E0.00555

G1 X88.622 Y40.168 E0.01193

G1 X88.770 Y40.317 E0.00548

G1 X89.156 Y40.110 E0.01140

G1 X89.015 Y39.970 E0.00517

G1 X89.370 Y39.733 E0.01113

G1 X89.505 Y39.868 E0.00498

G1 X89.820 Y39.591 E0.01094

G1 X89.687 Y39.459 E0.00488

G1 X89.963 Y39.143 E0.01094

G1 X90.098 Y39.277 E0.00496

G1 X90.275 Y39.037 E0.00778

G1 X90.341 Y38.929 E0.00332

G1 X90.200 Y38.788 E0.00519

G1 X90.298 Y38.641 E0.00460

G1 X90.400 Y38.396 E0.00693

G1 X90.548 Y38.544 E0.00546

G1 X90.716 Y38.120 E0.01189

G1 X90.567 Y37.971 E0.00550

G1 X90.665 Y37.477 E0.01314

G1 X90.833 Y37.645 E0.00621

G1 X90.874 Y37.369 E0.00728

G1 X90.887 Y37.108 E0.00683

G1 X90.690 Y36.911 E0.00726

G1 X90.690 Y36.670 E0.00630

G1 X90.604 Y36.233 E0.01161

G1 X91.065 Y36.694 E0.01699

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.604 Y36.233 E-0.36088

G1 X90.690 Y36.670 E-0.24657

G1 X90.690 Y36.911 E-0.13378

G1 X90.887 Y37.108 E-0.15421

G1 X90.885 Y37.138 E-0.01657

G1 E-0.04800 F4200.00000

G1 Z1.600 F9000.000

G1 X96.034 Y35.154

G1 Z1.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X93.382 Y32.503 E0.09784

G1 X92.901 Y32.365 E0.01306

G1 X92.626 Y32.338 E0.00721

G1 X93.448 Y33.160 E0.03033

G1 X92.904 Y32.988 E0.01489

G1 X92.656 Y32.960 E0.00650

G1 X91.992 Y32.295 E0.02452

G1 X91.400 Y32.295 E0.01544

G1 X92.014 Y32.909 E0.02265

G1 X91.422 Y32.909 E0.01544

G1 X90.808 Y32.295 E0.02265

G1 X90.216 Y32.295 E0.01544

G1 X90.830 Y32.909 E0.02265

G1 X90.239 Y32.909 E0.01544

G1 X89.625 Y32.295 E0.02265

G1 X89.033 Y32.295 E0.01544

G1 X89.647 Y32.909 E0.02265

G1 X89.055 Y32.909 E0.01544

G1 X88.441 Y32.295 E0.02265

G1 X87.850 Y32.295 E0.01544

G1 X88.684 Y33.129 E0.03077

G1 X88.599 Y33.619 E0.01296

G1 X88.961 Y33.790 E0.01045

G1 X89.267 Y33.973 E0.00933

G1 X89.555 Y34.186 E0.00935

G1 X89.826 Y34.431 E0.00952

G1 X90.066 Y34.697 E0.00934

G1 X90.279 Y34.985 E0.00936

G1 X90.462 Y35.292 E0.00932

G1 X90.636 Y35.674 E0.01094

G1 X87.258 Y32.295 E0.12465

G1 X86.666 Y32.295 E0.01544

G1 X88.019 Y33.648 E0.04992

G1 X87.586 Y33.563 E0.01151

G1 X87.340 Y33.561 E0.00642

G1 X86.075 Y32.295 E0.04670

G1 X85.483 Y32.295 E0.01544

G1 X86.775 Y33.588 E0.04768

G1 X86.579 Y33.613 E0.00516

G1 X86.282 Y33.687 E0.00798

G1 X84.891 Y32.295 E0.05133

G1 X84.299 Y32.295 E0.01544

G1 X84.913 Y32.909 E0.02265

G1 X84.322 Y32.909 E0.01544

G1 X83.708 Y32.295 E0.02265

G1 X83.116 Y32.295 E0.01544

G1 X83.730 Y32.909 E0.02265

G1 X83.138 Y32.909 E0.01544

G1 X82.524 Y32.295 E0.02265

G1 X82.275 Y32.295 E0.00650

G1 X81.953 Y32.316 E0.00841

G1 X82.546 Y32.909 E0.02188

G1 X82.279 Y32.909 E0.00697

G1 X81.986 Y32.940 E0.00770

G1 X81.458 Y32.413 E0.01946

G1 X81.092 Y32.486 E0.00975

G1 X80.985 Y32.531 E0.00303

G1 X81.474 Y33.020 E0.01803

G1 X81.376 Y33.039 E0.00258

G1 X81.042 Y33.180 E0.00948

G1 X80.569 Y32.707 E0.01744

G1 X80.205 Y32.935 E0.01120

G1 X80.641 Y33.371 E0.01607

G1 X80.297 Y33.618 E0.01106

G1 X79.870 Y33.192 E0.01574

G1 X79.566 Y33.479 E0.01092

G1 X79.984 Y33.897 E0.01544

G1 X79.822 Y34.082 E0.00642

G1 X79.726 Y34.231 E0.00462

G1 X79.292 Y33.797 E0.01599

G1 X79.050 Y34.147 E0.01110

G1 X79.493 Y34.590 E0.01634

G1 X79.374 Y34.859 E0.00769

G1 X79.326 Y35.014 E0.00424

G1 X78.857 Y34.545 E0.01733

G1 X78.738 Y34.813 E0.00766

G1 X78.696 Y34.976 E0.00437

G1 X79.196 Y35.476 E0.01846

G1 X79.142 Y36.013 E0.01410

G1 X78.578 Y35.450 E0.02078

G1 X78.531 Y35.994 E0.01425

G1 X79.139 Y36.602 E0.02245

G1 X79.139 Y37.194 E0.01544

G1 X78.525 Y36.580 E0.02265

G1 X78.525 Y37.172 E0.01544

G1 X79.139 Y37.786 E0.02265

G1 X79.139 Y38.377 E0.01544

G1 X78.525 Y37.764 E0.02265

G1 X78.525 Y38.355 E0.01544

G1 X79.139 Y38.969 E0.02265

G1 X79.139 Y39.561 E0.01544

G1 X78.525 Y38.947 E0.02265

G1 X78.525 Y39.539 E0.01544

G1 X79.139 Y40.153 E0.02265

G1 X79.139 Y40.744 E0.01544

G1 X78.525 Y40.131 E0.02265

G1 X78.525 Y40.722 E0.01544

G1 X79.139 Y41.336 E0.02265

G1 X79.139 Y41.928 E0.01544

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M204 S1000

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G1 X90.109 Y121.124 E0.01112

G1 X90.395 Y121.440 E0.01111

G1 X90.632 Y121.762 E0.01042

G1 X90.823 Y122.080 E0.00967

G1 X90.995 Y122.439 E0.01038

G1 X91.139 Y122.842 E0.01113

G1 X91.234 Y123.229 E0.01040

G1 X91.291 Y123.623 E0.01037

G1 X91.310 Y123.994 E0.00968

G1 X91.294 Y124.343 E0.00910

G1 X91.727 Y124.372 E0.01132

G1 X92.175 Y124.543 E0.01251

G1 X92.624 Y124.921 E0.01528

G1 X93.520 Y125.842 E0.03349

G1 X93.968 Y126.114 E0.01366

G1 X94.417 Y126.271 E0.01238

G1 X94.591 Y126.297 E0.00458

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X94.417 Y126.271 E-0.09740

G1 X93.968 Y126.114 E-0.26325

G1 X93.520 Y125.842 E-0.29045

G1 X93.192 Y125.505 E-0.26090

G1 E-0.04800 F4200.00000

G1 Z1.600 F9000.000

G1 X88.503 Y127.030

G1 Z1.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.783 Y127.310 E0.01034

G1 X88.960 Y127.227 E0.00511

G1 X89.168 Y127.103 E0.00630

G1 X89.028 Y126.963 E0.00516

G1 X89.167 Y126.888 E0.00413

G1 X89.375 Y126.719 E0.00700

G1 X89.516 Y126.859 E0.00520

G1 X89.826 Y126.585 E0.01080

G1 X89.699 Y126.451 E0.00481

G1 X89.965 Y126.126 E0.01097

G1 X90.106 Y126.266 E0.00518

G1 X90.348 Y125.916 E0.01109

G1 X90.207 Y125.776 E0.00519

G1 X90.414 Y125.390 E0.01141

G1 X90.554 Y125.531 E0.00519

G1 X90.721 Y125.106 E0.01191

G1 X90.561 Y124.946 E0.00590

G1 X90.640 Y124.683 E0.00717

G1 X90.663 Y124.456 E0.00595

G1 X90.835 Y124.629 E0.00636

G1 X90.874 Y124.363 E0.00702

G1 X90.888 Y124.090 E0.00713

G1 X90.696 Y123.898 E0.00708

G1 X90.641 Y123.333 E0.01479

G1 X90.605 Y123.214 E0.00324

G1 X91.064 Y123.673 E0.01694

M204 S1250

G1 X90.928 Y122.946 F9000.000

M204 S1000

G1 F4800.000

G1 X88.609 Y120.627 E0.08557

G1 X88.300 Y120.517 E0.00857

G1 X87.797 Y120.407 E0.01341

G1 X88.038 Y120.648 E0.00888

G1 X87.574 Y120.564 E0.01230

G1 X87.356 Y120.558 E0.00568

G1 X87.168 Y120.370 E0.00693

G1 X86.625 Y120.419 E0.01423

G1 X86.795 Y120.589 E0.00628

G1 X86.566 Y120.613 E0.00601

G1 X86.306 Y120.691 E0.00708

G1 X86.146 Y120.531 E0.00590

G1 X85.721 Y120.698 E0.01191

G1 X85.862 Y120.839 E0.00519

G1 X85.476 Y121.045 E0.01141

G1 X85.336 Y120.904 E0.00519

G1 X84.986 Y121.147 E0.01109

G1 X85.127 Y121.287 E0.00518

G1 X84.801 Y121.553 E0.01097

G1 X84.671 Y121.423 E0.00481

G1 X84.393 Y121.736 E0.01094

G1 X84.534 Y121.877 E0.00520

G1 X84.364 Y122.085 E0.00700

G1 X84.289 Y122.225 E0.00413

G1 X84.149 Y122.085 E0.00516

G1 X83.942 Y122.469 E0.01139

G1 X84.083 Y122.610 E0.00521

G1 X84.044 Y122.683 E0.00216

G1 X83.933 Y123.052 E0.01005

G1 X83.774 Y122.892 E0.00587

G1 X83.752 Y122.953 E0.00167

G1 X83.656 Y123.367 E0.01109

G1 X83.827 Y123.538 E0.00632

G1 X83.780 Y124.008 E0.01234

G1 X83.788 Y124.090 E0.00216

G1 X83.602 Y123.904 E0.00689

G1 X83.614 Y124.362 E0.01196

G1 X83.639 Y124.533 E0.00450

G1 X84.154 Y125.048 E0.01903

M204 S1250

G1 X83.221 Y124.562 F9000.000

M204 S1000

G1 F4800.000

G1 X82.761 Y124.838 E0.01396

G1 X81.865 Y125.759 E0.03349

G1 X81.416 Y126.137 E0.01528

G1 X80.968 Y126.309 E0.01251

G1 X80.520 Y126.338 E0.01171

G1 X80.071 Y126.271 E0.01181

G1 X79.853 Y126.195 E0.00602

G1 X79.613 Y125.507 E0.01899

G1 X79.557 Y124.954 E0.01448

G1 X79.557 Y122.747 E0.05750

G1 X80.071 Y122.685 E0.01351

G1 X80.520 Y122.528 E0.01238

G1 X80.968 Y122.256 E0.01366

G1 X81.865 Y121.335 E0.03349

G1 X82.313 Y120.957 E0.01528

G1 X82.761 Y120.785 E0.01251

G1 X83.210 Y120.756 E0.01171

G1 X83.658 Y120.823 E0.01181

G1 X84.106 Y120.980 E0.01238

G1 X84.366 Y121.137 E0.00791

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;1.55

G1 Z1.550 F9000.000

;AFTER\_LAYER\_CHANGE

;1.55

G1 X85.017 Y121.781

M204 S800

G1 F1500.000

G1 X85.496 Y121.390 E0.01610

G1 X86.039 Y121.099 E0.01607

G1 X86.629 Y120.921 E0.01605

G1 X87.184 Y120.864 E0.01454

G1 X87.548 Y120.877 E0.00949

G1 X87.873 Y120.925 E0.00856

G1 X88.449 Y121.099 E0.01568

G1 X88.993 Y121.390 E0.01606

G1 X89.471 Y121.781 E0.01610

G1 X89.862 Y122.260 E0.01610

G1 X90.153 Y122.804 E0.01607

G1 X90.332 Y123.395 E0.01609

G1 X90.392 Y124.008 E0.01607

G1 X90.332 Y124.622 E0.01607

G1 X90.153 Y125.213 E0.01609

G1 X89.862 Y125.757 E0.01606

G1 X89.471 Y126.235 E0.01610

G1 X88.993 Y126.627 E0.01611

G1 X88.449 Y126.917 E0.01607

G1 X87.858 Y127.096 E0.01607

G1 X87.244 Y127.157 E0.01608

G1 X86.630 Y127.096 E0.01609

G1 X86.039 Y126.917 E0.01608

G1 X85.496 Y126.627 E0.01606

G1 X85.017 Y126.235 E0.01611

G1 X84.626 Y125.757 E0.01610

G1 X84.335 Y125.213 E0.01607

G1 X84.157 Y124.623 E0.01607

G1 X84.095 Y124.008 E0.01608

G1 X84.157 Y123.394 E0.01609

G1 X84.335 Y122.803 E0.01608

G1 X84.626 Y122.260 E0.01606

G1 X84.979 Y121.828 E0.01454

M204 S1250

G1 X85.303 Y122.093 F9000.000

M204 S800

G1 F1500.000

G1 X85.729 Y121.739 E0.01442

G1 X86.200 Y121.487 E0.01392

G1 X86.712 Y121.333 E0.01393

G1 X87.198 Y121.283 E0.01274

G1 X87.510 Y121.294 E0.00813

G1 X87.781 Y121.334 E0.00715

G1 X88.289 Y121.487 E0.01380

G1 X88.760 Y121.739 E0.01392

G1 X89.174 Y122.078 E0.01395

G1 X89.513 Y122.493 E0.01395

G1 X89.765 Y122.964 E0.01392

G1 X89.920 Y123.476 E0.01394

G1 X89.972 Y124.008 E0.01393

G1 X89.920 Y124.540 E0.01393

G1 X89.765 Y125.053 E0.01395

G1 X89.513 Y125.524 E0.01392

G1 X89.174 Y125.938 E0.01395

G1 X88.760 Y126.277 E0.01395

G1 X88.288 Y126.529 E0.01392

G1 X87.776 Y126.684 E0.01394

G1 X87.244 Y126.737 E0.01394

G1 X86.712 Y126.684 E0.01394

G1 X86.200 Y126.529 E0.01394

G1 X85.729 Y126.277 E0.01392

G1 X85.314 Y125.938 E0.01395

G1 X84.975 Y125.524 E0.01395

G1 X84.723 Y125.052 E0.01392

G1 X84.568 Y124.540 E0.01394

G1 X84.515 Y124.008 E0.01394

G1 X84.568 Y123.476 E0.01394

G1 X84.723 Y122.964 E0.01394

G1 X84.975 Y122.493 E0.01392

G1 X85.265 Y122.139 E0.01191

M204 S1250

G1 X85.197 Y121.707 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.729 Y121.739 E-0.33938

G1 X86.200 Y121.487 E-0.29615

G1 X86.677 Y121.343 E-0.27647

G1 E-0.04800 F4200.00000

G1 Z1.750 F9000.000

G1 X86.936 Y40.141

G1 Z1.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.331 Y40.022 E0.01607

G1 X85.759 Y39.785 E0.01612

G1 X85.260 Y39.451 E0.01565

G1 X85.019 Y39.233 E0.00846

G1 X84.802 Y38.992 E0.00846

G1 X84.467 Y38.493 E0.01566

G1 X84.231 Y37.921 E0.01611

G1 X84.115 Y37.333 E0.01563

G1 X84.097 Y37.008 E0.00847

G1 X84.115 Y36.683 E0.00848

G1 X84.231 Y36.095 E0.01562

G1 X84.468 Y35.524 E0.01612

G1 X84.802 Y35.024 E0.01565

G1 X85.019 Y34.783 E0.00846

G1 X85.260 Y34.566 E0.00846

G1 X85.760 Y34.232 E0.01566

G1 X86.317 Y34.001 E0.01571

G1 X86.635 Y33.922 E0.00855

G1 X86.996 Y33.873 E0.00948

G1 X87.554 Y33.876 E0.01453

G1 X88.157 Y33.995 E0.01603

G1 X88.729 Y34.232 E0.01612

G1 X89.228 Y34.566 E0.01565

G1 X89.469 Y34.783 E0.00846

G1 X89.687 Y35.024 E0.00846

G1 X90.021 Y35.524 E0.01566

G1 X90.257 Y36.095 E0.01611

G1 X90.377 Y36.700 E0.01607

G1 X90.377 Y37.316 E0.01605

G1 X90.257 Y37.921 E0.01607

G1 X90.021 Y38.493 E0.01612

G1 X89.687 Y38.992 E0.01565

G1 X89.469 Y39.233 E0.00846

G1 X89.228 Y39.451 E0.00846

G1 X88.729 Y39.785 E0.01566

G1 X88.157 Y40.022 E0.01611

G1 X87.552 Y40.141 E0.01607

M73 P21 R55

G1 X86.996 Y40.141 E0.01448

M204 S1250

G1 X86.996 Y39.723 F9000.000

M204 S800

G1 F1500.000

G1 X86.453 Y39.620 E0.01442

G1 X85.957 Y39.415 E0.01396

G1 X85.518 Y39.120 E0.01379

G1 X85.315 Y38.938 E0.00711

G1 X85.132 Y38.735 E0.00711

G1 X84.838 Y38.295 E0.01380

G1 X84.633 Y37.800 E0.01396

G1 X84.530 Y37.281 E0.01377

G1 X84.516 Y37.008 E0.00712

G1 X84.530 Y36.735 E0.00712

G1 X84.633 Y36.217 E0.01377

G1 X84.838 Y35.722 E0.01396

G1 X85.132 Y35.282 E0.01379

G1 X85.315 Y35.079 E0.00711

G1 X85.518 Y34.896 E0.00711

G1 X85.958 Y34.602 E0.01380

G1 X86.448 Y34.399 E0.01382

G1 X86.714 Y34.333 E0.00715

G1 X87.023 Y34.291 E0.00813

G1 X87.512 Y34.293 E0.01274

G1 X88.036 Y34.397 E0.01391

G1 X88.531 Y34.602 E0.01397

G1 X88.971 Y34.896 E0.01379

G1 X89.173 Y35.079 E0.00711

G1 X89.356 Y35.282 E0.00711

G1 X89.651 Y35.722 E0.01380

G1 X89.856 Y36.217 E0.01396

G1 X89.959 Y36.741 E0.01393

G1 X89.959 Y37.275 E0.01392

G1 X89.856 Y37.800 E0.01393

G1 X89.650 Y38.295 E0.01396

G1 X89.356 Y38.735 E0.01379

G1 X89.173 Y38.938 E0.00711

G1 X88.971 Y39.120 E0.00711

G1 X88.531 Y39.415 E0.01380

G1 X88.036 Y39.620 E0.01396

G1 X87.511 Y39.723 E0.01393

G1 X87.056 Y39.723 E0.01186

M204 S1250

G1 X86.765 Y40.050 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.453 Y39.620 E-0.33933

G1 X85.957 Y39.415 E-0.29698

G1 X85.544 Y39.138 E-0.27568

G1 E-0.04800 F4200.00000

G1 Z1.750 F9000.000

G1 X81.061 Y32.323

G1 Z1.550

G1 E3.20000 F2400.00000

M204 S800

G1 X81.873 Y32.161 E0.02157

G1 X82.268 Y32.132 E0.01031

G1 X92.212 Y32.132 E0.25910

G1 X92.950 Y32.207 E0.01933

G1 X93.682 Y32.419 E0.01986

G1 X94.267 Y32.713 E0.01706

G1 X94.947 Y33.241 E0.02245

G1 X95.380 Y33.742 E0.01725

G1 X95.777 Y34.426 E0.02061

G1 X95.955 Y34.888 E0.01289

G1 X96.101 Y35.629 E0.01969

G1 X96.126 Y36.034 E0.01056

G1 X96.126 Y124.981 E2.31760

G1 X96.064 Y125.668 E0.01796

G1 X95.607 Y126.926 E0.03488

G1 X95.142 Y127.575 E0.02080

G1 X94.670 Y128.025 E0.01699

G1 X94.029 Y128.444 E0.01996

G1 X93.232 Y128.750 E0.02223

G1 X92.201 Y128.890 E0.02713

G1 X82.156 Y128.878 E0.26172

G1 X81.254 Y128.750 E0.02375

G1 X80.534 Y128.482 E0.02003

G1 X79.906 Y128.094 E0.01922

G1 X79.345 Y127.574 E0.01993

G1 X78.905 Y126.967 E0.01952

G1 X78.846 Y126.850 E0.00343

G1 X78.426 Y125.676 E0.03249

G1 X78.362 Y124.980 E0.01822

G1 X78.362 Y36.041 E2.31736

G1 X78.427 Y35.324 E0.01876

G1 X78.545 Y34.871 E0.01219

G1 X78.854 Y34.145 E0.02056

G1 X79.280 Y33.525 E0.01961

G1 X79.909 Y32.927 E0.02261

G1 X80.469 Y32.573 E0.01727

G1 X81.006 Y32.346 E0.01519

M204 S1250

G1 X80.843 Y31.961 F9000.000

M204 S800

G1 F1800.000

G1 X80.938 Y31.921 E0.00267

G1 X81.817 Y31.746 E0.02335

G1 X82.252 Y31.714 E0.01138

G1 X92.233 Y31.714 E0.26005

G1 X93.029 Y31.795 E0.02086

G1 X93.835 Y32.028 E0.02185

G1 X94.473 Y32.349 E0.01861

G1 X94.605 Y32.433 E0.00408

G1 X95.254 Y32.956 E0.02171

G1 X95.722 Y33.499 E0.01867

G1 X96.155 Y34.245 E0.02249

G1 X96.358 Y34.771 E0.01470

G1 X96.516 Y35.576 E0.02135

G1 X96.544 Y36.020 E0.01161

G1 X96.544 Y124.999 E2.31842

G1 X96.474 Y125.764 E0.02001

G1 X95.980 Y127.122 E0.03766

G1 X95.459 Y127.850 E0.02332

G1 X94.943 Y128.342 E0.01858

G1 X94.217 Y128.819 E0.02263

G1 X93.337 Y129.157 E0.02457

G1 X92.229 Y129.308 E0.02914

G1 X82.127 Y129.296 E0.26322

G1 X81.151 Y129.157 E0.02568

G1 X80.349 Y128.859 E0.02229

G1 X79.668 Y128.437 E0.02088

G1 X79.545 Y128.342 E0.00404

G1 X79.029 Y127.850 E0.01859

G1 X78.548 Y127.186 E0.02136

G1 X78.461 Y127.016 E0.00497

G1 X78.015 Y125.767 E0.03456

G1 X77.944 Y124.999 E0.02009

G1 X77.944 Y36.023 E2.31834

G1 X78.016 Y35.248 E0.02028

G1 X78.149 Y34.737 E0.01377

G1 X78.485 Y33.943 E0.02246

G1 X78.958 Y33.254 E0.02177

G1 X79.546 Y32.679 E0.02143

G1 X79.669 Y32.585 E0.00403

G1 X80.275 Y32.201 E0.01868

G1 X80.788 Y31.985 E0.01452

M204 S1250

G1 X80.927 Y32.021 F9000.000

G1 X80.592 Y32.657

M204 S1000

G1 F4800.000

G1 X78.906 Y34.343 E0.06230

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.069 Y33.179 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.750 F9000.000

G1 X83.289 Y38.453

G1 Z1.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.210 Y38.473 E0.00213

G1 X82.761 Y38.696 E0.01304

G1 X82.313 Y39.056 E0.01499

G1 X81.865 Y39.518 E0.01676

G1 X81.416 Y39.908 E0.01550

G1 X80.968 Y40.126 E0.01298

G1 X80.520 Y40.202 E0.01185

G1 X80.071 Y40.178 E0.01170

G1 X79.707 Y40.086 E0.00980

G1 X79.707 Y36.611 E0.09053

G1 X80.071 Y36.592 E0.00951

G1 X80.520 Y36.478 E0.01205

G1 X80.968 Y36.256 E0.01304

G1 X81.416 Y35.895 E0.01499

G1 X81.865 Y35.434 E0.01676

G1 X82.313 Y35.043 E0.01550

G1 X82.761 Y34.826 E0.01298

G1 X83.210 Y34.749 E0.01185

G1 X83.672 Y34.777 E0.01208

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.210 Y34.749 E-0.25693

G1 X82.761 Y34.826 E-0.25201

G1 X82.313 Y35.043 E-0.27603

G1 X82.140 Y35.193 E-0.12703

G1 E-0.04800 F4200.00000

G1 Z1.750 F9000.000

G1 X85.536 Y34.230

G1 Z1.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X87.321 Y32.445 E0.06595

G1 X87.914 Y32.445 E0.01548

G1 X86.772 Y33.587 E0.04219

G1 X86.975 Y33.560 E0.00537

G1 X87.390 Y33.562 E0.01083

G1 X88.506 Y32.445 E0.04125

G1 X89.099 Y32.445 E0.01548

G1 X87.916 Y33.628 E0.04370

G1 X88.248 Y33.694 E0.00885

G1 X88.386 Y33.751 E0.00389

G1 X89.691 Y32.445 E0.04823

G1 X90.284 Y32.445 E0.01548

G1 X88.661 Y34.068 E0.05996

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.825 Y32.904 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.750 F9000.000

G1 X94.781 Y36.499

G1 Z1.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.417 Y36.592 E0.00980

G1 X93.968 Y36.616 E0.01170

G1 X93.520 Y36.539 E0.01185

G1 X93.072 Y36.322 E0.01298

G1 X92.624 Y35.931 E0.01550

G1 X92.175 Y35.470 E0.01676

G1 X91.727 Y35.109 E0.01499

G1 X91.279 Y34.887 E0.01304

G1 X90.813 Y34.772 E0.01250

G1 X90.968 Y35.033 E0.00792

G1 X91.133 Y35.382 E0.01005

G1 X91.274 Y35.771 E0.01079

G1 X91.376 Y36.173 E0.01080

G1 X91.438 Y36.581 E0.01076

G1 X91.460 Y37.022 E0.01150

G1 X91.438 Y37.435 E0.01078

G1 X91.376 Y37.844 E0.01076

G1 X91.241 Y38.338 E0.01334

G1 X91.727 Y38.412 E0.01281

G1 X92.175 Y38.629 E0.01298

G1 X92.624 Y39.020 E0.01550

G1 X93.072 Y39.481 E0.01676

G1 X93.520 Y39.842 E0.01499

G1 X93.968 Y40.065 E0.01304

G1 X94.417 Y40.178 E0.01205

G1 X94.781 Y40.198 E0.00951

G1 X94.781 Y43.672 E0.09053

G1 X94.417 Y43.765 E0.00980

G1 X93.968 Y43.788 E0.01170

G1 X93.520 Y43.712 E0.01185

G1 X93.072 Y43.495 E0.01298

G1 X92.624 Y43.104 E0.01550

G1 X92.175 Y42.643 E0.01676

G1 X91.727 Y42.282 E0.01499

G1 X91.279 Y42.059 E0.01304

G1 X90.830 Y41.945 E0.01205

G1 X90.382 Y41.922 E0.01170

G1 X89.934 Y41.998 E0.01185

G1 X89.486 Y42.215 E0.01298

G1 X89.037 Y42.606 E0.01550

G1 X88.589 Y43.067 E0.01676

G1 X88.141 Y43.428 E0.01499

G1 X87.692 Y43.651 E0.01304

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G1 X86.796 Y43.788 E0.01170

G1 X86.348 Y43.712 E0.01185

G1 X85.899 Y43.495 E0.01298

G1 X85.451 Y43.104 E0.01550

G1 X85.003 Y42.643 E0.01676

G1 X84.554 Y42.282 E0.01499

G1 X84.106 Y42.059 E0.01304

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G1 X83.210 Y41.922 E0.01170

G1 X82.761 Y41.998 E0.01185

G1 X82.313 Y42.215 E0.01298

G1 X81.865 Y42.606 E0.01550

G1 X81.416 Y43.067 E0.01676

G1 X80.968 Y43.428 E0.01499

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G1 X80.071 Y43.765 E0.01205

G1 X79.707 Y43.784 E0.00951

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G1 X82.313 Y46.229 E0.01676

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G1 X85.899 Y46.654 E0.01676

G1 X86.348 Y47.015 E0.01499

G1 X86.796 Y47.237 E0.01304

G1 X87.244 Y47.351 E0.01205

G1 X87.692 Y47.375 E0.01170

G1 X88.141 Y47.298 E0.01185

G1 X88.589 Y47.081 E0.01298

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G1 X89.486 Y46.229 E0.01676

G1 X89.934 Y45.868 E0.01499

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G1 X90.830 Y45.532 E0.01205

G1 X91.279 Y45.508 E0.01170

G1 X91.727 Y45.585 E0.01185

G1 X92.175 Y45.802 E0.01298

G1 X92.624 Y46.193 E0.01550

G1 X93.072 Y46.654 E0.01676

G1 X93.520 Y47.015 E0.01499

G1 X93.968 Y47.237 E0.01304

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G1 X87.244 Y50.937 E0.01205

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G1 X86.348 Y50.884 E0.01185

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G1 X86.348 Y58.057 E0.01185

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G1 X91.279 Y63.577 E0.01304

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G1 X90.382 Y63.440 E0.01170

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G1 F4800.000

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G1 X79.289 Y93.805 E0.01548

G1 X78.675 Y94.418 E0.02268

G1 X78.675 Y95.011 E0.01548

G1 X79.289 Y94.397 E0.02268

G1 X79.289 Y94.990 E0.01548

G1 X78.675 Y95.603 E0.02268

G1 X78.675 Y96.196 E0.01548

G1 X79.289 Y95.582 E0.02268

G1 X79.289 Y96.175 E0.01548

G1 X78.675 Y96.788 E0.02268

G1 X78.675 Y97.381 E0.01548

G1 X79.289 Y96.767 E0.02268

G1 X79.289 Y97.360 E0.01548

G1 X78.675 Y97.974 E0.02268

G1 X78.675 Y98.566 E0.01548

G1 X79.289 Y97.952 E0.02268

G1 X79.289 Y98.545 E0.01548

G1 X78.675 Y99.159 E0.02268

G1 X78.675 Y99.751 E0.01548

G1 X79.289 Y99.137 E0.02268

G1 X79.289 Y99.730 E0.01548

G1 X78.675 Y100.344 E0.02268

G1 X78.675 Y100.936 E0.01548

G1 X79.289 Y100.322 E0.02268

G1 X79.289 Y100.915 E0.01548

G1 X78.675 Y101.529 E0.02268

G1 X78.675 Y102.121 E0.01548

G1 X79.289 Y101.507 E0.02268

G1 X79.289 Y102.100 E0.01548

G1 X78.675 Y102.714 E0.02268

G1 X78.675 Y103.306 E0.01548

G1 X79.289 Y102.692 E0.02268

G1 X79.289 Y103.285 E0.01548

G1 X78.675 Y103.899 E0.02268

G1 X78.675 Y104.491 E0.01548

G1 X79.289 Y103.877 E0.02268

G1 X79.289 Y104.470 E0.01548

G1 X78.675 Y105.084 E0.02268

G1 X78.675 Y105.676 E0.01548

G1 X79.289 Y105.063 E0.02268

G1 X79.289 Y105.655 E0.01548

G1 X78.675 Y106.269 E0.02268

G1 X78.675 Y106.861 E0.01548

G1 X79.289 Y106.248 E0.02268

G1 X79.289 Y106.840 E0.01548

G1 X78.675 Y107.454 E0.02268

G1 X78.675 Y108.046 E0.01548

G1 X79.289 Y107.433 E0.02268

G1 X79.289 Y108.025 E0.01548

G1 X78.675 Y108.639 E0.02268

G1 X78.675 Y109.231 E0.01548

G1 X79.289 Y108.618 E0.02268

G1 X79.289 Y109.210 E0.01548

G1 X78.675 Y109.824 E0.02268

G1 X78.675 Y110.417 E0.01548

G1 X79.289 Y109.803 E0.02268

G1 X79.289 Y110.395 E0.01548

G1 X78.675 Y111.009 E0.02268

G1 X78.675 Y111.602 E0.01548

G1 X79.289 Y110.988 E0.02268

G1 X79.289 Y111.580 E0.01548

G1 X78.675 Y112.194 E0.02268

G1 X78.675 Y112.787 E0.01548

G1 X79.289 Y112.173 E0.02268

G1 X79.289 Y112.765 E0.01548

G1 X78.675 Y113.379 E0.02268

G1 X78.675 Y113.972 E0.01548

G1 X79.289 Y113.358 E0.02268

G1 X79.289 Y113.950 E0.01548

G1 X78.675 Y114.564 E0.02268

G1 X78.675 Y115.157 E0.01548

G1 X79.289 Y114.543 E0.02268

G1 X79.289 Y115.135 E0.01548

G1 X78.675 Y115.749 E0.02268

G1 X78.675 Y116.342 E0.01548

G1 X79.289 Y115.728 E0.02268

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G1 X78.675 Y116.934 E0.02268

G1 X78.675 Y117.527 E0.01548

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G1 X79.289 Y117.506 E0.01548

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G1 X78.675 Y118.712 E0.01548

G1 X79.289 Y118.098 E0.02268

G1 X79.289 Y118.691 E0.01548

G1 X78.675 Y119.304 E0.02268

G1 X78.675 Y119.897 E0.01548

G1 X79.289 Y119.283 E0.02268

G1 X79.289 Y119.876 E0.01548

G1 X78.675 Y120.489 E0.02268

G1 X78.675 Y121.082 E0.01548

G1 X79.289 Y120.468 E0.02268

G1 X79.289 Y121.061 E0.01548

G1 X78.675 Y121.674 E0.02268

G1 X78.675 Y122.267 E0.01548

G1 X79.289 Y121.653 E0.02268

G1 X79.289 Y122.246 E0.01548

G1 X78.675 Y122.860 E0.02268

G1 X78.675 Y123.452 E0.01548

G1 X79.289 Y122.838 E0.02268

G1 X79.289 Y123.431 E0.01548

G1 X78.675 Y124.045 E0.02268

G1 X78.675 Y124.637 E0.01548

G1 X79.289 Y124.023 E0.02268

G1 X79.289 Y124.616 E0.01548

G1 X78.698 Y125.207 E0.02185

G1 X78.735 Y125.608 E0.01051

G1 X78.776 Y125.722 E0.00317

G1 X79.311 Y125.186 E0.01978

G1 X79.352 Y125.583 E0.01041

G1 X79.391 Y125.699 E0.00320

G1 X78.931 Y126.158 E0.01698

G1 X79.087 Y126.595 E0.01211

G1 X79.540 Y126.142 E0.01673

G1 X79.673 Y126.457 E0.00892

G1 X79.729 Y126.546 E0.00274

G1 X79.299 Y126.976 E0.01591

G1 X79.548 Y127.320 E0.01109

G1 X79.977 Y126.890 E0.01587

G1 X80.269 Y127.191 E0.01095

G1 X79.848 Y127.612 E0.01556

G1 X80.097 Y127.843 E0.00887

G1 X80.166 Y127.886 E0.00214

G1 X80.603 Y127.450 E0.01612

G1 X80.976 Y127.669 E0.01131

G1 X80.533 Y128.113 E0.01638

G1 X80.672 Y128.199 E0.00429

G1 X80.939 Y128.298 E0.00745

G1 X81.416 Y127.822 E0.01762

G1 X81.598 Y127.883 E0.00501

G1 X81.904 Y127.927 E0.00807

G1 X81.379 Y128.451 E0.01938

G1 X81.898 Y128.525 E0.01369

G1 X82.459 Y127.963 E0.02075

G1 X83.052 Y127.963 E0.01548

G1 X82.450 Y128.565 E0.02223

G1 X83.042 Y128.566 E0.01546

G1 X83.644 Y127.963 E0.02226

G1 X84.237 Y127.963 E0.01548

G1 X83.634 Y128.566 E0.02229

G1 X84.226 Y128.567 E0.01546

G1 X85.701 Y127.092 E0.05452

G1 X85.919 Y127.208 E0.00645

G1 X86.117 Y127.268 E0.00541

G1 X84.817 Y128.568 E0.04803

G1 X85.409 Y128.569 E0.01546

G1 X86.573 Y127.405 E0.04300

G1 X87.111 Y127.459 E0.01414

G1 X86.001 Y128.569 E0.04103

G1 X86.593 Y128.570 E0.01546

G1 X87.740 Y127.422 E0.04241

G1 X87.920 Y127.404 E0.00471

G1 X88.538 Y127.218 E0.01686

G1 X86.997 Y128.759 E0.05694

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.160 Y127.595 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.750 F9000.000

G1 X84.942 Y127.258

G1 Z1.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X85.316 Y126.884 E0.01380

G1 X84.990 Y126.618 E0.01100

G1 X84.745 Y126.863 E0.00905

G1 X84.556 Y126.691 E0.00666

G1 X84.446 Y126.569 E0.00430

G1 X84.688 Y126.327 E0.00894

G1 X84.421 Y126.001 E0.01100

G1 X84.179 Y126.243 E0.00894

G1 X83.946 Y125.884 E0.01119

G1 X84.202 Y125.628 E0.00945

G1 X84.044 Y125.333 E0.00874

G1 X84.012 Y125.226 E0.00293

G1 X83.749 Y125.489 E0.00972

G1 X83.609 Y125.107 E0.01062

G1 X83.595 Y125.050 E0.00153

G1 X83.874 Y124.771 E0.01033

G1 X83.848 Y124.684 E0.00237

G1 X83.804 Y124.248 E0.01144

G1 X83.492 Y124.561 E0.01155

G1 X83.447 Y124.013 E0.01436

G1 X83.817 Y123.643 E0.01367

G1 X83.848 Y123.332 E0.00816

G1 X83.983 Y122.884 E0.01224

G1 X83.505 Y123.362 E0.01766

G1 X83.609 Y122.909 E0.01214

G1 X83.735 Y122.558 E0.00975

G1 X85.761 Y120.514 E0.07522

G1 X86.145 Y120.373 E0.01067

G1 X86.596 Y120.272 E0.01207

G1 X86.120 Y120.748 E0.01758

G1 X86.567 Y120.612 E0.01221

G1 X86.880 Y120.580 E0.00820

G1 X87.240 Y120.220 E0.01332

G1 X87.611 Y120.228 E0.00970

G1 X87.797 Y120.256 E0.00490

G1 X87.491 Y120.562 E0.01130

G1 X88.007 Y120.638 E0.01362

G1 X88.286 Y120.359 E0.01033

G1 X88.350 Y120.375 E0.00172

G1 X88.725 Y120.513 E0.01044

G1 X88.462 Y120.776 E0.00972

G1 X88.569 Y120.808 E0.00294

G1 X88.864 Y120.966 E0.00873

G1 X89.120 Y120.710 E0.00945

G1 X89.479 Y120.943 E0.01119

G1 X89.237 Y121.185 E0.00894

G1 X89.563 Y121.452 E0.01100

G1 X89.805 Y121.210 E0.00894

G1 X89.932 Y121.325 E0.00448

G1 X90.098 Y121.509 E0.00648

G1 X89.854 Y121.754 E0.00905

G1 X90.120 Y122.080 E0.01100

G1 X90.359 Y121.841 E0.00883

G1 X90.586 Y122.207 E0.01124

G1 X90.328 Y122.465 E0.00956

G1 X90.444 Y122.683 E0.00646

G1 X90.504 Y122.881 E0.00541

G1 X90.773 Y122.612 E0.00995

G1 X90.917 Y123.061 E0.01231

G1 X90.641 Y123.337 E0.01021

G1 X90.694 Y123.876 E0.01416

G1 X91.012 Y123.558 E0.01175

G1 X91.042 Y124.005 E0.01169

G1 X91.036 Y124.127 E0.00319

G1 X90.658 Y124.505 E0.01397

G1 X90.640 Y124.683 E0.00468

G1 X90.454 Y125.302 E0.01689

G1 X90.956 Y124.799 E0.01857

G1 X90.877 Y125.114 E0.00848

G1 X90.754 Y125.459 E0.00957

G1 X90.633 Y125.715 E0.00742

G1 X87.776 Y128.572 E0.10554

G1 X88.368 Y128.572 E0.01546

G1 X89.271 Y127.670 E0.03335

G1 X89.329 Y127.963 E0.00782

G1 X89.570 Y127.963 E0.00628

G1 X88.960 Y128.573 E0.02253

G1 X89.552 Y128.574 E0.01546

G1 X90.162 Y127.963 E0.02256

G1 X90.755 Y127.963 E0.01548

G1 X90.144 Y128.574 E0.02258

G1 X90.735 Y128.575 E0.01546

G1 X91.347 Y127.963 E0.02261

G1 X91.940 Y127.963 E0.01548

G1 X91.327 Y128.576 E0.02264

G1 X91.919 Y128.577 E0.01546

G1 X92.577 Y127.919 E0.02430

G1 X92.898 Y127.881 E0.00845

G1 X93.367 Y127.721 E0.01295

G1 X92.563 Y128.525 E0.02969

G1 X93.154 Y128.444 E0.01557

G1 X93.288 Y128.393 E0.00375

G1 X95.570 Y126.111 E0.08431

G1 X95.327 Y126.778 E0.01855

G1 X94.905 Y127.368 E0.01893

G1 X93.923 Y128.350 E0.03630

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X94.905 Y127.368 E-0.76999

G1 X95.055 Y127.159 E-0.14201

G1 E-0.04800 F4200.00000

G1 Z1.750 F9000.000

G1 X83.077 Y124.610

G1 Z1.550

G1 E3.20000 F2400.00000

M73 P23 R54

M204 S1000

G1 F4800.000

G1 X82.761 Y124.767 E0.00917

G1 X82.313 Y125.128 E0.01499

G1 X81.865 Y125.589 E0.01676

G1 X81.416 Y125.980 E0.01550

G1 X80.968 Y126.197 E0.01298

G1 X80.520 Y126.273 E0.01185

G1 X80.035 Y126.240 E0.01267

G1 X79.942 Y126.025 E0.00610

G1 X79.763 Y125.494 E0.01462

G1 X79.707 Y124.953 E0.01416

G1 X79.707 Y122.683 E0.05916

G1 X80.071 Y122.663 E0.00951

G1 X80.520 Y122.550 E0.01205

G1 X80.968 Y122.327 E0.01304

G1 X81.416 Y121.966 E0.01499

G1 X81.865 Y121.505 E0.01676

G1 X82.313 Y121.114 E0.01550

G1 X82.761 Y120.897 E0.01298

G1 X83.210 Y120.821 E0.01185

G1 X83.658 Y120.844 E0.01170

G1 X84.106 Y120.958 E0.01205

G1 X84.258 Y121.033 E0.00441

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;1.7

G1 Z1.700 F9000.000

;AFTER\_LAYER\_CHANGE

;1.7

G1 X85.017 Y121.781

M204 S800

G1 F1500.000

G1 X85.496 Y121.390 E0.01610

G1 X86.039 Y121.099 E0.01607

G1 X86.630 Y120.921 E0.01607

G1 X87.208 Y120.863 E0.01514

G1 X87.550 Y120.877 E0.00892

G1 X87.873 Y120.925 E0.00850

G1 X88.449 Y121.099 E0.01568

G1 X88.993 Y121.390 E0.01606

G1 X89.471 Y121.781 E0.01610

G1 X89.862 Y122.260 E0.01610

G1 X90.153 Y122.804 E0.01607

G1 X90.332 Y123.395 E0.01609

G1 X90.392 Y124.008 E0.01607

G1 X90.332 Y124.622 E0.01607

G1 X90.153 Y125.213 E0.01609

G1 X89.862 Y125.757 E0.01606

G1 X89.471 Y126.235 E0.01610

G1 X88.993 Y126.627 E0.01611

G1 X88.449 Y126.917 E0.01607

G1 X87.858 Y127.096 E0.01607

G1 X87.244 Y127.157 E0.01608

G1 X86.630 Y127.096 E0.01609

G1 X86.039 Y126.917 E0.01608

G1 X85.496 Y126.627 E0.01606

G1 X85.017 Y126.235 E0.01611

G1 X84.626 Y125.757 E0.01610

G1 X84.335 Y125.213 E0.01607

G1 X84.157 Y124.622 E0.01607

G1 X84.095 Y124.008 E0.01608

G1 X84.157 Y123.394 E0.01609

G1 X84.335 Y122.803 E0.01608

G1 X84.626 Y122.260 E0.01606

G1 X84.979 Y121.828 E0.01454

M204 S1250

G1 X85.303 Y122.093 F9000.000

M204 S800

G1 F1500.000

G1 X85.729 Y121.739 E0.01442

G1 X86.200 Y121.487 E0.01392

G1 X86.712 Y121.333 E0.01394

G1 X87.220 Y121.282 E0.01331

G1 X87.511 Y121.294 E0.00757

G1 X87.781 Y121.334 E0.00713

G1 X88.289 Y121.487 E0.01380

G1 X88.760 Y121.739 E0.01392

G1 X89.174 Y122.078 E0.01395

G1 X89.513 Y122.493 E0.01395

G1 X89.765 Y122.964 E0.01393

G1 X89.920 Y123.476 E0.01394

G1 X89.972 Y124.008 E0.01393

G1 X89.920 Y124.540 E0.01393

G1 X89.765 Y125.053 E0.01395

G1 X89.513 Y125.524 E0.01392

G1 X89.174 Y125.938 E0.01395

G1 X88.760 Y126.277 E0.01395

G1 X88.288 Y126.529 E0.01392

G1 X87.776 Y126.684 E0.01394

G1 X87.244 Y126.737 E0.01394

G1 X86.712 Y126.684 E0.01394

G1 X86.200 Y126.529 E0.01394

G1 X85.729 Y126.277 E0.01392

G1 X85.314 Y125.938 E0.01395

G1 X84.975 Y125.524 E0.01395

G1 X84.723 Y125.052 E0.01393

G1 X84.568 Y124.540 E0.01394

G1 X84.515 Y124.008 E0.01394

G1 X84.568 Y123.476 E0.01394

G1 X84.723 Y122.964 E0.01394

G1 X84.975 Y122.493 E0.01392

G1 X85.265 Y122.139 E0.01191

M204 S1250

G1 X85.197 Y121.707 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.729 Y121.739 E-0.33938

G1 X86.200 Y121.487 E-0.29616

G1 X86.677 Y121.343 E-0.27646

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X86.936 Y40.141

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.331 Y40.022 E0.01607

G1 X85.759 Y39.785 E0.01612

G1 X85.260 Y39.451 E0.01565

G1 X85.019 Y39.233 E0.00846

G1 X84.802 Y38.992 E0.00846

G1 X84.468 Y38.493 E0.01565

G1 X84.231 Y37.921 E0.01612

G1 X84.115 Y37.333 E0.01563

G1 X84.097 Y37.008 E0.00847

G1 X84.115 Y36.683 E0.00848

G1 X84.231 Y36.095 E0.01562

G1 X84.468 Y35.524 E0.01612

G1 X84.802 Y35.024 E0.01565

G1 X85.019 Y34.783 E0.00846

G1 X85.260 Y34.566 E0.00846

G1 X85.759 Y34.232 E0.01565

G1 X86.317 Y34.001 E0.01572

G1 X86.633 Y33.922 E0.00850

G1 X86.954 Y33.877 E0.00845

G1 X87.244 Y33.862 E0.00756

G1 X87.569 Y33.879 E0.00848

G1 X88.157 Y33.995 E0.01562

G1 X88.729 Y34.232 E0.01612

G1 X89.228 Y34.566 E0.01565

G1 X89.469 Y34.783 E0.00846

G1 X89.687 Y35.024 E0.00846

G1 X90.021 Y35.524 E0.01565

G1 X90.257 Y36.095 E0.01612

G1 X90.377 Y36.700 E0.01607

G1 X90.377 Y37.316 E0.01605

G1 X90.257 Y37.921 E0.01607

G1 X90.021 Y38.493 E0.01612

G1 X89.687 Y38.992 E0.01565

G1 X89.469 Y39.233 E0.00846

G1 X89.228 Y39.451 E0.00846

G1 X88.729 Y39.785 E0.01565

G1 X88.157 Y40.022 E0.01612

G1 X87.552 Y40.141 E0.01607

G1 X86.996 Y40.141 E0.01448

M204 S1250

G1 X86.996 Y39.723 F9000.000

M204 S800

G1 F1500.000

G1 X86.453 Y39.620 E0.01442

G1 X85.957 Y39.415 E0.01396

G1 X85.518 Y39.120 E0.01379

G1 X85.315 Y38.938 E0.00711

G1 X85.132 Y38.735 E0.00711

G1 X84.838 Y38.295 E0.01379

G1 X84.633 Y37.800 E0.01396

G1 X84.530 Y37.281 E0.01377

G1 X84.516 Y37.008 E0.00712

G1 X84.530 Y36.735 E0.00712

G1 X84.633 Y36.217 E0.01377

G1 X84.838 Y35.722 E0.01396

G1 X85.132 Y35.282 E0.01379

G1 X85.315 Y35.079 E0.00711

G1 X85.518 Y34.896 E0.00711

G1 X85.957 Y34.602 E0.01379

G1 X86.448 Y34.399 E0.01382

G1 X86.713 Y34.333 E0.00713

G1 X86.995 Y34.293 E0.00741

G1 X87.244 Y34.280 E0.00650

G1 X87.517 Y34.294 E0.00712

G1 X88.036 Y34.397 E0.01377

G1 X88.531 Y34.602 E0.01397

G1 X88.971 Y34.896 E0.01379

G1 X89.173 Y35.079 E0.00711

G1 X89.356 Y35.282 E0.00711

G1 X89.650 Y35.722 E0.01379

G1 X89.856 Y36.217 E0.01397

G1 X89.959 Y36.741 E0.01393

G1 X89.959 Y37.275 E0.01392

G1 X89.856 Y37.800 E0.01393

G1 X89.650 Y38.295 E0.01396

G1 X89.356 Y38.735 E0.01379

G1 X89.173 Y38.938 E0.00711

G1 X88.971 Y39.120 E0.00711

G1 X88.531 Y39.415 E0.01379

G1 X88.036 Y39.620 E0.01396

G1 X87.511 Y39.723 E0.01393

G1 X87.056 Y39.723 E0.01186

M204 S1250

G1 X86.765 Y40.050 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.453 Y39.620 E-0.33933

G1 X85.957 Y39.415 E-0.29701

G1 X85.544 Y39.138 E-0.27566

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X81.123 Y32.461

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S800

G1 X81.847 Y32.317 E0.01925

G1 X82.270 Y32.282 E0.01106

G1 X92.211 Y32.282 E0.25902

G1 X92.940 Y32.358 E0.01908

G1 X93.642 Y32.564 E0.01906

G1 X94.162 Y32.826 E0.01518

G1 X94.307 Y32.918 E0.00448

G1 X94.863 Y33.369 E0.01864

G1 X95.248 Y33.815 E0.01538

G1 X95.636 Y34.477 E0.01999

G1 X95.811 Y34.933 E0.01272

G1 X95.953 Y35.674 E0.01966

G1 X95.976 Y36.034 E0.00939

G1 X95.976 Y124.981 E2.31760

G1 X95.914 Y125.653 E0.01757

G1 X95.477 Y126.854 E0.03331

G1 X95.039 Y127.470 E0.01969

G1 X94.599 Y127.889 E0.01583

G1 X94.464 Y127.994 E0.00446

G1 X93.970 Y128.306 E0.01522

G1 X93.197 Y128.607 E0.02162

G1 X92.201 Y128.740 E0.02617

G1 X82.274 Y128.740 E0.25865

G1 X81.311 Y128.610 E0.02534

G1 X80.610 Y128.353 E0.01944

G1 X80.021 Y127.991 E0.01800

G1 X79.889 Y127.889 E0.00435

G1 X79.468 Y127.487 E0.01517

G1 X79.048 Y126.914 E0.01852

G1 X78.958 Y126.736 E0.00521

G1 X78.576 Y125.661 E0.02972

G1 X78.512 Y124.979 E0.01785

G1 X78.512 Y36.041 E2.31734

G1 X78.577 Y35.346 E0.01819

G1 X78.743 Y34.756 E0.01597

G1 X78.974 Y34.236 E0.01481

G1 X79.383 Y33.634 E0.01897

G1 X79.894 Y33.130 E0.01870

G1 X80.025 Y33.029 E0.00431

G1 X80.522 Y32.714 E0.01535

G1 X81.067 Y32.484 E0.01540

M204 S1250

G1 X80.905 Y32.099 F9000.000

M204 S800

G1 F1800.000

G1 X80.999 Y32.059 E0.00267

G1 X81.789 Y31.902 E0.02099

G1 X82.253 Y31.864 E0.01213

G1 X92.233 Y31.864 E0.26003

G1 X93.021 Y31.946 E0.02064

G1 X93.796 Y32.174 E0.02104

G1 X94.368 Y32.462 E0.01671

G1 X94.548 Y32.576 E0.00555

G1 X95.059 Y32.975 E0.01690

G1 X95.169 Y33.084 E0.00402

G1 X95.589 Y33.571 E0.01677

G1 X96.013 Y34.295 E0.02186

G1 X96.215 Y34.817 E0.01458

G1 X96.369 Y35.621 E0.02132

G1 X96.394 Y36.020 E0.01043

G1 X96.394 Y124.999 E2.31842

G1 X96.324 Y125.749 E0.01961

G1 X95.851 Y127.048 E0.03602

G1 X95.342 Y127.758 E0.02276

G1 X94.872 Y128.206 E0.01693

G1 X94.704 Y128.336 E0.00554

G1 X94.161 Y128.679 E0.01672

G1 X93.287 Y129.016 E0.02442

G1 X92.229 Y129.158 E0.02781

G1 X82.255 Y129.158 E0.25989

G1 X81.208 Y129.017 E0.02752

G1 X80.427 Y128.730 E0.02168

G1 X79.783 Y128.335 E0.01968

G1 X79.617 Y128.206 E0.00550

G1 X79.153 Y127.764 E0.01670

G1 X78.691 Y127.133 E0.02036

G1 X78.573 Y126.901 E0.00679

G1 X78.165 Y125.752 E0.03178

G1 X78.094 Y124.999 E0.01971

G1 X78.094 Y36.023 E2.31833

G1 X78.165 Y35.265 E0.01983

G1 X78.349 Y34.614 E0.01763

G1 X78.607 Y34.033 E0.01657

G1 X79.061 Y33.366 E0.02102

G1 X79.618 Y32.815 E0.02042

G1 X79.785 Y32.686 E0.00549

G1 X80.328 Y32.342 E0.01676

G1 X80.850 Y32.123 E0.01474

M204 S1250

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G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X81.789 Y31.902 E-0.44633

G1 X82.253 Y31.864 E-0.25796

G1 X82.466 Y31.864 E-0.11772

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X83.959 Y32.407

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X85.956 Y33.811 E0.01174

G1 X84.741 Y32.595 E0.04500

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G1 X86.397 Y33.658 E0.03934

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G1 X90.688 Y37.356 E0.01578

G1 X90.591 Y37.852 E0.01322

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G1 X90.441 Y38.296 E0.01395

G1 X90.256 Y38.705 E0.01174

G1 X90.611 Y39.060 E0.01315

G1 X90.370 Y39.412 E0.01118

G1 X90.018 Y39.060 E0.01303

G1 X89.935 Y39.185 E0.00394

G1 X89.752 Y39.388 E0.00713

G1 X90.097 Y39.732 E0.01276

G1 X89.792 Y40.021 E0.01099

G1 X89.447 Y39.676 E0.01277

G1 X89.095 Y39.917 E0.01117

G1 X89.455 Y40.278 E0.01334

G1 X89.084 Y40.500 E0.01133

G1 X88.714 Y40.130 E0.01368

G1 X88.294 Y40.304 E0.01189

G1 X88.674 Y40.684 E0.01407

G1 X88.224 Y40.827 E0.01237

G1 X87.807 Y40.410 E0.01545

G1 X87.583 Y40.454 E0.00598

G1 X87.257 Y40.454 E0.00851

G1 X87.726 Y40.923 E0.01733

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G1 X79.502 Y125.569 E0.00805

G1 X79.659 Y126.046 E0.01314

G1 X78.851 Y125.239 E0.02989

G1 X78.885 Y125.593 E0.00931

G1 X79.035 Y126.016 E0.01175

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G1 X81.387 Y128.304 E0.00283

G1 X82.004 Y128.392 E0.01631

G1 X81.207 Y127.594 E0.02953

G1 X81.653 Y127.743 E0.01232

G1 X81.987 Y127.781 E0.00879

G1 X82.621 Y128.415 E0.02349

G1 X83.216 Y128.416 E0.01556

G1 X82.613 Y127.813 E0.02231

G1 X83.206 Y127.813 E0.01554

G1 X83.810 Y128.417 E0.02234

G1 X84.404 Y128.418 E0.01556

G1 X83.800 Y127.813 E0.02237

G1 X84.394 Y127.813 E0.01554

G1 X84.999 Y128.418 E0.02239

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G1 X84.854 Y127.153 E0.01091

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G1 X84.190 Y126.510 E0.01014

G1 X83.951 Y126.184 E0.01060

G1 X86.187 Y128.420 E0.08278

G1 X86.781 Y128.420 E0.01556

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G1 X95.441 Y34.392 E0.03239

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X94.566 Y33.517 E-0.68577

G1 X94.244 Y33.266 E-0.22623

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X93.771 Y33.910

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.487 Y32.626 E0.04753

G1 X92.195 Y32.595 E0.00770

G1 X91.864 Y32.595 E0.00867

G1 X92.514 Y33.246 E0.02407

G1 X92.205 Y33.209 E0.00812

G1 X91.884 Y33.209 E0.00842

G1 X91.270 Y32.595 E0.02272

G1 X90.676 Y32.595 E0.01554

G1 X91.290 Y33.209 E0.02272

G1 X90.697 Y33.209 E0.01554

G1 X90.083 Y32.595 E0.02272

G1 X89.489 Y32.595 E0.01554

G1 X90.103 Y33.209 E0.02272

G1 X89.861 Y33.209 E0.00634

G1 X89.774 Y33.473 E0.00728

G1 X88.896 Y32.595 E0.03250

G1 X88.302 Y32.595 E0.01554

G1 X91.005 Y35.298 E0.10005

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.841 Y34.135 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X94.631 Y36.547

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.417 Y36.581 E0.00566

G1 X93.968 Y36.562 E0.01169

G1 X93.520 Y36.441 E0.01210

G1 X93.072 Y36.182 E0.01349

G1 X92.175 Y35.345 E0.03196

G1 X91.727 Y35.032 E0.01424

G1 X91.279 Y34.855 E0.01255

G1 X91.012 Y34.813 E0.00703

G1 X91.272 Y35.325 E0.01495

G1 X91.418 Y35.728 E0.01118

G1 X91.523 Y36.144 E0.01117

G1 X91.587 Y36.567 E0.01114

G1 X91.610 Y37.022 E0.01189

G1 X91.587 Y37.450 E0.01116

G1 X91.523 Y37.873 E0.01114

G1 X91.372 Y38.415 E0.01465

G1 X91.727 Y38.511 E0.00957

G1 X92.175 Y38.770 E0.01349

G1 X93.072 Y39.607 E0.03196

G1 X93.520 Y39.919 E0.01424

G1 X93.968 Y40.096 E0.01255

G1 X94.417 Y40.167 E0.01183

G1 X94.631 Y40.158 E0.00560

G1 X94.631 Y43.719 E0.09279

G1 X94.417 Y43.754 E0.00566

G1 X93.968 Y43.735 E0.01169

G1 X93.520 Y43.613 E0.01210

G1 X93.072 Y43.354 E0.01349

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G1 X84.106 Y42.028 E0.01255

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G1 X80.071 Y43.754 E0.01183

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G1 X85.899 Y89.815 E0.03196

G1 X86.348 Y90.128 E0.01424

G1 X86.796 Y90.304 E0.01255

G1 X87.244 Y90.376 E0.01183

G1 X87.692 Y90.357 E0.01169

G1 X88.141 Y90.235 E0.01210

G1 X88.589 Y89.976 E0.01349

G1 X89.486 Y89.139 E0.03196

G1 X89.934 Y88.827 E0.01424

G1 X90.382 Y88.650 E0.01255

G1 X90.830 Y88.579 E0.01183

G1 X91.279 Y88.598 E0.01169

G1 X91.727 Y88.719 E0.01210

G1 X92.175 Y88.978 E0.01349

G1 X93.072 Y89.815 E0.03196

G1 X93.520 Y90.128 E0.01424

G1 X93.968 Y90.304 E0.01255

G1 X94.417 Y90.376 E0.01183

G1 X94.631 Y90.366 E0.00560

G1 X94.631 Y93.928 E0.09279

G1 X94.417 Y93.962 E0.00566

G1 X93.968 Y93.943 E0.01169

G1 X93.520 Y93.822 E0.01210

G1 X93.072 Y93.562 E0.01349

G1 X92.175 Y92.725 E0.03196

G1 X91.727 Y92.413 E0.01424

G1 X91.279 Y92.236 E0.01255

G1 X90.830 Y92.165 E0.01183

G1 X90.382 Y92.184 E0.01169

G1 X89.934 Y92.305 E0.01210

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G1 X88.589 Y93.401 E0.03196

G1 X88.141 Y93.714 E0.01424

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G1 X87.244 Y93.962 E0.01183

G1 X86.796 Y93.943 E0.01169

G1 X86.348 Y93.822 E0.01210

G1 X85.899 Y93.562 E0.01349

G1 X85.003 Y92.725 E0.03196

G1 X84.554 Y92.413 E0.01424

G1 X84.106 Y92.236 E0.01255

G1 X83.658 Y92.165 E0.01183

G1 X83.210 Y92.184 E0.01169

G1 X82.761 Y92.305 E0.01210

G1 X82.313 Y92.564 E0.01349

G1 X81.416 Y93.401 E0.03196

G1 X80.968 Y93.714 E0.01424

G1 X80.520 Y93.890 E0.01255

G1 X80.071 Y93.962 E0.01183

G1 X79.857 Y93.953 E0.00560

G1 X79.857 Y97.514 E0.09279

G1 X80.071 Y97.548 E0.00566

G1 X80.520 Y97.529 E0.01169

G1 X80.968 Y97.408 E0.01210

G1 X81.416 Y97.149 E0.01349

G1 X82.313 Y96.312 E0.03196

G1 X82.761 Y95.999 E0.01424

G1 X83.210 Y95.823 E0.01255

G1 X83.658 Y95.751 E0.01183

G1 X84.106 Y95.770 E0.01169

G1 X84.554 Y95.891 E0.01210

G1 X85.003 Y96.151 E0.01349

G1 X85.899 Y96.988 E0.03196

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G1 X86.796 Y97.477 E0.01255

G1 X87.244 Y97.548 E0.01183

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G1 X88.141 Y97.408 E0.01210

G1 X88.589 Y97.149 E0.01349

G1 X89.486 Y96.312 E0.03196

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G1 X90.830 Y95.751 E0.01183

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G1 X94.417 Y101.134 E0.00566

G1 X93.968 Y101.116 E0.01169

G1 X93.520 Y100.994 E0.01210

G1 X93.072 Y100.735 E0.01349

G1 X92.175 Y99.898 E0.03196

G1 X91.727 Y99.585 E0.01424

G1 X91.279 Y99.409 E0.01255

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G1 X89.486 Y99.737 E0.01349

G1 X88.589 Y100.574 E0.03196

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G1 X86.796 Y101.116 E0.01169

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G1 X85.899 Y100.735 E0.01349

G1 X85.003 Y99.898 E0.03196

G1 X84.554 Y99.585 E0.01424

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G1 X80.968 Y100.887 E0.01424

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G1 X82.761 Y103.172 E0.01424

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G1 X83.658 Y102.924 E0.01183

G1 X84.106 Y102.943 E0.01169

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G1 X86.796 Y104.649 E0.01255

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G1 X87.692 Y104.702 E0.01169

G1 X88.141 Y104.581 E0.01210

G1 X88.589 Y104.321 E0.01349

G1 X89.486 Y103.484 E0.03196

G1 X89.934 Y103.172 E0.01424

G1 X90.382 Y102.995 E0.01255

G1 X90.830 Y102.924 E0.01183

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G1 X82.761 Y106.650 E0.01210

G1 X82.313 Y106.909 E0.01349

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M73 P24 R53

G1 X80.968 Y108.059 E0.01424

G1 X80.520 Y108.236 E0.01255

G1 X80.071 Y108.307 E0.01183

G1 X79.857 Y108.298 E0.00560

G1 X79.857 Y111.859 E0.09279

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G1 X82.761 Y110.344 E0.01424

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G1 X83.658 Y110.096 E0.01183

G1 X84.106 Y110.115 E0.01169

G1 X84.554 Y110.237 E0.01210

G1 X85.003 Y110.496 E0.01349

G1 X85.899 Y111.333 E0.03196

G1 X86.348 Y111.645 E0.01424

G1 X86.796 Y111.822 E0.01255

G1 X87.244 Y111.893 E0.01183

G1 X87.692 Y111.874 E0.01169

G1 X88.141 Y111.753 E0.01210

G1 X88.589 Y111.494 E0.01349

G1 X89.486 Y110.657 E0.03196

G1 X89.934 Y110.344 E0.01424

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G1 X91.727 Y110.237 E0.01210

G1 X92.175 Y110.496 E0.01349

G1 X93.072 Y111.333 E0.03196

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G1 X88.141 Y115.232 E0.01424

G1 X87.692 Y115.408 E0.01255

G1 X87.244 Y115.480 E0.01183

G1 X86.796 Y115.461 E0.01169

G1 X86.348 Y115.339 E0.01210

G1 X85.899 Y115.080 E0.01349

G1 X85.003 Y114.243 E0.03196

G1 X84.554 Y113.931 E0.01424

G1 X84.106 Y113.754 E0.01255

G1 X83.658 Y113.683 E0.01183

G1 X83.210 Y113.702 E0.01169

G1 X82.761 Y113.823 E0.01210

G1 X82.313 Y114.082 E0.01349

G1 X81.416 Y114.919 E0.03196

G1 X80.968 Y115.232 E0.01424

G1 X80.520 Y115.408 E0.01255

G1 X80.071 Y115.480 E0.01183

G1 X79.857 Y115.471 E0.00560

G1 X79.857 Y119.032 E0.09279

G1 X80.071 Y119.066 E0.00566

G1 X80.520 Y119.047 E0.01169

G1 X80.968 Y118.926 E0.01210

G1 X81.416 Y118.667 E0.01349

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G1 X82.761 Y117.517 E0.01424

G1 X83.210 Y117.340 E0.01255

G1 X83.658 Y117.269 E0.01183

G1 X84.106 Y117.288 E0.01169

G1 X84.554 Y117.409 E0.01210

G1 X85.003 Y117.668 E0.01349

G1 X85.899 Y118.505 E0.03196

G1 X86.348 Y118.818 E0.01424

G1 X86.796 Y118.995 E0.01255

G1 X87.244 Y119.066 E0.01183

G1 X87.692 Y119.047 E0.01169

G1 X88.141 Y118.926 E0.01210

G1 X88.589 Y118.667 E0.01349

G1 X89.486 Y117.830 E0.03196

G1 X89.934 Y117.517 E0.01424

G1 X90.382 Y117.340 E0.01255

G1 X90.830 Y117.269 E0.01183

G1 X91.279 Y117.288 E0.01169

G1 X91.727 Y117.409 E0.01210

G1 X92.175 Y117.668 E0.01349

G1 X93.072 Y118.505 E0.03196

G1 X93.520 Y118.818 E0.01424

G1 X93.968 Y118.995 E0.01255

G1 X94.417 Y119.066 E0.01183

G1 X94.631 Y119.057 E0.00560

G1 X94.631 Y122.618 E0.09279

G1 X94.417 Y122.652 E0.00566

G1 X93.968 Y122.633 E0.01169

G1 X93.520 Y122.512 E0.01210

G1 X93.072 Y122.253 E0.01349

G1 X92.175 Y121.416 E0.03196

G1 X91.727 Y121.103 E0.01424

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G1 X90.830 Y120.855 E0.01183

G1 X90.382 Y120.874 E0.01169

G1 X90.303 Y120.896 E0.00213

G1 X90.610 Y121.228 E0.01178

G1 X90.882 Y121.595 E0.01190

G1 X91.087 Y121.939 E0.01043

G1 X91.272 Y122.325 E0.01114

G1 X91.418 Y122.728 E0.01118

G1 X91.523 Y123.144 E0.01117

G1 X91.590 Y123.594 E0.01185

G1 X91.610 Y124.022 E0.01118

G1 X91.573 Y124.540 E0.01353

G1 X91.727 Y124.582 E0.00414

G1 X92.175 Y124.841 E0.01349

G1 X93.072 Y125.678 E0.03196

G1 X93.520 Y125.991 E0.01424

G1 X93.968 Y126.167 E0.01255

G1 X94.291 Y126.219 E0.00851

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.968 Y126.167 E-0.18100

G1 X93.520 Y125.991 E-0.26701

G1 X93.072 Y125.678 E-0.30287

G1 X92.859 Y125.480 E-0.16112

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X90.536 Y128.613

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.935 Y127.013 E0.05924

G1 X88.545 Y127.216 E0.01152

G1 X89.753 Y128.424 E0.04473

G1 X89.159 Y128.423 E0.01556

G1 X88.089 Y127.353 E0.03961

G1 X87.920 Y127.404 E0.00462

G1 X87.580 Y127.438 E0.00894

G1 X88.564 Y128.423 E0.03643

G1 X87.970 Y128.422 E0.01556

G1 X86.995 Y127.447 E0.03608

G1 X86.568 Y127.404 E0.01124

G1 X86.268 Y127.314 E0.00820

G1 X87.564 Y128.609 E0.04796

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.400 Y127.446 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X84.140 Y120.940

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.658 Y120.855 E0.01275

G1 X83.210 Y120.874 E0.01169

G1 X82.761 Y120.996 E0.01210

G1 X82.313 Y121.255 E0.01349

G1 X81.416 Y122.092 E0.03196

G1 X80.968 Y122.404 E0.01424

G1 X80.520 Y122.581 E0.01255

G1 X80.071 Y122.652 E0.01183

G1 X79.857 Y122.643 E0.00560

G1 X79.857 Y124.952 E0.06015

G1 X79.913 Y125.481 E0.01387

G1 X80.055 Y125.914 E0.01187

G1 X80.207 Y126.233 E0.00920

G1 X80.520 Y126.220 E0.00816

G1 X80.968 Y126.098 E0.01210

G1 X81.416 Y125.839 E0.01349

G1 X82.313 Y125.002 E0.03196

G1 X82.761 Y124.690 E0.01424

G1 X82.927 Y124.624 E0.00465

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.761 Y124.690 E-0.09885

G1 X82.313 Y125.002 E-0.30287

G1 X81.640 Y125.631 E-0.51028

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X80.663 Y128.238

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X79.052 Y126.627 E0.05964

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.216 Y127.791 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z1.900 F9000.000

G1 X83.136 Y38.471

G1 Z1.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.761 Y38.618 E0.01049

G1 X82.313 Y38.931 E0.01424

G1 X81.416 Y39.768 E0.03196

G1 X80.968 Y40.027 E0.01349

G1 X80.520 Y40.148 E0.01210

G1 X80.071 Y40.167 E0.01169

G1 X79.857 Y40.133 E0.00566

G1 X79.857 Y36.572 E0.09279

G1 X80.071 Y36.581 E0.00560

G1 X80.520 Y36.510 E0.01183

G1 X80.968 Y36.333 E0.01255

G1 X81.416 Y36.020 E0.01424

G1 X82.313 Y35.183 E0.03196

G1 X82.761 Y34.924 E0.01349

G1 X83.210 Y34.803 E0.01210

G1 X83.489 Y34.791 E0.00729

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;1.85

G1 Z1.850 F9000.000

;AFTER\_LAYER\_CHANGE

;1.85

G1 E-3.20000 F4200.00000

G1 Z2.050 F9000.000

G1 X87.555 Y120.851

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.165 Y120.972 E0.01621

G1 X88.740 Y121.210 E0.01621

G1 X89.257 Y121.555 E0.01620

G1 X89.697 Y121.995 E0.01621

G1 X90.042 Y122.513 E0.01621

G1 X90.281 Y123.087 E0.01621

G1 X90.402 Y123.698 E0.01622

G1 X90.402 Y124.319 E0.01619

G1 X90.281 Y124.929 E0.01622

G1 X90.042 Y125.504 E0.01621

G1 X89.697 Y126.021 E0.01621

G1 X89.257 Y126.461 E0.01621

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G1 X88.165 Y127.045 E0.01621

G1 X87.555 Y127.166 E0.01622

G1 X86.933 Y127.166 E0.01619

G1 X86.323 Y127.045 E0.01622

G1 X85.748 Y126.806 E0.01621

G1 X85.231 Y126.461 E0.01620

G1 X84.791 Y126.021 E0.01621

G1 X84.446 Y125.504 E0.01621

G1 X84.208 Y124.929 E0.01621

G1 X84.086 Y124.319 E0.01622

G1 X84.086 Y123.697 E0.01619

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G1 X84.791 Y121.995 E0.01621

G1 X85.231 Y121.555 E0.01621

G1 X85.748 Y121.210 E0.01620

G1 X86.308 Y120.978 E0.01580

G1 X86.627 Y120.898 E0.00855

G1 X86.958 Y120.850 E0.00871

G1 X87.495 Y120.851 E0.01400

M204 S1250

G1 X87.495 Y121.268 F9000.000

M204 S800

G1 F1500.000

G1 X88.043 Y121.374 E0.01455

G1 X88.542 Y121.580 E0.01406

G1 X88.991 Y121.880 E0.01406

G1 X89.372 Y122.262 E0.01406

G1 X89.672 Y122.710 E0.01406

G1 X89.879 Y123.209 E0.01406

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G1 X89.372 Y125.755 E0.01406

G1 X88.991 Y126.137 E0.01406

G1 X88.542 Y126.436 E0.01406

G1 X88.043 Y126.643 E0.01406

G1 X87.514 Y126.748 E0.01407

G1 X86.974 Y126.748 E0.01405

G1 X86.445 Y126.643 E0.01407

G1 X85.946 Y126.436 E0.01406

G1 X85.497 Y126.137 E0.01406

G1 X85.116 Y125.755 E0.01406

G1 X84.816 Y125.306 E0.01406

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G1 X84.504 Y124.278 E0.01407

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G1 X85.497 Y121.880 E0.01406

G1 X85.946 Y121.580 E0.01406

G1 X86.440 Y121.376 E0.01392

G1 X86.708 Y121.309 E0.00720

G1 X86.988 Y121.268 E0.00738

G1 X87.435 Y121.268 E0.01165

M204 S1250

G1 X87.731 Y120.946 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.043 Y121.374 E-0.34225

G1 X88.542 Y121.580 E-0.29908

G1 X88.948 Y121.851 E-0.27067

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X87.244 Y40.181

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.625 Y40.120 E0.01620

G1 X86.030 Y39.940 E0.01621

G1 X85.481 Y39.647 E0.01620

G1 X85.000 Y39.252 E0.01621

G1 X84.606 Y38.771 E0.01621

G1 X84.313 Y38.223 E0.01621

G1 X84.132 Y37.627 E0.01621

G1 X84.071 Y37.008 E0.01620

G1 X84.132 Y36.389 E0.01620

G1 X84.313 Y35.794 E0.01621

G1 X84.606 Y35.245 E0.01621

G1 X85.000 Y34.765 E0.01621

G1 X85.481 Y34.370 E0.01621

G1 X86.030 Y34.077 E0.01621

G1 X86.625 Y33.896 E0.01620

G1 X87.220 Y33.837 E0.01559

G1 X87.554 Y33.853 E0.00871

G1 X87.878 Y33.901 E0.00853

G1 X88.458 Y34.077 E0.01580

G1 X89.007 Y34.370 E0.01621

G1 X89.488 Y34.765 E0.01621

G1 X89.882 Y35.245 E0.01621

G1 X90.176 Y35.794 E0.01621

G1 X90.356 Y36.389 E0.01621

G1 X90.417 Y37.008 E0.01621

G1 X90.356 Y37.627 E0.01621

G1 X90.176 Y38.223 E0.01621

G1 X89.882 Y38.771 E0.01621

G1 X89.488 Y39.252 E0.01621

G1 X89.007 Y39.647 E0.01621

G1 X88.458 Y39.940 E0.01620

G1 X87.863 Y40.120 E0.01621

G1 X87.304 Y40.175 E0.01464

M204 S1250

G1 X87.263 Y39.759 F9000.000

M204 S800

G1 F1500.000

G1 X86.707 Y39.708 E0.01454

G1 X86.190 Y39.552 E0.01407

G1 X85.715 Y39.298 E0.01406

G1 X85.297 Y38.955 E0.01407

G1 X84.955 Y38.538 E0.01406

G1 X84.700 Y38.062 E0.01406

G1 X84.544 Y37.545 E0.01407

G1 X84.491 Y37.008 E0.01406

G1 X84.544 Y36.471 E0.01406

G1 X84.700 Y35.955 E0.01407

G1 X84.955 Y35.479 E0.01406

G1 X85.297 Y35.061 E0.01406

G1 X85.715 Y34.719 E0.01406

G1 X86.190 Y34.465 E0.01406

G1 X86.707 Y34.308 E0.01406

G1 X87.231 Y34.256 E0.01372

G1 X87.514 Y34.269 E0.00737

G1 X87.786 Y34.310 E0.00719

G1 X88.298 Y34.465 E0.01392

G1 X88.774 Y34.719 E0.01406

G1 X89.191 Y35.061 E0.01406

G1 X89.533 Y35.479 E0.01406

G1 X89.788 Y35.955 E0.01406

G1 X89.944 Y36.471 E0.01407

G1 X89.997 Y37.008 E0.01406

G1 X89.944 Y37.545 E0.01406

G1 X89.788 Y38.062 E0.01407

G1 X89.533 Y38.538 E0.01406

G1 X89.191 Y38.955 E0.01406

G1 X88.774 Y39.298 E0.01407

G1 X88.298 Y39.552 E0.01406

G1 X87.781 Y39.708 E0.01407

G1 X87.323 Y39.754 E0.01200

M204 S1250

G1 X87.065 Y40.107 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.707 Y39.708 E-0.34200

G1 X86.190 Y39.552 E-0.29920

G1 X85.759 Y39.322 E-0.27080

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X81.184 Y32.599

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S800

G1 X81.821 Y32.472 E0.01693

G1 X82.272 Y32.432 E0.01181

G1 X92.210 Y32.432 E0.25894

G1 X92.929 Y32.508 E0.01884

G1 X93.601 Y32.709 E0.01827

G1 X94.057 Y32.938 E0.01331

G1 X94.250 Y33.061 E0.00595

G1 X94.668 Y33.386 E0.01379

G1 X94.778 Y33.496 E0.00405

G1 X95.116 Y33.889 E0.01350

G1 X95.494 Y34.528 E0.01936

G1 X95.668 Y34.977 E0.01255

G1 X95.806 Y35.718 E0.01964

G1 X95.826 Y36.033 E0.00823

G1 X95.826 Y124.981 E2.31760

G1 X95.764 Y125.641 E0.01727

G1 X95.412 Y126.641 E0.02762

G1 X95.359 Y126.763 E0.00347

G1 X94.914 Y127.384 E0.01991

G1 X94.528 Y127.753 E0.01392

G1 X94.348 Y127.892 E0.00593

G1 X93.915 Y128.166 E0.01335

G1 X93.140 Y128.467 E0.02167

G1 X92.202 Y128.590 E0.02464

G1 X82.274 Y128.590 E0.25867

G1 X81.367 Y128.470 E0.02385

G1 X80.687 Y128.223 E0.01885

G1 X80.136 Y127.889 E0.01679

G1 X79.961 Y127.753 E0.00578

G1 X79.574 Y127.384 E0.01392

G1 X79.135 Y126.774 E0.01959

G1 X78.726 Y125.646 E0.03126

G1 X78.662 Y124.978 E0.01748

G1 X78.662 Y36.041 E2.31732

G1 X78.726 Y35.363 E0.01776

G1 X78.895 Y34.780 E0.01582

G1 X79.104 Y34.306 E0.01349

G1 X79.496 Y33.729 E0.01818

G1 X79.961 Y33.270 E0.01703

G1 X80.141 Y33.130 E0.00593

G1 X80.576 Y32.855 E0.01343

G1 X81.129 Y32.622 E0.01562

M204 S1250

G1 X81.061 Y32.197 F9000.000

M204 S800

G1 F1800.000

G1 X81.762 Y32.058 E0.01862

G1 X82.254 Y32.014 E0.01288

G1 X92.233 Y32.014 E0.26000

G1 X93.012 Y32.097 E0.02042

G1 X93.756 Y32.319 E0.02024

G1 X94.264 Y32.575 E0.01481

G1 X94.491 Y32.719 E0.00702

G1 X94.945 Y33.073 E0.01498

G1 X95.084 Y33.212 E0.00513

G1 X95.457 Y33.644 E0.01487

G1 X95.872 Y34.345 E0.02123

G1 X96.071 Y34.863 E0.01446

G1 X96.222 Y35.666 E0.02130

G1 X96.244 Y36.020 E0.00924

G1 X96.244 Y124.999 E2.31842

G1 X96.174 Y125.735 E0.01926

G1 X95.801 Y126.793 E0.02923

G1 X95.726 Y126.966 E0.00492

G1 X95.321 Y127.551 E0.01853

G1 X95.218 Y127.672 E0.00415

G1 X94.800 Y128.070 E0.01502

G1 X94.588 Y128.235 E0.00701

G1 X94.107 Y128.539 E0.01482

G1 X93.445 Y128.809 E0.01862

G1 X93.229 Y128.876 E0.00589

G1 X92.229 Y129.008 E0.02628

G1 X82.255 Y129.008 E0.25990

G1 X81.265 Y128.877 E0.02601

G1 X80.505 Y128.602 E0.02106

G1 X79.899 Y128.234 E0.01849

G1 X79.688 Y128.070 E0.00695

G1 X79.271 Y127.672 E0.01502

G1 X79.166 Y127.551 E0.00418

G1 X78.764 Y126.970 E0.01839

G1 X78.315 Y125.737 E0.03420

G1 X78.244 Y124.998 E0.01933

G1 X78.244 Y36.023 E2.31832

G1 X78.315 Y35.281 E0.01943

G1 X78.501 Y34.636 E0.01748

G1 X78.732 Y34.115 E0.01486

G1 X79.166 Y33.472 E0.02021

G1 X79.688 Y32.952 E0.01919

G1 X79.900 Y32.788 E0.00701

G1 X80.382 Y32.483 E0.01485

G1 X81.006 Y32.221 E0.01762

M204 S1250

G1 X81.351 Y32.473 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.762 Y32.058 E-0.42857

G1 X82.254 Y32.014 E-0.27388

G1 X82.632 Y32.014 E-0.20955

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X79.145 Y34.523

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.168 Y33.506 E0.03760

G1 X80.321 Y33.387 E0.00505

G1 X80.722 Y33.134 E0.01237

G1 X81.276 Y32.900 E0.01569

G1 X81.380 Y32.879 E0.00276

G1 X78.847 Y35.413 E0.09340

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.011 Y34.249 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X80.019 Y36.573

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.520 Y36.551 E0.01306

G1 X80.968 Y36.419 E0.01218

G1 X81.416 Y36.149 E0.01363

G1 X82.313 Y35.314 E0.03193

G1 X82.761 Y35.012 E0.01408

G1 X83.210 Y34.846 E0.01245

G1 X83.288 Y34.836 E0.00206

G1 X83.078 Y35.267 E0.01250

G1 X82.919 Y35.711 E0.01228

G1 X82.813 Y36.141 E0.01155

G1 X82.752 Y36.552 E0.01082

G1 X82.729 Y36.995 E0.01154

G1 X82.752 Y37.464 E0.01225

G1 X82.818 Y37.902 E0.01154

G1 X82.919 Y38.305 E0.01084

G1 X83.068 Y38.724 E0.01157

G1 X83.269 Y39.149 E0.01224

G1 X83.497 Y39.528 E0.01154

G1 X83.762 Y39.883 E0.01156

G1 X84.042 Y40.191 E0.01083

G1 X84.390 Y40.507 E0.01225

G1 X84.747 Y40.770 E0.01157

G1 X85.104 Y40.984 E0.01082

G1 X85.503 Y41.174 E0.01153

G1 X85.947 Y41.333 E0.01228

G1 X86.350 Y41.434 E0.01084

G1 X86.788 Y41.500 E0.01153

G1 X87.230 Y41.523 E0.01154

G1 X87.700 Y41.500 E0.01225

G1 X88.138 Y41.434 E0.01154

G1 X88.541 Y41.333 E0.01084

G1 X88.960 Y41.185 E0.01157

G1 X89.384 Y40.984 E0.01224

G1 X89.764 Y40.755 E0.01154

G1 X90.119 Y40.490 E0.01156

G1 X90.427 Y40.211 E0.01083

G1 X90.743 Y39.862 E0.01225

G1 X90.991 Y39.528 E0.01085

G1 X91.220 Y39.149 E0.01154

G1 X91.421 Y38.724 E0.01224

G1 X91.569 Y38.306 E0.01157

G1 X91.670 Y37.902 E0.01084

G1 X91.736 Y37.465 E0.01152

G1 X91.760 Y36.994 E0.01227

G1 X91.736 Y36.552 E0.01154

G1 X91.675 Y36.141 E0.01081

G1 X91.569 Y35.711 E0.01155

G1 X91.410 Y35.267 E0.01228

G1 X91.184 Y34.808 E0.01333

G1 X91.279 Y34.814 E0.00248

G1 X91.727 Y34.946 E0.01218

G1 X92.175 Y35.216 E0.01363

G1 X93.072 Y36.051 E0.03193

G1 X93.520 Y36.353 E0.01408

G1 X93.968 Y36.519 E0.01245

G1 X94.481 Y36.576 E0.01344

M204 S1250

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G1 F7200.000

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G1 X93.072 Y36.051 E-0.29949

G1 X92.990 Y35.975 E-0.06173

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X94.481 Y40.157

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X93.520 Y40.005 E0.01218

G1 X93.072 Y39.736 E0.01363

G1 X92.175 Y38.900 E0.03193

G1 X91.727 Y38.598 E0.01408

G1 X91.496 Y38.513 E0.00641

M204 S1250

G1 X90.342 Y38.106 F9000.000

M204 S1000

G1 F4800.000

G1 X91.337 Y37.111 E0.03668

G1 X91.321 Y36.603 E0.01325

G1 X91.313 Y36.544 E0.00155

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G1 X90.591 Y36.084 E0.01817

G1 X90.447 Y35.637 E0.01225

G1 X90.906 Y35.178 E0.01691

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G1 X90.241 Y35.251 E0.01664

G1 X90.144 Y35.071 E0.00534

G1 X90.003 Y34.898 E0.00581

G1 X90.446 Y34.455 E0.01634

G1 X90.169 Y34.141 E0.01092

G1 X89.736 Y34.573 E0.01595

G1 X89.417 Y34.301 E0.01093

G1 X89.862 Y33.857 E0.01638

G1 X89.690 Y33.727 E0.00562

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G1 X92.194 Y32.745 E0.00100

G1 X92.694 Y32.798 E0.01310

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G1 X92.668 Y33.415 E0.01403

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G1 X93.485 Y33.001 E0.00844

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G1 X93.141 Y33.534 E0.01730

G1 X93.345 Y33.603 E0.00562

G1 X93.539 Y33.726 E0.00601

G1 X93.995 Y33.270 E0.01681

G1 X94.334 Y33.523 E0.01101

G1 X93.901 Y33.956 E0.01595

G1 X93.961 Y33.994 E0.00187

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G1 X94.632 Y33.816 E0.01574

G1 X94.900 Y34.139 E0.01094

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G1 X94.622 Y34.847 E0.00812

G1 X94.667 Y34.964 E0.00325

G1 X95.120 Y34.510 E0.01671

G1 X95.211 Y34.665 E0.00468

G1 X95.307 Y34.914 E0.00696

G1 X94.802 Y35.419 E0.01862

G1 X94.880 Y35.933 E0.01355

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G1 X95.513 Y83.186 E0.01541

G1 X94.893 Y83.806 E0.02287

G1 X94.893 Y84.397 E0.01541

G1 X95.513 Y83.777 E0.02287

G1 X95.513 Y84.368 E0.01541

G1 X94.892 Y84.988 E0.02288

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G1 X94.891 Y95.040 E0.01541

G1 X95.513 Y94.418 E0.02293

G1 X95.513 Y95.009 E0.01541

G1 X94.891 Y95.631 E0.02293

G1 X94.891 Y96.222 E0.01541

G1 X95.513 Y95.600 E0.02293

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G1 X94.891 Y96.814 E0.02294

G1 X94.891 Y97.405 E0.01541

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G1 X95.513 Y97.374 E0.01541

G1 X94.891 Y97.996 E0.02294

G1 X94.891 Y98.587 E0.01541

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G1 X95.513 Y98.556 E0.01541

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G1 X95.513 Y99.739 E0.01541

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G1 X94.889 Y110.413 E0.01541

G1 X95.513 Y109.789 E0.02300

G1 X95.513 Y110.380 E0.01541

G1 X94.889 Y111.004 E0.02301

G1 X94.889 Y111.595 E0.01541

G1 X95.513 Y110.971 E0.02301

G1 X95.513 Y111.562 E0.01541

G1 X94.889 Y112.187 E0.02301

G1 X94.889 Y112.778 E0.01541

G1 X95.513 Y112.154 E0.02302

G1 X95.513 Y112.745 E0.01541

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G1 X95.513 Y121.021 E0.01541

G1 X94.887 Y121.647 E0.02306

G1 X94.887 Y122.238 E0.01541

G1 X95.513 Y121.612 E0.02306

G1 X95.513 Y122.204 E0.01541

G1 X94.887 Y122.829 E0.02307

G1 X94.887 Y123.421 E0.01541

G1 X95.513 Y122.795 E0.02307

G1 X95.513 Y123.386 E0.01541

G1 X94.887 Y124.012 E0.02307

G1 X94.887 Y124.603 E0.01541

G1 X95.513 Y123.977 E0.02308

G1 X95.513 Y124.568 E0.01541

G1 X94.876 Y125.205 E0.02347

G1 X94.837 Y125.555 E0.00919

G1 X94.703 Y125.970 E0.01135

G1 X95.494 Y125.178 E0.02919

G1 X95.457 Y125.569 E0.01024

G1 X95.322 Y125.941 E0.01032

G1 X92.890 Y128.373 E0.08966

M204 S1250

G1 X92.209 Y128.463 F9000.000

M204 S1000

G1 F4800.000

G1 X93.210 Y127.462 E0.03690

G1 X92.789 Y127.600 E0.01154

G1 X92.444 Y127.637 E0.00906

G1 X91.804 Y128.277 E0.02358

G1 X91.213 Y128.277 E0.01541

G1 X91.827 Y127.663 E0.02263

G1 X91.236 Y127.663 E0.01541

G1 X90.622 Y128.277 E0.02263

G1 X90.031 Y128.277 E0.01541

G1 X90.644 Y127.663 E0.02263

G1 X90.053 Y127.663 E0.01541

G1 X89.439 Y128.277 E0.02263

G1 X88.848 Y128.277 E0.01541

G1 X89.719 Y127.407 E0.03208

G1 X89.682 Y127.296 E0.00305

G1 X89.846 Y127.173 E0.00534

G1 X90.139 Y126.908 E0.01030

G1 X90.414 Y126.605 E0.01066

G1 X90.653 Y126.282 E0.01050

G1 X90.856 Y125.943 E0.01029

G1 X91.070 Y125.464 E0.01366

G1 X88.257 Y128.277 E0.10370

G1 X87.666 Y128.277 E0.01541

G1 X91.285 Y124.658 E0.13343

G1 X91.322 Y124.407 E0.00662

G1 X91.342 Y124.010 E0.01035

G1 X90.644 Y124.708 E0.02572

G1 X90.715 Y124.350 E0.00951

G1 X90.715 Y124.045 E0.00793

G1 X91.300 Y123.460 E0.02157

G1 X91.262 Y123.206 E0.00671

G1 X91.202 Y122.967 E0.00642

G1 X90.680 Y123.490 E0.01926

G1 X90.582 Y122.996 E0.01311

G1 X91.058 Y122.520 E0.01756

G1 X90.875 Y122.112 E0.01165

G1 X90.409 Y122.578 E0.01717

G1 X90.320 Y122.364 E0.00604

G1 X90.205 Y122.191 E0.00542

G1 X90.656 Y121.740 E0.01664

G1 X90.404 Y121.401 E0.01102

G1 X89.968 Y121.837 E0.01608

G1 X89.679 Y121.534 E0.01090

G1 X90.121 Y121.092 E0.01630

G1 X89.808 Y120.814 E0.01092

G1 X89.369 Y121.253 E0.01619

G1 X89.015 Y121.017 E0.01111

G1 X89.464 Y120.567 E0.01657

G1 X89.087 Y120.353 E0.01130

G1 X88.619 Y120.821 E0.01725

G1 X88.191 Y120.657 E0.01194

G1 X88.675 Y120.174 E0.01784

G1 X88.223 Y120.034 E0.01233

G1 X87.698 Y120.560 E0.01936

G1 X87.586 Y120.537 E0.00298

G1 X87.129 Y120.537 E0.01190

G1 X87.724 Y119.942 E0.02193

G1 X87.160 Y119.915 E0.01472

G1 X86.180 Y120.895 E0.03615

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.160 Y119.915 E-0.76839

G1 X87.419 Y119.927 E-0.14361

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X83.993 Y120.878

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.658 Y120.857 E0.00876

G1 X83.210 Y120.918 E0.01179

G1 X82.761 Y121.083 E0.01245

G1 X82.313 Y121.385 E0.01408

G1 X81.416 Y122.221 E0.03193

G1 X80.968 Y122.490 E0.01363

G1 X80.520 Y122.622 E0.01218

G1 X80.007 Y122.642 E0.01337

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X80.968 Y122.490 E-0.25897

G1 X81.416 Y122.221 E-0.28981

G1 X81.521 Y122.123 E-0.07894

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X80.361 Y126.198

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.520 Y126.176 E0.00417

G1 X80.968 Y126.011 E0.01245

G1 X81.416 Y125.709 E0.01408

G1 X82.313 Y124.873 E0.03193

G1 X82.772 Y124.601 E0.01392

M204 S1250

G1 X82.994 Y123.491 F9000.000

M204 S1000

G1 F4800.000

G1 X86.503 Y119.981 E0.12939

G1 X86.058 Y120.086 E0.01192

G1 X85.665 Y120.228 E0.01089

G1 X83.150 Y122.742 E0.09271

M204 S1250

G1 X84.131 Y122.944 F9000.000

M204 S1000

G1 F4800.000

G1 X83.151 Y123.924 E0.03615

G1 X83.166 Y124.406 E0.01256

G1 X83.178 Y124.488 E0.00217

G1 X83.773 Y123.893 E0.02194

G1 X83.773 Y124.350 E0.01190

G1 X83.795 Y124.462 E0.00299

G1 X83.270 Y124.987 E0.01936

G1 X83.409 Y125.439 E0.01233

G1 X83.893 Y124.955 E0.01784

G1 X84.057 Y125.383 E0.01194

G1 X83.589 Y125.851 E0.01725

G1 X83.803 Y126.228 E0.01130

G1 X84.252 Y125.779 E0.01657

G1 X84.489 Y126.133 E0.01111

G1 X84.050 Y126.572 E0.01619

G1 X84.328 Y126.885 E0.01092

G1 X84.770 Y126.443 E0.01630

G1 X85.073 Y126.732 E0.01090

G1 X84.503 Y127.301 E0.02099

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X84.770 Y126.443 E-0.23172

G1 X84.472 Y126.742 E-0.23405

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X86.887 Y128.465

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X87.586 Y127.479 E0.00952

G1 X87.281 Y127.479 E0.00793

G1 X86.484 Y128.277 E0.02941

G1 X85.892 Y128.277 E0.01541

G1 X86.725 Y127.444 E0.03071

G1 X86.232 Y127.346 E0.01311

G1 X85.301 Y128.277 E0.03432

G1 X84.710 Y128.277 E0.01541

G1 X85.814 Y127.173 E0.04071

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G1 X82.959 Y127.663 E0.02263

G1 X82.368 Y127.663 E0.01541

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G1 X81.825 Y127.615 E0.01860

G1 X81.709 Y127.603 E0.00304

G1 X81.360 Y127.489 E0.00957

G1 X80.886 Y127.962 E0.01745

G1 X80.823 Y127.939 E0.00176

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G1 X80.158 Y127.508 E0.01632

G1 X79.856 Y127.220 E0.01090

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G1 X80.030 Y126.454 E0.00489

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G1 X79.595 Y81.959 E0.01541

G1 X78.975 Y82.579 E0.02285

G1 X78.975 Y81.988 E0.01541

G1 X79.595 Y81.368 E0.02285

G1 X79.595 Y80.777 E0.01541

G1 X78.975 Y81.397 E0.02285

G1 X78.975 Y80.805 E0.01541

G1 X79.595 Y80.185 E0.02286

G1 X79.595 Y79.594 E0.01541

G1 X78.975 Y80.214 E0.02286

G1 X78.975 Y79.623 E0.01541

G1 X79.595 Y79.003 E0.02286

G1 X79.595 Y78.412 E0.01541

G1 X78.975 Y79.032 E0.02286

G1 X78.975 Y78.441 E0.01541

G1 X79.596 Y77.820 E0.02287

G1 X79.596 Y77.229 E0.01541

G1 X78.975 Y77.850 E0.02287

G1 X78.975 Y77.258 E0.01541

G1 X79.596 Y76.638 E0.02287

G1 X79.596 Y76.047 E0.01541

G1 X78.975 Y76.667 E0.02288

G1 X78.975 Y76.076 E0.01541

G1 X79.596 Y75.455 E0.02288

G1 X79.596 Y74.864 E0.01541

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G1 X78.975 Y74.894 E0.01541

G1 X79.596 Y74.273 E0.02289

G1 X79.596 Y73.682 E0.01541

G1 X78.975 Y74.302 E0.02289

G1 X78.975 Y73.711 E0.01541

G1 X79.596 Y73.090 E0.02289

G1 X79.596 Y72.499 E0.01541

G1 X78.975 Y73.120 E0.02289

G1 X78.975 Y72.529 E0.01541

G1 X79.596 Y71.908 E0.02290

G1 X79.596 Y71.317 E0.01541

G1 X78.975 Y71.938 E0.02290

G1 X78.975 Y71.347 E0.01541

G1 X79.596 Y70.725 E0.02290

G1 X79.597 Y70.134 E0.01541

G1 X78.975 Y70.755 E0.02291

G1 X78.975 Y70.164 E0.01541

G1 X79.597 Y69.543 E0.02291

G1 X79.597 Y68.951 E0.01541

G1 X78.975 Y69.573 E0.02291

G1 X78.975 Y68.982 E0.01541

G1 X79.597 Y68.360 E0.02292

G1 X79.597 Y67.769 E0.01541

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G1 X79.599 Y54.761 E0.01541

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G1 X78.975 Y54.202 E0.02299

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G1 X78.975 Y52.429 E0.01541

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G1 X79.599 Y51.214 E0.01541

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G1 X79.599 Y50.031 E0.01541

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G1 X78.975 Y50.064 E0.01541

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G1 X79.600 Y47.666 E0.01541

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G1 X78.975 Y44.743 E0.02304

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G1 X78.975 Y42.970 E0.01541

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G1 X79.601 Y40.571 E0.01541

G1 X78.975 Y41.196 E0.02306

G1 X78.975 Y40.605 E0.01541

G1 X79.601 Y39.980 E0.02306

G1 X79.601 Y39.388 E0.01541

G1 X78.975 Y40.014 E0.02306

G1 X78.975 Y39.423 E0.01541

G1 X79.601 Y38.797 E0.02306

G1 X79.601 Y38.206 E0.01541

G1 X78.975 Y38.831 E0.02307

G1 X78.975 Y38.240 E0.01541

G1 X79.601 Y37.615 E0.02307

G1 X79.601 Y37.023 E0.01541

G1 X78.975 Y37.649 E0.02307

G1 X78.975 Y37.058 E0.01541

G1 X79.601 Y36.432 E0.02308

G1 X79.610 Y35.832 E0.01565

G1 X78.975 Y36.467 E0.02342

G1 X78.975 Y36.055 E0.01073

G1 X78.993 Y35.858 E0.00515

G1 X79.790 Y35.060 E0.02942

G1 X79.860 Y34.856 E0.00562

G1 X80.134 Y34.412 E0.01361

G1 X80.425 Y34.093 E0.01127

G1 X80.913 Y33.724 E0.01592

G1 X81.280 Y33.570 E0.01039

G1 X82.088 Y32.763 E0.02977

G1 X82.697 Y32.745 E0.01588

G1 X82.050 Y33.392 E0.02383

G1 X82.290 Y33.359 E0.00630

G1 X82.674 Y33.359 E0.01002

G1 X83.288 Y32.745 E0.02263

G1 X83.879 Y32.745 E0.01541

G1 X83.265 Y33.359 E0.02263

G1 X83.856 Y33.359 E0.01541

G1 X84.470 Y32.745 E0.02263

G1 X85.061 Y32.745 E0.01541

G1 X84.448 Y33.359 E0.02263

G1 X84.677 Y33.359 E0.00598

G1 X84.767 Y33.631 E0.00747

G1 X85.652 Y32.745 E0.03266

G1 X86.244 Y32.745 E0.01541

G1 X83.408 Y35.581 E0.10455

G1 X83.322 Y35.822 E0.00667

G1 X83.200 Y36.380 E0.01489

G1 X86.835 Y32.745 E0.13401

G1 X87.426 Y32.745 E0.01541

G1 X86.586 Y33.585 E0.03096

G1 X87.238 Y33.524 E0.01708

G1 X88.017 Y32.745 E0.02871

G1 X88.608 Y32.745 E0.01541

G1 X87.784 Y33.570 E0.03040

G1 X87.947 Y33.594 E0.00430

G1 X88.257 Y33.688 E0.00844

G1 X89.200 Y32.745 E0.03476

G1 X89.791 Y32.745 E0.01541

G1 X88.691 Y33.846 E0.04056

G1 X89.076 Y34.051 E0.01139

G1 X90.570 Y32.557 E0.05508

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.406 Y33.721 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X88.539 Y41.092

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.008 Y38.622 E0.09103

G1 X91.164 Y38.201 E0.01171

G1 X91.268 Y37.771 E0.01154

G1 X88.007 Y41.032 E0.12024

G1 X87.649 Y41.085 E0.00943

G1 X87.347 Y41.101 E0.00787

G1 X88.060 Y40.388 E0.02627

G1 X87.924 Y40.429 E0.00370

G1 X87.374 Y40.483 E0.01443

G1 X86.780 Y41.077 E0.02188

G1 X86.442 Y41.026 E0.00892

G1 X86.280 Y40.986 E0.00435

G1 X86.812 Y40.454 E0.01962

G1 X86.564 Y40.429 E0.00650

G1 X86.319 Y40.355 E0.00666

G1 X85.827 Y40.848 E0.01817

G1 X85.414 Y40.670 E0.01173

G1 X85.872 Y40.211 E0.01691

G1 X85.487 Y40.005 E0.01139

G1 X85.036 Y40.456 E0.01663

G1 X84.691 Y40.210 E0.01105

G1 X85.134 Y39.767 E0.01634

G1 X84.809 Y39.500 E0.01095

G1 X84.377 Y39.933 E0.01595

G1 X84.093 Y39.626 E0.01091

G1 X84.537 Y39.181 E0.01638

G1 X84.344 Y38.946 E0.00794

G1 X84.287 Y38.840 E0.00313

G1 X83.839 Y39.288 E0.01651

G1 X83.629 Y38.937 E0.01068

G1 X83.620 Y38.917 E0.00058

G1 X84.081 Y38.455 E0.01703

G1 X84.022 Y38.343 E0.00330

G1 X83.924 Y38.021 E0.00877

G1 X83.435 Y38.510 E0.01804

G1 X83.290 Y38.064 E0.01223

G1 X83.809 Y37.545 E0.01916

G1 X83.757 Y37.006 E0.01411

G1 X83.190 Y37.572 E0.02087

G1 X83.147 Y37.024 E0.01433

G1 X84.096 Y36.075 E0.03499

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.147 Y37.024 E-0.74370

G1 X83.171 Y37.327 E-0.16830

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X82.976 Y38.469

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.761 Y38.533 E0.00584

G1 X82.313 Y38.802 E0.01363

G1 X81.416 Y39.637 E0.03193

G1 X80.968 Y39.939 E0.01408

G1 X80.520 Y40.105 E0.01245

G1 X80.018 Y40.163 E0.01315

G1 X80.018 Y43.745 E0.09334

M73 P25 R52

G1 X80.520 Y43.723 E0.01309

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G1 X81.416 Y43.322 E0.01363

G1 X82.313 Y42.486 E0.03193

G1 X82.761 Y42.185 E0.01408

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G1 X83.658 Y41.958 E0.01179

G1 X84.106 Y41.987 E0.01171

G1 X84.554 Y42.119 E0.01218

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G1 X85.899 Y43.224 E0.03193

G1 X86.348 Y43.526 E0.01408

G1 X86.796 Y43.691 E0.01245

G1 X87.244 Y43.752 E0.01179

G1 X87.692 Y43.723 E0.01171

G1 X88.141 Y43.591 E0.01218

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G1 X89.486 Y42.486 E0.03193

G1 X89.934 Y42.185 E0.01408

G1 X90.382 Y42.019 E0.01245

G1 X90.830 Y41.958 E0.01179

G1 X91.279 Y41.987 E0.01171

G1 X91.727 Y42.119 E0.01218

G1 X92.175 Y42.388 E0.01363

G1 X93.072 Y43.224 E0.03193

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G1 X94.480 Y47.330 E0.09333

G1 X93.968 Y47.310 E0.01333

G1 X93.520 Y47.177 E0.01218

G1 X93.072 Y46.908 E0.01363

G1 X92.175 Y46.073 E0.03193

G1 X91.727 Y45.771 E0.01408

G1 X91.279 Y45.605 E0.01245

G1 X90.830 Y45.544 E0.01179

G1 X90.382 Y45.573 E0.01171

G1 X89.934 Y45.705 E0.01218

G1 X89.486 Y45.975 E0.01363

G1 X88.589 Y46.810 E0.03193

G1 X88.141 Y47.112 E0.01408

G1 X87.692 Y47.278 E0.01245

G1 X87.244 Y47.339 E0.01179

G1 X86.796 Y47.310 E0.01171

G1 X86.348 Y47.177 E0.01218

G1 X85.899 Y46.908 E0.01363

G1 X85.003 Y46.073 E0.03193

G1 X84.554 Y45.771 E0.01408

G1 X84.106 Y45.605 E0.01245

G1 X83.658 Y45.544 E0.01179

G1 X83.210 Y45.573 E0.01171

G1 X82.761 Y45.705 E0.01218

G1 X82.313 Y45.975 E0.01363

G1 X81.416 Y46.810 E0.03193

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G1 X80.520 Y47.278 E0.01245

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G1 X80.520 Y50.896 E0.01311

G1 X80.968 Y50.764 E0.01218

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G1 X82.761 Y49.357 E0.01408

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G1 X83.658 Y49.130 E0.01179

G1 X84.106 Y49.160 E0.01171

G1 X84.554 Y49.292 E0.01218

G1 X85.003 Y49.561 E0.01363

G1 X85.899 Y50.396 E0.03193

G1 X86.348 Y50.698 E0.01408

G1 X86.796 Y50.864 E0.01245

G1 X87.244 Y50.925 E0.01179

G1 X87.692 Y50.896 E0.01171

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G1 X80.017 Y54.508 E0.01320

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G1 X81.416 Y57.667 E0.01363

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G1 X84.106 Y56.332 E0.01171

G1 X84.554 Y56.464 E0.01218

G1 X85.003 Y56.734 E0.01363

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G1 X86.348 Y57.871 E0.01408

G1 X86.796 Y58.036 E0.01245

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G1 X87.692 Y58.068 E0.01171

G1 X88.141 Y57.936 E0.01218

G1 X88.589 Y57.667 E0.01363

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G1 X90.830 Y56.303 E0.01179

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G1 X84.554 Y63.637 E0.01218

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G1 X87.692 Y65.241 E0.01171

G1 X88.141 Y65.109 E0.01218

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G1 X93.072 Y68.426 E0.01363

G1 X92.175 Y67.591 E0.03193

G1 X91.727 Y67.289 E0.01408

G1 X91.279 Y67.123 E0.01245

G1 X90.830 Y67.062 E0.01179

G1 X90.382 Y67.091 E0.01171

G1 X89.934 Y67.223 E0.01218

G1 X89.486 Y67.492 E0.01363

G1 X88.589 Y68.328 E0.03193

G1 X88.141 Y68.630 E0.01408

G1 X87.692 Y68.795 E0.01245

G1 X87.244 Y68.857 E0.01179

G1 X86.796 Y68.827 E0.01171

G1 X86.348 Y68.695 E0.01218

G1 X85.899 Y68.426 E0.01363

G1 X85.003 Y67.591 E0.03193

G1 X84.554 Y67.289 E0.01408

G1 X84.106 Y67.123 E0.01245

G1 X83.658 Y67.062 E0.01179

G1 X83.210 Y67.091 E0.01171

G1 X82.761 Y67.223 E0.01218

G1 X82.313 Y67.492 E0.01363

G1 X81.416 Y68.328 E0.03193

G1 X80.968 Y68.630 E0.01408

G1 X80.520 Y68.795 E0.01245

G1 X80.015 Y68.853 E0.01325

G1 X80.014 Y72.435 E0.09334

G1 X80.520 Y72.414 E0.01319

G1 X80.968 Y72.282 E0.01218

G1 X81.416 Y72.012 E0.01363

G1 X82.313 Y71.177 E0.03193

G1 X82.761 Y70.875 E0.01408

G1 X83.210 Y70.709 E0.01245

G1 X83.658 Y70.648 E0.01179

G1 X84.106 Y70.677 E0.01171

G1 X84.554 Y70.809 E0.01218

G1 X85.003 Y71.079 E0.01363

G1 X85.899 Y71.914 E0.03193

G1 X86.348 Y72.216 E0.01408

G1 X86.796 Y72.382 E0.01245

G1 X87.244 Y72.443 E0.01179

G1 X87.692 Y72.414 E0.01171

G1 X88.141 Y72.282 E0.01218

G1 X88.589 Y72.012 E0.01363

G1 X89.486 Y71.177 E0.03193

G1 X89.934 Y70.875 E0.01408

G1 X90.382 Y70.709 E0.01245

G1 X90.830 Y70.648 E0.01179

G1 X91.279 Y70.677 E0.01171

G1 X91.727 Y70.809 E0.01218

G1 X92.175 Y71.079 E0.01363

G1 X93.072 Y71.914 E0.03193

G1 X93.520 Y72.216 E0.01408

G1 X93.968 Y72.382 E0.01245

G1 X94.476 Y72.439 E0.01332

G1 X94.476 Y76.021 E0.09333

G1 X93.968 Y76.000 E0.01323

G1 X93.520 Y75.868 E0.01218

G1 X93.072 Y75.599 E0.01363

G1 X92.175 Y74.763 E0.03193

G1 X91.727 Y74.461 E0.01408

G1 X91.279 Y74.296 E0.01245

G1 X90.830 Y74.235 E0.01179

G1 X90.382 Y74.264 E0.01171

G1 X89.934 Y74.396 E0.01218

G1 X89.486 Y74.665 E0.01363

G1 X88.589 Y75.500 E0.03193

G1 X88.141 Y75.802 E0.01408

G1 X87.692 Y75.968 E0.01245

G1 X87.244 Y76.029 E0.01179

G1 X86.796 Y76.000 E0.01171

G1 X86.348 Y75.868 E0.01218

G1 X85.899 Y75.599 E0.01363

G1 X85.003 Y74.763 E0.03193

G1 X84.554 Y74.461 E0.01408

G1 X84.106 Y74.296 E0.01245

G1 X83.658 Y74.235 E0.01179

G1 X83.210 Y74.264 E0.01171

G1 X82.761 Y74.396 E0.01218

G1 X82.313 Y74.665 E0.01363

G1 X81.416 Y75.500 E0.03193

G1 X80.968 Y75.802 E0.01408

G1 X80.520 Y75.968 E0.01245

G1 X80.014 Y76.025 E0.01327

G1 X80.013 Y79.607 E0.09333

G1 X80.520 Y79.586 E0.01321

G1 X80.968 Y79.454 E0.01218

G1 X81.416 Y79.185 E0.01363

G1 X82.313 Y78.350 E0.03193

G1 X82.761 Y78.048 E0.01408

G1 X83.210 Y77.882 E0.01245

G1 X83.658 Y77.821 E0.01179

G1 X84.106 Y77.850 E0.01171

G1 X84.554 Y77.982 E0.01218

G1 X85.003 Y78.251 E0.01363

G1 X85.899 Y79.087 E0.03193

G1 X86.348 Y79.389 E0.01408

G1 X86.796 Y79.554 E0.01245

G1 X87.244 Y79.615 E0.01179

G1 X87.692 Y79.586 E0.01171

G1 X88.141 Y79.454 E0.01218

G1 X88.589 Y79.185 E0.01363

G1 X89.486 Y78.350 E0.03193

G1 X89.934 Y78.048 E0.01408

G1 X90.382 Y77.882 E0.01245

G1 X90.830 Y77.821 E0.01179

G1 X91.279 Y77.850 E0.01171

G1 X91.727 Y77.982 E0.01218

G1 X92.175 Y78.251 E0.01363

G1 X93.072 Y79.087 E0.03193

G1 X93.520 Y79.389 E0.01408

G1 X93.968 Y79.554 E0.01245

G1 X94.475 Y79.612 E0.01329

G1 X94.475 Y83.194 E0.09334

G1 X93.968 Y83.173 E0.01321

G1 X93.520 Y83.041 E0.01218

G1 X93.072 Y82.771 E0.01363

G1 X92.175 Y81.936 E0.03193

G1 X91.727 Y81.634 E0.01408

G1 X91.279 Y81.468 E0.01245

G1 X90.830 Y81.407 E0.01179

G1 X90.382 Y81.436 E0.01171

G1 X89.934 Y81.568 E0.01218

G1 X89.486 Y81.838 E0.01363

G1 X88.589 Y82.673 E0.03193

G1 X88.141 Y82.975 E0.01408

G1 X87.692 Y83.141 E0.01245

G1 X87.244 Y83.202 E0.01179

G1 X86.796 Y83.173 E0.01171

G1 X86.348 Y83.041 E0.01218

G1 X85.899 Y82.771 E0.01363

G1 X85.003 Y81.936 E0.03193

G1 X84.554 Y81.634 E0.01408

G1 X84.106 Y81.468 E0.01245

G1 X83.658 Y81.407 E0.01179

G1 X83.210 Y81.436 E0.01171

G1 X82.761 Y81.568 E0.01218

G1 X82.313 Y81.838 E0.01363

G1 X81.416 Y82.673 E0.03193

G1 X80.968 Y82.975 E0.01408

G1 X80.520 Y83.141 E0.01245

G1 X80.013 Y83.198 E0.01330

G1 X80.012 Y86.780 E0.09333

G1 X80.520 Y86.759 E0.01324

G1 X80.968 Y86.627 E0.01218

G1 X81.416 Y86.358 E0.01363

G1 X82.313 Y85.522 E0.03193

G1 X82.761 Y85.220 E0.01408

G1 X83.210 Y85.055 E0.01245

G1 X83.658 Y84.993 E0.01179

G1 X84.106 Y85.023 E0.01171

G1 X84.554 Y85.155 E0.01218

G1 X85.003 Y85.424 E0.01363

G1 X85.899 Y86.259 E0.03193

G1 X86.348 Y86.561 E0.01408

G1 X86.796 Y86.727 E0.01245

G1 X87.244 Y86.788 E0.01179

G1 X87.692 Y86.759 E0.01171

G1 X88.141 Y86.627 E0.01218

G1 X88.589 Y86.358 E0.01363

G1 X89.486 Y85.522 E0.03193

G1 X89.934 Y85.220 E0.01408

G1 X90.382 Y85.055 E0.01245

G1 X90.830 Y84.993 E0.01179

G1 X91.279 Y85.023 E0.01171

G1 X91.727 Y85.155 E0.01218

G1 X92.175 Y85.424 E0.01363

G1 X93.072 Y86.259 E0.03193

G1 X93.520 Y86.561 E0.01408

G1 X93.968 Y86.727 E0.01245

G1 X94.474 Y86.784 E0.01327

G1 X94.474 Y90.367 E0.09334

G1 X93.968 Y90.345 E0.01318

G1 X93.520 Y90.213 E0.01218

G1 X93.072 Y89.944 E0.01363

G1 X92.175 Y89.108 E0.03193

G1 X91.727 Y88.807 E0.01408

G1 X91.279 Y88.641 E0.01245

G1 X90.830 Y88.580 E0.01179

G1 X90.382 Y88.609 E0.01171

G1 X89.934 Y88.741 E0.01218

G1 X89.486 Y89.010 E0.01363

G1 X88.589 Y89.846 E0.03193

G1 X88.141 Y90.147 E0.01408

G1 X87.692 Y90.313 E0.01245

G1 X87.244 Y90.374 E0.01179

G1 X86.796 Y90.345 E0.01171

G1 X86.348 Y90.213 E0.01218

G1 X85.899 Y89.944 E0.01363

G1 X85.003 Y89.108 E0.03193

G1 X84.554 Y88.807 E0.01408

G1 X84.106 Y88.641 E0.01245

G1 X83.658 Y88.580 E0.01179

G1 X83.210 Y88.609 E0.01171

G1 X82.761 Y88.741 E0.01218

G1 X82.313 Y89.010 E0.01363

G1 X81.416 Y89.846 E0.03193

G1 X80.968 Y90.147 E0.01408

G1 X80.520 Y90.313 E0.01245

G1 X80.012 Y90.370 E0.01332

G1 X80.011 Y93.952 E0.09333

G1 X80.520 Y93.931 E0.01326

G1 X80.968 Y93.799 E0.01218

G1 X81.416 Y93.530 E0.01363

G1 X82.313 Y92.695 E0.03193

G1 X82.761 Y92.393 E0.01408

G1 X83.210 Y92.227 E0.01245

G1 X83.658 Y92.166 E0.01179

G1 X84.106 Y92.195 E0.01171

G1 X84.554 Y92.327 E0.01218

G1 X85.003 Y92.597 E0.01363

G1 X85.899 Y93.432 E0.03193

G1 X86.348 Y93.734 E0.01408

G1 X86.796 Y93.900 E0.01245

G1 X87.244 Y93.961 E0.01179

G1 X87.692 Y93.931 E0.01171

G1 X88.141 Y93.799 E0.01218

G1 X88.589 Y93.530 E0.01363

G1 X89.486 Y92.695 E0.03193

G1 X89.934 Y92.393 E0.01408

G1 X90.382 Y92.227 E0.01245

G1 X90.830 Y92.166 E0.01179

G1 X91.279 Y92.195 E0.01171

G1 X91.727 Y92.327 E0.01218

G1 X92.175 Y92.597 E0.01363

G1 X93.072 Y93.432 E0.03193

G1 X93.520 Y93.734 E0.01408

G1 X93.968 Y93.900 E0.01245

G1 X94.473 Y93.957 E0.01324

G1 X94.473 Y97.539 E0.09334

G1 X93.968 Y97.518 E0.01316

G1 X93.520 Y97.386 E0.01218

G1 X93.072 Y97.116 E0.01363

G1 X92.175 Y96.281 E0.03193

G1 X91.727 Y95.979 E0.01408

G1 X91.279 Y95.814 E0.01245

G1 X90.830 Y95.752 E0.01179

G1 X90.382 Y95.782 E0.01171

G1 X89.934 Y95.914 E0.01218

G1 X89.486 Y96.183 E0.01363

G1 X88.589 Y97.018 E0.03193

G1 X88.141 Y97.320 E0.01408

G1 X87.692 Y97.486 E0.01245

G1 X87.244 Y97.547 E0.01179

G1 X86.796 Y97.518 E0.01171

G1 X86.348 Y97.386 E0.01218

G1 X85.899 Y97.116 E0.01363

G1 X85.003 Y96.281 E0.03193

G1 X84.554 Y95.979 E0.01408

G1 X84.106 Y95.814 E0.01245

G1 X83.658 Y95.752 E0.01179

G1 X83.210 Y95.782 E0.01171

G1 X82.761 Y95.914 E0.01218

G1 X82.313 Y96.183 E0.01363

G1 X81.416 Y97.018 E0.03193

G1 X80.968 Y97.320 E0.01408

G1 X80.520 Y97.486 E0.01245

G1 X80.011 Y97.543 E0.01335

G1 X80.010 Y101.125 E0.09333

G1 X80.520 Y101.104 E0.01329

G1 X80.968 Y100.972 E0.01218

G1 X81.416 Y100.703 E0.01363

G1 X82.313 Y99.867 E0.03193

G1 X82.761 Y99.566 E0.01408

G1 X83.210 Y99.400 E0.01245

G1 X83.658 Y99.339 E0.01179

G1 X84.106 Y99.368 E0.01171

G1 X84.554 Y99.500 E0.01218

G1 X85.003 Y99.769 E0.01363

G1 X85.899 Y100.605 E0.03193

G1 X86.348 Y100.906 E0.01408

G1 X86.796 Y101.072 E0.01245

G1 X87.244 Y101.133 E0.01179

G1 X87.692 Y101.104 E0.01171

G1 X88.141 Y100.972 E0.01218

G1 X88.589 Y100.703 E0.01363

G1 X89.486 Y99.867 E0.03193

G1 X89.934 Y99.566 E0.01408

G1 X90.382 Y99.400 E0.01245

G1 X90.830 Y99.339 E0.01179

G1 X91.279 Y99.368 E0.01171

G1 X91.727 Y99.500 E0.01218

G1 X92.175 Y99.769 E0.01363

G1 X93.072 Y100.605 E0.03193

G1 X93.520 Y100.906 E0.01408

G1 X93.968 Y101.072 E0.01245

G1 X94.472 Y101.130 E0.01322

G1 X94.472 Y104.712 E0.09334

G1 X93.968 Y104.690 E0.01313

G1 X93.520 Y104.558 E0.01218

G1 X93.072 Y104.289 E0.01363

G1 X92.175 Y103.454 E0.03193

G1 X91.727 Y103.152 E0.01408

G1 X91.279 Y102.986 E0.01245

G1 X90.830 Y102.925 E0.01179

G1 X90.382 Y102.954 E0.01171

G1 X89.934 Y103.086 E0.01218

G1 X89.486 Y103.355 E0.01363

G1 X88.589 Y104.191 E0.03193

G1 X88.141 Y104.493 E0.01408

G1 X87.692 Y104.658 E0.01245

G1 X87.244 Y104.720 E0.01179

G1 X86.796 Y104.690 E0.01171

G1 X86.348 Y104.558 E0.01218

G1 X85.899 Y104.289 E0.01363

G1 X85.003 Y103.454 E0.03193

G1 X84.554 Y103.152 E0.01408

G1 X84.106 Y102.986 E0.01245

G1 X83.658 Y102.925 E0.01179

G1 X83.210 Y102.954 E0.01171

G1 X82.761 Y103.086 E0.01218

G1 X82.313 Y103.355 E0.01363

G1 X81.416 Y104.191 E0.03193

G1 X80.968 Y104.493 E0.01408

G1 X80.520 Y104.658 E0.01245

G1 X80.010 Y104.716 E0.01337

G1 X80.009 Y108.297 E0.09333

G1 X80.520 Y108.277 E0.01332

G1 X80.968 Y108.145 E0.01218

G1 X81.416 Y107.875 E0.01363

G1 X82.313 Y107.040 E0.03193

G1 X82.761 Y106.738 E0.01408

G1 X83.210 Y106.572 E0.01245

G1 X83.658 Y106.511 E0.01179

G1 X84.106 Y106.540 E0.01171

G1 X84.554 Y106.672 E0.01218

G1 X85.003 Y106.942 E0.01363

G1 X85.899 Y107.777 E0.03193

G1 X86.348 Y108.079 E0.01408

G1 X86.796 Y108.245 E0.01245

G1 X87.244 Y108.306 E0.01179

G1 X87.692 Y108.277 E0.01171

G1 X88.141 Y108.145 E0.01218

G1 X88.589 Y107.875 E0.01363

G1 X89.486 Y107.040 E0.03193

G1 X89.934 Y106.738 E0.01408

G1 X90.382 Y106.572 E0.01245

G1 X90.830 Y106.511 E0.01179

G1 X91.279 Y106.540 E0.01171

G1 X91.727 Y106.672 E0.01218

G1 X92.175 Y106.942 E0.01363

G1 X93.072 Y107.777 E0.03193

G1 X93.520 Y108.079 E0.01408

G1 X93.968 Y108.245 E0.01245

G1 X94.471 Y108.302 E0.01319

G1 X94.471 Y111.885 E0.09334

G1 X93.968 Y111.863 E0.01311

G1 X93.520 Y111.731 E0.01218

G1 X93.072 Y111.462 E0.01363

G1 X92.175 Y110.626 E0.03193

G1 X91.727 Y110.324 E0.01408

G1 X91.279 Y110.159 E0.01245

G1 X90.830 Y110.098 E0.01179

G1 X90.382 Y110.127 E0.01171

G1 X89.934 Y110.259 E0.01218

G1 X89.486 Y110.528 E0.01363

G1 X88.589 Y111.363 E0.03193

G1 X88.141 Y111.665 E0.01408

G1 X87.692 Y111.831 E0.01245

G1 X87.244 Y111.892 E0.01179

G1 X86.796 Y111.863 E0.01171

G1 X86.348 Y111.731 E0.01218

G1 X85.899 Y111.462 E0.01363

G1 X85.003 Y110.626 E0.03193

G1 X84.554 Y110.324 E0.01408

G1 X84.106 Y110.159 E0.01245

G1 X83.658 Y110.098 E0.01179

G1 X83.210 Y110.127 E0.01171

G1 X82.761 Y110.259 E0.01218

G1 X82.313 Y110.528 E0.01363

G1 X81.416 Y111.363 E0.03193

G1 X80.968 Y111.665 E0.01408

G1 X80.520 Y111.831 E0.01245

G1 X80.009 Y111.888 E0.01340

G1 X80.008 Y115.470 E0.09333

G1 X80.520 Y115.449 E0.01334

G1 X80.968 Y115.317 E0.01218

G1 X81.416 Y115.048 E0.01363

G1 X82.313 Y114.213 E0.03193

G1 X82.761 Y113.911 E0.01408

G1 X83.210 Y113.745 E0.01245

G1 X83.658 Y113.684 E0.01179

G1 X84.106 Y113.713 E0.01171

G1 X84.554 Y113.845 E0.01218

G1 X85.003 Y114.114 E0.01363

G1 X85.899 Y114.950 E0.03193

G1 X86.348 Y115.252 E0.01408

G1 X86.796 Y115.417 E0.01245

G1 X87.244 Y115.478 E0.01179

G1 X87.692 Y115.449 E0.01171

G1 X88.141 Y115.317 E0.01218

G1 X88.589 Y115.048 E0.01363

G1 X89.486 Y114.213 E0.03193

G1 X89.934 Y113.911 E0.01408

G1 X90.382 Y113.745 E0.01245

G1 X90.830 Y113.684 E0.01179

G1 X91.279 Y113.713 E0.01171

G1 X91.727 Y113.845 E0.01218

G1 X92.175 Y114.114 E0.01363

G1 X93.072 Y114.950 E0.03193

G1 X93.520 Y115.252 E0.01408

G1 X93.968 Y115.417 E0.01245

G1 X94.470 Y115.475 E0.01317

G1 X94.470 Y119.058 E0.09335

G1 X93.968 Y119.036 E0.01308

G1 X93.520 Y118.904 E0.01218

G1 X93.072 Y118.634 E0.01363

G1 X92.175 Y117.799 E0.03193

G1 X91.727 Y117.497 E0.01408

G1 X91.279 Y117.331 E0.01245

G1 X90.830 Y117.270 E0.01179

G1 X90.382 Y117.299 E0.01171

G1 X89.934 Y117.431 E0.01218

G1 X89.486 Y117.701 E0.01363

G1 X88.589 Y118.536 E0.03193

G1 X88.141 Y118.838 E0.01408

G1 X87.692 Y119.004 E0.01245

G1 X87.244 Y119.065 E0.01179

G1 X86.796 Y119.036 E0.01171

G1 X86.348 Y118.904 E0.01218

G1 X85.899 Y118.634 E0.01363

G1 X85.003 Y117.799 E0.03193

G1 X84.554 Y117.497 E0.01408

G1 X84.106 Y117.331 E0.01245

G1 X83.658 Y117.270 E0.01179

G1 X83.210 Y117.299 E0.01171

G1 X82.761 Y117.431 E0.01218

G1 X82.313 Y117.701 E0.01363

G1 X81.416 Y118.536 E0.03193

G1 X80.968 Y118.838 E0.01408

G1 X80.520 Y119.004 E0.01245

G1 X80.008 Y119.061 E0.01343

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.520 Y119.004 E-0.28553

G1 X80.968 Y118.838 E-0.26486

G1 X81.416 Y118.536 E-0.29949

G1 X81.498 Y118.460 E-0.06212

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X90.514 Y120.900

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.830 Y120.857 E0.00832

G1 X91.279 Y120.886 E0.01171

G1 X91.727 Y121.018 E0.01218

G1 X92.175 Y121.287 E0.01363

G1 X93.072 Y122.122 E0.03193

G1 X93.520 Y122.424 E0.01408

G1 X93.968 Y122.590 E0.01245

G1 X94.469 Y122.648 E0.01314

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.968 Y122.590 E-0.27949

G1 X93.520 Y122.424 E-0.26486

G1 X93.072 Y122.122 E-0.29949

G1 X92.982 Y122.039 E-0.06816

G1 E-0.04800 F4200.00000

G1 Z2.050 F9000.000

G1 X91.707 Y124.662

G1 Z1.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.175 Y124.972 E0.01463

G1 X93.072 Y125.807 E0.03193

G1 X93.520 Y126.076 E0.01363

G1 X93.968 Y126.208 E0.01218

G1 X94.114 Y126.218 E0.00380

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;2

G1 Z2.000 F9000.000

;AFTER\_LAYER\_CHANGE

;2

G1 E-3.20000 F4200.00000

G1 Z2.200 F9000.000

G1 X90.422 Y124.972

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.312 Y125.280 E0.00851

G1 X90.172 Y125.574 E0.00848

G1 X90.005 Y125.853 E0.00848

G1 X89.811 Y126.115 E0.00850

G1 X89.592 Y126.356 E0.00849

G1 X89.351 Y126.575 E0.00849

G1 X89.089 Y126.770 E0.00850

G1 X88.809 Y126.937 E0.00848

G1 X88.515 Y127.076 E0.00848

G1 X88.208 Y127.186 E0.00850

G1 X87.892 Y127.265 E0.00850

G1 X87.570 Y127.313 E0.00848

G1 X87.244 Y127.329 E0.00849

G1 X86.918 Y127.313 E0.00850

G1 X86.597 Y127.265 E0.00848

G1 X86.280 Y127.186 E0.00850

G1 X85.973 Y127.076 E0.00851

G1 X85.679 Y126.937 E0.00848

G1 X85.400 Y126.770 E0.00848

G1 X85.137 Y126.575 E0.00850

G1 X84.896 Y126.356 E0.00849

G1 X84.677 Y126.115 E0.00849

G1 X84.483 Y125.853 E0.00850

G1 X84.316 Y125.574 E0.00848

G1 X84.176 Y125.279 E0.00848

G1 X84.066 Y124.972 E0.00850

G1 X83.987 Y124.656 E0.00850

G1 X83.940 Y124.333 E0.00849

G1 X83.924 Y124.008 E0.00848

G1 X83.940 Y123.683 E0.00849

G1 X83.987 Y123.361 E0.00849

G1 X84.066 Y123.044 E0.00850

G1 X84.176 Y122.737 E0.00851

G1 X84.316 Y122.443 E0.00848

G1 X84.483 Y122.164 E0.00848

G1 X84.677 Y121.902 E0.00850

G1 X84.896 Y121.660 E0.00849

G1 X85.137 Y121.441 E0.00849

G1 X85.399 Y121.247 E0.00850

G1 X85.679 Y121.080 E0.00848

G1 X85.973 Y120.941 E0.00848

G1 X86.280 Y120.830 E0.00850

G1 X86.602 Y120.750 E0.00863

G1 X86.993 Y120.699 E0.01028

G1 X87.556 Y120.702 E0.01466

G1 X87.892 Y120.751 E0.00885

G1 X88.208 Y120.830 E0.00850

G1 X88.515 Y120.941 E0.00851

G1 X88.810 Y121.080 E0.00848

G1 X89.089 Y121.247 E0.00848

G1 X89.351 Y121.441 E0.00850

G1 X89.592 Y121.660 E0.00849

G1 X89.811 Y121.902 E0.00849

G1 X90.005 Y122.164 E0.00850

G1 X90.173 Y122.443 E0.00848

G1 X90.312 Y122.737 E0.00848

G1 X90.422 Y123.044 E0.00850

G1 X90.501 Y123.361 E0.00850

G1 X90.549 Y123.683 E0.00848

G1 X90.565 Y124.008 E0.00849

G1 X90.549 Y124.334 E0.00850

G1 X90.501 Y124.656 E0.00848

G1 X90.436 Y124.914 E0.00694

M204 S1250

G1 X90.031 Y124.813 F9000.000

M204 S800

G1 F1500.000

G1 X89.925 Y125.119 E0.00845

G1 X89.803 Y125.377 E0.00742

G1 X89.657 Y125.621 E0.00741

G1 X89.488 Y125.850 E0.00743

G1 X89.296 Y126.061 E0.00742

G1 X89.085 Y126.252 E0.00742

G1 X88.856 Y126.422 E0.00743

G1 X88.612 Y126.568 E0.00742

G1 X88.355 Y126.690 E0.00742

G1 X88.087 Y126.786 E0.00742

G1 X87.810 Y126.855 E0.00743

G1 X87.528 Y126.897 E0.00742

G1 X87.244 Y126.911 E0.00742

G1 X86.960 Y126.897 E0.00742

G1 X86.678 Y126.855 E0.00742

G1 X86.401 Y126.786 E0.00743

G1 X86.133 Y126.690 E0.00743

G1 X85.876 Y126.568 E0.00742

G1 X85.632 Y126.422 E0.00741

G1 X85.403 Y126.252 E0.00743

G1 X85.192 Y126.061 E0.00742

G1 X85.001 Y125.850 E0.00742

G1 X84.831 Y125.621 E0.00743

G1 X84.685 Y125.376 E0.00742

G1 X84.563 Y125.119 E0.00742

G1 X84.467 Y124.851 E0.00742

G1 X84.398 Y124.574 E0.00743

G1 X84.356 Y124.292 E0.00742

G1 X84.342 Y124.008 E0.00741

G1 X84.356 Y123.724 E0.00742

G1 X84.398 Y123.442 E0.00742

G1 X84.467 Y123.166 E0.00743

G1 X84.563 Y122.897 E0.00743

G1 X84.685 Y122.640 E0.00742

G1 X84.831 Y122.396 E0.00741

G1 X85.001 Y122.167 E0.00743

G1 X85.192 Y121.956 E0.00742

G1 X85.403 Y121.765 E0.00742

G1 X85.632 Y121.595 E0.00743

G1 X85.876 Y121.449 E0.00742

G1 X86.133 Y121.327 E0.00742

G1 X86.402 Y121.231 E0.00742

G1 X86.680 Y121.161 E0.00747

G1 X87.019 Y121.117 E0.00892

G1 X87.524 Y121.119 E0.01314

G1 X87.810 Y121.162 E0.00755

G1 X88.087 Y121.231 E0.00743

G1 X88.355 Y121.327 E0.00743

G1 X88.612 Y121.449 E0.00742

G1 X88.856 Y121.595 E0.00741

G1 X89.085 Y121.765 E0.00743

G1 X89.296 Y121.956 E0.00742

G1 X89.488 Y122.167 E0.00742

G1 X89.657 Y122.396 E0.00743

G1 X89.804 Y122.640 E0.00742

G1 X89.925 Y122.897 E0.00742

G1 X90.022 Y123.166 E0.00742

G1 X90.091 Y123.442 E0.00743

G1 X90.132 Y123.724 E0.00742

G1 X90.147 Y124.008 E0.00742

G1 X90.132 Y124.293 E0.00742

G1 X90.046 Y124.755 E0.01224

M204 S1250

G1 X90.259 Y125.044 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.925 Y125.119 E-0.21282

G1 X89.803 Y125.377 E-0.15776

G1 X89.657 Y125.621 E-0.15763

G1 X89.488 Y125.850 E-0.15795

G1 X89.296 Y126.061 E-0.15779

G1 X89.205 Y126.143 E-0.06805

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X87.244 Y40.329

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.919 Y40.313 E0.00849

G1 X86.597 Y40.265 E0.00849

G1 X86.280 Y40.186 E0.00850

G1 X85.973 Y40.076 E0.00851

G1 X85.679 Y39.937 E0.00848

G1 X85.400 Y39.770 E0.00848

G1 X85.137 Y39.575 E0.00850

G1 X84.896 Y39.356 E0.00849

G1 X84.677 Y39.115 E0.00849

G1 X84.483 Y38.853 E0.00850

G1 X84.316 Y38.574 E0.00848

G1 X84.176 Y38.279 E0.00848

G1 X84.066 Y37.972 E0.00850

G1 X83.987 Y37.656 E0.00850

G1 X83.940 Y37.333 E0.00849

G1 X83.924 Y37.008 E0.00848

G1 X83.940 Y36.683 E0.00849

G1 X83.987 Y36.361 E0.00849

G1 X84.066 Y36.044 E0.00850

G1 X84.176 Y35.737 E0.00851

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G1 X87.170 Y33.690 E0.01467

G1 X87.565 Y33.703 E0.01028

G1 X87.892 Y33.751 E0.00861

G1 X88.208 Y33.830 E0.00850

G1 X88.515 Y33.941 E0.00851

G1 X88.810 Y34.080 E0.00848

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G1 X89.351 Y34.441 E0.00850

G1 X89.592 Y34.660 E0.00849

G1 X89.811 Y34.902 E0.00849

G1 X90.005 Y35.164 E0.00850

G1 X90.173 Y35.443 E0.00848

G1 X90.312 Y35.737 E0.00848

G1 X90.422 Y36.044 E0.00850

G1 X90.501 Y36.361 E0.00850

G1 X90.549 Y36.683 E0.00848

G1 X90.565 Y37.008 E0.00849

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G1 X90.501 Y37.656 E0.00848

G1 X90.422 Y37.972 E0.00850

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G1 X89.592 Y39.356 E0.00849

G1 X89.351 Y39.575 E0.00849

G1 X89.089 Y39.770 E0.00851

G1 X88.809 Y39.937 E0.00848

G1 X88.515 Y40.076 E0.00848

G1 X88.208 Y40.186 E0.00850

G1 X87.892 Y40.265 E0.00850

G1 X87.569 Y40.313 E0.00849

G1 X87.304 Y40.326 E0.00692

M204 S1250

G1 X87.284 Y39.909 F9000.000

M204 S800

G1 F1500.000

G1 X86.960 Y39.897 E0.00844

G1 X86.678 Y39.855 E0.00742

G1 X86.401 Y39.786 E0.00743

G1 X86.133 Y39.690 E0.00743

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G1 X85.192 Y39.061 E0.00742

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G1 X87.527 Y34.120 E0.00891

G1 X87.810 Y34.162 E0.00746

G1 X88.087 Y34.231 E0.00743

G1 X88.355 Y34.327 E0.00743

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G1 X89.804 Y35.640 E0.00742

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G1 X89.657 Y38.621 E0.00741

G1 X89.488 Y38.850 E0.00743

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G1 X89.085 Y39.252 E0.00742

G1 X88.856 Y39.422 E0.00743

G1 X88.612 Y39.568 E0.00741

G1 X88.355 Y39.690 E0.00742

G1 X88.087 Y39.786 E0.00742

G1 X87.810 Y39.855 E0.00743

G1 X87.344 Y39.906 E0.01223

M204 S1250

G1 X87.129 Y40.193 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.960 Y39.897 E-0.21273

G1 X86.678 Y39.855 E-0.15781

G1 X86.401 Y39.786 E-0.15799

G1 X86.133 Y39.690 E-0.15801

G1 X85.876 Y39.568 E-0.15775

G1 X85.771 Y39.505 E-0.06772

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X81.246 Y32.737

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S800

G1 X81.795 Y32.628 E0.01459

G1 X82.274 Y32.582 E0.01256

G1 X92.210 Y32.582 E0.25888

G1 X92.927 Y32.660 E0.01880

G1 X93.546 Y32.847 E0.01686

G1 X93.953 Y33.051 E0.01186

G1 X94.193 Y33.204 E0.00742

G1 X94.553 Y33.484 E0.01188

G1 X94.693 Y33.624 E0.00516

G1 X94.984 Y33.962 E0.01162

G1 X95.353 Y34.579 E0.01873

G1 X95.524 Y35.022 E0.01237

G1 X95.659 Y35.763 E0.01962

G1 X95.676 Y36.034 E0.00707

G1 X95.676 Y124.981 E2.31759

G1 X95.614 Y125.627 E0.01690

G1 X95.299 Y126.526 E0.02483

G1 X95.230 Y126.687 E0.00457

G1 X94.888 Y127.184 E0.01571

G1 X94.790 Y127.299 E0.00394

G1 X94.456 Y127.617 E0.01201

G1 X94.232 Y127.791 E0.00740

G1 X93.739 Y128.090 E0.01502

G1 X93.083 Y128.327 E0.01819

G1 X92.203 Y128.440 E0.02312

G1 X82.274 Y128.440 E0.25869

G1 X81.409 Y128.328 E0.02273

G1 X80.770 Y128.098 E0.01771

G1 X80.251 Y127.786 E0.01578

G1 X80.032 Y127.617 E0.00721

G1 X79.698 Y127.299 E0.01201

G1 X79.597 Y127.181 E0.00404

G1 X79.263 Y126.698 E0.01531

G1 X78.876 Y125.631 E0.02957

G1 X78.812 Y124.978 E0.01711

G1 X78.812 Y36.041 E2.31731

G1 X78.877 Y35.369 E0.01760

G1 X79.040 Y34.815 E0.01505

G1 X79.227 Y34.395 E0.01197

G1 X79.597 Y33.841 E0.01736

G1 X80.032 Y33.406 E0.01603

G1 X80.257 Y33.232 E0.00740

G1 X80.630 Y32.996 E0.01151

G1 X81.190 Y32.760 E0.01583

M204 S1250

G1 X81.123 Y32.335 F9000.000

M204 S800

G1 F1800.000

G1 X81.734 Y32.214 E0.01624

G1 X82.255 Y32.164 E0.01363

G1 X92.232 Y32.164 E0.25998

G1 X93.006 Y32.248 E0.02027

G1 X93.712 Y32.462 E0.01922

G1 X94.159 Y32.687 E0.01306

G1 X94.434 Y32.862 E0.00849

G1 X94.830 Y33.170 E0.01307

G1 X94.999 Y33.339 E0.00623

G1 X95.324 Y33.716 E0.01297

G1 X95.730 Y34.395 E0.02061

G1 X95.928 Y34.908 E0.01433

G1 X96.074 Y35.712 E0.02128

G1 X96.094 Y36.020 E0.00806

G1 X96.094 Y124.999 E2.31842

G1 X96.024 Y125.720 E0.01887

G1 X95.689 Y126.678 E0.02644

G1 X95.597 Y126.890 E0.00602

G1 X95.220 Y127.439 E0.01736

G1 X95.093 Y127.587 E0.00507

G1 X94.729 Y127.934 E0.01311

G1 X94.472 Y128.133 E0.00847

G1 X93.910 Y128.472 E0.01710

G1 X93.172 Y128.737 E0.02042

G1 X92.230 Y128.858 E0.02476

G1 X82.255 Y128.858 E0.25990

G1 X81.318 Y128.737 E0.02462

G1 X80.586 Y128.475 E0.02026

G1 X80.014 Y128.132 E0.01737

G1 X79.759 Y127.934 E0.00841

G1 X79.395 Y127.587 E0.01311

G1 X79.268 Y127.438 E0.00510

G1 X78.893 Y126.894 E0.01722

G1 X78.799 Y126.678 E0.00613

G1 X78.465 Y125.722 E0.02640

G1 X78.394 Y124.998 E0.01895

G1 X78.394 Y36.023 E2.31832

G1 X78.465 Y35.293 E0.01912

G1 X78.651 Y34.663 E0.01711

G1 X78.854 Y34.204 E0.01309

G1 X78.976 Y33.998 E0.00622

G1 X79.268 Y33.584 E0.01319

G1 X79.395 Y33.436 E0.00510

G1 X79.759 Y33.089 E0.01311

G1 X80.016 Y32.889 E0.00847

G1 X80.436 Y32.624 E0.01294

G1 X81.067 Y32.359 E0.01784

M204 S1250

G1 X81.412 Y32.611 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.734 Y32.214 E-0.37814

G1 X82.255 Y32.164 E-0.28981

G1 X82.695 Y32.164 E-0.24405

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X84.254 Y33.697

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.452 Y32.895 E0.02961

G1 X82.860 Y32.895 E0.01546

G1 X83.474 Y33.509 E0.02267

G1 X82.882 Y33.509 E0.01547

G1 X82.270 Y32.897 E0.02260

G1 X81.739 Y32.958 E0.01396

G1 X82.290 Y33.509 E0.02035

G1 X81.766 Y33.578 E0.01378

G1 X81.259 Y33.071 E0.01872

G1 X80.842 Y33.246 E0.01181

G1 X81.315 Y33.719 E0.01747

G1 X80.967 Y33.865 E0.00987

G1 X80.911 Y33.908 E0.00182

G1 X80.471 Y33.467 E0.01627

G1 X80.240 Y33.641 E0.00756

G1 X80.146 Y33.735 E0.00345

G1 X80.578 Y34.166 E0.01593

G1 X80.500 Y34.226 E0.00256

G1 X80.286 Y34.467 E0.00841

G1 X79.851 Y34.031 E0.01609

G1 X79.611 Y34.384 E0.01113

G1 X80.058 Y34.831 E0.01652

G1 X79.967 Y34.989 E0.00476

G1 X79.881 Y35.246 E0.00708

G1 X79.404 Y34.769 E0.01763

G1 X79.335 Y34.923 E0.00441

G1 X79.251 Y35.209 E0.00777

G1 X79.773 Y35.731 E0.01928

G1 X79.746 Y35.976 E0.00646

G1 X79.746 Y36.295 E0.00832

G1 X79.156 Y35.705 E0.02178

G1 X79.125 Y36.055 E0.00917

G1 X79.125 Y36.267 E0.00553

G1 X79.746 Y36.887 E0.02291

G1 X79.746 Y37.479 E0.01546

G1 X79.125 Y36.859 E0.02291

G1 X79.125 Y37.451 E0.01546

G1 X79.745 Y38.072 E0.02291

G1 X79.745 Y38.664 E0.01546

G1 X79.125 Y38.044 E0.02290

G1 X79.125 Y38.636 E0.01546

G1 X79.745 Y39.256 E0.02290

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G1 X79.745 Y40.440 E0.02290

G1 X79.745 Y41.032 E0.01546

G1 X79.125 Y40.412 E0.02290

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G1 X79.745 Y41.625 E0.02290

G1 X79.745 Y42.217 E0.01546

G1 X79.125 Y41.597 E0.02289

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G1 X79.745 Y43.401 E0.01546

G1 X79.125 Y42.781 E0.02289

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G1 X79.745 Y43.993 E0.02289

G1 X79.745 Y44.585 E0.01546

G1 X79.125 Y43.966 E0.02289

G1 X79.125 Y44.558 E0.01546

G1 X79.745 Y45.177 E0.02289

G1 X79.745 Y45.770 E0.01546

G1 X79.125 Y45.150 E0.02288

G1 X79.125 Y45.742 E0.01546

G1 X79.745 Y46.362 E0.02288

G1 X79.745 Y46.954 E0.01546

G1 X79.125 Y46.334 E0.02288

G1 X79.125 Y46.927 E0.01546

G1 X79.745 Y47.546 E0.02288

G1 X79.745 Y48.138 E0.01546

G1 X79.125 Y47.519 E0.02288

G1 X79.125 Y48.111 E0.01546

G1 X79.745 Y48.730 E0.02288

G1 X79.745 Y49.323 E0.01546

G1 X79.125 Y48.703 E0.02287

G1 X79.125 Y49.295 E0.01546

G1 X79.745 Y49.915 E0.02287

G1 X79.745 Y50.507 E0.01546

G1 X79.125 Y49.888 E0.02287

G1 X79.125 Y50.480 E0.01546

G1 X79.745 Y51.099 E0.02287

G1 X79.744 Y51.691 E0.01546

G1 X79.125 Y51.072 E0.02287

G1 X79.125 Y51.664 E0.01546

G1 X79.744 Y52.283 E0.02287

G1 X79.744 Y52.876 E0.01546

G1 X79.125 Y52.256 E0.02286

G1 X79.125 Y52.849 E0.01546

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G1 X95.363 Y73.232 E0.01546

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G1 X95.363 Y38.884 E0.01546

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G1 X94.749 Y37.678 E0.01546

G1 X95.363 Y38.292 E0.02267

G1 X95.363 Y37.700 E0.01546

G1 X94.749 Y37.086 E0.02267

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G1 X95.363 Y37.107 E0.02267

G1 X95.363 Y36.515 E0.01546

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G1 X94.634 Y35.296 E0.01522

G1 X94.570 Y35.130 E0.00466

G1 X95.551 Y36.111 E0.03624

M204 S1250

G1 X95.473 Y35.441 F9000.000

M204 S1000

G1 F4800.000

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G1 X92.864 Y32.968 E0.00531

G1 X92.353 Y32.913 E0.01344

G1 X93.125 Y33.685 E0.02852

G1 X92.847 Y33.588 E0.00768

G1 X92.378 Y33.531 E0.01233

G1 X91.743 Y32.895 E0.02346

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G1 X91.765 Y33.509 E0.02267

G1 X91.173 Y33.509 E0.01547

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M73 P27 R51

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G1 X84.843 Y34.286 E0.01101

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G1 X84.112 Y34.147 E0.01094

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G1 X83.230 Y35.634 E0.00689

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G1 X83.631 Y36.627 E0.01329

G1 X83.099 Y36.096 E0.01964

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G1 X83.620 Y37.208 E0.02227

G1 X83.680 Y37.717 E0.01337

G1 X83.727 Y37.908 E0.00515

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G1 X88.157 Y41.153 E0.01348

G1 X87.625 Y40.621 E0.01964

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G1 X89.672 Y39.707 E0.01100

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G1 X90.400 Y39.843 E0.01094

G1 X89.967 Y39.410 E0.01601

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G1 X90.666 Y39.517 E0.01617

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G1 X90.454 Y38.712 E0.01652

G1 X90.636 Y38.303 E0.01171

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G1 X91.271 Y38.346 E0.01192

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G1 X90.862 Y37.344 E0.01340

G1 X91.399 Y37.881 E0.01983

G1 X91.474 Y37.364 E0.01364

G1 X90.866 Y36.756 E0.02245

G1 X90.809 Y36.300 E0.01201

G1 X90.744 Y36.042 E0.00694

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M204 S1250

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G1 F7200.000

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G1 X90.816 Y36.358 E-0.03259

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X91.615 Y38.625

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X82.313 Y42.612 E0.01479

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G1 X87.692 Y61.589 E0.01199

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G1 X89.037 Y107.619 E0.01661

G1 X88.589 Y108.013 E0.01555

G1 X88.141 Y108.240 E0.01310

G1 X87.692 Y108.328 E0.01190

G1 X87.244 Y108.315 E0.01169

G1 X86.796 Y108.211 E0.01199

G1 X86.348 Y108.000 E0.01291

G1 X85.899 Y107.651 E0.01479

G1 X85.451 Y107.198 E0.01661

G1 X85.003 Y106.804 E0.01555

G1 X84.554 Y106.577 E0.01310

G1 X84.106 Y106.489 E0.01190

G1 X83.658 Y106.503 E0.01169

G1 X83.210 Y106.606 E0.01199

G1 X82.761 Y106.817 E0.01291

G1 X82.313 Y107.166 E0.01479

G1 X81.865 Y107.619 E0.01661

G1 X81.416 Y108.013 E0.01555

G1 X80.968 Y108.240 E0.01310

G1 X80.520 Y108.328 E0.01190

G1 X80.158 Y108.317 E0.00943

G1 X80.158 Y111.881 E0.09286

G1 X80.520 Y111.797 E0.00968

G1 X80.968 Y111.586 E0.01291

G1 X81.416 Y111.238 E0.01479

G1 X81.865 Y110.785 E0.01661

G1 X82.313 Y110.391 E0.01555

G1 X82.761 Y110.163 E0.01310

G1 X83.210 Y110.076 E0.01190

G1 X83.658 Y110.089 E0.01169

G1 X84.106 Y110.192 E0.01199

G1 X84.554 Y110.404 E0.01291

G1 X85.003 Y110.752 E0.01479

G1 X85.451 Y111.205 E0.01661

G1 X85.899 Y111.599 E0.01555

G1 X86.348 Y111.827 E0.01310

G1 X86.796 Y111.914 E0.01190

G1 X87.244 Y111.901 E0.01169

G1 X87.692 Y111.797 E0.01199

G1 X88.141 Y111.586 E0.01291

G1 X88.589 Y111.238 E0.01479

G1 X89.037 Y110.785 E0.01661

G1 X89.486 Y110.391 E0.01555

G1 X89.934 Y110.163 E0.01310

G1 X90.382 Y110.076 E0.01190

G1 X90.830 Y110.089 E0.01169

G1 X91.279 Y110.192 E0.01199

G1 X91.727 Y110.404 E0.01291

G1 X92.175 Y110.752 E0.01479

G1 X92.624 Y111.205 E0.01661

G1 X93.072 Y111.599 E0.01555

G1 X93.520 Y111.827 E0.01310

G1 X93.968 Y111.914 E0.01190

G1 X94.326 Y111.904 E0.00931

G1 X94.325 Y115.466 E0.09283

G1 X93.968 Y115.384 E0.00955

G1 X93.520 Y115.172 E0.01291

G1 X93.072 Y114.824 E0.01479

G1 X92.624 Y114.371 E0.01661

G1 X92.175 Y113.977 E0.01555

G1 X91.727 Y113.749 E0.01310

G1 X91.279 Y113.662 E0.01190

G1 X90.830 Y113.675 E0.01169

G1 X90.382 Y113.779 E0.01199

G1 X89.934 Y113.990 E0.01291

G1 X89.486 Y114.338 E0.01479

G1 X89.037 Y114.792 E0.01661

G1 X88.589 Y115.186 E0.01555

G1 X88.141 Y115.413 E0.01310

G1 X87.692 Y115.500 E0.01190

G1 X87.244 Y115.487 E0.01169

G1 X86.796 Y115.384 E0.01199

G1 X86.348 Y115.172 E0.01291

G1 X85.899 Y114.824 E0.01479

G1 X85.451 Y114.371 E0.01661

G1 X85.003 Y113.977 E0.01555

G1 X84.554 Y113.749 E0.01310

G1 X84.106 Y113.662 E0.01190

G1 X83.658 Y113.675 E0.01169

G1 X83.210 Y113.779 E0.01199

G1 X82.761 Y113.990 E0.01291

G1 X82.313 Y114.338 E0.01479

G1 X81.865 Y114.792 E0.01661

G1 X81.416 Y115.186 E0.01555

G1 X80.968 Y115.413 E0.01310

G1 X80.520 Y115.500 E0.01190

G1 X80.158 Y115.490 E0.00944

G1 X80.157 Y119.054 E0.09286

G1 X80.520 Y118.970 E0.00969

G1 X80.968 Y118.759 E0.01291

G1 X81.416 Y118.410 E0.01479

G1 X81.865 Y117.957 E0.01661

G1 X82.313 Y117.563 E0.01555

G1 X82.761 Y117.336 E0.01310

G1 X83.210 Y117.248 E0.01190

G1 X83.658 Y117.262 E0.01169

G1 X84.106 Y117.365 E0.01199

G1 X84.554 Y117.576 E0.01291

G1 X85.003 Y117.925 E0.01479

G1 X85.451 Y118.378 E0.01661

G1 X85.899 Y118.772 E0.01555

G1 X86.348 Y118.999 E0.01310

G1 X86.796 Y119.087 E0.01190

G1 X87.244 Y119.073 E0.01169

G1 X87.692 Y118.970 E0.01199

G1 X88.141 Y118.759 E0.01291

G1 X88.589 Y118.410 E0.01479

G1 X89.037 Y117.957 E0.01661

G1 X89.486 Y117.563 E0.01555

G1 X89.934 Y117.336 E0.01310

G1 X90.382 Y117.248 E0.01190

G1 X90.830 Y117.262 E0.01169

G1 X91.279 Y117.365 E0.01199

G1 X91.727 Y117.576 E0.01291

G1 X92.175 Y117.925 E0.01479

G1 X92.624 Y118.378 E0.01661

G1 X93.072 Y118.772 E0.01555

G1 X93.520 Y118.999 E0.01310

G1 X93.968 Y119.087 E0.01190

G1 X94.325 Y119.076 E0.00930

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.968 Y119.087 E-0.19779

G1 X93.520 Y118.999 E-0.25310

G1 X93.072 Y118.772 E-0.27857

G1 X92.824 Y118.554 E-0.18254

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X93.916 Y126.249

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X93.520 Y126.172 E0.01050

G1 X93.072 Y125.944 E0.01310

G1 X92.624 Y125.550 E0.01555

G1 X92.175 Y125.097 E0.01661

G1 X91.833 Y124.831 E0.01129

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.175 Y125.097 E-0.24018

G1 X92.624 Y125.550 E-0.35320

G1 X93.055 Y125.930 E-0.31861

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X94.325 Y122.639

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X93.968 Y122.556 E0.00953

G1 X93.520 Y122.345 E0.01291

G1 X93.072 Y121.997 E0.01479

G1 X92.624 Y121.543 E0.01661

G1 X92.175 Y121.149 E0.01555

G1 X91.727 Y120.922 E0.01310

G1 X91.279 Y120.835 E0.01190

G1 X90.830 Y120.848 E0.01169

G1 X90.697 Y120.879 E0.00356

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.830 Y120.848 E-0.07578

G1 X91.279 Y120.835 E-0.24853

G1 X91.727 Y120.922 E-0.25310

G1 X92.175 Y121.149 E-0.27857

G1 X92.251 Y121.216 E-0.05601

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X91.453 Y122.620

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.633 Y119.800 E0.10415

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.796 Y120.963 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X83.823 Y120.843

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.658 Y120.848 E0.00432

G1 X83.210 Y120.951 E0.01199

G1 X82.761 Y121.163 E0.01291

G1 X82.313 Y121.511 E0.01479

G1 X81.865 Y121.964 E0.01661

G1 X81.416 Y122.358 E0.01555

G1 X80.968 Y122.586 E0.01310

G1 X80.520 Y122.673 E0.01190

G1 X80.157 Y122.662 E0.00946

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.520 Y122.673 E-0.20110

G1 X80.968 Y122.586 E-0.25310

G1 X81.416 Y122.358 E-0.27857

G1 X81.659 Y122.145 E-0.17924

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X82.618 Y124.581

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.313 Y124.736 E0.00891

G1 X81.865 Y125.130 E0.01555

G1 X81.416 Y125.583 E0.01661

G1 X80.968 Y125.931 E0.01479

G1 X80.504 Y126.146 E0.01332

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.968 Y125.931 E-0.28330

G1 X81.416 Y125.583 E-0.31466

G1 X81.815 Y125.180 E-0.31405

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X80.830 Y127.987

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X79.934 Y127.090 E0.03312

G1 X79.589 Y126.624 E0.01513

G1 X79.478 Y126.404 E0.00645

G1 X79.283 Y125.847 E0.01539

G1 X81.675 Y128.239 E0.08833

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.511 Y127.075 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X85.850 Y41.215

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.037 Y38.403 E0.10387

M204 S1250

G1 X82.803 Y38.429 F9000.000

M204 S1000

G1 F4800.000

G1 X82.313 Y38.664 E0.01416

G1 X81.865 Y39.058 E0.01555

G1 X81.416 Y39.512 E0.01661

G1 X80.968 Y39.860 E0.01479

G1 X80.520 Y40.071 E0.01291

G1 X80.163 Y40.154 E0.00954

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.520 Y40.071 E-0.20284

G1 X80.968 Y39.860 E-0.27463

G1 X81.416 Y39.512 E-0.31466

G1 X81.569 Y39.358 E-0.11987

G1 E-0.04800 F4200.00000

G1 Z2.200 F9000.000

G1 X80.163 Y36.591

G1 Z2.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.520 Y36.602 E0.00929

G1 X80.968 Y36.514 E0.01190

G1 X81.416 Y36.287 E0.01310

G1 X81.865 Y35.893 E0.01555

G1 X82.313 Y35.440 E0.01661

G1 X82.761 Y35.091 E0.01479

G1 X83.063 Y34.949 E0.00869

G1 X82.929 Y35.235 E0.00823

G1 X82.784 Y35.641 E0.01123

G1 X82.666 Y36.112 E0.01266

G1 X82.600 Y36.565 E0.01192

G1 X82.579 Y36.995 E0.01121

G1 X82.600 Y37.452 E0.01192

G1 X82.671 Y37.931 E0.01263

G1 X82.784 Y38.376 E0.01195

G1 X82.940 Y38.807 E0.01194

G1 X83.124 Y39.195 E0.01120

G1 X83.357 Y39.588 E0.01191

G1 X83.629 Y39.957 E0.01195

G1 X83.955 Y40.317 E0.01264

G1 X84.295 Y40.623 E0.01193

G1 X84.641 Y40.880 E0.01123

G1 X85.033 Y41.116 E0.01192

G1 X85.471 Y41.323 E0.01262

G1 X85.903 Y41.477 E0.01195

G1 X86.321 Y41.581 E0.01122

G1 X86.773 Y41.650 E0.01192

G1 X87.258 Y41.673 E0.01264

G1 X87.715 Y41.650 E0.01192

G1 X88.167 Y41.581 E0.01192

G1 X88.585 Y41.477 E0.01122

G1 X89.043 Y41.313 E0.01267

G1 X89.455 Y41.116 E0.01191

G1 X89.824 Y40.895 E0.01120

G1 X90.193 Y40.623 E0.01194

G1 X90.553 Y40.297 E0.01264

G1 X90.842 Y39.979 E0.01121

G1 X91.116 Y39.611 E0.01194

G1 X91.352 Y39.219 E0.01192

G1 X91.559 Y38.781 E0.01263

G1 X91.713 Y38.349 E0.01195

G1 X91.817 Y37.931 E0.01122

G1 X91.885 Y37.479 E0.01191

G1 X91.909 Y36.994 E0.01266

G1 X91.888 Y36.564 E0.01122

G1 X91.822 Y36.112 E0.01191

G1 X91.713 Y35.667 E0.01193

G1 X91.549 Y35.210 E0.01267

G1 X91.339 Y34.775 E0.01258

G1 X91.727 Y34.851 E0.01031

G1 X92.175 Y35.078 E0.01310

G1 X92.624 Y35.472 E0.01555

G1 X93.072 Y35.925 E0.01661

G1 X93.520 Y36.274 E0.01479

G1 X93.968 Y36.485 E0.01291

G1 X94.331 Y36.569 E0.00970

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;2.15

G1 Z2.150 F9000.000

;AFTER\_LAYER\_CHANGE

;2.15

G1 E-3.20000 F4200.00000

G1 Z2.350 F9000.000

G1 X87.572 Y120.553

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.921 Y120.604 E0.00919

G1 X88.252 Y120.687 E0.00888

G1 X88.573 Y120.802 E0.00889

G1 X88.880 Y120.948 E0.00886

G1 X89.172 Y121.122 E0.00886

G1 X89.446 Y121.325 E0.00888

G1 X89.698 Y121.554 E0.00887

G1 X89.927 Y121.806 E0.00887

G1 X90.130 Y122.080 E0.00888

G1 X90.305 Y122.372 E0.00887

G1 X90.450 Y122.680 E0.00886

G1 X90.565 Y123.001 E0.00888

G1 X90.648 Y123.332 E0.00888

G1 X90.698 Y123.668 E0.00886

G1 X90.715 Y124.008 E0.00888

G1 X90.698 Y124.349 E0.00888

G1 X90.648 Y124.685 E0.00886

G1 X90.565 Y125.016 E0.00888

G1 X90.450 Y125.337 E0.00889

G1 X90.305 Y125.644 E0.00886

G1 X90.130 Y125.936 E0.00886

G1 X89.927 Y126.210 E0.00888

G1 X89.698 Y126.462 E0.00887

G1 X89.446 Y126.691 E0.00887

G1 X89.172 Y126.894 E0.00889

G1 X88.880 Y127.069 E0.00887

G1 X88.573 Y127.215 E0.00886

G1 X88.252 Y127.330 E0.00888

G1 X87.921 Y127.412 E0.00888

G1 X87.584 Y127.462 E0.00886

G1 X87.244 Y127.479 E0.00888

G1 X86.904 Y127.462 E0.00888

G1 X86.567 Y127.412 E0.00886

G1 X86.237 Y127.330 E0.00888

G1 X85.915 Y127.214 E0.00889

G1 X85.608 Y127.069 E0.00886

G1 X85.316 Y126.894 E0.00886

G1 X85.042 Y126.691 E0.00889

G1 X84.790 Y126.462 E0.00887

G1 X84.561 Y126.210 E0.00887

G1 X84.358 Y125.936 E0.00888

G1 X84.183 Y125.644 E0.00887

G1 X84.038 Y125.337 E0.00887

G1 X83.923 Y125.016 E0.00888

G1 X83.840 Y124.685 E0.00888

G1 X83.790 Y124.348 E0.00887

G1 X83.774 Y124.008 E0.00887

G1 X83.790 Y123.668 E0.00887

G1 X83.840 Y123.332 E0.00887

G1 X83.923 Y123.001 E0.00888

G1 X84.038 Y122.680 E0.00889

G1 X84.184 Y122.372 E0.00886

G1 X84.358 Y122.080 E0.00886

G1 X84.561 Y121.806 E0.00888

G1 X84.790 Y121.554 E0.00887

G1 X85.042 Y121.325 E0.00887

G1 X85.316 Y121.122 E0.00888

G1 X85.608 Y120.948 E0.00887

G1 X85.916 Y120.802 E0.00887

G1 X86.237 Y120.687 E0.00888

G1 X86.575 Y120.602 E0.00909

G1 X87.027 Y120.547 E0.01185

G1 X87.512 Y120.552 E0.01264

M204 S1250

G1 X87.507 Y120.970 F9000.000

M204 S800

G1 F1500.000

G1 X87.839 Y121.015 E0.00873

G1 X88.130 Y121.087 E0.00781

G1 X88.412 Y121.188 E0.00781

G1 X88.683 Y121.317 E0.00780

G1 X88.940 Y121.470 E0.00780

G1 X89.181 Y121.649 E0.00781

G1 X89.402 Y121.850 E0.00780

G1 X89.604 Y122.072 E0.00780

G1 X89.782 Y122.313 E0.00781

G1 X89.936 Y122.569 E0.00780

G1 X90.064 Y122.840 E0.00780

G1 X90.165 Y123.122 E0.00781

G1 X90.238 Y123.413 E0.00781

G1 X90.282 Y123.709 E0.00780

G1 X90.297 Y124.008 E0.00780

G1 X90.282 Y124.307 E0.00780

G1 X90.238 Y124.604 E0.00780

G1 X90.165 Y124.894 E0.00781

G1 X90.064 Y125.177 E0.00781

G1 X89.936 Y125.447 E0.00780

G1 X89.782 Y125.704 E0.00780

G1 X89.604 Y125.945 E0.00781

G1 X89.402 Y126.167 E0.00780

G1 X89.181 Y126.368 E0.00780

G1 X88.940 Y126.546 E0.00781

G1 X88.683 Y126.700 E0.00780

G1 X88.412 Y126.828 E0.00780

G1 X88.130 Y126.929 E0.00781

G1 X87.839 Y127.002 E0.00781

G1 X87.543 Y127.046 E0.00780

G1 X87.244 Y127.061 E0.00780

G1 X86.945 Y127.046 E0.00780

G1 X86.649 Y127.002 E0.00780

G1 X86.358 Y126.929 E0.00781

G1 X86.076 Y126.828 E0.00781

G1 X85.805 Y126.700 E0.00780

G1 X85.548 Y126.546 E0.00779

G1 X85.308 Y126.368 E0.00781

G1 X85.086 Y126.167 E0.00780

G1 X84.885 Y125.945 E0.00780

G1 X84.706 Y125.704 E0.00781

G1 X84.552 Y125.447 E0.00780

G1 X84.424 Y125.176 E0.00780

G1 X84.323 Y124.894 E0.00781

G1 X84.251 Y124.604 E0.00781

G1 X84.207 Y124.307 E0.00781

G1 X84.192 Y124.008 E0.00780

G1 X84.207 Y123.709 E0.00780

G1 X84.251 Y123.413 E0.00780

G1 X84.323 Y123.122 E0.00781

G1 X84.424 Y122.840 E0.00781

G1 X84.552 Y122.569 E0.00780

G1 X84.706 Y122.313 E0.00780

G1 X84.885 Y122.072 E0.00781

G1 X85.086 Y121.850 E0.00780

G1 X85.308 Y121.649 E0.00780

G1 X85.548 Y121.470 E0.00781

G1 X85.805 Y121.317 E0.00780

G1 X86.076 Y121.188 E0.00780

G1 X86.358 Y121.087 E0.00781

G1 X86.652 Y121.014 E0.00789

G1 X87.050 Y120.965 E0.01046

G1 X87.447 Y120.969 E0.01035

M204 S1250

G1 X87.695 Y120.693 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.839 Y121.015 E-0.21863

G1 X88.130 Y121.087 E-0.16611

G1 X88.412 Y121.188 E-0.16617

G1 X88.683 Y121.317 E-0.16591

G1 X88.940 Y121.470 E-0.16580

G1 X88.982 Y121.502 E-0.02937

G1 E-0.04800 F4200.00000

G1 Z2.350 F9000.000

G1 X87.244 Y40.479

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.904 Y40.462 E0.00887

G1 X86.567 Y40.412 E0.00887

G1 X86.237 Y40.330 E0.00888

G1 X85.915 Y40.214 E0.00889

G1 X85.608 Y40.069 E0.00886

G1 X85.316 Y39.894 E0.00886

G1 X85.042 Y39.691 E0.00889

G1 X84.790 Y39.462 E0.00887

G1 X84.561 Y39.210 E0.00887

G1 X84.358 Y38.936 E0.00888

G1 X84.183 Y38.644 E0.00887

G1 X84.038 Y38.337 E0.00887

G1 X83.923 Y38.016 E0.00888

G1 X83.840 Y37.685 E0.00888

G1 X83.790 Y37.348 E0.00887

G1 X83.774 Y37.008 E0.00887

G1 X83.790 Y36.668 E0.00887

G1 X83.840 Y36.332 E0.00887

G1 X83.923 Y36.001 E0.00888

G1 X84.038 Y35.680 E0.00889

G1 X84.184 Y35.372 E0.00886

G1 X84.358 Y35.080 E0.00886

G1 X84.561 Y34.806 E0.00888

G1 X84.790 Y34.554 E0.00887

G1 X85.042 Y34.325 E0.00887

G1 X85.316 Y34.122 E0.00888

G1 X85.608 Y33.948 E0.00887

G1 X85.916 Y33.802 E0.00886

G1 X86.237 Y33.687 E0.00888

G1 X86.579 Y33.601 E0.00921

G1 X87.121 Y33.542 E0.01421

G1 X87.576 Y33.553 E0.01185

G1 X87.921 Y33.604 E0.00908

G1 X88.252 Y33.687 E0.00888

G1 X88.573 Y33.802 E0.00889

G1 X88.880 Y33.948 E0.00886

G1 X89.172 Y34.122 E0.00886

G1 X89.446 Y34.325 E0.00888

G1 X89.698 Y34.554 E0.00887

G1 X89.927 Y34.806 E0.00887

G1 X90.130 Y35.080 E0.00888

G1 X90.305 Y35.372 E0.00887

G1 X90.450 Y35.680 E0.00886

G1 X90.565 Y36.001 E0.00888

G1 X90.648 Y36.332 E0.00888

G1 X90.698 Y36.668 E0.00886

G1 X90.715 Y37.008 E0.00888

G1 X90.698 Y37.349 E0.00888

G1 X90.648 Y37.685 E0.00886

G1 X90.565 Y38.016 E0.00888

G1 X90.450 Y38.337 E0.00889

G1 X90.305 Y38.644 E0.00886

G1 X90.130 Y38.936 E0.00886

G1 X89.927 Y39.210 E0.00888

G1 X89.698 Y39.462 E0.00887

G1 X89.446 Y39.691 E0.00887

G1 X89.172 Y39.894 E0.00888

G1 X88.880 Y40.069 E0.00887

G1 X88.573 Y40.215 E0.00886

G1 X88.252 Y40.330 E0.00888

G1 X87.921 Y40.412 E0.00888

G1 X87.584 Y40.462 E0.00887

G1 X87.304 Y40.476 E0.00730

M204 S1250

G1 X87.284 Y40.058 F9000.000

M204 S800

G1 F1500.000

G1 X86.945 Y40.046 E0.00883

G1 X86.649 Y40.002 E0.00780

G1 X86.358 Y39.929 E0.00781

G1 X86.076 Y39.828 E0.00781

G1 X85.805 Y39.700 E0.00780

G1 X85.548 Y39.546 E0.00779

G1 X85.308 Y39.368 E0.00781

G1 X85.086 Y39.167 E0.00780

G1 X84.885 Y38.945 E0.00780

G1 X84.706 Y38.704 E0.00781

G1 X84.552 Y38.447 E0.00780

G1 X84.424 Y38.176 E0.00780

G1 X84.323 Y37.894 E0.00781

G1 X84.251 Y37.604 E0.00781

G1 X84.207 Y37.307 E0.00781

G1 X84.192 Y37.008 E0.00780

G1 X84.207 Y36.709 E0.00780

G1 X84.251 Y36.413 E0.00780

G1 X84.323 Y36.122 E0.00781

G1 X84.424 Y35.840 E0.00781

G1 X84.552 Y35.569 E0.00780

G1 X84.706 Y35.313 E0.00780

G1 X84.885 Y35.072 E0.00781

G1 X85.086 Y34.850 E0.00780

G1 X85.308 Y34.649 E0.00780

G1 X85.548 Y34.470 E0.00781

G1 X85.805 Y34.317 E0.00780

G1 X86.076 Y34.188 E0.00780

G1 X86.358 Y34.087 E0.00781

G1 X86.653 Y34.014 E0.00792

G1 X87.139 Y33.961 E0.01274

G1 X87.540 Y33.970 E0.01046

G1 X87.839 Y34.015 E0.00788

G1 X88.130 Y34.087 E0.00781

G1 X88.412 Y34.188 E0.00781

G1 X88.683 Y34.317 E0.00780

G1 X88.940 Y34.470 E0.00780

G1 X89.181 Y34.649 E0.00781

G1 X89.402 Y34.850 E0.00780

G1 X89.604 Y35.072 E0.00780

G1 X89.782 Y35.313 E0.00781

G1 X89.936 Y35.569 E0.00780

G1 X90.064 Y35.840 E0.00780

G1 X90.165 Y36.122 E0.00781

G1 X90.238 Y36.413 E0.00781

G1 X90.282 Y36.709 E0.00780

G1 X90.297 Y37.008 E0.00780

G1 X90.282 Y37.307 E0.00780

G1 X90.238 Y37.604 E0.00780

G1 X90.165 Y37.894 E0.00781

G1 X90.064 Y38.177 E0.00781

G1 X89.936 Y38.447 E0.00780

G1 X89.782 Y38.704 E0.00780

G1 X89.604 Y38.945 E0.00781

G1 X89.402 Y39.167 E0.00780

G1 X89.181 Y39.368 E0.00780

G1 X88.940 Y39.546 E0.00781

G1 X88.683 Y39.700 E0.00780

G1 X88.412 Y39.828 E0.00780

G1 X88.130 Y39.929 E0.00781

G1 X87.839 Y40.002 E0.00781

G1 X87.344 Y40.056 E0.01299

M204 S1250

G1 X87.122 Y40.356 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.945 Y40.046 E-0.22088

G1 X86.649 Y40.002 E-0.16596

G1 X86.358 Y39.929 E-0.16615

G1 X86.076 Y39.828 E-0.16614

G1 X85.805 Y39.700 E-0.16591

G1 X85.763 Y39.675 E-0.02697

G1 E-0.04800 F4200.00000

G1 Z2.350 F9000.000

G1 X81.307 Y32.875

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S800

G1 X81.768 Y32.783 E0.01225

G1 X82.276 Y32.732 E0.01330

G1 X92.209 Y32.732 E0.25881

G1 X92.918 Y32.811 E0.01859

G1 X93.507 Y32.992 E0.01606

G1 X93.848 Y33.164 E0.00995

G1 X94.136 Y33.347 E0.00889

G1 X94.438 Y33.582 E0.00996

G1 X94.608 Y33.752 E0.00626

G1 X94.860 Y34.044 E0.01005

G1 X95.208 Y34.622 E0.01758

G1 X95.380 Y35.067 E0.01243

G1 X95.512 Y35.807 E0.01960

G1 X95.526 Y36.034 E0.00591

G1 X95.526 Y124.981 E2.31759

G1 X95.464 Y125.613 E0.01654

G1 X95.187 Y126.412 E0.02204

G1 X95.101 Y126.612 E0.00567

G1 X94.786 Y127.073 E0.01453

G1 X94.665 Y127.213 E0.00483

G1 X94.385 Y127.481 E0.01010

G1 X94.116 Y127.689 E0.00887

G1 X93.660 Y127.962 E0.01384

G1 X93.026 Y128.187 E0.01753

G1 X92.204 Y128.290 E0.02159

G1 X82.274 Y128.290 E0.25872

G1 X81.467 Y128.188 E0.02120

G1 X81.199 Y128.105 E0.00732

G1 X80.704 Y127.899 E0.01397

G1 X80.372 Y127.689 E0.01022

G1 X80.103 Y127.481 E0.00887

G1 X79.823 Y127.213 E0.01010

G1 X79.699 Y127.069 E0.00496

G1 X79.392 Y126.622 E0.01413

G1 X79.301 Y126.412 E0.00595

G1 X79.026 Y125.617 E0.02193

G1 X78.962 Y124.977 E0.01675

G1 X78.962 Y36.041 E2.31729

G1 X79.027 Y35.384 E0.01721

G1 X79.192 Y34.837 E0.01490

G1 X79.349 Y34.484 E0.01006

G1 X79.699 Y33.954 E0.01655

G1 X79.823 Y33.809 E0.00496

G1 X80.103 Y33.542 E0.01010

G1 X80.372 Y33.334 E0.00887

G1 X80.684 Y33.137 E0.00960

G1 X81.252 Y32.898 E0.01605

M204 S1250

G1 X81.184 Y32.473 F9000.000

M204 S800

G1 F1800.000

G1 X81.706 Y32.370 E0.01387

G1 X82.255 Y32.314 E0.01438

G1 X92.232 Y32.314 E0.25996

G1 X92.997 Y32.399 E0.02006

G1 X93.408 Y32.513 E0.01110

G1 X93.673 Y32.608 E0.00733

G1 X94.055 Y32.800 E0.01115

G1 X94.377 Y33.005 E0.00996

G1 X94.715 Y33.268 E0.01116

G1 X94.914 Y33.467 E0.00733

G1 X95.195 Y33.792 E0.01118

G1 X95.587 Y34.442 E0.01980

G1 X95.784 Y34.954 E0.01428

G1 X95.927 Y35.757 E0.02126

G1 X95.944 Y36.020 E0.00687

G1 X95.944 Y124.999 E2.31842

G1 X95.874 Y125.706 E0.01849

G1 X95.577 Y126.564 E0.02366

G1 X95.468 Y126.815 E0.00712

G1 X95.118 Y127.327 E0.01618

G1 X94.969 Y127.501 E0.00598

G1 X94.658 Y127.798 E0.01120

G1 X94.356 Y128.032 E0.00994

G1 X93.831 Y128.344 E0.01592

G1 X93.426 Y128.500 E0.01129

G1 X93.114 Y128.597 E0.00851

G1 X92.230 Y128.708 E0.02323

G1 X82.255 Y128.708 E0.25991

G1 X81.375 Y128.597 E0.02309

G1 X81.062 Y128.500 E0.00856

G1 X80.657 Y128.344 E0.01129

G1 X80.497 Y128.262 E0.00469

G1 X80.132 Y128.032 E0.01124

G1 X79.831 Y127.798 E0.00994

G1 X79.520 Y127.501 E0.01120

G1 X79.369 Y127.326 E0.00602

G1 X79.021 Y126.818 E0.01604

G1 X78.911 Y126.564 E0.00722

G1 X78.615 Y125.707 E0.02362

G1 X78.544 Y124.998 E0.01857

G1 X78.544 Y36.023 E2.31831

G1 X78.615 Y35.308 E0.01873

G1 X78.803 Y34.685 E0.01696

G1 X78.977 Y34.292 E0.01118

G1 X79.120 Y34.050 E0.00733

G1 X79.369 Y33.696 E0.01128

G1 X79.520 Y33.521 E0.00602

G1 X79.831 Y33.225 E0.01120

G1 X80.132 Y32.991 E0.00994

G1 X80.490 Y32.765 E0.01102

G1 X81.129 Y32.497 E0.01805

M204 S1250

G1 X81.473 Y32.750 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.706 Y32.370 E-0.32768

G1 X82.255 Y32.314 E-0.30575

G1 X82.758 Y32.314 E-0.27857

G1 E-0.04800 F4200.00000

G1 Z2.350 F9000.000

G1 X82.153 Y33.759

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F1800.000

G1 X80.196 Y35.715 E0.12299

G1 X80.164 Y36.000 E0.01273

G1 X80.164 Y36.340 E0.01512

G1 X82.616 Y33.888 E0.15416

G1 X83.299 Y33.798 E0.03061

G1 X80.164 Y36.933 E0.19708

G1 X80.164 Y37.525 E0.02634

G1 X83.265 Y34.424 E0.19493

G1 X82.863 Y35.419 E0.04768

G1 X80.164 Y38.118 E0.16966

G1 X80.164 Y38.710 E0.02634

G1 X82.649 Y36.225 E0.15621

G1 X82.600 Y36.565 E0.01525

G1 X82.584 Y36.882 E0.01413

G1 X80.164 Y39.303 E0.15216

G1 X80.164 Y39.895 E0.02634

G1 X82.600 Y37.459 E0.15318

G1 X82.681 Y37.971 E0.02305

G1 X80.164 Y40.488 E0.15823

G1 X80.164 Y41.081 E0.02634

G1 X82.806 Y38.438 E0.16609

G1 X82.968 Y38.868 E0.02043

G1 X80.164 Y41.673 E0.17631

G1 X80.163 Y42.266 E0.02634

G1 X83.163 Y39.266 E0.18859

G1 X83.388 Y39.633 E0.01916

G1 X80.163 Y42.858 E0.20273

G1 X80.163 Y43.451 E0.02634

G1 X83.641 Y39.973 E0.21863

G1 X83.923 Y40.284 E0.01865

G1 X80.163 Y44.043 E0.23633

G1 X80.163 Y44.636 E0.02634

G1 X84.231 Y40.568 E0.25573

G1 X84.566 Y40.825 E0.01878

G1 X80.163 Y45.228 E0.27680

G1 X80.163 Y45.821 E0.02634

G1 X84.929 Y41.055 E0.29963

G1 X85.322 Y41.255 E0.01958

G1 X80.163 Y46.413 E0.32429

G1 X80.163 Y47.006 E0.02634

G1 X85.747 Y41.423 E0.35099

G1 X86.208 Y41.553 E0.02133

G1 X80.163 Y47.599 E0.38002

G1 X80.163 Y48.191 E0.02634

G1 X86.713 Y41.641 E0.41176

G1 X87.274 Y41.673 E0.02496

G1 X80.163 Y48.784 E0.44700

G1 X80.163 Y49.376 E0.02634

G1 X87.919 Y41.620 E0.48760

G1 X88.167 Y41.582 E0.01114

G1 X88.691 Y41.441 E0.02410

G1 X79.974 Y50.157 E0.54794

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.138 Y48.993 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.350 F9000.000

G1 X91.303 Y38.788

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.024 Y41.067 E0.08430

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.188 Y39.904 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.350 F9000.000

G1 X79.136 Y35.533

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X81.517 Y33.153 E0.08806

G1 X81.399 Y33.176 E0.00315

G1 X80.829 Y33.415 E0.01617

G1 X80.553 Y33.590 E0.00856

G1 X80.308 Y33.780 E0.00809

G1 X79.401 Y34.676 E0.03336

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.308 Y33.780 E-0.70684

G1 X80.553 Y33.590 E-0.17138

G1 X80.604 Y33.558 E-0.03378

G1 E-0.04800 F4200.00000

G1 Z2.350 F9000.000

G1 X85.964 Y32.857

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.253 Y35.568 E0.10028

G1 X83.656 Y34.573 E0.02809

G1 X85.183 Y33.045 E0.05649

G1 X84.590 Y33.045 E0.01551

G1 X84.076 Y33.559 E0.01901

G1 X84.202 Y33.257 E0.00857

G1 X83.723 Y33.320 E0.01264

G1 X83.997 Y33.045 E0.01015

G1 X83.404 Y33.045 E0.01551

G1 X83.039 Y33.410 E0.01349

G1 X82.356 Y33.500 E0.01803

G1 X82.811 Y33.045 E0.01682

G1 X82.209 Y33.054 E0.01573

G1 X81.673 Y33.591 E0.01985

G1 X81.602 Y33.600 E0.00186

G1 X80.967 Y33.865 E0.01801

G1 X80.500 Y34.226 E0.01543

G1 X80.244 Y34.515 E0.01010

G1 X79.967 Y34.989 E0.01436

G1 X79.813 Y35.450 E0.01271

G1 X79.282 Y35.981 E0.01966

G1 X79.275 Y36.055 E0.00194

G1 X79.275 Y36.581 E0.01375

G1 X79.746 Y36.111 E0.01740

G1 X79.746 Y36.704 E0.01551

G1 X79.275 Y37.174 E0.01740

G1 X79.275 Y37.767 E0.01551

G1 X79.746 Y37.297 E0.01739

G1 X79.745 Y37.890 E0.01551

G1 X79.275 Y38.360 E0.01739

G1 X79.275 Y38.953 E0.01551

G1 X79.745 Y38.483 E0.01739

G1 X79.745 Y39.076 E0.01551

G1 X79.275 Y39.547 E0.01739

G1 X79.275 Y40.140 E0.01551

G1 X79.745 Y39.670 E0.01739

G1 X79.745 Y40.263 E0.01551

G1 X79.275 Y40.733 E0.01739

G1 X79.275 Y41.326 E0.01551

G1 X79.745 Y40.856 E0.01738

G1 X79.745 Y41.449 E0.01551

G1 X79.275 Y41.919 E0.01738

G1 X79.275 Y42.512 E0.01551

G1 X79.745 Y42.042 E0.01738

G1 X79.745 Y42.636 E0.01551

G1 X79.275 Y43.105 E0.01738

G1 X79.275 Y43.699 E0.01551

G1 X79.745 Y43.229 E0.01738

G1 X79.745 Y43.822 E0.01551

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G1 X79.275 Y44.885 E0.01551

G1 X79.745 Y44.415 E0.01738

G1 X79.745 Y45.008 E0.01551

G1 X79.275 Y45.478 E0.01737

G1 X79.275 Y46.071 E0.01551

G1 X79.745 Y45.601 E0.01737

G1 X79.745 Y46.195 E0.01551

G1 X79.275 Y46.664 E0.01737

G1 X79.275 Y47.257 E0.01551

G1 X79.745 Y46.788 E0.01737

G1 X79.745 Y47.381 E0.01551

G1 X79.275 Y47.850 E0.01737

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G1 X79.745 Y50.940 E0.01551

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G1 X79.275 Y52.002 E0.01551

G1 X79.744 Y51.533 E0.01736

G1 X79.744 Y52.126 E0.01551

G1 X79.275 Y52.596 E0.01735

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G1 X79.744 Y52.720 E0.01735

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G1 X79.275 Y53.782 E0.01735

G1 X79.275 Y54.375 E0.01551

G1 X79.744 Y53.906 E0.01735

G1 X79.744 Y54.499 E0.01551

G1 X79.275 Y54.968 E0.01735

G1 X79.275 Y55.561 E0.01551

G1 X79.744 Y55.092 E0.01735

G1 X79.744 Y55.685 E0.01551

G1 X79.275 Y56.154 E0.01734

G1 X79.275 Y56.747 E0.01551

G1 X79.744 Y56.279 E0.01734

G1 X79.744 Y56.872 E0.01551

G1 X79.275 Y57.341 E0.01734

G1 X79.275 Y57.934 E0.01551

G1 X79.744 Y57.465 E0.01734

G1 X79.744 Y58.058 E0.01551

G1 X79.275 Y58.527 E0.01734

G1 X79.275 Y59.120 E0.01551

G1 X79.744 Y58.651 E0.01734

G1 X79.744 Y59.244 E0.01551

G1 X79.275 Y59.713 E0.01733

G1 X79.275 Y60.306 E0.01551

G1 X79.744 Y59.838 E0.01733

G1 X79.744 Y60.431 E0.01551

G1 X79.275 Y60.899 E0.01733

G1 X79.275 Y61.493 E0.01551

G1 X79.744 Y61.024 E0.01733

G1 X79.744 Y61.617 E0.01551

G1 X79.275 Y62.086 E0.01733

G1 X79.275 Y62.679 E0.01551

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G1 X79.744 Y62.804 E0.01551

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G1 X79.275 Y64.458 E0.01732

G1 X79.275 Y65.051 E0.01551

G1 X79.744 Y64.583 E0.01732

G1 X79.743 Y65.176 E0.01551

G1 X79.275 Y65.644 E0.01732

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G1 X79.275 Y66.831 E0.01732

G1 X79.275 Y67.424 E0.01551

G1 X79.743 Y66.956 E0.01731

G1 X79.743 Y67.549 E0.01551

G1 X79.275 Y68.017 E0.01731

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G1 X79.743 Y69.329 E0.01731

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G1 X79.275 Y70.390 E0.01731

G1 X79.275 Y70.983 E0.01551

G1 X79.743 Y70.515 E0.01730

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G1 X79.275 Y71.576 E0.01730

G1 X79.275 Y72.169 E0.01551

G1 X79.743 Y71.701 E0.01730

G1 X79.743 Y72.294 E0.01551

G1 X79.275 Y72.762 E0.01730

G1 X79.275 Y73.355 E0.01551

G1 X79.743 Y72.888 E0.01730

G1 X79.743 Y73.481 E0.01551

G1 X79.275 Y73.948 E0.01730

G1 X79.275 Y74.541 E0.01551

G1 X79.743 Y74.074 E0.01729

G1 X79.743 Y74.667 E0.01551

G1 X79.275 Y75.135 E0.01729

G1 X79.275 Y75.728 E0.01551

G1 X79.743 Y75.260 E0.01729

G1 X79.743 Y75.853 E0.01551

G1 X79.275 Y76.321 E0.01729

G1 X79.275 Y76.914 E0.01551

G1 X79.743 Y76.447 E0.01729

G1 X79.743 Y77.040 E0.01551

G1 X79.275 Y77.507 E0.01729

G1 X79.275 Y78.100 E0.01551

G1 X79.743 Y77.633 E0.01728

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M73 P28 R50

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G1 X94.748 Y46.019 E0.01551

G1 X95.213 Y45.555 E0.01718

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G1 X94.749 Y40.088 E0.01551

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G1 X94.655 Y35.437 E0.01364

G1 X95.039 Y35.053 E0.01420

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M204 S1250

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M204 S1000

G1 F1800.000

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M73 P30 R49

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M204 S1250

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G1 F7200.000

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G1 E-0.04800 F4200.00000

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G1 X82.902 Y123.111

G1 Z2.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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M204 S1250

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G1 F4800.000

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G1 X83.328 Y125.650 E0.01333

G1 X83.518 Y126.053 E0.01165

G1 X83.866 Y125.706 E0.01285

G1 X84.081 Y126.083 E0.01137

G1 X83.709 Y126.455 E0.01376

G1 X83.900 Y126.858 E0.01165

G1 X84.333 Y126.425 E0.01603

G1 X84.620 Y126.731 E0.01098

G1 X83.949 Y127.402 E0.02481

M204 S1250

G1 X83.325 Y127.386 F9000.000

M204 S1000

G1 F1800.000

G1 X83.571 Y127.141 E0.01542

G1 X83.380 Y126.739 E0.01978

G1 X82.959 Y127.161 E0.02651

G1 X82.419 Y127.107 E0.02408

G1 X83.190 Y126.337 E0.04844

G1 X83.000 Y125.935 E0.01978

G1 X81.880 Y127.054 E0.07036

G1 X81.425 Y126.917 E0.02115

G1 X82.831 Y125.510 E0.08844

G1 X82.700 Y125.049 E0.02132

G1 X81.057 Y126.692 E0.10332

G1 X80.783 Y126.485 E0.01525

G1 X80.731 Y126.426 E0.00352

G1 X82.612 Y124.545 E0.11828

G1 X82.579 Y123.985 E0.02491

G1 X80.471 Y126.094 E0.13255

G1 X80.282 Y125.689 E0.01982

G1 X82.632 Y123.340 E0.14769

G1 X82.671 Y123.085 E0.01146

G1 X82.808 Y122.571 E0.02366

G1 X80.184 Y125.195 E0.16494

G1 X80.157 Y124.949 E0.01097

G1 X80.157 Y124.629 E0.01423

G1 X94.325 Y110.461 E0.89065

G1 X94.325 Y111.054 E0.02634

G1 X85.807 Y119.572 E0.53551

G1 X86.321 Y119.435 E0.02366

G1 X86.576 Y119.396 E0.01146

G1 X94.325 Y111.646 E0.48716

G1 X94.325 Y112.239 E0.02634

G1 X87.219 Y119.345 E0.44669

G1 X87.780 Y119.376 E0.02497

G1 X94.325 Y112.831 E0.41143

G1 X94.325 Y113.424 E0.02634

G1 X88.285 Y119.464 E0.37972

G1 X88.746 Y119.596 E0.02132

G1 X94.325 Y114.017 E0.35072

G1 X94.325 Y114.609 E0.02634

G1 X89.170 Y119.764 E0.32404

G1 X89.562 Y119.964 E0.01957

G1 X94.325 Y115.202 E0.29939

G1 X94.325 Y115.794 E0.02634

G1 X89.925 Y120.194 E0.27659

G1 X90.260 Y120.452 E0.01878

G1 X94.325 Y116.387 E0.25553

G1 X94.325 Y116.979 E0.02634

G1 X90.568 Y120.736 E0.23615

G1 X90.850 Y121.047 E0.01865

G1 X94.325 Y117.572 E0.21846

G1 X94.325 Y118.164 E0.02634

G1 X91.102 Y121.387 E0.20257

G1 X91.327 Y121.755 E0.01916

G1 X94.325 Y118.757 E0.18845

G1 X94.325 Y119.349 E0.02634

G1 X91.522 Y122.152 E0.17619

G1 X91.684 Y122.582 E0.02044

G1 X94.325 Y119.942 E0.16599

G1 X94.325 Y120.535 E0.02634

G1 X91.809 Y123.050 E0.15816

G1 X91.888 Y123.563 E0.02307

G1 X94.325 Y121.127 E0.15315

G1 X94.325 Y121.720 E0.02634

G1 X91.904 Y124.140 E0.15216

G1 X91.886 Y124.479 E0.01511

G1 X91.839 Y124.798 E0.01432

G1 X94.324 Y122.312 E0.15628

G1 X94.324 Y122.905 E0.02634

G1 X91.622 Y125.607 E0.16987

G1 X91.215 Y126.607 E0.04801

G1 X94.324 Y123.497 E0.19550

G1 X94.324 Y124.090 E0.02634

G1 X91.219 Y127.195 E0.19520

G1 X91.880 Y127.127 E0.02952

G1 X94.324 Y124.682 E0.15367

G1 X94.324 Y125.023 E0.01513

G1 X94.292 Y125.307 E0.01272

G1 X92.329 Y127.270 E0.12339

M204 S1250

G1 X93.590 Y127.844 F9000.000

M204 S1000

G1 F4800.000

G1 X94.537 Y126.881 E0.03531

G1 X94.825 Y126.460 E0.01335

G1 X95.082 Y125.759 E0.01952

G1 X92.963 Y127.878 E0.07838

G1 X92.283 Y127.965 E0.01792

G1 X92.813 Y127.434 E0.01962

G1 X92.736 Y127.459 E0.00213

G1 X92.133 Y127.521 E0.01584

G1 X91.677 Y127.977 E0.01686

G1 X91.084 Y127.977 E0.01551

G1 X91.472 Y127.589 E0.01434

G1 X90.811 Y127.658 E0.01739

G1 X90.491 Y127.977 E0.01182

G1 X89.898 Y127.977 E0.01551

G1 X90.397 Y127.478 E0.01846

G1 X90.823 Y126.459 E0.02889

G1 X89.305 Y127.977 E0.05615

G1 X88.712 Y127.977 E0.01551

G1 X91.231 Y125.458 E0.09320

G1 X91.310 Y125.238 E0.00610

G1 X91.436 Y124.660 E0.01548

G1 X90.797 Y125.299 E0.02365

G1 X90.866 Y125.107 E0.00534

G1 X90.956 Y124.746 E0.00972

G1 X90.990 Y124.512 E0.00618

G1 X91.492 Y124.011 E0.01854

G1 X91.451 Y123.458 E0.01449

G1 X91.023 Y123.887 E0.01586

G1 X91.010 Y123.637 E0.00654

G1 X90.967 Y123.349 E0.00762

G1 X91.355 Y122.961 E0.01435

G1 X91.214 Y122.510 E0.01238

G1 X90.852 Y122.871 E0.01338

G1 X90.686 Y122.444 E0.01198

G1 X91.033 Y122.097 E0.01285

G1 X90.991 Y122.009 E0.00254

G1 X90.818 Y121.719 E0.00884

G1 X90.481 Y122.056 E0.01248

G1 X90.241 Y121.703 E0.01117

G1 X90.571 Y121.373 E0.01223

G1 X90.294 Y121.056 E0.01099

G1 X89.967 Y121.384 E0.01212

G1 X89.661 Y121.097 E0.01098

G1 X89.988 Y120.770 E0.01212

G1 X89.652 Y120.512 E0.01107

G1 X89.319 Y120.845 E0.01232

G1 X88.941 Y120.630 E0.01137

G1 X89.285 Y120.286 E0.01273

G1 X88.886 Y120.092 E0.01161

G1 X88.526 Y120.452 E0.01333

G1 X88.067 Y120.318 E0.01250

G1 X88.449 Y119.936 E0.01411

G1 X87.965 Y119.827 E0.01296

G1 X87.553 Y120.239 E0.01526

G1 X86.959 Y120.240 E0.01553

G1 X87.427 Y119.772 E0.01731

G1 X87.204 Y119.763 E0.00585

G1 X86.824 Y119.782 E0.00995

G1 X85.949 Y120.657 E0.03237

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;2.3

G1 Z2.300 F9000.000

;AFTER\_LAYER\_CHANGE

;2.3

G1 X85.940 Y120.634

M204 S800

G1 F1500.000

G1 X86.193 Y120.544 E0.00700

G1 X86.548 Y120.455 E0.00953

G1 X87.060 Y120.396 E0.01343

G1 X87.588 Y120.404 E0.01376

G1 X87.950 Y120.457 E0.00953

G1 X88.295 Y120.544 E0.00927

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G1 X90.795 Y124.714 E0.00924

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G1 X90.589 Y125.394 E0.00927

G1 X90.437 Y125.715 E0.00925

G1 X90.255 Y126.020 E0.00925

G1 X90.043 Y126.305 E0.00927

G1 X89.804 Y126.568 E0.00926

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G1 X88.951 Y127.201 E0.00924

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G1 X88.295 Y127.473 E0.00927

G1 X87.950 Y127.559 E0.00927

G1 X87.599 Y127.611 E0.00925

G1 X87.244 Y127.629 E0.00926

G1 X86.889 Y127.611 E0.00926

G1 X86.538 Y127.559 E0.00924

G1 X86.193 Y127.473 E0.00927

G1 X85.858 Y127.353 E0.00927

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G1 X85.233 Y127.019 E0.00925

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G1 X83.779 Y125.059 E0.00927

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G1 X83.899 Y122.622 E0.00927

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G1 X84.445 Y121.711 E0.00927

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G1 X85.884 Y120.654 E0.00995

M204 S1250

G1 X86.019 Y121.050 F9000.000

M204 S800

G1 F1500.000

G1 X86.314 Y120.944 E0.00819

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G1 X87.081 Y120.814 E0.01201

G1 X87.554 Y120.821 E0.01233

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G1 X88.174 Y120.944 E0.00819

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G1 X90.431 Y124.322 E0.00819

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G1 X84.103 Y124.633 E0.00820

G1 X84.057 Y124.322 E0.00819

G1 X84.042 Y124.008 E0.00818

G1 X84.057 Y123.695 E0.00818

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G1 X84.180 Y123.079 E0.00819

G1 X84.286 Y122.783 E0.00820

G1 X84.420 Y122.499 E0.00818

G1 X84.581 Y122.229 E0.00818

G1 X84.769 Y121.977 E0.00820

G1 X84.980 Y121.744 E0.00818

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G1 X85.465 Y121.345 E0.00820

G1 X85.735 Y121.184 E0.00818

G1 X85.964 Y121.076 E0.00662

M204 S1250

G1 X86.059 Y120.738 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.314 Y120.944 E-0.20734

G1 X86.623 Y120.867 E-0.17627

G1 X87.081 Y120.814 E-0.25542

G1 X87.554 Y120.821 E-0.26224

G1 X87.573 Y120.824 E-0.01073

G1 E-0.04800 F4200.00000

G1 Z2.500 F9000.000

G1 X87.244 Y40.629

G1 Z2.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.889 Y40.611 E0.00925

G1 X86.538 Y40.559 E0.00925

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M204 S1250

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M204 S800

G1 F1500.000

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G1 X87.344 Y40.205 E0.00559

M204 S1250

G1 X87.109 Y40.516 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.930 Y40.195 E-0.22903

G1 X86.620 Y40.149 E-0.17412

G1 X86.314 Y40.073 E-0.17430

G1 X86.018 Y39.967 E-0.17429

G1 X85.757 Y39.843 E-0.16027

G1 E-0.04800 F4200.00000

G1 Z2.500 F9000.000

G1 X81.369 Y33.013

G1 Z2.300

G1 E3.20000 F2400.00000

M204 S800

G1 X81.741 Y32.939 E0.00991

G1 X82.278 Y32.882 E0.01405

G1 X92.208 Y32.882 E0.25875

G1 X92.909 Y32.961 E0.01838

G1 X93.468 Y33.138 E0.01528

G1 X93.744 Y33.277 E0.00803

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G1 X94.323 Y33.680 E0.00805

G1 X94.721 Y34.108 E0.01523

G1 X95.070 Y34.681 E0.01748

G1 X95.236 Y35.112 E0.01203

G1 X95.365 Y35.852 E0.01957

G1 X95.376 Y124.981 E2.32233

G1 X95.314 Y125.599 E0.01618

G1 X95.075 Y126.298 E0.01926

G1 X94.972 Y126.537 E0.00677

G1 X94.684 Y126.961 E0.01336

G1 X94.541 Y127.128 E0.00573

G1 X94.313 Y127.345 E0.00819

G1 X94.000 Y127.587 E0.01033

G1 X93.581 Y127.834 E0.01266

G1 X92.969 Y128.047 E0.01688

M73 P31 R48

G1 X92.205 Y128.140 E0.02006

G1 X82.274 Y128.140 E0.25874

G1 X81.525 Y128.048 E0.01967

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G1 X80.758 Y127.758 E0.01279

G1 X80.488 Y127.587 E0.00831

G1 X80.175 Y127.345 E0.01033

G1 X79.947 Y127.128 E0.00819

G1 X79.800 Y126.957 E0.00588

G1 X79.520 Y126.546 E0.01296

G1 X79.413 Y126.298 E0.00702

G1 X79.176 Y125.603 E0.01916

G1 X79.112 Y124.977 E0.01639

G1 X79.112 Y36.041 E2.31728

G1 X79.176 Y35.413 E0.01645

G1 X79.348 Y34.849 E0.01536

G1 X79.471 Y34.572 E0.00789

G1 X79.800 Y34.066 E0.01574

G1 X79.947 Y33.895 E0.00588

G1 X80.175 Y33.678 E0.00819

G1 X80.488 Y33.435 E0.01033

G1 X80.738 Y33.278 E0.00768

G1 X81.313 Y33.036 E0.01626

M204 S1250

G1 X81.246 Y32.612 F9000.000

M204 S800

G1 F1800.000

G1 X81.678 Y32.525 E0.01150

G1 X82.256 Y32.464 E0.01513

G1 X92.232 Y32.464 E0.25994

G1 X92.989 Y32.550 E0.01985

G1 X93.329 Y32.644 E0.00920

G1 X93.634 Y32.753 E0.00843

G1 X93.950 Y32.913 E0.00923

G1 X94.320 Y33.148 E0.01143

G1 X94.600 Y33.366 E0.00924

G1 X94.829 Y33.595 E0.00844

G1 X95.060 Y33.861 E0.00918

G1 X95.447 Y34.496 E0.01936

G1 X95.641 Y35.000 E0.01408

G1 X95.780 Y35.803 E0.02123

G1 X95.794 Y36.020 E0.00569

G1 X95.794 Y124.999 E2.31842

G1 X95.724 Y125.691 E0.01812

G1 X95.465 Y126.449 E0.02087

G1 X95.340 Y126.739 E0.00822

G1 X95.016 Y127.215 E0.01500

G1 X94.844 Y127.416 E0.00689

G1 X94.586 Y127.662 E0.00928

G1 X94.240 Y127.930 E0.01141

G1 X93.752 Y128.216 E0.01474

G1 X93.057 Y128.457 E0.01915

G1 X92.230 Y128.558 E0.02170

G1 X82.255 Y128.558 E0.25992

G1 X81.433 Y128.457 E0.02157

G1 X81.072 Y128.345 E0.00984

G1 X80.737 Y128.216 E0.00938

G1 X80.551 Y128.121 E0.00543

G1 X80.248 Y127.930 E0.00933

G1 X79.902 Y127.662 E0.01141

G1 X79.644 Y127.416 E0.00929

G1 X79.470 Y127.214 E0.00694

G1 X79.150 Y126.742 E0.01486

G1 X79.023 Y126.449 E0.00831

G1 X78.765 Y125.692 E0.02084

G1 X78.694 Y124.998 E0.01819

G1 X78.694 Y36.023 E2.31830

G1 X78.765 Y35.328 E0.01821

G1 X78.956 Y34.703 E0.01702

G1 X79.099 Y34.381 E0.00918

G1 X79.263 Y34.102 E0.00843

G1 X79.470 Y33.809 E0.00936

G1 X79.644 Y33.607 E0.00694

G1 X79.902 Y33.361 E0.00929

G1 X80.248 Y33.093 E0.01141

G1 X80.544 Y32.906 E0.00911

G1 X81.190 Y32.635 E0.01827

M204 S1250

G1 X81.534 Y32.889 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.678 Y32.525 E-0.27719

G1 X82.256 Y32.464 E-0.32170

G1 X82.821 Y32.464 E-0.31312

G1 E-0.04800 F4200.00000

G1 Z2.500 F9000.000

G1 X84.889 Y33.007

G1 Z2.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X85.410 Y33.529 E0.01932

G1 X85.039 Y33.752 E0.01134

G1 X84.483 Y33.195 E0.02060

G1 X83.888 Y33.195 E0.01556

G1 X84.702 Y34.009 E0.03014

G1 X84.397 Y34.298 E0.01101

G1 X83.294 Y33.195 E0.04085

G1 X82.700 Y33.195 E0.01556

G1 X84.124 Y34.619 E0.05274

G1 X83.883 Y34.972 E0.01120

G1 X82.124 Y33.213 E0.06516

G1 X81.603 Y33.286 E0.01379

G1 X83.677 Y35.360 E0.07684

G1 X83.508 Y35.785 E0.01199

G1 X81.162 Y33.439 E0.08692

G1 X80.883 Y33.556 E0.00793

G1 X80.762 Y33.633 E0.00376

G1 X83.383 Y36.255 E0.09713

G1 X83.321 Y36.786 E0.01402

G1 X80.419 Y33.885 E0.10749

G1 X80.118 Y34.177 E0.01101

G1 X83.329 Y37.388 E0.11896

G1 X83.385 Y37.775 E0.01025

G1 X83.473 Y38.127 E0.00949

G1 X79.874 Y34.528 E0.13335

G1 X79.747 Y34.722 E0.00608

G1 X79.664 Y34.911 E0.00542

G1 X95.063 Y50.311 E0.57052

G1 X95.063 Y49.717 E0.01556

G1 X86.125 Y40.779 E0.33112

G1 X86.477 Y40.867 E0.00949

G1 X86.864 Y40.924 E0.01025

G1 X95.063 Y49.123 E0.30375

G1 X95.063 Y48.528 E0.01556

G1 X87.466 Y40.932 E0.28145

G1 X87.998 Y40.869 E0.01402

G1 X95.063 Y47.934 E0.26176

G1 X95.063 Y47.340 E0.01556

G1 X88.467 Y40.744 E0.24437

G1 X88.892 Y40.576 E0.01199

G1 X95.063 Y46.746 E0.22861

G1 X95.063 Y46.152 E0.01556

G1 X89.280 Y40.369 E0.21425

G1 X89.633 Y40.129 E0.01120

G1 X95.063 Y45.558 E0.20115

G1 X95.063 Y44.964 E0.01556

G1 X89.954 Y39.855 E0.18927

G1 X90.243 Y39.550 E0.01101

G1 X95.063 Y44.370 E0.17855

G1 X95.063 Y43.776 E0.01556

G1 X90.501 Y39.214 E0.16902

G1 X90.723 Y38.842 E0.01134

G1 X95.063 Y43.182 E0.16077

G1 X95.063 Y42.588 E0.01556

G1 X90.908 Y38.433 E0.15394

G1 X91.051 Y37.982 E0.01239

G1 X95.063 Y41.994 E0.14863

G1 X95.063 Y41.400 E0.01556

G1 X91.146 Y37.483 E0.14511

G1 X91.174 Y36.917 E0.01485

G1 X95.063 Y40.805 E0.14408

G1 X95.063 Y40.211 E0.01556

G1 X91.104 Y36.253 E0.14665

G1 X91.009 Y35.866 E0.01043

G1 X90.817 Y35.371 E0.01392

G1 X95.063 Y39.617 E0.15732

G1 X95.063 Y39.023 E0.01556

G1 X89.235 Y33.195 E0.21591

G1 X89.829 Y33.195 E0.01556

G1 X95.063 Y38.429 E0.19390

G1 X95.063 Y37.835 E0.01556

G1 X90.423 Y33.195 E0.17189

G1 X91.017 Y33.195 E0.01556

G1 X95.063 Y37.241 E0.14988

G1 X95.063 Y36.647 E0.01556

G1 X91.611 Y33.195 E0.12787

G1 X92.207 Y33.197 E0.01561

G1 X95.063 Y36.053 E0.10579

G1 X95.053 Y35.889 E0.00431

G1 X94.961 Y35.356 E0.01415

G1 X92.887 Y33.283 E0.07682

G1 X93.350 Y33.429 E0.01272

G1 X93.589 Y33.550 E0.00701

G1 X93.899 Y33.746 E0.00961

G1 X94.106 Y33.908 E0.00689

G1 X94.971 Y34.773 E0.03206

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X94.106 Y33.908 E-0.67822

G1 X93.899 Y33.746 E-0.14569

G1 X93.765 Y33.661 E-0.08809

G1 E-0.04800 F4200.00000

G1 Z2.500 F9000.000

G1 X88.633 Y33.262

G1 Z2.300

G1 E3.20000 F2400.00000

G1 X88.400 Y33.221 E0.00430

G1 X88.199 Y33.196 E0.00328

G1 X88.011 Y33.173 E0.00248

G1 X87.808 Y33.158 E0.00207

G1 X87.614 Y33.143 E0.00162

G1 X87.058 Y33.138 E0.00363

G1 X86.492 Y33.171 E0.00370

G1 X86.089 Y33.221 E0.00527

G1 X85.855 Y33.262 E0.00430

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.089 Y33.221 E-0.13126

G1 E-0.82874 F4200.00000

G1 Z2.500 F9000.000

G1 X95.251 Y51.093

G1 Z2.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X79.519 Y35.361 E0.58283

G1 X79.484 Y35.477 E0.00318

G1 X79.441 Y35.877 E0.01053

G1 X95.063 Y51.499 E0.57877

G1 X95.063 Y52.093 E0.01556

G1 X79.425 Y36.455 E0.57935

G1 X79.425 Y37.049 E0.01556

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G1 X95.063 Y55.657 E0.01556

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G1 X79.425 Y52.495 E0.01556

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G1 X95.063 Y68.727 E0.01556

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G1 X79.425 Y72.694 E0.01556

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G1 X95.063 Y100.807 E0.01556

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G1 X95.063 Y111.500 E0.01556

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G1 X79.425 Y97.645 E0.01556

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G1 X95.063 Y113.877 E0.01556

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G1 X79.425 Y100.021 E0.01556

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G1 X95.063 Y117.441 E0.01556

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G1 X95.063 Y118.035 E0.57935

M73 P32 R47

G1 X95.063 Y118.629 E0.01556

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G1 X79.425 Y103.586 E0.01556

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G1 X95.063 Y119.818 E0.01556

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G1 X95.063 Y124.570 E0.01556

G1 X79.425 Y108.932 E0.57935

G1 X79.425 Y109.527 E0.01556

G1 X95.047 Y125.148 E0.57876

G1 X95.006 Y125.530 E0.01005

G1 X94.963 Y125.658 E0.00354

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G1 X79.425 Y110.715 E0.01556

G1 X94.811 Y126.101 E0.57002

G1 X94.696 Y126.385 E0.00805

G1 X94.617 Y126.501 E0.00366

G1 X91.018 Y122.901 E0.13336

G1 X91.103 Y123.241 E0.00918

G1 X91.160 Y123.638 E0.01049

G1 X94.369 Y126.847 E0.11889

G1 X94.067 Y127.139 E0.01101

G1 X91.167 Y124.239 E0.10744

G1 X91.104 Y124.769 E0.01400

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G1 X93.449 Y127.548 E0.00830

G1 X93.330 Y127.590 E0.00330

G1 X90.978 Y125.238 E0.08713

G1 X90.809 Y125.662 E0.01198

G1 X92.887 Y127.741 E0.07700

G1 X92.358 Y127.806 E0.01396

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G1 X90.361 Y126.403 E0.01120

G1 X91.785 Y127.827 E0.05277

G1 X91.191 Y127.827 E0.01556

G1 X90.087 Y126.723 E0.04090

G1 X89.782 Y127.012 E0.01101

G1 X90.597 Y127.827 E0.03020

G1 X90.003 Y127.827 E0.01556

G1 X89.444 Y127.269 E0.02069

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G1 X89.597 Y128.015 E0.01944

M204 S1250

G1 X88.620 Y127.760 F9000.000

G1 F2400.000

G1 X88.401 Y127.798 E0.00406

G1 X88.199 Y127.824 E0.00337

G1 X88.011 Y127.847 E0.00255

G1 X87.815 Y127.861 E0.00208

G1 X87.628 Y127.875 E0.00165

G1 X87.246 Y127.885 E0.00268

G1 X86.477 Y127.847 E0.00449

G1 X85.868 Y127.760 E0.00828

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.477 Y127.847 E-0.34070

G1 E-0.61930 F4200.00000

G1 Z2.500 F9000.000

G1 X80.997 Y127.733

G1 Z2.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.048 Y126.764 E0.03553

G1 X79.798 Y126.399 E0.01159

G1 X79.706 Y126.185 E0.00609

G1 X79.530 Y125.672 E0.01422

G1 X81.601 Y127.743 E0.07673

G1 X82.279 Y127.826 E0.01788

G1 X79.427 Y124.974 E0.10567

G1 X79.425 Y124.378 E0.01560

G1 X82.874 Y127.827 E0.12777

G1 X83.468 Y127.827 E0.01556

G1 X79.425 Y123.784 E0.14978

G1 X79.425 Y123.190 E0.01556

G1 X84.062 Y127.827 E0.17179

G1 X84.656 Y127.827 E0.01556

G1 X79.425 Y122.596 E0.19379

G1 X79.425 Y122.002 E0.01556

G1 X85.250 Y127.827 E0.21580

G1 X85.538 Y127.827 E0.00755

G1 X85.583 Y127.570 E0.00685

G1 X85.389 Y127.478 E0.00562

G1 X85.059 Y127.280 E0.01010

G1 X84.748 Y127.050 E0.01013

G1 X84.462 Y126.790 E0.01011

G1 X84.203 Y126.504 E0.01011

G1 X83.972 Y126.194 E0.01013

G1 X83.774 Y125.863 E0.01010

G1 X83.680 Y125.662 E0.00581

G1 X79.425 Y121.408 E0.15762

G1 X79.425 Y120.814 E0.01556

G1 X83.385 Y124.774 E0.14671

G1 X83.329 Y124.394 E0.01007

G1 X83.315 Y124.110 E0.00745

G1 X79.425 Y120.220 E0.14411

G1 X79.425 Y119.626 E0.01556

G1 X83.341 Y123.541 E0.14507

G1 X83.435 Y123.042 E0.01332

G1 X79.425 Y119.032 E0.14856

G1 X79.425 Y118.438 E0.01556

G1 X83.578 Y122.590 E0.15385

G1 X83.762 Y122.180 E0.01177

G1 X79.425 Y117.844 E0.16067

G1 X79.425 Y117.250 E0.01556

G1 X83.984 Y121.808 E0.16888

G1 X84.241 Y121.471 E0.01110

G1 X79.425 Y116.655 E0.17840

G1 X79.425 Y116.061 E0.01556

G1 X84.529 Y121.165 E0.18909

G1 X84.850 Y120.892 E0.01104

G1 X79.425 Y115.467 E0.20096

G1 X79.425 Y114.873 E0.01556

G1 X85.203 Y120.651 E0.21404

G1 X85.590 Y120.444 E0.01150

G1 X79.425 Y114.279 E0.22839

G1 X79.425 Y113.685 E0.01556

G1 X86.015 Y120.275 E0.24413

G1 X86.483 Y120.148 E0.01269

G1 X79.425 Y113.091 E0.26146

G1 X79.425 Y112.497 E0.01556

G1 X87.014 Y120.085 E0.28114

G1 X87.613 Y120.091 E0.01570

G1 X79.425 Y111.903 E0.30334

G1 X79.425 Y111.309 E0.01556

G1 X88.656 Y120.540 E0.34199

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;2.45

G1 Z2.450 F9000.000

;AFTER\_LAYER\_CHANGE

;2.45

G1 X88.664 Y120.517

M204 S800

G1 F1500.000

G1 X89.022 Y120.683 E0.01026

G1 X89.339 Y120.873 E0.00963

G1 X89.636 Y121.094 E0.00965

G1 X89.910 Y121.342 E0.00964

G1 X90.159 Y121.616 E0.00964

G1 X90.379 Y121.914 E0.00966

G1 X90.569 Y122.231 E0.00963

G1 X90.727 Y122.565 E0.00963

G1 X90.852 Y122.914 E0.00965

G1 X90.942 Y123.273 E0.00965

G1 X90.996 Y123.639 E0.00963

G1 X91.015 Y124.008 E0.00964

G1 X90.996 Y124.378 E0.00965

G1 X90.942 Y124.743 E0.00963

G1 X90.852 Y125.103 E0.00965

G1 X90.727 Y125.452 E0.00965

G1 X90.569 Y125.786 E0.00963

G1 X90.379 Y126.103 E0.00963

G1 X90.159 Y126.400 E0.00965

G1 X89.910 Y126.674 E0.00964

G1 X89.636 Y126.923 E0.00964

G1 X89.338 Y127.144 E0.00966

G1 X89.021 Y127.333 E0.00963

G1 X88.687 Y127.492 E0.00963

G1 X88.339 Y127.617 E0.00965

G1 X87.979 Y127.706 E0.00965

G1 X87.614 Y127.760 E0.00963

G1 X87.244 Y127.779 E0.00964

G1 X86.874 Y127.760 E0.00965

G1 X86.509 Y127.706 E0.00963

G1 X86.150 Y127.617 E0.00965

G1 X85.801 Y127.492 E0.00965

G1 X85.467 Y127.333 E0.00963

G1 X85.150 Y127.144 E0.00963

G1 X84.852 Y126.923 E0.00965

G1 X84.578 Y126.674 E0.00964

G1 X84.329 Y126.400 E0.00964

G1 X84.109 Y126.103 E0.00966

G1 X83.919 Y125.786 E0.00963

G1 X83.761 Y125.451 E0.00963

G1 X83.636 Y125.103 E0.00965

G1 X83.546 Y124.743 E0.00965

G1 X83.492 Y124.378 E0.00964

G1 X83.474 Y124.008 E0.00963

G1 X83.492 Y123.639 E0.00964

G1 X83.546 Y123.273 E0.00964

G1 X83.636 Y122.914 E0.00965

G1 X83.761 Y122.565 E0.00965

G1 X83.919 Y122.231 E0.00963

G1 X84.109 Y121.914 E0.00963

G1 X84.329 Y121.616 E0.00965

G1 X84.578 Y121.342 E0.00964

G1 X84.852 Y121.094 E0.00964

G1 X85.150 Y120.873 E0.00966

G1 X85.467 Y120.683 E0.00963

G1 X85.801 Y120.525 E0.00963

G1 X86.150 Y120.400 E0.00965

G1 X86.520 Y120.307 E0.00996

G1 X87.093 Y120.244 E0.01501

G1 X87.605 Y120.255 E0.01334

G1 X87.979 Y120.310 E0.00987

G1 X88.339 Y120.400 E0.00965

G1 X88.608 Y120.497 E0.00746

M204 S1250

G1 X88.467 Y120.890 F9000.000

M204 S800

G1 F1500.000

G1 X88.824 Y121.052 E0.01022

G1 X89.106 Y121.221 E0.00856

G1 X89.371 Y121.417 E0.00858

G1 X89.615 Y121.638 E0.00857

G1 X89.835 Y121.882 E0.00857

G1 X90.032 Y122.146 E0.00858

G1 X90.200 Y122.428 E0.00856

G1 X90.341 Y122.725 E0.00857

G1 X90.452 Y123.035 E0.00857

G1 X90.532 Y123.355 E0.00858

G1 X90.580 Y123.680 E0.00857

G1 X90.596 Y124.008 E0.00857

G1 X90.580 Y124.337 E0.00857

G1 X90.532 Y124.662 E0.00857

G1 X90.452 Y124.981 E0.00858

G1 X90.341 Y125.291 E0.00858

G1 X90.200 Y125.589 E0.00857

G1 X90.031 Y125.871 E0.00856

G1 X89.835 Y126.135 E0.00858

G1 X89.615 Y126.379 E0.00857

G1 X89.371 Y126.600 E0.00857

G1 X89.106 Y126.796 E0.00858

G1 X88.824 Y126.964 E0.00856

G1 X88.527 Y127.105 E0.00857

G1 X88.217 Y127.216 E0.00857

G1 X87.898 Y127.296 E0.00858

G1 X87.573 Y127.344 E0.00857

G1 X87.244 Y127.361 E0.00857

G1 X86.916 Y127.344 E0.00857

G1 X86.590 Y127.296 E0.00857

G1 X86.271 Y127.216 E0.00858

G1 X85.961 Y127.105 E0.00858

G1 X85.664 Y126.964 E0.00857

G1 X85.382 Y126.796 E0.00856

G1 X85.117 Y126.600 E0.00858

G1 X84.874 Y126.379 E0.00857

G1 X84.653 Y126.135 E0.00857

G1 X84.457 Y125.870 E0.00858

G1 X84.288 Y125.588 E0.00856

G1 X84.147 Y125.291 E0.00857

G1 X84.036 Y124.981 E0.00857

G1 X83.956 Y124.662 E0.00858

G1 X83.908 Y124.337 E0.00857

G1 X83.892 Y124.008 E0.00857

G1 X83.908 Y123.680 E0.00857

G1 X83.956 Y123.354 E0.00857

G1 X84.036 Y123.035 E0.00858

G1 X84.147 Y122.725 E0.00858

G1 X84.288 Y122.428 E0.00857

G1 X84.457 Y122.146 E0.00856

G1 X84.653 Y121.882 E0.00858

G1 X84.874 Y121.638 E0.00857

G1 X85.117 Y121.417 E0.00857

G1 X85.382 Y121.221 E0.00858

G1 X85.664 Y121.052 E0.00856

G1 X85.961 Y120.911 E0.00857

G1 X86.271 Y120.800 E0.00857

G1 X86.594 Y120.720 E0.00869

G1 X87.112 Y120.662 E0.01356

G1 X87.569 Y120.672 E0.01193

G1 X87.898 Y120.721 E0.00865

G1 X88.217 Y120.800 E0.00858

G1 X88.411 Y120.870 E0.00535

M204 S1250

G1 X88.775 Y120.647 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.824 Y121.052 E-0.25062

G1 X89.106 Y121.221 E-0.18214

G1 X89.371 Y121.417 E-0.18251

G1 X89.615 Y121.638 E-0.18218

G1 X89.753 Y121.791 E-0.11456

G1 E-0.04800 F4200.00000

G1 Z2.650 F9000.000

G1 X87.244 Y40.779

G1 Z2.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.875 Y40.761 E0.00964

G1 X86.509 Y40.706 E0.00964

G1 X86.150 Y40.617 E0.00965

G1 X85.801 Y40.492 E0.00965

G1 X85.467 Y40.333 E0.00963

G1 X85.150 Y40.144 E0.00963

G1 X84.852 Y39.923 E0.00965

G1 X84.578 Y39.674 E0.00964

G1 X84.329 Y39.400 E0.00964

G1 X84.109 Y39.103 E0.00966

G1 X83.919 Y38.786 E0.00963

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G1 X83.636 Y38.103 E0.00965

G1 X83.546 Y37.743 E0.00965

G1 X83.492 Y37.378 E0.00964

G1 X83.474 Y37.008 E0.00963

G1 X83.492 Y36.639 E0.00964

G1 X83.546 Y36.273 E0.00964

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G1 X83.761 Y35.565 E0.00965

G1 X83.919 Y35.231 E0.00963

G1 X84.109 Y34.914 E0.00963

G1 X84.329 Y34.616 E0.00965

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G1 X84.852 Y34.094 E0.00964

G1 X85.150 Y33.873 E0.00966

G1 X85.467 Y33.683 E0.00963

G1 X85.801 Y33.525 E0.00963

G1 X86.150 Y33.400 E0.00965

G1 X86.518 Y33.308 E0.00988

G1 X87.026 Y33.247 E0.01334

G1 X87.602 Y33.254 E0.01501

G1 X87.979 Y33.310 E0.00994

G1 X88.339 Y33.400 E0.00965

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G1 X89.022 Y33.683 E0.00963

G1 X89.339 Y33.873 E0.00963

G1 X89.636 Y34.094 E0.00965

G1 X89.910 Y34.342 E0.00964

G1 X90.159 Y34.616 E0.00964

G1 X90.379 Y34.914 E0.00966

G1 X90.569 Y35.231 E0.00963

G1 X90.727 Y35.565 E0.00963

G1 X90.852 Y35.914 E0.00965

G1 X90.942 Y36.273 E0.00965

G1 X90.996 Y36.639 E0.00963

G1 X91.015 Y37.008 E0.00964

G1 X90.996 Y37.378 E0.00965

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G1 X90.852 Y38.103 E0.00965

G1 X90.727 Y38.452 E0.00965

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G1 X90.159 Y39.400 E0.00965

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G1 X89.339 Y40.144 E0.00965

G1 X89.021 Y40.333 E0.00963

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G1 X88.339 Y40.617 E0.00965

G1 X87.979 Y40.706 E0.00965

G1 X87.613 Y40.761 E0.00964

G1 X87.304 Y40.776 E0.00807

M204 S1250

G1 X87.284 Y40.358 F9000.000

M204 S800

G1 F1500.000

G1 X86.916 Y40.344 E0.00959

G1 X86.590 Y40.296 E0.00857

G1 X86.271 Y40.216 E0.00858

G1 X85.961 Y40.105 E0.00858

G1 X85.664 Y39.964 E0.00857

G1 X85.382 Y39.796 E0.00856

G1 X85.117 Y39.600 E0.00858

G1 X84.874 Y39.379 E0.00857

G1 X84.653 Y39.135 E0.00857

G1 X84.457 Y38.870 E0.00858

G1 X84.288 Y38.588 E0.00856

G1 X84.147 Y38.291 E0.00857

G1 X84.036 Y37.981 E0.00857

G1 X83.956 Y37.662 E0.00858

G1 X83.908 Y37.337 E0.00857

G1 X83.892 Y37.008 E0.00857

G1 X83.908 Y36.680 E0.00857

G1 X83.956 Y36.354 E0.00857

G1 X84.036 Y36.035 E0.00858

G1 X84.147 Y35.725 E0.00858

G1 X84.288 Y35.428 E0.00857

G1 X84.457 Y35.146 E0.00856

G1 X84.653 Y34.882 E0.00858

G1 X84.874 Y34.638 E0.00857

G1 X85.117 Y34.417 E0.00857

G1 X85.382 Y34.221 E0.00858

G1 X85.664 Y34.052 E0.00856

G1 X85.961 Y33.911 E0.00857

G1 X86.271 Y33.800 E0.00857

G1 X86.593 Y33.720 E0.00866

G1 X87.048 Y33.665 E0.01193

G1 X87.568 Y33.672 E0.01356

G1 X87.898 Y33.721 E0.00868

G1 X88.217 Y33.800 E0.00858

G1 X88.527 Y33.911 E0.00858

G1 X88.824 Y34.052 E0.00857

G1 X89.106 Y34.221 E0.00856

G1 X89.371 Y34.417 E0.00858

G1 X89.614 Y34.638 E0.00857

G1 X89.835 Y34.882 E0.00857

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G1 X90.200 Y35.428 E0.00856

G1 X90.341 Y35.725 E0.00857

G1 X90.452 Y36.035 E0.00857

G1 X90.532 Y36.355 E0.00858

G1 X90.580 Y36.680 E0.00857

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G1 X90.580 Y37.337 E0.00857

G1 X90.532 Y37.662 E0.00857

G1 X90.452 Y37.981 E0.00858

G1 X90.341 Y38.291 E0.00858

G1 X90.200 Y38.589 E0.00857

G1 X90.031 Y38.871 E0.00856

G1 X89.835 Y39.135 E0.00858

G1 X89.615 Y39.379 E0.00857

G1 X89.371 Y39.600 E0.00857

G1 X89.106 Y39.796 E0.00858

G1 X88.824 Y39.964 E0.00857

G1 X88.527 Y40.105 E0.00857

G1 X88.217 Y40.216 E0.00857

G1 X87.898 Y40.296 E0.00858

G1 X87.572 Y40.344 E0.00857

G1 X87.344 Y40.355 E0.00597

M204 S1250

G1 X87.102 Y40.679 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.916 Y40.344 E-0.23718

G1 X86.590 Y40.296 E-0.18227

G1 X86.271 Y40.216 E-0.18245

G1 X85.961 Y40.105 E-0.18242

G1 X85.753 Y40.007 E-0.12767

G1 E-0.04800 F4200.00000

G1 Z2.650 F9000.000

G1 X81.430 Y33.151

G1 Z2.450

G1 E3.20000 F2400.00000

M204 S800

G1 X81.714 Y33.094 E0.00756

G1 X82.279 Y33.032 E0.01481

G1 X92.208 Y33.032 E0.25869

G1 X92.901 Y33.112 E0.01817

G1 X93.429 Y33.284 E0.01449

G1 X93.639 Y33.389 E0.00612

G1 X94.023 Y33.633 E0.01183

G1 X94.208 Y33.778 E0.00614

G1 X94.589 Y34.182 E0.01447

G1 X94.929 Y34.732 E0.01685

G1 X95.092 Y35.157 E0.01185

G1 X95.218 Y35.896 E0.01955

G1 X95.226 Y124.981 E2.32117

G1 X95.164 Y125.586 E0.01584

G1 X94.962 Y126.185 E0.01647

G1 X94.843 Y126.462 E0.00786

G1 X94.582 Y126.850 E0.01218

G1 X94.416 Y127.042 E0.00661

G1 X94.242 Y127.208 E0.00628

G1 X93.884 Y127.486 E0.01180

G1 X93.514 Y127.700 E0.01115

G1 X92.904 Y127.907 E0.01678

G1 X92.206 Y127.990 E0.01831

G1 X82.274 Y127.990 E0.25878

G1 X81.591 Y127.910 E0.01792

G1 X80.975 Y127.700 E0.01697

G1 X80.812 Y127.617 E0.00476

G1 X80.604 Y127.486 E0.00640

G1 X80.246 Y127.208 E0.01180

G1 X80.072 Y127.042 E0.00628

G1 X79.902 Y126.844 E0.00680

G1 X79.649 Y126.470 E0.01178

G1 X79.526 Y126.185 E0.00808

G1 X79.325 Y125.589 E0.01639

G1 X79.262 Y124.976 E0.01605

G1 X79.262 Y36.041 E2.31726

G1 X79.325 Y35.430 E0.01602

G1 X79.500 Y34.873 E0.01521

G1 X79.593 Y34.661 E0.00603

G1 X79.902 Y34.178 E0.01494

G1 X80.246 Y33.814 E0.01306

G1 X80.604 Y33.537 E0.01180

G1 X80.791 Y33.418 E0.00577

G1 X81.375 Y33.174 E0.01648

M204 S1250

G1 X81.307 Y32.750 F9000.000

M204 S800

G1 F1800.000

G1 X81.651 Y32.681 E0.00912

G1 X82.256 Y32.614 E0.01588

G1 X92.232 Y32.614 E0.25991

G1 X92.981 Y32.701 E0.01964

G1 X93.595 Y32.899 E0.01681

G1 X93.846 Y33.026 E0.00732

G1 X94.264 Y33.291 E0.01290

G1 X94.485 Y33.464 E0.00733

G1 X94.927 Y33.934 E0.01681

G1 X95.305 Y34.546 E0.01873

G1 X95.497 Y35.046 E0.01395

G1 X95.633 Y35.848 E0.02121

G1 X95.644 Y124.999 E2.32291

G1 X95.574 Y125.677 E0.01774

G1 X95.353 Y126.335 E0.01809

G1 X95.211 Y126.663 E0.00932

G1 X94.915 Y127.103 E0.01383

G1 X94.720 Y127.330 E0.00780

G1 X94.515 Y127.526 E0.00737

G1 X94.124 Y127.828 E0.01288

G1 X93.677 Y128.086 E0.01345

G1 X92.997 Y128.317 E0.01871

G1 X92.231 Y128.408 E0.02010

G1 X82.255 Y128.408 E0.25993

G1 X81.494 Y128.318 E0.01996

G1 X80.812 Y128.086 E0.01878

G1 X80.605 Y127.980 E0.00604

G1 X80.364 Y127.828 E0.00742

G1 X79.974 Y127.526 E0.01288

G1 X79.769 Y127.330 E0.00737

G1 X79.572 Y127.102 E0.00786

G1 X79.279 Y126.666 E0.01369

G1 X79.135 Y126.335 E0.00940

G1 X78.915 Y125.678 E0.01806

G1 X78.844 Y124.998 E0.01782

G1 X78.844 Y36.023 E2.31830

G1 X78.915 Y35.343 E0.01781

G1 X79.108 Y34.725 E0.01687

G1 X79.221 Y34.470 E0.00729

G1 X79.407 Y34.155 E0.00953

G1 X79.572 Y33.921 E0.00745

G1 X79.769 Y33.692 E0.00786

G1 X79.974 Y33.497 E0.00737

G1 X80.364 Y33.194 E0.01288

G1 X80.598 Y33.047 E0.00720

G1 X81.252 Y32.773 E0.01848

M204 S1250

G1 X81.559 Y32.993 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.651 Y32.681 E-0.22667

G1 X82.256 Y32.614 E-0.33779

G1 X82.884 Y32.614 E-0.34754

G1 E-0.04800 F4200.00000

G1 Z2.650 F9000.000

G1 X79.641 Y34.864

G1 Z2.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.457 Y34.047 E0.03013

G1 X80.784 Y33.794 E0.01079

G1 X80.937 Y33.697 E0.00470

G1 X81.522 Y33.452 E0.01656

G1 X81.674 Y33.422 E0.00404

G1 X79.648 Y35.448 E0.07476

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G1 X82.342 Y33.345 E0.10210

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G1 X79.575 Y36.704 E0.12393

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G1 X83.526 Y33.345 E0.14576

G1 X84.117 Y33.345 E0.01544

G1 X79.575 Y37.887 E0.16759

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G1 X84.709 Y33.345 E0.18943

G1 X84.914 Y33.345 E0.00535

G1 X84.787 Y33.670 E0.00909

G1 X84.857 Y33.700 E0.00198

G1 X84.653 Y33.851 E0.00662

G1 X84.356 Y34.120 E0.01046

G1 X84.087 Y34.417 E0.01046

G1 X83.760 Y34.886 E0.01490

G1 X79.575 Y39.071 E0.15443

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G1 X83.309 Y35.929 E0.13778

G1 X83.238 Y36.212 E0.00762

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G1 X79.575 Y40.254 E0.13292

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G1 X83.234 Y37.778 E0.01390

G1 X79.575 Y41.438 E0.13502

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G1 X83.355 Y38.249 E0.13948

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G1 X83.722 Y39.066 E0.15300

G1 X83.956 Y39.423 E0.01115

G1 X79.575 Y43.804 E0.16166

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G1 X84.222 Y39.749 E0.17147

G1 X84.519 Y40.044 E0.01092

G1 X79.575 Y44.988 E0.18242

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G1 X84.846 Y40.309 E0.19448

G1 X85.205 Y40.542 E0.01116

G1 X79.575 Y46.171 E0.20771

G1 X79.575 Y46.763 E0.01544

G1 X85.596 Y40.741 E0.22217

G1 X86.025 Y40.905 E0.01196

G1 X79.575 Y47.354 E0.23798

G1 X79.575 Y47.946 E0.01544

G1 X86.500 Y41.022 E0.25550

G1 X87.031 Y41.082 E0.01395

G1 X79.575 Y48.538 E0.27511

G1 X79.575 Y49.129 E0.01544

G1 X87.631 Y41.073 E0.29726

G1 X88.040 Y41.014 E0.01079

G1 X88.363 Y40.933 E0.00867

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M73 P34 R46

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G1 X94.913 Y110.118 E0.01544

G1 X79.454 Y125.577 E0.57042

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.04800 F4200.00000

G1 Z2.650 F9000.000

G1 X89.063 Y127.782

G1 Z2.450

G1 E3.20000 F2400.00000

G1 X89.193 Y127.479 E0.00282

G1 X89.237 Y127.641 F9000.000

G1 F2400.000

G1 X88.626 Y127.759 E0.00395

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.237 Y127.641 E-0.34498

G1 E-0.61502 F4200.00000

G1 Z2.650 F9000.000

G1 X85.862 Y127.759

G1 Z2.450

G1 E3.20000 F2400.00000

G1 X85.251 Y127.641 E0.00387

G1 X85.296 Y127.479 F9000.000

G1 F2400.000

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G1 X84.967 Y127.164 F9000.000

M204 S1000

G1 F4800.000

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G1 X83.271 Y127.677 E0.03470

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G1 X83.231 Y124.758 E0.09079

G1 X83.171 Y124.227 E0.01394

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G1 X80.152 Y126.654 E0.01092

G1 X83.179 Y123.627 E0.11169

G1 X83.238 Y123.212 E0.01095

G1 X83.317 Y122.898 E0.00845

G1 X79.916 Y126.298 E0.12548

G1 X79.751 Y125.872 E0.01193

G1 X94.913 Y110.710 E0.55945

G1 X94.913 Y111.302 E0.01544

G1 X86.133 Y120.081 E0.32395

G1 X86.465 Y119.998 E0.00892

G1 X86.851 Y119.956 E0.01013

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G1 X94.913 Y112.485 E0.01544

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G1 X87.631 Y119.942 E0.00447

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G1 X90.269 Y121.271 E0.01092

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G1 X90.534 Y121.597 E0.16156

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G1 X91.134 Y122.772 E0.01194

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G1 X94.913 Y120.177 E0.13269

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G1 X91.310 Y124.371 E0.13293

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G1 X94.913 Y121.360 E0.13785

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G1 X90.719 Y126.146 E0.15476

G1 X90.401 Y126.599 E0.01444

G1 X90.132 Y126.896 E0.01046

G1 X89.835 Y127.165 E0.01046

G1 X89.623 Y127.323 E0.00689

G1 X89.682 Y127.348 E0.00168

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G1 X92.597 Y127.818 E0.08258

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.04800 F4200.00000

G1 Z2.650 F9000.000

G1 X90.869 Y38.427

G1 Z2.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.562 Y34.734 E0.13625

G1 X94.335 Y34.369 E0.01121

G1 X91.309 Y37.395 E0.11166

G1 X91.329 Y37.008 E0.01011

G1 X91.318 Y36.795 E0.00557

G1 X94.048 Y34.065 E0.10075

G1 X93.842 Y33.889 E0.00707

G1 X93.714 Y33.808 E0.00396

G1 X91.257 Y36.264 E0.09063

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G1 X93.340 Y33.590 E0.08116

G1 X92.897 Y33.440 E0.01219

G1 X90.977 Y35.361 E0.07085

G1 X90.777 Y34.969 E0.01148

G1 X92.379 Y33.367 E0.05909

G1 X92.190 Y33.345 E0.00497

G1 X91.809 Y33.345 E0.00993

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M204 S1250

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G1 F2400.000

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G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.61865 F4200.00000

G1 Z2.650 F9000.000

G1 X85.845 Y33.263

G1 Z2.450

G1 E3.20000 F2400.00000

G1 X85.240 Y33.380 E0.00359

G1 X85.285 Y33.543 F9000.000

G1 F2400.000

G1 X85.415 Y33.241 E0.00321

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;2.6

G1 Z2.600 F9000.000

;AFTER\_LAYER\_CHANGE

;2.6

G1 E-3.20000 F4200.00000

G1 Z2.800 F9000.000

G1 X87.149 Y120.511

G1 Z2.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.585 Y120.523 E0.01137

G1 X87.927 Y120.574 E0.00902

G1 X88.261 Y120.657 E0.00896

G1 X88.585 Y120.773 E0.00896

G1 X88.895 Y120.920 E0.00895

G1 X89.190 Y121.096 E0.00895

G1 X89.466 Y121.301 E0.00896

G1 X89.721 Y121.532 E0.00895

G1 X89.951 Y121.786 E0.00895

G1 X90.156 Y122.063 E0.00897

G1 X90.333 Y122.357 E0.00895

G1 X90.480 Y122.668 E0.00895

G1 X90.596 Y122.992 E0.00896

G1 X90.679 Y123.325 E0.00896

G1 X90.729 Y123.665 E0.00895

G1 X90.746 Y124.008 E0.00895

G1 X90.729 Y124.351 E0.00895

G1 X90.679 Y124.691 E0.00895

G1 X90.596 Y125.025 E0.00896

G1 X90.480 Y125.349 E0.00896

G1 X90.333 Y125.659 E0.00895

G1 X90.156 Y125.954 E0.00895

G1 X89.951 Y126.230 E0.00897

G1 X89.721 Y126.485 E0.00895

G1 X89.466 Y126.715 E0.00895

G1 X89.190 Y126.920 E0.00897

G1 X88.895 Y127.097 E0.00895

G1 X88.584 Y127.244 E0.00895

G1 X88.261 Y127.360 E0.00896

G1 X87.927 Y127.443 E0.00896

G1 X87.587 Y127.493 E0.00895

G1 X87.244 Y127.511 E0.00895

G1 X86.901 Y127.493 E0.00895

G1 X86.561 Y127.443 E0.00895

G1 X86.227 Y127.360 E0.00896

G1 X85.904 Y127.244 E0.00896

G1 X85.593 Y127.097 E0.00895

G1 X85.299 Y126.920 E0.00895

G1 X85.022 Y126.715 E0.00897

G1 X84.768 Y126.485 E0.00895

G1 X84.537 Y126.230 E0.00895

G1 X84.332 Y125.954 E0.00897

G1 X84.156 Y125.659 E0.00895

G1 X84.009 Y125.349 E0.00895

G1 X83.893 Y125.025 E0.00896

G1 X83.809 Y124.691 E0.00896

G1 X83.759 Y124.351 E0.00895

G1 X83.742 Y124.008 E0.00895

G1 X83.759 Y123.665 E0.00895

G1 X83.809 Y123.325 E0.00895

G1 X83.893 Y122.992 E0.00896

G1 X84.009 Y122.668 E0.00896

G1 X84.156 Y122.357 E0.00895

G1 X84.332 Y122.063 E0.00895

G1 X84.537 Y121.786 E0.00897

G1 X84.768 Y121.532 E0.00895

G1 X85.022 Y121.301 E0.00895

G1 X85.299 Y121.096 E0.00897

G1 X85.593 Y120.920 E0.00895

G1 X85.904 Y120.773 E0.00895

G1 X86.228 Y120.657 E0.00896

G1 X86.561 Y120.574 E0.00896

G1 X87.089 Y120.514 E0.01383

M204 S1250

G1 X87.337 Y120.158 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.585 Y120.523 E-0.27500

G1 X87.927 Y120.574 E-0.19180

G1 X88.261 Y120.657 E-0.19061

G1 X88.585 Y120.773 E-0.19056

G1 X88.689 Y120.822 E-0.06403

G1 E-0.04800 F4200.00000

G1 Z2.800 F9000.000

G1 X87.244 Y40.510

G1 Z2.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.901 Y40.493 E0.00895

G1 X86.561 Y40.443 E0.00895

G1 X86.227 Y40.360 E0.00896

G1 X85.904 Y40.244 E0.00896

G1 X85.593 Y40.097 E0.00895

G1 X85.299 Y39.920 E0.00895

G1 X85.022 Y39.715 E0.00897

G1 X84.768 Y39.485 E0.00895

G1 X84.537 Y39.230 E0.00895

G1 X84.332 Y38.954 E0.00897

G1 X84.156 Y38.659 E0.00895

G1 X84.009 Y38.349 E0.00895

G1 X83.893 Y38.025 E0.00896

G1 X83.809 Y37.691 E0.00896

G1 X83.759 Y37.351 E0.00895

G1 X83.742 Y37.008 E0.00895

G1 X83.759 Y36.665 E0.00895

G1 X83.809 Y36.325 E0.00895

G1 X83.893 Y35.992 E0.00896

G1 X84.009 Y35.668 E0.00896

G1 X84.156 Y35.357 E0.00895

G1 X84.332 Y35.063 E0.00895

G1 X84.537 Y34.786 E0.00897

G1 X84.768 Y34.532 E0.00895

G1 X85.022 Y34.301 E0.00895

G1 X85.299 Y34.096 E0.00897

G1 X85.593 Y33.920 E0.00895

G1 X85.904 Y33.773 E0.00895

G1 X86.228 Y33.657 E0.00896

G1 X86.563 Y33.573 E0.00902

G1 X87.244 Y33.506 E0.01782

G1 X87.587 Y33.523 E0.00895

G1 X87.927 Y33.574 E0.00895

G1 X88.261 Y33.657 E0.00896

G1 X88.585 Y33.773 E0.00896

G1 X88.895 Y33.920 E0.00895

G1 X89.190 Y34.096 E0.00895

G1 X89.466 Y34.301 E0.00897

G1 X89.721 Y34.532 E0.00895

G1 X89.951 Y34.786 E0.00895

G1 X90.156 Y35.063 E0.00897

G1 X90.333 Y35.357 E0.00895

G1 X90.480 Y35.668 E0.00895

G1 X90.596 Y35.992 E0.00896

G1 X90.679 Y36.325 E0.00896

G1 X90.729 Y36.665 E0.00895

G1 X90.746 Y37.008 E0.00895

G1 X90.729 Y37.351 E0.00895

G1 X90.679 Y37.691 E0.00895

G1 X90.596 Y38.025 E0.00896

G1 X90.480 Y38.349 E0.00896

G1 X90.333 Y38.659 E0.00895

G1 X90.156 Y38.954 E0.00895

G1 X89.951 Y39.230 E0.00897

G1 X89.721 Y39.485 E0.00895

G1 X89.466 Y39.715 E0.00895

G1 X89.190 Y39.920 E0.00896

G1 X88.895 Y40.097 E0.00895

G1 X88.584 Y40.244 E0.00895

G1 X88.261 Y40.360 E0.00896

G1 X87.927 Y40.443 E0.00896

G1 X87.587 Y40.493 E0.00895

G1 X87.304 Y40.507 E0.00739

M204 S1250

G1 X87.072 Y40.808 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.901 Y40.493 E-0.22348

G1 X86.561 Y40.443 E-0.19043

G1 X86.227 Y40.360 E-0.19061

G1 X85.904 Y40.244 E-0.19057

G1 X85.713 Y40.153 E-0.11692

G1 E-0.04800 F4200.00000

G1 Z2.800 F9000.000

G1 X88.084 Y33.182

G1 Z2.600

G1 E3.20000 F2400.00000

M204 S800

G1 X92.207 Y33.182 E0.10742

G1 X92.876 Y33.261 E0.01755

G1 X93.398 Y33.433 E0.01432

G1 X93.966 Y33.776 E0.01727

G1 X94.094 Y33.875 E0.00423

G1 X94.458 Y34.255 E0.01371

G1 X94.788 Y34.783 E0.01623

G1 X94.947 Y35.197 E0.01154

G1 X95.076 Y36.061 E0.02277

G1 X95.076 Y124.981 E2.31688

G1 X95.014 Y125.573 E0.01551

G1 X94.850 Y126.072 E0.01369

G1 X94.713 Y126.387 E0.00895

G1 X94.479 Y126.739 E0.01100

G1 X94.171 Y127.072 E0.01184

G1 X93.781 Y127.374 E0.01284

G1 X93.424 Y127.575 E0.01068

G1 X92.849 Y127.767 E0.01578

G1 X92.207 Y127.840 E0.01683

G1 X88.060 Y127.840 E0.10806

G1 X88.382 Y127.760 E0.00865

G1 X88.745 Y127.630 E0.01004

G1 X89.092 Y127.466 E0.01002

G1 X89.422 Y127.268 E0.01001

G1 X89.731 Y127.039 E0.01004

G1 X90.016 Y126.780 E0.01002

G1 X90.274 Y126.496 E0.01002

G1 X90.504 Y126.186 E0.01004

G1 X90.701 Y125.856 E0.01001

G1 X90.866 Y125.509 E0.01001

G1 X90.996 Y125.146 E0.01004

G1 X91.089 Y124.773 E0.01003

G1 X91.146 Y124.393 E0.01001

G1 X91.165 Y124.008 E0.01003

G1 X91.146 Y123.624 E0.01003

G1 X91.089 Y123.244 E0.01001

G1 X90.996 Y122.870 E0.01003

G1 X90.866 Y122.508 E0.01004

G1 X90.701 Y122.160 E0.01002

G1 X90.504 Y121.831 E0.01001

G1 X90.275 Y121.521 E0.01004

G1 X90.016 Y121.236 E0.01002

G1 X89.731 Y120.978 E0.01002

G1 X89.422 Y120.748 E0.01004

G1 X89.092 Y120.551 E0.01001

G1 X88.745 Y120.386 E0.01002

G1 X88.382 Y120.257 E0.01004

G1 X88.009 Y120.163 E0.01003

G1 X87.621 Y120.106 E0.01020

G1 X87.144 Y120.093 E0.01244

G1 X86.860 Y120.107 E0.00740

G1 X86.480 Y120.163 E0.01002

G1 X86.106 Y120.256 E0.01003

G1 X85.744 Y120.386 E0.01004

G1 X85.396 Y120.551 E0.01002

G1 X85.066 Y120.748 E0.01001

G1 X84.757 Y120.978 E0.01004

G1 X84.472 Y121.236 E0.01002

G1 X84.214 Y121.521 E0.01002

G1 X83.984 Y121.830 E0.01004

G1 X83.787 Y122.160 E0.01001

G1 X83.622 Y122.508 E0.01001

G1 X83.492 Y122.870 E0.01004

G1 X83.399 Y123.244 E0.01003

G1 X83.343 Y123.624 E0.01002

G1 X83.324 Y124.008 E0.01002

G1 X83.343 Y124.392 E0.01002

G1 X83.399 Y124.773 E0.01002

G1 X83.492 Y125.146 E0.01003

G1 X83.622 Y125.509 E0.01004

G1 X83.787 Y125.856 E0.01002

G1 X83.984 Y126.186 E0.01001

G1 X84.214 Y126.495 E0.01004

G1 X84.472 Y126.780 E0.01002

G1 X84.757 Y127.039 E0.01002

G1 X85.066 Y127.268 E0.01004

G1 X85.396 Y127.466 E0.01001

G1 X85.743 Y127.630 E0.01001

G1 X86.106 Y127.760 E0.01004

G1 X86.428 Y127.840 E0.00865

G1 X82.274 Y127.840 E0.10823

G1 X81.647 Y127.770 E0.01644

G1 X81.065 Y127.575 E0.01600

G1 X80.707 Y127.374 E0.01068

G1 X80.318 Y127.072 E0.01284

G1 X80.196 Y126.957 E0.00436

G1 X80.009 Y126.739 E0.00750

G1 X79.775 Y126.387 E0.01100

G1 X79.639 Y126.072 E0.00895

G1 X79.475 Y125.575 E0.01363

G1 X79.412 Y124.975 E0.01572

G1 X79.412 Y36.041 E2.31724

G1 X79.475 Y35.447 E0.01558

G1 X79.651 Y34.896 E0.01506

G1 X79.712 Y34.758 E0.00393

G1 X80.014 Y34.278 E0.01480

G1 X80.318 Y33.950 E0.01163

G1 X80.720 Y33.638 E0.01327

G1 X80.845 Y33.559 E0.00385

G1 X81.492 Y33.289 E0.01825

G1 X82.281 Y33.182 E0.02075

G1 X86.404 Y33.182 E0.10743

G1 X86.106 Y33.256 E0.00800

G1 X85.744 Y33.386 E0.01004

G1 X85.396 Y33.551 E0.01002

G1 X85.066 Y33.748 E0.01001

G1 X84.757 Y33.978 E0.01004

G1 X84.472 Y34.236 E0.01002

G1 X84.214 Y34.521 E0.01002

G1 X83.984 Y34.830 E0.01004

G1 X83.787 Y35.160 E0.01001

G1 X83.622 Y35.508 E0.01001

G1 X83.492 Y35.870 E0.01004

G1 X83.399 Y36.244 E0.01003

G1 X83.343 Y36.624 E0.01002

G1 X83.324 Y37.008 E0.01002

G1 X83.343 Y37.392 E0.01002

G1 X83.399 Y37.773 E0.01002

G1 X83.492 Y38.146 E0.01003

G1 X83.622 Y38.509 E0.01004

G1 X83.787 Y38.856 E0.01002

G1 X83.984 Y39.186 E0.01001

G1 X84.214 Y39.495 E0.01004

G1 X84.472 Y39.780 E0.01002

G1 X84.757 Y40.039 E0.01002

G1 X85.066 Y40.268 E0.01004

G1 X85.396 Y40.466 E0.01001

G1 X85.743 Y40.630 E0.01001

G1 X86.106 Y40.760 E0.01004

G1 X86.480 Y40.853 E0.01003

G1 X86.860 Y40.910 E0.01002

G1 X87.244 Y40.929 E0.01002

G1 X87.628 Y40.910 E0.01002

G1 X88.009 Y40.853 E0.01002

G1 X88.382 Y40.760 E0.01003

G1 X88.745 Y40.630 E0.01004

G1 X89.092 Y40.466 E0.01002

G1 X89.422 Y40.268 E0.01002

G1 X89.731 Y40.039 E0.01004

G1 X90.016 Y39.780 E0.01002

G1 X90.274 Y39.496 E0.01002

G1 X90.504 Y39.186 E0.01004

G1 X90.701 Y38.856 E0.01001

G1 X90.866 Y38.509 E0.01001

G1 X90.996 Y38.146 E0.01004

G1 X91.089 Y37.773 E0.01003

G1 X91.146 Y37.393 E0.01001

G1 X91.165 Y37.008 E0.01003

G1 X91.146 Y36.624 E0.01003

G1 X91.089 Y36.244 E0.01001

G1 X90.996 Y35.870 E0.01003

G1 X90.866 Y35.508 E0.01004

G1 X90.701 Y35.160 E0.01002

G1 X90.504 Y34.831 E0.01001

G1 X90.275 Y34.521 E0.01004

G1 X90.016 Y34.236 E0.01002

G1 X89.732 Y33.978 E0.01002

G1 X89.422 Y33.748 E0.01004

G1 X89.092 Y33.551 E0.01001

G1 X88.745 Y33.386 E0.01002

G1 X88.382 Y33.257 E0.01004

G1 X88.142 Y33.197 E0.00644

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.788 Y33.191 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.800 F9000.000

G1 X95.353 Y35.090

G1 Z2.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1800.000

G1 X95.494 Y36.030 E0.02477

G1 X95.494 Y124.999 E2.31816

G1 X95.424 Y125.663 E0.01737

G1 X95.241 Y126.220 E0.01530

G1 X95.082 Y126.587 E0.01042

G1 X94.813 Y126.992 E0.01265

G1 X94.595 Y127.245 E0.00870

G1 X94.443 Y127.390 E0.00546

G1 X94.013 Y127.723 E0.01420

G1 X93.594 Y127.959 E0.01252

G1 X92.940 Y128.177 E0.01796

G1 X92.231 Y128.258 E0.01859

G1 X82.255 Y128.258 E0.25995

G1 X81.551 Y128.178 E0.01845

G1 X80.894 Y127.959 E0.01804

G1 X80.476 Y127.723 E0.01252

G1 X80.045 Y127.390 E0.01420

G1 X79.893 Y127.245 E0.00546

G1 X79.675 Y126.992 E0.00870

G1 X79.406 Y126.587 E0.01265

G1 X79.248 Y126.220 E0.01042

G1 X79.065 Y125.663 E0.01528

G1 X78.994 Y124.997 E0.01745

G1 X78.994 Y36.023 E2.31829

G1 X79.064 Y35.359 E0.01740

G1 X79.260 Y34.748 E0.01672

G1 X79.342 Y34.561 E0.00531

G1 X79.677 Y34.029 E0.01640

G1 X79.893 Y33.778 E0.00863

G1 X80.045 Y33.633 E0.00546

G1 X80.480 Y33.296 E0.01435

G1 X80.652 Y33.188 E0.00528

G1 X81.369 Y32.888 E0.02026

G1 X81.623 Y32.837 E0.00674

G1 X82.257 Y32.764 E0.01663

G1 X92.232 Y32.764 E0.25990

G1 X92.967 Y32.851 E0.01929

G1 X93.558 Y33.046 E0.01623

G1 X93.741 Y33.138 E0.00533

G1 X94.207 Y33.434 E0.01437

G1 X94.371 Y33.562 E0.00542

G1 X94.795 Y34.007 E0.01602

G1 X95.163 Y34.596 E0.01811

G1 X95.332 Y35.034 E0.01222

M204 S1250

G1 X95.069 Y35.371 F9000.000

G1 X94.713 Y34.940

M204 S1000

G1 F4800.000

G1 X93.880 Y34.107 E0.03079

G1 X93.788 Y34.034 E0.00307

G1 X93.266 Y33.720 E0.01591

G1 X92.742 Y33.561 E0.01432

G1 X94.674 Y35.493 E0.07142

G1 X94.763 Y36.174 E0.01796

G1 X92.084 Y33.495 E0.09901

G1 X91.491 Y33.495 E0.01549

G1 X94.763 Y36.767 E0.12091

G1 X94.763 Y37.360 E0.01549

G1 X90.899 Y33.495 E0.14282

G1 X90.306 Y33.495 E0.01549

G1 X94.763 Y37.952 E0.16472

G1 X94.763 Y38.545 E0.01549

G1 X89.831 Y33.613 E0.18228

M204 S1250

G1 X89.725 Y33.534 F9000.000

G1 F2400.000

G1 X89.305 Y33.404 E0.00598

G1 X87.876 Y33.163 F9000.000

G1 F2400.000

G1 X87.252 Y33.135 E0.01377

G1 X86.612 Y33.164 E0.01293

G1 X85.183 Y33.404 F9000.000

G1 F2400.000

G1 X84.763 Y33.534 E0.00557

G1 X84.723 Y33.839 F9000.000

M204 S1000

G1 F4800.000

G1 X84.380 Y33.495 E0.01270

G1 X83.787 Y33.495 E0.01549

G1 X84.279 Y33.988 E0.01820

G1 X83.995 Y34.296 E0.01096

G1 X83.194 Y33.495 E0.02958

G1 X82.602 Y33.495 E0.01549

G1 X83.740 Y34.634 E0.04207

G1 X83.516 Y35.002 E0.01127

G1 X82.044 Y33.530 E0.05440

G1 X81.533 Y33.612 E0.01353

G1 X83.326 Y35.405 E0.06629

G1 X83.175 Y35.847 E0.01220

G1 X81.115 Y33.786 E0.07616

G1 X80.990 Y33.838 E0.00352

G1 X80.749 Y34.013 E0.00780

G1 X83.069 Y36.333 E0.08576

G1 X83.030 Y36.593 E0.00687

G1 X83.017 Y36.874 E0.00733

G1 X80.431 Y34.288 E0.09555

G1 X80.264 Y34.469 E0.00644

G1 X80.170 Y34.619 E0.00463

G1 X83.040 Y37.490 E0.10610

G1 X83.091 Y37.834 E0.00908

G1 X83.191 Y38.233 E0.01077

G1 X79.951 Y34.993 E0.11977

G1 X79.806 Y35.441 E0.01230

G1 X94.763 Y50.398 E0.55280

G1 X94.763 Y50.991 E0.01549

G1 X79.735 Y35.963 E0.55541

G1 X79.725 Y36.546 E0.01523

G1 X94.763 Y51.583 E0.55578

G1 X94.763 Y52.176 E0.01549

G1 X79.725 Y37.138 E0.55578

G1 X79.725 Y37.731 E0.01549

G1 X94.763 Y52.769 E0.55578

G1 X94.763 Y53.361 E0.01549

G1 X79.725 Y38.323 E0.55578

G1 X79.725 Y38.916 E0.01549

G1 X94.763 Y53.954 E0.55578

G1 X94.763 Y54.546 E0.01549

G1 X79.725 Y39.509 E0.55578

G1 X79.725 Y40.101 E0.01549

G1 X94.763 Y55.139 E0.55578

G1 X94.763 Y55.732 E0.01549

G1 X79.725 Y40.694 E0.55578

G1 X79.725 Y41.287 E0.01549

G1 X94.763 Y56.324 E0.55578

G1 X94.763 Y56.917 E0.01549

G1 X79.725 Y41.879 E0.55578

G1 X79.725 Y42.472 E0.01549

G1 X94.763 Y57.510 E0.55578

G1 X94.763 Y58.102 E0.01549

G1 X79.725 Y43.065 E0.55578

G1 X79.725 Y43.657 E0.01549

G1 X94.763 Y58.695 E0.55578

G1 X94.763 Y59.288 E0.01549

G1 X79.725 Y44.250 E0.55578

G1 X79.725 Y44.843 E0.01549

G1 X94.763 Y59.880 E0.55578

G1 X94.763 Y60.473 E0.01549

G1 X79.725 Y45.435 E0.55578

G1 X79.725 Y46.028 E0.01549

G1 X94.763 Y61.066 E0.55578

G1 X94.763 Y61.658 E0.01549

G1 X79.725 Y46.621 E0.55578

G1 X79.725 Y47.213 E0.01549

G1 X94.763 Y62.251 E0.55578

G1 X94.763 Y62.844 E0.01549

G1 X79.725 Y47.806 E0.55578

G1 X79.725 Y48.398 E0.01549

G1 X94.763 Y63.436 E0.55578

M73 P35 R45

G1 X94.763 Y64.029 E0.01549

G1 X79.725 Y48.991 E0.55578

G1 X79.725 Y49.584 E0.01549

G1 X94.763 Y64.621 E0.55578

G1 X94.763 Y65.214 E0.01549

G1 X79.725 Y50.176 E0.55578

G1 X79.725 Y50.769 E0.01549

G1 X94.763 Y65.807 E0.55578

G1 X94.763 Y66.399 E0.01549

G1 X79.725 Y51.362 E0.55578

G1 X79.725 Y51.954 E0.01549

G1 X94.763 Y66.992 E0.55578

G1 X94.763 Y67.585 E0.01549

G1 X79.725 Y52.547 E0.55578

G1 X79.725 Y53.140 E0.01549

G1 X94.763 Y68.177 E0.55578

G1 X94.763 Y68.770 E0.01549

G1 X79.725 Y53.732 E0.55578

G1 X79.725 Y54.325 E0.01549

G1 X94.763 Y69.363 E0.55578

G1 X94.763 Y69.955 E0.01549

G1 X79.725 Y54.918 E0.55578

G1 X79.725 Y55.510 E0.01549

G1 X94.763 Y70.548 E0.55578

G1 X94.763 Y71.141 E0.01549

G1 X79.725 Y56.103 E0.55578

G1 X79.725 Y56.696 E0.01549

G1 X94.763 Y71.733 E0.55578

G1 X94.763 Y72.326 E0.01549

G1 X79.725 Y57.288 E0.55578

G1 X79.725 Y57.881 E0.01549

G1 X94.763 Y72.919 E0.55578

G1 X94.763 Y73.511 E0.01549

G1 X79.725 Y58.474 E0.55578

G1 X79.725 Y59.066 E0.01549

G1 X94.763 Y74.104 E0.55578

G1 X94.763 Y74.696 E0.01549

G1 X79.725 Y59.659 E0.55578

G1 X79.725 Y60.251 E0.01549

G1 X94.763 Y75.289 E0.55578

G1 X94.763 Y75.882 E0.01549

G1 X79.725 Y60.844 E0.55578

G1 X79.725 Y61.437 E0.01549

G1 X94.763 Y76.474 E0.55578

G1 X94.763 Y77.067 E0.01549

G1 X79.725 Y62.029 E0.55578

G1 X79.725 Y62.622 E0.01549

G1 X94.763 Y77.660 E0.55578

G1 X94.763 Y78.252 E0.01549

G1 X79.725 Y63.215 E0.55578

G1 X79.725 Y63.807 E0.01549

G1 X94.763 Y78.845 E0.55578

G1 X94.763 Y79.438 E0.01549

G1 X79.725 Y64.400 E0.55578

G1 X79.725 Y64.993 E0.01549

G1 X94.763 Y80.030 E0.55578

G1 X94.763 Y80.623 E0.01549

G1 X79.725 Y65.585 E0.55578

G1 X79.725 Y66.178 E0.01549

G1 X94.763 Y81.216 E0.55578

G1 X94.763 Y81.808 E0.01549

G1 X79.725 Y66.771 E0.55578

G1 X79.725 Y67.363 E0.01549

G1 X94.763 Y82.401 E0.55578

G1 X94.763 Y82.994 E0.01549

G1 X79.725 Y67.956 E0.55578

G1 X79.725 Y68.549 E0.01549

G1 X94.763 Y83.586 E0.55578

G1 X94.763 Y84.179 E0.01549

G1 X79.725 Y69.141 E0.55578

G1 X79.725 Y69.734 E0.01549

G1 X94.763 Y84.771 E0.55578

G1 X94.763 Y85.364 E0.01549

G1 X79.725 Y70.326 E0.55578

G1 X79.725 Y70.919 E0.01549

G1 X94.763 Y85.957 E0.55578

G1 X94.763 Y86.549 E0.01549

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G1 X79.725 Y72.104 E0.01549

G1 X94.763 Y87.142 E0.55578

G1 X94.763 Y87.735 E0.01549

G1 X79.725 Y72.697 E0.55578

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G1 X94.763 Y88.327 E0.55578

G1 X94.763 Y88.920 E0.01549

G1 X79.725 Y73.882 E0.55578

G1 X79.725 Y74.475 E0.01549

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G1 X94.763 Y90.105 E0.01549

G1 X79.725 Y75.068 E0.55578

G1 X79.725 Y75.660 E0.01549

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G1 X79.725 Y76.253 E0.55578

G1 X79.725 Y76.846 E0.01549

G1 X94.763 Y91.883 E0.55578

G1 X94.763 Y92.476 E0.01549

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G1 X94.763 Y93.661 E0.01549

G1 X79.725 Y78.624 E0.55578

G1 X79.725 Y79.216 E0.01549

G1 X94.763 Y94.254 E0.55578

G1 X94.763 Y94.846 E0.01549

G1 X79.725 Y79.809 E0.55578

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G1 X94.763 Y95.439 E0.55578

G1 X94.763 Y96.032 E0.01549

G1 X79.725 Y80.994 E0.55578

G1 X79.725 Y81.587 E0.01549

G1 X94.763 Y96.624 E0.55578

G1 X94.763 Y97.217 E0.01549

G1 X79.725 Y82.179 E0.55578

G1 X79.725 Y82.772 E0.01549

G1 X94.763 Y97.810 E0.55578

G1 X94.763 Y98.402 E0.01549

G1 X79.725 Y83.365 E0.55578

G1 X79.725 Y83.957 E0.01549

G1 X94.763 Y98.995 E0.55578

G1 X94.763 Y99.588 E0.01549

G1 X79.725 Y84.550 E0.55578

G1 X79.725 Y85.143 E0.01549

G1 X94.763 Y100.180 E0.55578

G1 X94.763 Y100.773 E0.01549

G1 X79.725 Y85.735 E0.55578

G1 X79.725 Y86.328 E0.01549

G1 X94.763 Y101.366 E0.55578

G1 X94.763 Y101.958 E0.01549

G1 X79.725 Y86.921 E0.55578

G1 X79.725 Y87.513 E0.01549

G1 X94.763 Y102.551 E0.55578

G1 X94.763 Y103.144 E0.01549

G1 X79.725 Y88.106 E0.55578

G1 X79.725 Y88.699 E0.01549

G1 X94.763 Y103.736 E0.55578

G1 X94.763 Y104.329 E0.01549

G1 X79.725 Y89.291 E0.55578

G1 X79.725 Y89.884 E0.01549

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G1 X79.725 Y90.476 E0.55578

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G1 X94.763 Y106.107 E0.55578

G1 X94.763 Y106.699 E0.01549

G1 X79.725 Y91.662 E0.55578

G1 X79.725 Y92.254 E0.01549

G1 X94.763 Y107.292 E0.55578

G1 X94.763 Y107.885 E0.01549

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G1 X79.725 Y93.440 E0.01549

G1 X94.763 Y108.477 E0.55578

G1 X94.763 Y109.070 E0.01549

G1 X79.725 Y94.032 E0.55578

G1 X79.725 Y94.625 E0.01549

G1 X94.763 Y109.663 E0.55578

G1 X94.763 Y110.255 E0.01549

G1 X79.725 Y95.218 E0.55578

G1 X79.725 Y95.810 E0.01549

G1 X94.763 Y110.848 E0.55578

G1 X94.763 Y111.441 E0.01549

G1 X79.725 Y96.403 E0.55578

G1 X79.725 Y96.996 E0.01549

G1 X94.763 Y112.033 E0.55578

G1 X94.763 Y112.626 E0.01549

G1 X79.725 Y97.588 E0.55578

G1 X79.725 Y98.181 E0.01549

G1 X94.763 Y113.219 E0.55578

G1 X94.763 Y113.811 E0.01549

G1 X79.725 Y98.774 E0.55578

G1 X79.725 Y99.366 E0.01549

G1 X94.763 Y114.404 E0.55578

G1 X94.763 Y114.996 E0.01549

G1 X79.725 Y99.959 E0.55578

G1 X79.725 Y100.551 E0.01549

G1 X94.763 Y115.589 E0.55578

G1 X94.763 Y116.182 E0.01549

G1 X79.725 Y101.144 E0.55578

G1 X79.725 Y101.737 E0.01549

G1 X94.763 Y116.774 E0.55578

G1 X94.763 Y117.367 E0.01549

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G1 X79.725 Y102.922 E0.01549

G1 X94.763 Y117.960 E0.55578

G1 X94.763 Y118.552 E0.01549

G1 X79.725 Y103.515 E0.55578

G1 X79.725 Y104.107 E0.01549

G1 X94.763 Y119.145 E0.55578

G1 X94.763 Y119.738 E0.01549

G1 X79.725 Y104.700 E0.55578

G1 X79.725 Y105.293 E0.01549

G1 X94.763 Y120.330 E0.55578

G1 X94.763 Y120.923 E0.01549

G1 X79.725 Y105.885 E0.55578

G1 X79.725 Y106.478 E0.01549

G1 X94.763 Y121.516 E0.55578

G1 X94.763 Y122.108 E0.01549

G1 X79.725 Y107.071 E0.55578

G1 X79.725 Y107.663 E0.01549

G1 X94.763 Y122.701 E0.55578

G1 X94.763 Y123.294 E0.01549

G1 X79.725 Y108.256 E0.55578

G1 X79.725 Y108.849 E0.01549

G1 X94.763 Y123.886 E0.55578

G1 X94.763 Y124.479 E0.01549

G1 X79.725 Y109.441 E0.55578

G1 X79.725 Y110.034 E0.01549

G1 X94.753 Y125.061 E0.55540

G1 X94.705 Y125.507 E0.01171

G1 X94.681 Y125.582 E0.00207

G1 X79.725 Y110.626 E0.55274

G1 X79.725 Y111.219 E0.01549

G1 X88.459 Y119.953 E0.32278

G1 X88.070 Y119.855 E0.01048

G1 X87.717 Y119.803 E0.00933

G1 X79.725 Y111.812 E0.29535

G1 X79.725 Y112.404 E0.01549

G1 X87.102 Y119.781 E0.27264

G1 X86.829 Y119.795 E0.00714

G1 X86.562 Y119.834 E0.00705

G1 X79.725 Y112.997 E0.25269

G1 X79.725 Y113.590 E0.01549

G1 X86.076 Y119.941 E0.23474

G1 X85.635 Y120.092 E0.01219

G1 X79.725 Y114.182 E0.21843

G1 X79.725 Y114.775 E0.01549

G1 X85.233 Y120.283 E0.20357

G1 X84.865 Y120.507 E0.01127

G1 X79.725 Y115.368 E0.18996

G1 X79.725 Y115.960 E0.01549

G1 X84.528 Y120.763 E0.17749

G1 X84.220 Y121.048 E0.01096

G1 X79.725 Y116.553 E0.16612

G1 X79.725 Y117.146 E0.01549

G1 X83.942 Y121.362 E0.15583

G1 X83.693 Y121.706 E0.01110

G1 X79.725 Y117.738 E0.14665

G1 X79.725 Y118.331 E0.01549

G1 X83.477 Y122.082 E0.13866

G1 X83.295 Y122.493 E0.01174

G1 X79.725 Y118.924 E0.13192

G1 X79.725 Y119.516 E0.01549

G1 X83.151 Y122.942 E0.12663

G1 X83.054 Y123.437 E0.01318

G1 X79.725 Y120.109 E0.12301

G1 X79.725 Y120.701 E0.01549

G1 X83.011 Y123.987 E0.12144

G1 X83.030 Y124.423 E0.01140

G1 X83.061 Y124.630 E0.00547

G1 X79.725 Y121.294 E0.12329

G1 X79.725 Y121.887 E0.01549

G1 X83.257 Y125.419 E0.13053

G1 X83.332 Y125.629 E0.00584

G1 X83.510 Y126.004 E0.01085

G1 X83.723 Y126.360 E0.01085

G1 X83.971 Y126.695 E0.01088

G1 X84.250 Y127.002 E0.01086

G1 X84.521 Y127.248 E0.00955

G1 X84.514 Y127.268 E0.00056

G1 X79.725 Y122.479 E0.17699

G1 X79.725 Y123.072 E0.01549

G1 X84.180 Y127.527 E0.16465

G1 X83.588 Y127.527 E0.01549

G1 X79.725 Y123.665 E0.14275

G1 X79.725 Y124.257 E0.01549

G1 X82.995 Y127.527 E0.12085

G1 X82.402 Y127.527 E0.01549

G1 X79.725 Y124.850 E0.09894

G1 X79.783 Y125.500 E0.01705

G1 X81.748 Y127.466 E0.07266

G1 X81.192 Y127.288 E0.01526

G1 X80.881 Y127.112 E0.00933

G1 X80.532 Y126.842 E0.01156

G1 X79.785 Y126.095 E0.02759

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.532 Y126.842 E-0.58495

G1 X80.881 Y127.112 E-0.24503

G1 X81.010 Y127.185 E-0.08202

G1 E-0.04800 F4200.00000

G1 Z2.800 F9000.000

G1 X84.771 Y127.488

G1 Z2.600

G1 E3.20000 F2400.00000

G1 X85.193 Y127.619 E0.00578

G1 X86.636 Y127.858 F9000.000

G1 F2400.000

G1 X87.252 Y127.884 E0.01268

G1 X87.852 Y127.858 E0.01331

G1 X89.295 Y127.619 F9000.000

G1 F2400.000

G1 X89.717 Y127.488 E0.00601

G1 X89.756 Y127.176 F9000.000

M204 S1000

G1 F4800.000

G1 X90.107 Y127.527 E0.01296

G1 X90.699 Y127.527 E0.01549

G1 X90.205 Y127.033 E0.01828

G1 X90.490 Y126.725 E0.01096

G1 X91.292 Y127.527 E0.02965

G1 X91.885 Y127.527 E0.01549

G1 X90.745 Y126.387 E0.04212

G1 X90.969 Y126.019 E0.01127

G1 X92.448 Y127.498 E0.05464

G1 X92.781 Y127.459 E0.00877

G1 X92.947 Y127.404 E0.00457

G1 X91.160 Y125.617 E0.06604

G1 X91.311 Y125.176 E0.01219

G1 X93.377 Y127.242 E0.07635

G1 X93.607 Y127.112 E0.00689

G1 X93.739 Y127.010 E0.00435

G1 X91.418 Y124.690 E0.08576

G1 X91.458 Y124.424 E0.00704

G1 X91.471 Y124.151 E0.00714

G1 X94.063 Y126.742 E0.09578

G1 X94.229 Y126.549 E0.00666

G1 X94.322 Y126.409 E0.00440

G1 X91.449 Y123.536 E0.10619

G1 X91.397 Y123.183 E0.00933

G1 X91.300 Y122.794 E0.01048

G1 X94.672 Y126.166 E0.12465

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.509 Y125.002 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.800 F9000.000

G1 X85.708 Y40.751

G1 Z2.600

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.763 Y49.805 E0.33465

G1 X94.763 Y49.213 E0.01549

G1 X86.762 Y41.212 E0.29570

G1 X87.379 Y41.236 E0.01612

G1 X94.763 Y48.620 E0.27292

G1 X94.763 Y48.027 E0.01549

G1 X87.919 Y41.183 E0.25295

G1 X88.405 Y41.077 E0.01301

G1 X94.763 Y47.435 E0.23497

G1 X94.763 Y46.842 E0.01549

G1 X88.847 Y40.926 E0.21864

G1 X89.250 Y40.736 E0.01164

G1 X94.763 Y46.249 E0.20376

G1 X94.763 Y45.657 E0.01549

G1 X89.619 Y40.512 E0.19013

G1 X89.956 Y40.258 E0.01106

G1 X94.763 Y45.064 E0.17764

G1 X94.763 Y44.471 E0.01549

G1 X90.265 Y39.973 E0.16625

G1 X90.543 Y39.659 E0.01097

G1 X94.763 Y43.879 E0.15595

G1 X94.763 Y43.286 E0.01549

G1 X90.792 Y39.315 E0.14676

G1 X91.009 Y38.939 E0.01134

G1 X94.763 Y42.694 E0.13875

G1 X94.763 Y42.101 E0.01549

G1 X91.191 Y38.529 E0.13200

G1 X91.335 Y38.081 E0.01232

G1 X94.763 Y41.508 E0.12668

G1 X94.763 Y40.916 E0.01549

G1 X91.434 Y37.586 E0.12305

G1 X91.477 Y37.037 E0.01440

G1 X94.763 Y40.323 E0.12144

G1 X94.763 Y39.730 E0.01549

G1 X91.428 Y36.396 E0.12324

G1 X91.397 Y36.183 E0.00563

G1 X91.236 Y35.610 E0.01554

G1 X94.951 Y39.326 E0.13732

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;2.75

G1 Z2.750 F9000.000

;AFTER\_LAYER\_CHANGE

;2.75

G1 E-3.20000 F4200.00000

G1 Z2.950 F9000.000

G1 X87.600 Y120.374

G1 Z2.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.956 Y120.426 E0.00938

G1 X88.304 Y120.513 E0.00935

G1 X88.642 Y120.634 E0.00934

G1 X88.966 Y120.788 E0.00933

G1 X89.273 Y120.972 E0.00933

G1 X89.561 Y121.185 E0.00935

G1 X89.827 Y121.426 E0.00934

G1 X90.067 Y121.691 E0.00934

G1 X90.281 Y121.979 E0.00935

G1 X90.465 Y122.287 E0.00933

G1 X90.618 Y122.611 E0.00933

G1 X90.739 Y122.948 E0.00934

G1 X90.826 Y123.296 E0.00934

G1 X90.878 Y123.650 E0.00933

G1 X90.896 Y124.008 E0.00934

G1 X90.878 Y124.366 E0.00934

G1 X90.826 Y124.721 E0.00933

G1 X90.739 Y125.069 E0.00935

G1 X90.618 Y125.406 E0.00934

G1 X90.465 Y125.730 E0.00933

G1 X90.281 Y126.037 E0.00933

G1 X90.067 Y126.325 E0.00935

G1 X89.827 Y126.591 E0.00933

G1 X89.561 Y126.831 E0.00934

G1 X89.273 Y127.045 E0.00935

G1 X88.966 Y127.229 E0.00933

G1 X88.642 Y127.382 E0.00933

G1 X88.304 Y127.503 E0.00934

G1 X87.956 Y127.590 E0.00934

G1 X87.602 Y127.643 E0.00933

G1 X87.244 Y127.661 E0.00934

G1 X86.886 Y127.643 E0.00934

G1 X86.532 Y127.590 E0.00933

G1 X86.184 Y127.503 E0.00935

G1 X85.846 Y127.382 E0.00934

G1 X85.523 Y127.229 E0.00933

G1 X85.215 Y127.045 E0.00933

G1 X84.927 Y126.831 E0.00935

G1 X84.662 Y126.591 E0.00933

G1 X84.421 Y126.325 E0.00934

G1 X84.207 Y126.037 E0.00935

G1 X84.023 Y125.730 E0.00933

G1 X83.870 Y125.406 E0.00933

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G1 X83.610 Y124.366 E0.00934

G1 X83.592 Y124.008 E0.00933

G1 X83.610 Y123.650 E0.00933

G1 X83.662 Y123.296 E0.00934

G1 X83.749 Y122.948 E0.00935

G1 X83.870 Y122.610 E0.00934

G1 X84.023 Y122.287 E0.00933

G1 X84.207 Y121.979 E0.00933

G1 X84.421 Y121.691 E0.00935

G1 X84.662 Y121.426 E0.00933

G1 X84.927 Y121.185 E0.00934

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G1 X85.846 Y120.634 E0.00933

G1 X86.184 Y120.513 E0.00934

G1 X86.532 Y120.426 E0.00934

G1 X86.886 Y120.374 E0.00934

G1 X87.179 Y120.360 E0.00763

G1 X87.540 Y120.372 E0.00943

M204 S1250

G1 X87.810 Y120.081 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.956 Y120.426 E-0.23262

G1 X88.304 Y120.513 E-0.19877

G1 X88.642 Y120.634 E-0.19870

G1 X88.966 Y120.788 E-0.19852

G1 X89.095 Y120.865 E-0.08339

G1 E-0.04800 F4200.00000

G1 Z2.950 F9000.000

G1 X87.244 Y40.660

G1 Z2.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.886 Y40.643 E0.00933

G1 X86.532 Y40.590 E0.00934

G1 X86.184 Y40.503 E0.00935

G1 X85.846 Y40.382 E0.00934

G1 X85.523 Y40.229 E0.00933

G1 X85.215 Y40.045 E0.00933

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G1 X83.662 Y37.721 E0.00934

G1 X83.610 Y37.366 E0.00934

G1 X83.592 Y37.008 E0.00933

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G1 X85.523 Y33.788 E0.00933

G1 X85.846 Y33.634 E0.00933

G1 X86.184 Y33.513 E0.00934

G1 X86.534 Y33.426 E0.00939

G1 X86.951 Y33.371 E0.01098

G1 X87.244 Y33.356 E0.00764

G1 X87.602 Y33.374 E0.00934

G1 X87.956 Y33.426 E0.00933

G1 X88.304 Y33.513 E0.00935

G1 X88.642 Y33.634 E0.00934

G1 X88.966 Y33.788 E0.00933

G1 X89.273 Y33.972 E0.00933

G1 X89.561 Y34.185 E0.00935

G1 X89.827 Y34.426 E0.00933

G1 X90.067 Y34.691 E0.00934

G1 X90.281 Y34.979 E0.00935

G1 X90.465 Y35.287 E0.00933

G1 X90.618 Y35.611 E0.00933

G1 X90.739 Y35.948 E0.00934

G1 X90.826 Y36.296 E0.00934

G1 X90.878 Y36.650 E0.00933

G1 X90.896 Y37.008 E0.00934

G1 X90.878 Y37.366 E0.00934

G1 X90.826 Y37.721 E0.00933

G1 X90.739 Y38.069 E0.00935

G1 X90.618 Y38.406 E0.00934

G1 X90.465 Y38.730 E0.00933

G1 X90.281 Y39.037 E0.00933

G1 X90.067 Y39.325 E0.00935

G1 X89.827 Y39.591 E0.00933

G1 X89.561 Y39.831 E0.00934

G1 X89.273 Y40.045 E0.00935

G1 X88.966 Y40.229 E0.00933

G1 X88.642 Y40.382 E0.00933

G1 X88.304 Y40.503 E0.00934

G1 X87.956 Y40.590 E0.00934

G1 X87.602 Y40.643 E0.00934

G1 X87.304 Y40.657 E0.00777

M204 S1250

G1 X87.065 Y40.970 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.886 Y40.643 E-0.23163

G1 X86.532 Y40.590 E-0.19858

G1 X86.184 Y40.503 E-0.19877

G1 X85.846 Y40.382 E-0.19870

G1 X85.709 Y40.317 E-0.08432

G1 E-0.04800 F4200.00000

G1 Z2.950 F9000.000

G1 X88.980 Y33.332

G1 Z2.750

G1 E3.20000 F2400.00000

M204 S800

G1 X92.206 Y33.332 E0.08406

G1 X92.865 Y33.411 E0.01728

G1 X93.357 Y33.578 E0.01354

G1 X93.979 Y33.973 E0.01920

G1 X94.326 Y34.329 E0.01295

G1 X94.646 Y34.835 E0.01560

G1 X94.803 Y35.243 E0.01140

G1 X94.926 Y36.061 E0.02155

G1 X94.914 Y125.112 E2.32028

G1 X94.863 Y125.561 E0.01178

G1 X94.737 Y125.960 E0.01091

G1 X94.584 Y126.313 E0.01001

G1 X94.382 Y126.620 E0.00959

G1 X94.081 Y126.950 E0.01163

G1 X93.668 Y127.270 E0.01363

G1 X93.349 Y127.445 E0.00946

G1 X92.795 Y127.626 E0.01520

G1 X92.209 Y127.690 E0.01536

G1 X88.967 Y127.690 E0.08447

G1 X89.163 Y127.598 E0.00564

G1 X89.505 Y127.393 E0.01040

G1 X89.826 Y127.155 E0.01042

G1 X90.122 Y126.887 E0.01041

G1 X90.390 Y126.591 E0.01040

G1 X90.629 Y126.269 E0.01042

G1 X90.834 Y125.927 E0.01040

G1 X91.004 Y125.566 E0.01040

G1 X91.139 Y125.190 E0.01042

G1 X91.236 Y124.802 E0.01042

G1 X91.295 Y124.407 E0.01039

G1 X91.315 Y124.008 E0.01041

G1 X91.295 Y123.609 E0.01041

G1 X91.236 Y123.215 E0.01040

G1 X91.139 Y122.827 E0.01041

G1 X91.005 Y122.450 E0.01042

G1 X90.834 Y122.090 E0.01040

G1 X90.629 Y121.747 E0.01040

G1 X90.391 Y121.426 E0.01042

G1 X90.122 Y121.130 E0.01041

G1 X89.826 Y120.862 E0.01041

G1 X89.505 Y120.624 E0.01042

G1 X89.163 Y120.419 E0.01040

G1 X88.802 Y120.248 E0.01040

G1 X88.426 Y120.113 E0.01042

G1 X88.038 Y120.016 E0.01042

G1 X87.638 Y119.957 E0.01053

G1 X87.175 Y119.941 E0.01206

G1 X86.845 Y119.958 E0.00861

G1 X86.450 Y120.016 E0.01040

G1 X86.063 Y120.113 E0.01041

G1 X85.686 Y120.248 E0.01042

G1 X85.325 Y120.419 E0.01040

G1 X84.983 Y120.624 E0.01040

G1 X84.662 Y120.862 E0.01042

G1 X84.366 Y121.130 E0.01041

G1 X84.098 Y121.426 E0.01040

G1 X83.859 Y121.747 E0.01042

G1 X83.655 Y122.090 E0.01040

G1 X83.484 Y122.450 E0.01040

G1 X83.349 Y122.827 E0.01042

G1 X83.252 Y123.215 E0.01042

G1 X83.193 Y123.609 E0.01040

G1 X83.174 Y124.008 E0.01040

G1 X83.193 Y124.407 E0.01040

G1 X83.252 Y124.802 E0.01040

G1 X83.349 Y125.190 E0.01041

G1 X83.484 Y125.566 E0.01042

G1 X83.654 Y125.927 E0.01040

G1 X83.859 Y126.269 E0.01040

G1 X84.098 Y126.591 E0.01042

G1 X84.366 Y126.887 E0.01041

G1 X84.662 Y127.155 E0.01040

G1 X84.983 Y127.393 E0.01042

G1 X85.325 Y127.598 E0.01040

G1 X85.521 Y127.690 E0.00564

G1 X82.274 Y127.690 E0.08459

G1 X81.703 Y127.630 E0.01497

G1 X81.139 Y127.445 E0.01547

G1 X80.821 Y127.270 E0.00946

G1 X80.321 Y126.871 E0.01667

G1 X80.112 Y126.628 E0.00837

G1 X79.904 Y126.313 E0.00983

G1 X79.752 Y125.960 E0.01001

G1 X79.625 Y125.563 E0.01086

G1 X79.562 Y124.975 E0.01541

G1 X79.574 Y35.911 E2.32063

G1 X79.625 Y35.464 E0.01172

G1 X79.835 Y34.845 E0.01704

G1 X80.113 Y34.396 E0.01375

G1 X80.407 Y34.072 E0.01139

G1 X80.899 Y33.700 E0.01607

G1 X81.535 Y33.435 E0.01795

G1 X82.288 Y33.332 E0.01980

G1 X85.508 Y33.332 E0.08391

G1 X85.325 Y33.419 E0.00527

G1 X84.983 Y33.624 E0.01040

G1 X84.662 Y33.862 E0.01042

G1 X84.366 Y34.130 E0.01041

G1 X84.098 Y34.426 E0.01040

G1 X83.859 Y34.747 E0.01042

G1 X83.655 Y35.090 E0.01040

G1 X83.484 Y35.450 E0.01040

G1 X83.349 Y35.827 E0.01042

G1 X83.252 Y36.215 E0.01042

G1 X83.193 Y36.609 E0.01040

G1 X83.174 Y37.008 E0.01040

G1 X83.193 Y37.407 E0.01040

G1 X83.252 Y37.802 E0.01040

G1 X83.349 Y38.190 E0.01041

G1 X83.484 Y38.566 E0.01042

G1 X83.654 Y38.927 E0.01040

G1 X83.859 Y39.269 E0.01040

G1 X84.098 Y39.591 E0.01042

G1 X84.366 Y39.887 E0.01041

G1 X84.662 Y40.155 E0.01040

G1 X84.983 Y40.393 E0.01042

G1 X85.325 Y40.598 E0.01040

G1 X85.686 Y40.769 E0.01040

G1 X86.062 Y40.903 E0.01042

G1 X86.450 Y41.000 E0.01042

G1 X86.845 Y41.059 E0.01040

G1 X87.244 Y41.078 E0.01040

G1 X87.643 Y41.059 E0.01040

G1 X88.038 Y41.000 E0.01040

G1 X88.426 Y40.904 E0.01041

G1 X88.802 Y40.769 E0.01042

G1 X89.163 Y40.598 E0.01040

G1 X89.505 Y40.393 E0.01040

G1 X89.826 Y40.155 E0.01042

G1 X90.122 Y39.887 E0.01041

G1 X90.390 Y39.591 E0.01040

G1 X90.629 Y39.269 E0.01042

G1 X90.834 Y38.927 E0.01040

G1 X91.004 Y38.566 E0.01040

G1 X91.139 Y38.190 E0.01042

G1 X91.236 Y37.802 E0.01042

G1 X91.295 Y37.407 E0.01039

G1 X91.315 Y37.008 E0.01041

G1 X91.295 Y36.609 E0.01041

G1 X91.236 Y36.215 E0.01040

G1 X91.139 Y35.827 E0.01041

G1 X91.005 Y35.450 E0.01042

G1 X90.834 Y35.090 E0.01040

G1 X90.629 Y34.747 E0.01040

G1 X90.391 Y34.426 E0.01042

G1 X90.122 Y34.130 E0.01041

G1 X89.827 Y33.862 E0.01040

G1 X89.505 Y33.624 E0.01042

G1 X89.034 Y33.358 E0.01409

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.680 Y33.344 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.950 F9000.000

G1 X81.424 Y33.028

G1 Z2.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1800.000

G1 X82.259 Y32.914 E0.02197

G1 X92.231 Y32.914 E0.25983

G1 X92.958 Y33.002 E0.01906

M73 P37 R44

G1 X93.519 Y33.192 E0.01543

G1 X93.636 Y33.251 E0.00344

G1 X94.256 Y33.659 E0.01933

G1 X94.663 Y34.079 E0.01523

G1 X95.022 Y34.646 E0.01748

G1 X95.210 Y35.136 E0.01367

G1 X95.344 Y36.030 E0.02356

G1 X95.332 Y125.135 E2.32171

G1 X95.274 Y125.649 E0.01346

G1 X95.128 Y126.106 E0.01252

G1 X94.953 Y126.512 E0.01151

G1 X94.713 Y126.877 E0.01139

G1 X94.366 Y127.258 E0.01343

G1 X93.897 Y127.621 E0.01543

G1 X93.516 Y127.830 E0.01133

G1 X92.884 Y128.037 E0.01735

G1 X92.232 Y128.108 E0.01708

G1 X82.255 Y128.108 E0.25996

G1 X81.608 Y128.038 E0.01695

G1 X80.972 Y127.830 E0.01744

G1 X80.591 Y127.621 E0.01133

G1 X80.018 Y127.159 E0.01917

G1 X79.777 Y126.880 E0.00961

G1 X79.535 Y126.512 E0.01147

G1 X79.360 Y126.106 E0.01151

G1 X79.215 Y125.649 E0.01250

G1 X79.144 Y124.997 E0.01709

G1 X79.156 Y35.887 E2.32183

G1 X79.214 Y35.375 E0.01344

G1 X79.411 Y34.770 E0.01657

G1 X79.465 Y34.649 E0.00344

G1 X79.778 Y34.143 E0.01551

G1 X80.123 Y33.764 E0.01335

G1 X80.596 Y33.398 E0.01561

G1 X80.705 Y33.328 E0.00337

G1 X81.369 Y33.051 E0.01873

M204 S1250

G1 X81.698 Y33.320 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.259 Y32.914 E-0.49938

G1 X83.004 Y32.914 E-0.41262

G1 E-0.04800 F4200.00000

G1 Z2.950 F9000.000

G1 X79.910 Y35.015

G1 Z2.750

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.621 Y34.303 E0.02634

G1 X81.056 Y33.974 E0.01428

G1 X81.618 Y33.740 E0.01592

G1 X81.804 Y33.714 E0.00492

G1 X79.925 Y35.593 E0.06954

G1 X79.887 Y35.928 E0.00884

G1 X79.887 Y36.224 E0.00775

G1 X82.466 Y33.645 E0.09547

G1 X83.060 Y33.645 E0.01554

G1 X79.887 Y36.818 E0.11745

G1 X79.887 Y37.412 E0.01554

G1 X83.654 Y33.645 E0.13942

G1 X84.247 Y33.645 E0.01554

G1 X79.887 Y38.005 E0.16140

G1 X79.887 Y38.599 E0.01554

G1 X83.228 Y35.258 E0.12367

G1 X83.049 Y35.736 E0.01335

G1 X82.950 Y36.130 E0.01063

G1 X79.887 Y39.193 E0.11340

G1 X79.887 Y39.786 E0.01554

G1 X82.870 Y36.803 E0.11044

G1 X82.860 Y37.008 E0.00537

G1 X82.879 Y37.388 E0.00996

G1 X79.887 Y40.380 E0.11076

G1 X79.887 Y40.974 E0.01554

G1 X82.955 Y37.906 E0.11358

G1 X83.082 Y38.373 E0.01267

G1 X79.887 Y41.568 E0.11827

G1 X79.887 Y42.161 E0.01554

G1 X83.248 Y38.800 E0.12442

G1 X83.448 Y39.193 E0.01155

G1 X79.887 Y42.755 E0.13186

G1 X79.886 Y43.349 E0.01554

G1 X83.681 Y39.554 E0.14046

G1 X83.943 Y39.886 E0.01106

G1 X79.886 Y43.942 E0.15016

G1 X79.886 Y44.536 E0.01554

G1 X84.233 Y40.189 E0.16092

G1 X84.552 Y40.464 E0.01102

G1 X79.886 Y45.130 E0.17273

G1 X79.886 Y45.723 E0.01554

G1 X84.901 Y40.709 E0.18563

G1 X85.280 Y40.923 E0.01140

G1 X79.886 Y46.317 E0.19968

G1 X79.886 Y46.911 E0.01554

G1 X85.693 Y41.104 E0.21496

G1 X86.144 Y41.247 E0.01238

G1 X79.886 Y47.504 E0.23165

G1 X79.886 Y48.098 E0.01554

G1 X86.639 Y41.345 E0.24999

G1 X87.188 Y41.389 E0.01442

G1 X79.886 Y48.692 E0.27032

G1 X79.886 Y49.285 E0.01554

G1 X87.822 Y41.349 E0.29379

G1 X88.099 Y41.308 E0.00733

G1 X88.586 Y41.179 E0.01318

G1 X79.697 Y50.067 E0.32903

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.861 Y48.903 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.950 F9000.000

G1 X85.712 Y33.287

G1 Z2.750

G1 E3.20000 F2400.00000

G1 X85.901 Y33.254 E0.00334

G1 X86.291 Y33.196 E0.00474

G1 X86.846 Y33.148 E0.00339

G1 X87.675 Y33.148 F9000.000

G1 F2400.000

G1 X88.009 Y33.173 E0.00208

G1 X88.199 Y33.196 E0.00174

G1 X88.398 Y33.221 E0.00245

G1 X88.587 Y33.254 E0.00284

G1 X88.776 Y33.287 E0.00334

G1 X89.989 Y33.840 F9000.000

M204 S1000

G1 F4800.000

G1 X90.183 Y33.645 E0.00719

G1 X90.777 Y33.645 E0.01554

G1 X90.425 Y33.997 E0.01302

G1 X90.699 Y34.316 E0.01102

G1 X91.370 Y33.645 E0.02484

G1 X91.964 Y33.645 E0.01554

G1 X90.945 Y34.665 E0.03773

G1 X91.159 Y35.044 E0.01140

G1 X92.518 Y33.685 E0.05030

G1 X92.795 Y33.719 E0.00731

G1 X93.006 Y33.790 E0.00584

G1 X91.340 Y35.457 E0.06170

G1 X91.483 Y35.908 E0.01238

G1 X93.408 Y33.982 E0.07129

G1 X93.771 Y34.213 E0.01126

G1 X91.581 Y36.403 E0.08108

G1 X91.626 Y36.952 E0.01442

G1 X94.066 Y34.511 E0.09035

G1 X94.299 Y34.872 E0.01124

G1 X91.585 Y37.586 E0.10047

G1 X91.544 Y37.863 E0.00733

G1 X91.415 Y38.350 E0.01318

G1 X94.483 Y35.282 E0.11356

G1 X94.569 Y35.790 E0.01348

G1 X79.885 Y50.473 E0.54355

G1 X79.885 Y51.067 E0.01554

G1 X94.613 Y36.339 E0.54520

G1 X94.613 Y36.933 E0.01554

G1 X79.885 Y51.660 E0.54520

G1 X79.885 Y52.254 E0.01554

G1 X94.613 Y37.526 E0.54520

G1 X94.613 Y38.120 E0.01554

G1 X79.885 Y52.848 E0.54520

G1 X79.885 Y53.441 E0.01554

G1 X94.613 Y38.714 E0.54520

G1 X94.612 Y39.307 E0.01554

G1 X79.885 Y54.035 E0.54520

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G1 X94.612 Y39.901 E0.54520

G1 X94.612 Y40.495 E0.01554

G1 X79.885 Y55.222 E0.54520

G1 X79.885 Y55.816 E0.01554

G1 X94.612 Y41.088 E0.54520

G1 X94.612 Y41.682 E0.01554

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G1 X79.885 Y57.003 E0.01554

G1 X94.612 Y42.276 E0.54520

G1 X94.612 Y42.870 E0.01554

G1 X79.884 Y57.597 E0.54520

G1 X79.884 Y58.191 E0.01554

G1 X94.612 Y43.463 E0.54520

G1 X94.612 Y44.057 E0.01554

G1 X79.884 Y58.784 E0.54520

G1 X79.884 Y59.378 E0.01554

G1 X94.612 Y44.651 E0.54520

G1 X94.612 Y45.244 E0.01554

G1 X79.884 Y59.972 E0.54520

G1 X79.884 Y60.565 E0.01554

G1 X94.612 Y45.838 E0.54520

G1 X94.612 Y46.432 E0.01554

G1 X79.884 Y61.159 E0.54520

G1 X79.884 Y61.753 E0.01554

G1 X94.611 Y47.025 E0.54520

G1 X94.611 Y47.619 E0.01554

G1 X79.884 Y62.347 E0.54520

G1 X79.884 Y62.940 E0.01554

G1 X94.611 Y48.213 E0.54520

G1 X94.611 Y48.806 E0.01554

G1 X79.884 Y63.534 E0.54520

G1 X79.884 Y64.128 E0.01554

G1 X94.611 Y49.400 E0.54520

G1 X94.611 Y49.994 E0.01554

G1 X79.884 Y64.721 E0.54520

G1 X79.883 Y65.315 E0.01554

G1 X94.611 Y50.587 E0.54520

G1 X94.611 Y51.181 E0.01554

G1 X79.883 Y65.909 E0.54520

G1 X79.883 Y66.502 E0.01554

G1 X94.611 Y51.775 E0.54520

G1 X94.611 Y52.369 E0.01554

G1 X79.883 Y67.096 E0.54520

G1 X79.883 Y67.690 E0.01554

G1 X94.611 Y52.962 E0.54520

G1 X94.611 Y53.556 E0.01554

G1 X79.883 Y68.283 E0.54520

G1 X79.883 Y68.877 E0.01554

G1 X94.610 Y54.150 E0.54520

G1 X94.610 Y54.743 E0.01554

G1 X79.883 Y69.471 E0.54520

G1 X79.883 Y70.064 E0.01554

G1 X94.610 Y55.337 E0.54520

G1 X94.610 Y55.931 E0.01554

G1 X79.883 Y70.658 E0.54520

G1 X79.883 Y71.252 E0.01554

G1 X94.610 Y56.524 E0.54520

G1 X94.610 Y57.118 E0.01554

G1 X79.883 Y71.846 E0.54520

G1 X79.882 Y72.439 E0.01554

G1 X94.610 Y57.712 E0.54520

G1 X94.610 Y58.305 E0.01554

G1 X79.882 Y73.033 E0.54520

G1 X79.882 Y73.627 E0.01554

G1 X94.610 Y58.899 E0.54520

G1 X94.610 Y59.493 E0.01554

G1 X79.882 Y74.220 E0.54520

G1 X79.882 Y74.814 E0.01554

G1 X94.610 Y60.086 E0.54520

G1 X94.610 Y60.680 E0.01554

G1 X79.882 Y75.408 E0.54520

G1 X79.882 Y76.001 E0.01554

G1 X94.609 Y61.274 E0.54520

G1 X94.609 Y61.868 E0.01554

G1 X79.882 Y76.595 E0.54520

G1 X79.882 Y77.189 E0.01554

G1 X94.609 Y62.461 E0.54520

G1 X94.609 Y63.055 E0.01554

G1 X79.882 Y77.782 E0.54520

G1 X79.882 Y78.376 E0.01554

G1 X94.609 Y63.649 E0.54520

G1 X94.609 Y64.242 E0.01554

G1 X79.882 Y78.970 E0.54520

G1 X79.881 Y79.563 E0.01554

G1 X94.609 Y64.836 E0.54520

G1 X94.609 Y65.430 E0.01554

G1 X79.881 Y80.157 E0.54520

G1 X79.881 Y80.751 E0.01554

G1 X94.609 Y66.023 E0.54520

G1 X94.609 Y66.617 E0.01554

G1 X79.881 Y81.344 E0.54520

G1 X79.881 Y81.938 E0.01554

G1 X94.609 Y67.211 E0.54520

G1 X94.609 Y67.804 E0.01554

G1 X79.881 Y82.532 E0.54520

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G1 X94.608 Y68.992 E0.01554

G1 X79.881 Y83.719 E0.54520

G1 X79.881 Y84.313 E0.01554

G1 X94.608 Y69.585 E0.54520

G1 X94.608 Y70.179 E0.01554

G1 X79.881 Y84.907 E0.54520

G1 X79.881 Y85.500 E0.01554

G1 X94.608 Y70.773 E0.54520

G1 X94.608 Y71.366 E0.01554

G1 X79.881 Y86.094 E0.54520

G1 X79.881 Y86.688 E0.01554

G1 X94.608 Y71.960 E0.54520

G1 X94.608 Y72.554 E0.01554

G1 X79.880 Y87.281 E0.54520

G1 X79.880 Y87.875 E0.01554

G1 X94.608 Y73.148 E0.54520

G1 X94.608 Y73.741 E0.01554

G1 X79.880 Y88.469 E0.54520

G1 X79.880 Y89.062 E0.01554

G1 X94.608 Y74.335 E0.54520

G1 X94.608 Y74.929 E0.01554

G1 X79.880 Y89.656 E0.54520

G1 X79.880 Y90.250 E0.01554

G1 X94.608 Y75.522 E0.54520

G1 X94.607 Y76.116 E0.01554

G1 X79.880 Y90.843 E0.54520

G1 X79.880 Y91.437 E0.01554

G1 X94.607 Y76.710 E0.54520

G1 X94.607 Y77.303 E0.01554

G1 X79.880 Y92.031 E0.54520

G1 X79.880 Y92.625 E0.01554

G1 X94.607 Y77.897 E0.54520

G1 X94.607 Y78.491 E0.01554

G1 X79.880 Y93.218 E0.54520

G1 X79.880 Y93.812 E0.01554

G1 X94.607 Y79.084 E0.54520

G1 X94.607 Y79.678 E0.01554

G1 X79.879 Y94.406 E0.54520

G1 X79.879 Y94.999 E0.01554

G1 X94.607 Y80.272 E0.54520

G1 X94.607 Y80.865 E0.01554

G1 X79.879 Y95.593 E0.54520

G1 X79.879 Y96.187 E0.01554

G1 X94.607 Y81.459 E0.54520

G1 X94.607 Y82.053 E0.01554

G1 X79.879 Y96.780 E0.54520

G1 X79.879 Y97.374 E0.01554

G1 X94.607 Y82.647 E0.54520

G1 X94.606 Y83.240 E0.01554

G1 X79.879 Y97.968 E0.54520

G1 X79.879 Y98.561 E0.01554

G1 X94.606 Y83.834 E0.54520

G1 X94.606 Y84.428 E0.01554

G1 X79.879 Y99.155 E0.54520

G1 X79.879 Y99.749 E0.01554

G1 X94.606 Y85.021 E0.54520

G1 X94.606 Y85.615 E0.01554

G1 X79.879 Y100.342 E0.54520

G1 X79.879 Y100.936 E0.01554

G1 X94.606 Y86.209 E0.54520

G1 X94.606 Y86.802 E0.01554

G1 X79.878 Y101.530 E0.54520

G1 X79.878 Y102.124 E0.01554

G1 X94.606 Y87.396 E0.54520

G1 X94.606 Y87.990 E0.01554

G1 X79.878 Y102.717 E0.54520

G1 X79.878 Y103.311 E0.01554

G1 X94.606 Y88.583 E0.54520

G1 X94.606 Y89.177 E0.01554

G1 X79.878 Y103.905 E0.54520

G1 X79.878 Y104.498 E0.01554

G1 X94.606 Y89.771 E0.54520

G1 X94.606 Y90.364 E0.01554

G1 X79.878 Y105.092 E0.54520

G1 X79.878 Y105.686 E0.01554

G1 X94.605 Y90.958 E0.54520

G1 X94.605 Y91.552 E0.01554

G1 X79.878 Y106.279 E0.54520

G1 X79.878 Y106.873 E0.01554

G1 X94.605 Y92.145 E0.54520

G1 X94.605 Y92.739 E0.01554

G1 X79.878 Y107.467 E0.54520

G1 X79.878 Y108.060 E0.01554

G1 X94.605 Y93.333 E0.54520

G1 X94.605 Y93.927 E0.01554

G1 X79.878 Y108.654 E0.54520

G1 X79.877 Y109.248 E0.01554

G1 X94.605 Y94.520 E0.54520

G1 X94.605 Y95.114 E0.01554

G1 X79.877 Y109.841 E0.54520

G1 X79.877 Y110.435 E0.01554

G1 X94.605 Y95.708 E0.54520

G1 X94.605 Y96.301 E0.01554

G1 X79.877 Y111.029 E0.54520

G1 X79.877 Y111.622 E0.01554

G1 X94.605 Y96.895 E0.54520

G1 X94.605 Y97.489 E0.01554

G1 X79.877 Y112.216 E0.54520

G1 X79.877 Y112.810 E0.01554

G1 X94.604 Y98.082 E0.54520

G1 X94.604 Y98.676 E0.01554

G1 X79.877 Y113.404 E0.54520

G1 X79.877 Y113.997 E0.01554

G1 X94.604 Y99.270 E0.54520

G1 X94.604 Y99.863 E0.01554

G1 X79.877 Y114.591 E0.54520

G1 X79.877 Y115.185 E0.01554

G1 X94.604 Y100.457 E0.54520

G1 X94.604 Y101.051 E0.01554

G1 X79.877 Y115.778 E0.54520

G1 X79.876 Y116.372 E0.01554

G1 X94.604 Y101.644 E0.54520

G1 X94.604 Y102.238 E0.01554

G1 X79.876 Y116.966 E0.54520

G1 X79.876 Y117.559 E0.01554

G1 X94.604 Y102.832 E0.54520

G1 X94.604 Y103.426 E0.01554

G1 X79.876 Y118.153 E0.54520

G1 X79.876 Y118.747 E0.01554

G1 X94.604 Y104.019 E0.54520

G1 X94.604 Y104.613 E0.01554

G1 X79.876 Y119.340 E0.54520

G1 X79.876 Y119.934 E0.01554

G1 X94.603 Y105.207 E0.54520

G1 X94.603 Y105.800 E0.01554

G1 X79.876 Y120.528 E0.54520

G1 X79.876 Y121.121 E0.01554

G1 X94.603 Y106.394 E0.54520

G1 X94.603 Y106.988 E0.01554

G1 X79.876 Y121.715 E0.54520

G1 X79.876 Y122.309 E0.01554

G1 X94.603 Y107.581 E0.54520

G1 X94.603 Y108.175 E0.01554

G1 X79.876 Y122.903 E0.54520

G1 X79.875 Y123.496 E0.01554

G1 X94.603 Y108.769 E0.54520

G1 X94.603 Y109.362 E0.01554

G1 X79.875 Y124.090 E0.54520

G1 X79.875 Y124.684 E0.01554

G1 X94.603 Y109.956 E0.54520

G1 X94.603 Y110.550 E0.01554

G1 X79.736 Y125.417 E0.55036

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.899 Y124.253 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.950 F9000.000

G1 X88.763 Y127.735

G1 Z2.750

G1 E3.20000 F2400.00000

G1 X88.581 Y127.767 E0.00323

G1 X88.399 Y127.798 E0.00278

G1 X88.199 Y127.823 E0.00253

G1 X88.010 Y127.847 E0.00181

G1 X87.819 Y127.861 E0.00126

G1 X87.634 Y127.874 E0.00092

G1 X86.854 Y127.874 F9000.000

G1 F2400.000

G1 X86.289 Y127.823 E0.00281

G1 X85.725 Y127.735 E0.00708

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.289 Y127.823 E-0.31615

G1 E-0.64385 F4200.00000

G1 Z2.950 F9000.000

G1 X84.117 Y127.565

G1 Z2.750

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.369 Y127.313 E0.00934

G1 X84.066 Y127.022 E0.01099

G1 X83.711 Y127.377 E0.01313

G1 X83.118 Y127.377 E0.01554

G1 X83.791 Y126.704 E0.02493

G1 X83.546 Y126.356 E0.01115

G1 X82.524 Y127.377 E0.03782

G1 X82.291 Y127.377 E0.00611

G1 X81.965 Y127.342 E0.00857

G1 X83.331 Y125.976 E0.05057

G1 X83.150 Y125.564 E0.01179

G1 X81.485 Y127.229 E0.06163

G1 X81.264 Y127.157 E0.00609

G1 X81.070 Y127.050 E0.00578

G1 X83.007 Y125.114 E0.07169

M73 P38 R43

G1 X82.908 Y124.619 E0.01321

G1 X80.726 Y126.801 E0.08077

G1 X80.603 Y126.706 E0.00407

G1 X80.425 Y126.508 E0.00696

G1 X82.863 Y124.070 E0.09025

G1 X82.902 Y123.438 E0.01659

G1 X80.180 Y126.160 E0.10078

G1 X80.009 Y125.737 E0.01195

G1 X83.389 Y122.357 E0.12511

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.226 Y123.521 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z2.950 F9000.000

G1 X85.593 Y120.153

G1 Z2.750

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.603 Y111.143 E0.33354

G1 X94.603 Y111.737 E0.01554

G1 X86.673 Y119.666 E0.29353

G1 X86.815 Y119.645 E0.00374

G1 X87.301 Y119.632 E0.01274

G1 X94.603 Y112.331 E0.27029

G1 X94.602 Y112.924 E0.01554

G1 X87.855 Y119.672 E0.24979

G1 X88.349 Y119.771 E0.01321

G1 X94.602 Y113.518 E0.23147

G1 X94.602 Y114.112 E0.01554

G1 X88.800 Y119.914 E0.21480

G1 X89.212 Y120.095 E0.01179

G1 X94.602 Y114.706 E0.19953

G1 X94.602 Y115.299 E0.01554

G1 X89.591 Y120.310 E0.18549

G1 X89.939 Y120.555 E0.01115

G1 X94.602 Y115.893 E0.17260

G1 X94.602 Y116.487 E0.01554

G1 X90.258 Y120.830 E0.16080

G1 X90.549 Y121.134 E0.01099

G1 X94.602 Y117.080 E0.15005

G1 X94.602 Y117.674 E0.01554

G1 X90.810 Y121.466 E0.14036

G1 X91.042 Y121.827 E0.01125

G1 X94.602 Y118.268 E0.13178

G1 X94.602 Y118.861 E0.01554

G1 X91.242 Y122.221 E0.12435

G1 X91.408 Y122.648 E0.01201

G1 X94.602 Y119.455 E0.11821

G1 X94.601 Y120.049 E0.01554

G1 X91.534 Y123.116 E0.11354

G1 X91.610 Y123.634 E0.01371

G1 X94.601 Y120.642 E0.11075

G1 X94.601 Y121.236 E0.01554

G1 X91.618 Y124.220 E0.11044

G1 X91.607 Y124.438 E0.00573

G1 X91.536 Y124.895 E0.01210

G1 X94.601 Y121.830 E0.11347

G1 X94.601 Y122.423 E0.01554

G1 X91.255 Y125.770 E0.12387

G1 X91.110 Y126.075 E0.00884

G1 X90.890 Y126.444 E0.01125

G1 X90.633 Y126.790 E0.01128

G1 X90.344 Y127.108 E0.01126

G1 X90.048 Y127.377 E0.01047

G1 X90.241 Y127.377 E0.00506

G1 X94.601 Y123.017 E0.16140

G1 X94.601 Y123.611 E0.01554

G1 X90.835 Y127.377 E0.13942

G1 X91.428 Y127.377 E0.01554

G1 X94.601 Y124.205 E0.11745

G1 X94.601 Y124.798 E0.01554

G1 X92.022 Y127.377 E0.09547

G1 X92.192 Y127.377 E0.00445

G1 X92.667 Y127.325 E0.01252

G1 X94.563 Y125.430 E0.07016

G1 X94.443 Y125.850 E0.01144

G1 X94.307 Y126.163 E0.00893

G1 X94.133 Y126.427 E0.00827

G1 X93.873 Y126.713 E0.01011

G1 X93.236 Y127.351 E0.02362

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;2.9

G1 Z2.900 F9000.000

;AFTER\_LAYER\_CHANGE

;2.9

G1 E-3.20000 F4200.00000

G1 Z3.100 F9000.000

G1 X90.597 Y125.800

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.405 Y126.120 E0.00972

G1 X90.183 Y126.420 E0.00973

G1 X89.933 Y126.697 E0.00972

G1 X89.656 Y126.947 E0.00972

G1 X89.356 Y127.170 E0.00973

G1 X89.036 Y127.361 E0.00972

G1 X88.699 Y127.521 E0.00972

G1 X88.348 Y127.647 E0.00973

G1 X87.986 Y127.737 E0.00973

G1 X87.617 Y127.792 E0.00972

G1 X87.244 Y127.810 E0.00972

G1 X86.871 Y127.792 E0.00972

G1 X86.503 Y127.737 E0.00972

G1 X86.140 Y127.647 E0.00973

G1 X85.789 Y127.521 E0.00973

G1 X85.452 Y127.361 E0.00972

G1 X85.132 Y127.170 E0.00972

G1 X84.832 Y126.947 E0.00973

G1 X84.556 Y126.697 E0.00972

G1 X84.305 Y126.420 E0.00972

G1 X84.083 Y126.120 E0.00973

G1 X83.891 Y125.800 E0.00972

G1 X83.732 Y125.463 E0.00972

G1 X83.606 Y125.112 E0.00973

G1 X83.515 Y124.750 E0.00973

G1 X83.461 Y124.381 E0.00972

G1 X83.442 Y124.008 E0.00972

G1 X83.461 Y123.636 E0.00972

G1 X83.515 Y123.267 E0.00972

G1 X83.606 Y122.904 E0.00973

G1 X83.732 Y122.553 E0.00973

G1 X83.891 Y122.216 E0.00972

G1 X84.083 Y121.896 E0.00972

G1 X84.305 Y121.596 E0.00973

G1 X84.556 Y121.320 E0.00972

G1 X84.832 Y121.069 E0.00972

G1 X85.132 Y120.847 E0.00973

G1 X85.452 Y120.655 E0.00972

G1 X85.789 Y120.496 E0.00972

G1 X86.140 Y120.370 E0.00973

G1 X86.503 Y120.279 E0.00973

G1 X86.872 Y120.225 E0.00972

G1 X87.209 Y120.208 E0.00880

G1 X87.616 Y120.225 E0.01061

G1 X87.986 Y120.279 E0.00975

G1 X88.348 Y120.370 E0.00973

G1 X88.699 Y120.496 E0.00973

G1 X89.036 Y120.655 E0.00972

G1 X89.356 Y120.847 E0.00972

G1 X89.656 Y121.069 E0.00973

G1 X89.933 Y121.320 E0.00972

G1 X90.183 Y121.596 E0.00972

G1 X90.406 Y121.896 E0.00973

G1 X90.597 Y122.216 E0.00972

G1 X90.757 Y122.553 E0.00972

G1 X90.883 Y122.905 E0.00973

G1 X90.973 Y123.267 E0.00973

G1 X91.028 Y123.636 E0.00972

G1 X91.046 Y124.008 E0.00972

G1 X91.028 Y124.381 E0.00972

G1 X90.973 Y124.750 E0.00972

G1 X90.882 Y125.112 E0.00973

G1 X90.757 Y125.463 E0.00973

G1 X90.623 Y125.746 E0.00815

M204 S1250

G1 X90.794 Y126.117 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.405 Y126.120 E-0.23977

G1 X90.183 Y126.420 E-0.20697

G1 X89.933 Y126.697 E-0.20666

G1 X89.656 Y126.947 E-0.20670

G1 X89.581 Y127.003 E-0.05191

G1 E-0.04800 F4200.00000

G1 Z3.100 F9000.000

G1 X89.589 Y127.518

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S800

G1 X89.922 Y127.271 E0.01080

G1 X90.228 Y126.993 E0.01079

G1 X90.506 Y126.686 E0.01079

G1 X90.753 Y126.353 E0.01080

G1 X90.966 Y125.998 E0.01078

G1 X91.143 Y125.624 E0.01078

G1 X91.283 Y125.233 E0.01080

G1 X91.383 Y124.831 E0.01080

G1 X91.444 Y124.422 E0.01078

G1 X91.465 Y124.008 E0.01079

G1 X91.444 Y123.595 E0.01079

G1 X91.383 Y123.185 E0.01078

G1 X91.283 Y122.783 E0.01080

G1 X91.143 Y122.393 E0.01080

G1 X90.966 Y122.019 E0.01078

G1 X90.753 Y121.664 E0.01078

G1 X90.506 Y121.331 E0.01080

G1 X90.228 Y121.024 E0.01079

G1 X89.922 Y120.746 E0.01079

G1 X89.589 Y120.499 E0.01080

G1 X89.233 Y120.286 E0.01078

G1 X88.860 Y120.109 E0.01078

G1 X88.469 Y119.970 E0.01080

G1 X88.067 Y119.869 E0.01080

G1 X87.655 Y119.808 E0.01086

G1 X87.207 Y119.790 E0.01168

G1 X86.831 Y119.808 E0.00982

G1 X86.421 Y119.869 E0.01079

G1 X86.019 Y119.970 E0.01080

G1 X85.629 Y120.109 E0.01080

G1 X85.255 Y120.286 E0.01078

G1 X84.900 Y120.499 E0.01078

G1 X84.567 Y120.746 E0.01080

G1 X84.260 Y121.024 E0.01079

G1 X83.982 Y121.331 E0.01079

G1 X83.735 Y121.664 E0.01080

G1 X83.522 Y122.019 E0.01078

G1 X83.345 Y122.393 E0.01078

G1 X83.205 Y122.783 E0.01080

G1 X83.105 Y123.185 E0.01080

G1 X83.044 Y123.595 E0.01079

G1 X83.024 Y124.008 E0.01079

G1 X83.044 Y124.422 E0.01079

G1 X83.105 Y124.831 E0.01079

G1 X83.205 Y125.233 E0.01080

G1 X83.345 Y125.624 E0.01080

G1 X83.522 Y125.998 E0.01078

G1 X83.735 Y126.353 E0.01078

G1 X83.982 Y126.686 E0.01080

G1 X84.260 Y126.993 E0.01079

G1 X84.567 Y127.271 E0.01079

G1 X84.938 Y127.540 E0.01196

G1 X82.274 Y127.540 E0.06940

G1 X81.756 Y127.489 E0.01357

G1 X81.277 Y127.341 E0.01305

G1 X80.993 Y127.203 E0.00824

G1 X80.479 Y126.814 E0.01678

G1 X80.211 Y126.513 E0.01050

G1 X80.034 Y126.238 E0.00851

G1 X79.865 Y125.849 E0.01105

G1 X79.776 Y125.552 E0.00810

G1 X79.712 Y124.974 E0.01514

G1 X79.718 Y35.975 E2.31894

G1 X79.774 Y35.481 E0.01295

G1 X79.942 Y34.977 E0.01382

G1 X80.221 Y34.499 E0.01445

G1 X80.482 Y34.206 E0.01020

G1 X80.953 Y33.841 E0.01553

G1 X81.595 Y33.573 E0.01813

G1 X82.286 Y33.482 E0.01817

G1 X84.928 Y33.482 E0.06883

G1 X84.567 Y33.746 E0.01165

G1 X84.260 Y34.024 E0.01079

G1 X83.982 Y34.331 E0.01079

G1 X83.735 Y34.664 E0.01080

G1 X83.522 Y35.019 E0.01078

G1 X83.345 Y35.393 E0.01078

G1 X83.205 Y35.783 E0.01080

G1 X83.105 Y36.185 E0.01080

G1 X83.044 Y36.595 E0.01079

G1 X83.024 Y37.008 E0.01079

G1 X83.044 Y37.422 E0.01079

G1 X83.105 Y37.831 E0.01079

G1 X83.205 Y38.233 E0.01080

G1 X83.345 Y38.624 E0.01080

G1 X83.522 Y38.998 E0.01078

G1 X83.735 Y39.353 E0.01078

G1 X83.982 Y39.686 E0.01080

G1 X84.260 Y39.993 E0.01079

G1 X84.567 Y40.271 E0.01079

G1 X84.900 Y40.518 E0.01080

G1 X85.255 Y40.730 E0.01078

G1 X85.629 Y40.907 E0.01078

G1 X86.019 Y41.047 E0.01080

G1 X86.421 Y41.147 E0.01080

G1 X86.831 Y41.208 E0.01079

G1 X87.244 Y41.228 E0.01079

G1 X87.658 Y41.208 E0.01079

G1 X88.067 Y41.147 E0.01079

G1 X88.469 Y41.047 E0.01080

G1 X88.859 Y40.907 E0.01080

G1 X89.233 Y40.730 E0.01078

G1 X89.589 Y40.518 E0.01078

G1 X89.922 Y40.271 E0.01080

G1 X90.228 Y39.993 E0.01079

G1 X90.506 Y39.686 E0.01079

G1 X90.753 Y39.353 E0.01080

G1 X90.966 Y38.998 E0.01078

G1 X91.143 Y38.624 E0.01078

G1 X91.283 Y38.233 E0.01080

G1 X91.383 Y37.831 E0.01080

G1 X91.444 Y37.422 E0.01078

G1 X91.465 Y37.008 E0.01079

G1 X91.444 Y36.595 E0.01079

G1 X91.383 Y36.185 E0.01078

G1 X91.283 Y35.783 E0.01080

G1 X91.143 Y35.393 E0.01080

G1 X90.966 Y35.019 E0.01078

G1 X90.753 Y34.664 E0.01078

G1 X90.506 Y34.331 E0.01080

G1 X90.228 Y34.024 E0.01079

G1 X89.922 Y33.746 E0.01079

G1 X89.560 Y33.482 E0.01166

G1 X92.206 Y33.482 E0.06892

G1 X92.853 Y33.562 E0.01700

G1 X93.288 Y33.713 E0.01201

G1 X93.826 Y34.046 E0.01647

G1 X94.159 Y34.366 E0.01204

G1 X94.507 Y34.891 E0.01641

G1 X94.660 Y35.289 E0.01112

G1 X94.776 Y36.061 E0.02034

G1 X94.770 Y125.048 E2.31861

G1 X94.713 Y125.551 E0.01319

G1 X94.623 Y125.849 E0.00812

G1 X94.455 Y126.238 E0.01105

G1 X94.277 Y126.513 E0.00851

G1 X94.007 Y126.816 E0.01059

G1 X93.555 Y127.166 E0.01489

G1 X93.276 Y127.315 E0.00823

G1 X92.741 Y127.486 E0.01463

G1 X92.211 Y127.540 E0.01389

G1 X89.566 Y127.540 E0.06892

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.922 Y127.271 E-0.24747

G1 X90.228 Y126.993 E-0.22946

G1 X90.506 Y126.686 E-0.22941

G1 X90.727 Y126.388 E-0.20566

G1 E-0.04800 F4200.00000

G1 Z3.100 F9000.000

G1 X87.244 Y40.810

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.872 Y40.792 E0.00972

G1 X86.503 Y40.737 E0.00972

G1 X86.140 Y40.647 E0.00973

G1 X85.789 Y40.521 E0.00973

G1 X85.452 Y40.361 E0.00972

G1 X85.132 Y40.170 E0.00972

G1 X84.832 Y39.947 E0.00973

G1 X84.556 Y39.697 E0.00972

G1 X84.305 Y39.420 E0.00972

G1 X84.083 Y39.120 E0.00973

G1 X83.891 Y38.800 E0.00972

G1 X83.732 Y38.463 E0.00972

G1 X83.606 Y38.112 E0.00973

G1 X83.515 Y37.750 E0.00973

G1 X83.461 Y37.381 E0.00972

G1 X83.442 Y37.008 E0.00972

G1 X83.461 Y36.636 E0.00972

G1 X83.515 Y36.267 E0.00972

G1 X83.606 Y35.904 E0.00973

G1 X83.732 Y35.553 E0.00973

G1 X83.891 Y35.216 E0.00972

G1 X84.083 Y34.896 E0.00972

G1 X84.305 Y34.596 E0.00973

G1 X84.556 Y34.320 E0.00972

G1 X84.832 Y34.069 E0.00972

G1 X85.132 Y33.847 E0.00973

G1 X85.452 Y33.655 E0.00972

G1 X85.789 Y33.496 E0.00972

G1 X86.140 Y33.370 E0.00973

G1 X86.504 Y33.279 E0.00975

G1 X86.906 Y33.223 E0.01060

G1 X87.244 Y33.206 E0.00881

G1 X87.617 Y33.225 E0.00972

G1 X87.986 Y33.279 E0.00972

G1 X88.348 Y33.370 E0.00973

G1 X88.699 Y33.496 E0.00973

G1 X89.036 Y33.655 E0.00972

G1 X89.356 Y33.847 E0.00972

G1 X89.656 Y34.069 E0.00973

G1 X89.933 Y34.320 E0.00972

G1 X90.183 Y34.596 E0.00972

G1 X90.406 Y34.896 E0.00973

G1 X90.597 Y35.216 E0.00972

G1 X90.757 Y35.553 E0.00972

G1 X90.883 Y35.905 E0.00973

G1 X90.973 Y36.267 E0.00973

G1 X91.028 Y36.636 E0.00972

G1 X91.046 Y37.008 E0.00972

G1 X91.028 Y37.381 E0.00972

G1 X90.973 Y37.750 E0.00972

G1 X90.882 Y38.112 E0.00973

G1 X90.757 Y38.463 E0.00972

G1 X90.597 Y38.800 E0.00972

G1 X90.405 Y39.120 E0.00972

G1 X90.183 Y39.420 E0.00973

G1 X89.933 Y39.697 E0.00972

G1 X89.656 Y39.947 E0.00972

G1 X89.356 Y40.170 E0.00973

G1 X89.036 Y40.361 E0.00972

G1 X88.699 Y40.521 E0.00972

G1 X88.348 Y40.647 E0.00973

G1 X87.986 Y40.737 E0.00973

G1 X87.617 Y40.792 E0.00972

G1 X87.304 Y40.807 E0.00815

M204 S1250

G1 X87.058 Y41.133 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.872 Y40.792 E-0.23978

G1 X86.503 Y40.737 E-0.20674

G1 X86.140 Y40.647 E-0.20692

G1 X85.789 Y40.521 E-0.20684

G1 X85.705 Y40.481 E-0.05171

G1 E-0.04800 F4200.00000

G1 Z3.100 F9000.000

G1 X81.485 Y33.166

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1800.000

G1 X82.259 Y33.064 E0.02033

G1 X92.231 Y33.064 E0.25983

G1 X92.948 Y33.153 E0.01883

G1 X93.469 Y33.334 E0.01437

G1 X94.084 Y33.714 E0.01883

G1 X94.481 Y34.097 E0.01439

G1 X94.881 Y34.698 E0.01880

G1 X95.066 Y35.182 E0.01351

G1 X95.194 Y36.030 E0.02234

G1 X95.188 Y125.071 E2.32004

G1 X95.124 Y125.635 E0.01479

G1 X95.016 Y125.993 E0.00974

G1 X94.824 Y126.436 E0.01259

G1 X94.610 Y126.766 E0.01025

G1 X94.293 Y127.123 E0.01243

G1 X93.783 Y127.518 E0.01682

G1 X93.439 Y127.702 E0.01014

G1 X92.827 Y127.897 E0.01674

G1 X92.233 Y127.958 E0.01558

G1 X82.255 Y127.958 E0.25998

G1 X81.664 Y127.898 E0.01547

G1 X81.124 Y127.731 E0.01475

G1 X80.773 Y127.561 E0.01014

G1 X80.194 Y127.122 E0.01893

G1 X79.878 Y126.766 E0.01240

G1 X79.664 Y126.436 E0.01025

G1 X79.472 Y125.993 E0.01259

G1 X79.365 Y125.636 E0.00973

G1 X79.294 Y124.997 E0.01674

G1 X79.301 Y35.951 E2.32015

G1 X79.364 Y35.390 E0.01471

G1 X79.559 Y34.804 E0.01609

G1 X79.882 Y34.252 E0.01666

G1 X80.195 Y33.900 E0.01229

G1 X80.712 Y33.499 E0.01704

G1 X81.430 Y33.190 E0.02037

M204 S1250

G1 X81.768 Y33.450 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.259 Y33.064 E-0.46463

G1 X83.066 Y33.064 E-0.44737

G1 E-0.04800 F4200.00000

G1 Z3.100 F9000.000

G1 X84.006 Y34.117

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.684 Y33.795 E0.01187

G1 X83.093 Y33.795 E0.01541

G1 X83.607 Y34.310 E0.01896

G1 X83.370 Y34.664 E0.01111

G1 X82.502 Y33.795 E0.03201

G1 X82.307 Y33.795 E0.00508

G1 X81.957 Y33.842 E0.00921

G1 X83.162 Y35.047 E0.04445

G1 X82.987 Y35.463 E0.01177

G1 X81.483 Y33.959 E0.05545

G1 X81.075 Y34.143 E0.01166

G1 X82.849 Y35.917 E0.06540

G1 X82.754 Y36.413 E0.01318

G1 X80.742 Y34.401 E0.07420

G1 X80.461 Y34.711 E0.01091

G1 X82.712 Y36.962 E0.08303

G1 X82.753 Y37.594 E0.01650

G1 X80.243 Y35.084 E0.09256

G1 X80.091 Y35.523 E0.01212

G1 X83.224 Y38.656 E0.11552

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.060 Y37.492 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z3.100 F9000.000

G1 X85.596 Y41.029

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X94.462 Y49.894 E0.32688

G1 X94.462 Y49.303 E0.01541

G1 X86.658 Y41.499 E0.28773

G1 X87.290 Y41.540 E0.01650

G1 X94.462 Y48.712 E0.26444

G1 X94.462 Y48.121 E0.01541

G1 X87.839 Y41.498 E0.24419

G1 X88.336 Y41.403 E0.01318

G1 X94.462 Y47.530 E0.22588

G1 X94.462 Y46.938 E0.01541

G1 X88.789 Y41.265 E0.20917

G1 X89.205 Y41.090 E0.01177

G1 X94.462 Y46.347 E0.19383

G1 X94.462 Y45.756 E0.01541

G1 X89.589 Y40.883 E0.17969

G1 X89.943 Y40.645 E0.01111

G1 X94.462 Y45.165 E0.16664

G1 X94.462 Y44.574 E0.01541

G1 X90.268 Y40.379 E0.15464

G1 X90.566 Y40.086 E0.01090

G1 X94.462 Y43.982 E0.14365

G1 X94.462 Y43.391 E0.01541

G1 X90.837 Y39.766 E0.13367

G1 X91.080 Y39.417 E0.01107

G1 X94.462 Y42.800 E0.12472

G1 X94.462 Y42.209 E0.01541

G1 X91.293 Y39.039 E0.11686

G1 X91.474 Y38.629 E0.01169

G1 X94.463 Y41.618 E0.11019

G1 X94.463 Y41.026 E0.01541

G1 X91.619 Y38.182 E0.10486

G1 X91.721 Y37.693 E0.01303

G1 X94.463 Y40.435 E0.10110

G1 X94.463 Y39.844 E0.01541

G1 X91.771 Y37.153 E0.09924

G1 X91.753 Y36.543 E0.01589

G1 X94.463 Y39.253 E0.09990

G1 X94.463 Y38.662 E0.01541

G1 X91.613 Y35.812 E0.10507

G1 X91.433 Y35.273 E0.01482

G1 X91.212 Y34.820 E0.01314

G1 X94.463 Y38.071 E0.11986

G1 X94.463 Y37.479 E0.01541

G1 X90.779 Y33.795 E0.13583

G1 X91.370 Y33.795 E0.01541

G1 X94.463 Y36.888 E0.11403

G1 X94.463 Y36.297 E0.01541

G1 X91.961 Y33.796 E0.09223

G1 X92.186 Y33.796 E0.00586

G1 X92.604 Y33.847 E0.01097

G1 X94.620 Y35.862 E0.07432

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.456 Y34.699 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z3.100 F9000.000

G1 X89.360 Y33.422

G1 Z2.900

G1 E3.20000 F2400.00000

G1 X88.813 Y33.285 E0.00748

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.360 Y33.422 E-0.31247

G1 E-0.64753 F4200.00000

G1 Z3.100 F9000.000

G1 X85.675 Y33.285

G1 Z2.900

G1 E3.20000 F2400.00000

G1 X85.128 Y33.422 E0.00748

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.675 Y33.285 E-0.31247

G1 E-0.64753 F4200.00000

G1 Z3.100 F9000.000

G1 X94.650 Y50.673

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X80.032 Y36.055 E0.53898

G1 X80.032 Y36.647 E0.01541

G1 X94.462 Y51.077 E0.53205

G1 X94.462 Y51.668 E0.01541

G1 X80.032 Y37.238 E0.53205

G1 X80.032 Y37.829 E0.01541

G1 X94.462 Y52.259 E0.53205

G1 X94.462 Y52.850 E0.01541

G1 X80.032 Y38.420 E0.53205

G1 X80.032 Y39.011 E0.01541

G1 X94.462 Y53.441 E0.53205

G1 X94.462 Y54.033 E0.01541

G1 X80.032 Y39.603 E0.53205

G1 X80.032 Y40.194 E0.01541

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G1 X94.462 Y55.215 E0.01541

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G1 X80.031 Y41.376 E0.01541

G1 X94.461 Y55.806 E0.53205

G1 X94.461 Y56.397 E0.01541

G1 X80.031 Y41.967 E0.53205

G1 X80.031 Y42.558 E0.01541

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G1 X94.461 Y57.580 E0.01541

G1 X80.031 Y43.150 E0.53205

G1 X80.031 Y43.741 E0.01541

G1 X94.461 Y58.171 E0.53205

G1 X94.461 Y58.762 E0.01541

G1 X80.031 Y44.332 E0.53205

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G1 X80.031 Y46.106 E0.01541

G1 X94.461 Y60.536 E0.53205

G1 X94.461 Y61.127 E0.01541

G1 X80.031 Y46.697 E0.53205

G1 X80.031 Y47.288 E0.01541

G1 X94.461 Y61.718 E0.53205

G1 X94.461 Y62.309 E0.01541

G1 X80.031 Y47.879 E0.53205

G1 X80.031 Y48.470 E0.01541

G1 X94.461 Y62.900 E0.53205

G1 X94.461 Y63.492 E0.01541

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G1 X80.031 Y49.653 E0.01541

G1 X94.461 Y64.083 E0.53205

G1 X94.461 Y64.674 E0.01541

G1 X80.031 Y50.244 E0.53205

G1 X80.031 Y50.835 E0.01541

G1 X94.461 Y65.265 E0.53205

G1 X94.461 Y65.856 E0.01541

G1 X80.031 Y51.426 E0.53205

G1 X80.031 Y52.017 E0.01541

G1 X94.461 Y66.448 E0.53205

G1 X94.461 Y67.039 E0.01541

G1 X80.031 Y52.609 E0.53205

G1 X80.031 Y53.200 E0.01541

G1 X94.461 Y67.630 E0.53205

G1 X94.461 Y68.221 E0.01541

G1 X80.031 Y53.791 E0.53205

G1 X80.030 Y54.382 E0.01541

G1 X94.461 Y68.812 E0.53205

G1 X94.460 Y69.403 E0.01541

G1 X80.030 Y54.973 E0.53205

G1 X80.030 Y55.565 E0.01541

G1 X94.460 Y69.995 E0.53205

G1 X94.460 Y70.586 E0.01541

G1 X80.030 Y56.156 E0.53205

G1 X80.030 Y56.747 E0.01541

G1 X94.460 Y71.177 E0.53205

G1 X94.460 Y71.768 E0.01541

G1 X80.030 Y57.338 E0.53205

G1 X80.030 Y57.929 E0.01541

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G1 X94.460 Y73.542 E0.53205

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G1 X80.030 Y59.703 E0.53205

G1 X80.030 Y60.294 E0.01541

G1 X94.460 Y74.724 E0.53205

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G1 X94.460 Y81.227 E0.01541

G1 X80.030 Y66.797 E0.53205

G1 X80.030 Y67.388 E0.01541

G1 X94.460 Y81.818 E0.53205

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G1 X80.029 Y68.571 E0.01541

G1 X94.459 Y83.001 E0.53205

G1 X94.459 Y83.592 E0.01541

G1 X80.029 Y69.162 E0.53205

G1 X80.029 Y69.753 E0.01541

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G1 X80.029 Y74.483 E0.01541

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G1 X94.459 Y93.051 E0.01541

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G1 X94.458 Y97.189 E0.53205

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G1 X80.028 Y83.942 E0.01541

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G1 X94.458 Y98.963 E0.01541

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G1 X80.028 Y85.124 E0.01541

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G1 X80.028 Y85.715 E0.53205

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M73 P40 R42

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G1 X80.028 Y87.489 E0.01541

G1 X94.458 Y101.919 E0.53205

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G1 X80.028 Y89.853 E0.01541

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G1 X94.458 Y107.239 E0.01541

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G1 X80.028 Y93.401 E0.01541

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G1 X94.458 Y108.422 E0.01541

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G1 X94.457 Y117.290 E0.53205

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G1 X94.457 Y119.063 E0.01541

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G1 X80.027 Y105.815 E0.53205

G1 X80.027 Y106.407 E0.01541

G1 X94.457 Y120.837 E0.53205

G1 X94.457 Y121.428 E0.01541

G1 X80.027 Y106.998 E0.53205

G1 X80.027 Y107.589 E0.01541

G1 X94.457 Y122.019 E0.53205

G1 X94.457 Y122.610 E0.01541

G1 X80.027 Y108.180 E0.53205

G1 X80.026 Y108.771 E0.01541

G1 X94.457 Y123.201 E0.53205

G1 X94.456 Y123.793 E0.01541

G1 X80.026 Y109.363 E0.53205

G1 X80.026 Y109.954 E0.01541

G1 X94.456 Y124.384 E0.53205

G1 X94.456 Y124.975 E0.01541

G1 X80.026 Y110.545 E0.53205

G1 X80.026 Y111.136 E0.01541

G1 X88.559 Y119.669 E0.31461

G1 X88.128 Y119.561 E0.01158

G1 X87.814 Y119.515 E0.00829

G1 X80.026 Y111.727 E0.28713

G1 X80.026 Y112.319 E0.01541

G1 X87.185 Y119.477 E0.26395

G1 X86.637 Y119.520 E0.01434

G1 X80.026 Y112.910 E0.24374

G1 X80.026 Y113.501 E0.01541

G1 X86.141 Y119.616 E0.22547

G1 X85.689 Y119.755 E0.01234

G1 X80.026 Y114.092 E0.20879

G1 X80.026 Y114.683 E0.01541

G1 X85.274 Y119.931 E0.19348

G1 X84.891 Y120.139 E0.01136

G1 X80.026 Y115.274 E0.17936

G1 X80.026 Y115.866 E0.01541

G1 X84.538 Y120.377 E0.16635

G1 X84.213 Y120.644 E0.01095

G1 X80.026 Y116.457 E0.15437

G1 X80.026 Y117.048 E0.01541

G1 X83.915 Y120.937 E0.14341

G1 X83.645 Y121.259 E0.01094

G1 X80.026 Y117.639 E0.13345

G1 X80.026 Y118.230 E0.01541

G1 X83.403 Y121.608 E0.12453

G1 X83.191 Y121.987 E0.01132

G1 X80.026 Y118.822 E0.11670

G1 X80.026 Y119.413 E0.01541

G1 X83.011 Y122.398 E0.11006

G1 X82.867 Y122.845 E0.01225

G1 X80.026 Y120.004 E0.10476

G1 X80.026 Y120.595 E0.01541

G1 X82.766 Y123.335 E0.10104

G1 X82.732 Y123.564 E0.00603

G1 X82.717 Y123.877 E0.00818

G1 X80.026 Y121.186 E0.09922

G1 X80.026 Y121.778 E0.01541

G1 X82.737 Y124.489 E0.09999

G1 X82.797 Y124.892 E0.01062

G1 X82.880 Y125.223 E0.00889

G1 X80.025 Y122.369 E0.10524

G1 X80.025 Y122.960 E0.01541

G1 X83.297 Y126.232 E0.12063

G1 X83.474 Y126.527 E0.00897

G1 X83.739 Y126.885 E0.01162

G1 X84.052 Y127.227 E0.01209

G1 X83.701 Y127.227 E0.00914

G1 X80.025 Y123.551 E0.13554

G1 X80.025 Y124.142 E0.01541

G1 X83.110 Y127.227 E0.11374

G1 X82.519 Y127.227 E0.01541

G1 X80.025 Y124.733 E0.09194

G1 X80.025 Y124.957 E0.00582

G1 X80.071 Y125.370 E0.01085

G1 X82.098 Y127.397 E0.07473

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X80.934 Y126.233 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z3.100 F9000.000

G1 X85.139 Y127.596

G1 Z2.900

G1 E3.20000 F2400.00000

G1 X85.688 Y127.738 E0.00775

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.139 Y127.596 E-0.31386

G1 E-0.64614 F4200.00000

G1 Z3.100 F9000.000

G1 X88.801 Y127.738

G1 Z2.900

G1 E3.20000 F2400.00000

G1 X89.191 Y127.640 E0.00551

G1 X89.349 Y127.596 E0.00247

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.191 Y127.640 E-0.09071

G1 E-0.86929 F4200.00000

G1 Z3.100 F9000.000

G1 X90.984 Y127.415

G1 Z2.900

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.609 Y127.040 E0.01385

G1 X90.875 Y126.715 E0.01095

G1 X91.387 Y127.227 E0.01889

G1 X91.979 Y127.227 E0.01541

G1 X91.113 Y126.362 E0.03191

G1 X91.322 Y125.979 E0.01136

G1 X92.535 Y127.192 E0.04473

G1 X92.677 Y127.177 E0.00373

G1 X93.006 Y127.072 E0.00901

G1 X91.497 Y125.563 E0.05563

G1 X91.636 Y125.111 E0.01234

G1 X93.408 Y126.883 E0.06534

G1 X93.742 Y126.625 E0.01099

G1 X91.732 Y124.616 E0.07410

G1 X91.775 Y124.068 E0.01433

G1 X94.028 Y126.320 E0.08305

G1 X94.177 Y126.090 E0.00716

G1 X94.241 Y125.942 E0.00419

G1 X91.738 Y123.439 E0.09231

G1 X91.691 Y123.124 E0.00829

G1 X91.583 Y122.693 E0.01158

G1 X94.549 Y125.659 E0.10935

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;3.05

G1 Z3.050 F9000.000

;AFTER\_LAYER\_CHANGE

;3.05

G1 E-3.20000 F4200.00000

G1 Z3.250 F9000.000

G1 X90.011 Y127.390

G1 Z3.050

G1 E3.20000 F2400.00000

M204 S800

G1 X90.334 Y127.099 E0.01134

G1 X90.622 Y126.781 E0.01117

G1 X90.878 Y126.436 E0.01119

G1 X91.098 Y126.068 E0.01117

G1 X91.282 Y125.681 E0.01116

G1 X91.426 Y125.277 E0.01118

G1 X91.530 Y124.860 E0.01118

G1 X91.593 Y124.437 E0.01116

G1 X91.615 Y124.008 E0.01118

G1 X91.593 Y123.580 E0.01118

G1 X91.530 Y123.156 E0.01116

G1 X91.426 Y122.740 E0.01118

G1 X91.282 Y122.336 E0.01118

G1 X91.098 Y121.948 E0.01117

G1 X90.878 Y121.580 E0.01117

G1 X90.622 Y121.236 E0.01119

G1 X90.334 Y120.918 E0.01117

G1 X90.017 Y120.630 E0.01117

G1 X89.672 Y120.374 E0.01119

G1 X89.304 Y120.154 E0.01117

G1 X88.917 Y119.971 E0.01117

G1 X88.513 Y119.826 E0.01118

G1 X88.096 Y119.722 E0.01118

G1 X87.672 Y119.659 E0.01118

G1 X87.239 Y119.638 E0.01130

G1 X86.816 Y119.659 E0.01103

G1 X86.392 Y119.722 E0.01117

G1 X85.975 Y119.826 E0.01118

G1 X85.571 Y119.971 E0.01118

G1 X85.184 Y120.154 E0.01117

G1 X84.816 Y120.374 E0.01117

G1 X84.471 Y120.630 E0.01119

G1 X84.154 Y120.918 E0.01117

G1 X83.866 Y121.236 E0.01117

G1 X83.610 Y121.580 E0.01119

G1 X83.390 Y121.948 E0.01117

G1 X83.207 Y122.336 E0.01116

G1 X83.062 Y122.740 E0.01118

G1 X82.958 Y123.156 E0.01118

G1 X82.895 Y123.580 E0.01117

G1 X82.874 Y124.008 E0.01117

G1 X82.895 Y124.436 E0.01117

G1 X82.958 Y124.860 E0.01117

G1 X83.062 Y125.277 E0.01118

G1 X83.207 Y125.681 E0.01118

G1 X83.390 Y126.068 E0.01116

G1 X83.610 Y126.436 E0.01117

G1 X83.866 Y126.781 E0.01119

G1 X84.154 Y127.099 E0.01117

G1 X84.477 Y127.390 E0.01134

G1 X82.274 Y127.390 E0.05739

G1 X81.815 Y127.347 E0.01203

G1 X81.292 Y127.187 E0.01423

G1 X81.054 Y127.067 E0.00696

G1 X80.556 Y126.683 E0.01638

G1 X80.317 Y126.406 E0.00953

G1 X80.163 Y126.165 E0.00746

G1 X79.980 Y125.742 E0.01200

G1 X79.926 Y125.544 E0.00534

G1 X79.862 Y124.973 E0.01497

G1 X79.863 Y36.039 E2.31723

G1 X79.926 Y35.490 E0.01440

G1 X80.096 Y34.992 E0.01371

G1 X80.324 Y34.609 E0.01162

G1 X80.557 Y34.340 E0.00927

G1 X81.025 Y33.976 E0.01545

G1 X81.656 Y33.712 E0.01781

G1 X82.285 Y33.632 E0.01652

G1 X84.469 Y33.632 E0.05692

G1 X84.154 Y33.918 E0.01109

G1 X83.866 Y34.236 E0.01117

G1 X83.610 Y34.580 E0.01119

G1 X83.390 Y34.948 E0.01117

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G1 X83.062 Y35.740 E0.01118

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G1 X82.895 Y36.580 E0.01117

G1 X82.874 Y37.008 E0.01117

G1 X82.895 Y37.436 E0.01117

G1 X82.958 Y37.860 E0.01117

G1 X83.062 Y38.277 E0.01118

G1 X83.207 Y38.681 E0.01118

G1 X83.390 Y39.068 E0.01116

G1 X83.610 Y39.436 E0.01117

G1 X83.866 Y39.781 E0.01119

G1 X84.154 Y40.099 E0.01117

G1 X84.471 Y40.387 E0.01117

G1 X84.816 Y40.642 E0.01119

G1 X85.184 Y40.862 E0.01117

G1 X85.571 Y41.046 E0.01116

G1 X85.975 Y41.190 E0.01118

G1 X86.392 Y41.294 E0.01118

G1 X86.816 Y41.357 E0.01117

G1 X87.244 Y41.378 E0.01117

G1 X87.672 Y41.357 E0.01117

G1 X88.096 Y41.294 E0.01117

G1 X88.513 Y41.190 E0.01118

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G1 X89.304 Y40.862 E0.01116

G1 X89.672 Y40.642 E0.01117

G1 X90.017 Y40.387 E0.01119

G1 X90.334 Y40.099 E0.01117

G1 X90.622 Y39.781 E0.01117

G1 X90.878 Y39.436 E0.01119

G1 X91.098 Y39.068 E0.01117

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G1 X91.593 Y37.437 E0.01116

G1 X91.615 Y37.008 E0.01118

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G1 X90.878 Y34.580 E0.01117

G1 X90.622 Y34.236 E0.01119

G1 X90.334 Y33.918 E0.01117

G1 X90.019 Y33.632 E0.01109

G1 X92.205 Y33.632 E0.05695

G1 X92.841 Y33.712 E0.01672

G1 X93.244 Y33.856 E0.01115

G1 X93.763 Y34.184 E0.01599

G1 X94.070 Y34.489 E0.01126

G1 X94.364 Y34.939 E0.01402

G1 X94.517 Y35.336 E0.01108

G1 X94.626 Y36.061 E0.01913

G1 X94.625 Y124.984 E2.31694

G1 X94.562 Y125.544 E0.01469

G1 X94.508 Y125.742 E0.00535

G1 X94.325 Y126.165 E0.01200

G1 X94.171 Y126.406 E0.00746

G1 X93.932 Y126.683 E0.00954

G1 X93.444 Y127.061 E0.01608

G1 X93.194 Y127.188 E0.00730

G1 X92.689 Y127.345 E0.01378

G1 X92.213 Y127.390 E0.01244

G1 X90.071 Y127.390 E0.05581

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.334 Y127.099 E-0.21771

G1 X90.622 Y126.781 E-0.23760

G1 X90.878 Y126.436 E-0.23792

G1 X91.081 Y126.097 E-0.21877

G1 E-0.04800 F4200.00000

G1 Z3.250 F9000.000

G1 X88.319 Y127.808

G1 Z3.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1800.000

G1 X88.757 Y127.659 E0.01205

G1 X89.107 Y127.493 E0.01010

G1 X89.440 Y127.294 E0.01010

G1 X89.751 Y127.063 E0.01011

G1 X90.039 Y126.803 E0.01010

G1 X90.299 Y126.516 E0.01010

G1 X90.530 Y126.204 E0.01011

G1 X90.729 Y125.871 E0.01010

G1 X90.895 Y125.521 E0.01010

G1 X91.026 Y125.156 E0.01011

G1 X91.120 Y124.779 E0.01011

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G1 X91.026 Y122.861 E0.01011

G1 X90.895 Y122.496 E0.01011

G1 X90.729 Y122.145 E0.01010

G1 X90.530 Y121.813 E0.01010

G1 X90.299 Y121.501 E0.01011

G1 X90.039 Y121.214 E0.01010

G1 X89.751 Y120.953 E0.01010

G1 X89.440 Y120.722 E0.01011

G1 X89.107 Y120.523 E0.01010

G1 X88.757 Y120.357 E0.01010

G1 X88.391 Y120.226 E0.01011

G1 X88.015 Y120.132 E0.01011

G1 X87.631 Y120.075 E0.01011

G1 X87.239 Y120.057 E0.01023

G1 X86.857 Y120.075 E0.00997

G1 X86.473 Y120.132 E0.01010

G1 X86.097 Y120.226 E0.01011

G1 X85.732 Y120.357 E0.01011

G1 X85.381 Y120.523 E0.01010

G1 X85.049 Y120.722 E0.01010

G1 X84.737 Y120.953 E0.01011

G1 X84.450 Y121.214 E0.01010

G1 X84.189 Y121.501 E0.01010

G1 X83.958 Y121.813 E0.01011

G1 X83.759 Y122.145 E0.01010

G1 X83.593 Y122.496 E0.01010

G1 X83.462 Y122.861 E0.01011

G1 X83.368 Y123.237 E0.01011

G1 X83.311 Y123.621 E0.01010

G1 X83.292 Y124.008 E0.01010

G1 X83.311 Y124.395 E0.01010

G1 X83.368 Y124.779 E0.01010

G1 X83.462 Y125.156 E0.01011

G1 X83.593 Y125.521 E0.01011

G1 X83.759 Y125.871 E0.01010

G1 X83.958 Y126.204 E0.01010

G1 X84.189 Y126.516 E0.01011

G1 X84.450 Y126.803 E0.01010

G1 X84.737 Y127.063 E0.01010

G1 X85.049 Y127.294 E0.01011

G1 X85.381 Y127.493 E0.01010

G1 X85.732 Y127.659 E0.01010

G1 X86.169 Y127.808 E0.01205

G1 X82.255 Y127.808 E0.10200

G1 X81.733 Y127.759 E0.01365

G1 X81.136 Y127.576 E0.01628

G1 X80.830 Y127.422 E0.00893

G1 X80.268 Y126.988 E0.01850

G1 X79.981 Y126.656 E0.01142

G1 X79.793 Y126.361 E0.00912

G1 X79.585 Y125.881 E0.01364

G1 X79.515 Y125.623 E0.00696

G1 X79.444 Y124.997 E0.01643

G1 X79.445 Y36.015 E2.31847

G1 X79.516 Y35.398 E0.01620

G1 X79.715 Y34.816 E0.01601

G1 X79.984 Y34.364 E0.01371

G1 X80.268 Y34.035 E0.01132

G1 X80.813 Y33.612 E0.01797

G1 X81.547 Y33.305 E0.02072

G1 X82.258 Y33.214 E0.01869

G1 X86.145 Y33.214 E0.10127

G1 X85.732 Y33.357 E0.01140

G1 X85.381 Y33.523 E0.01010

G1 X85.049 Y33.722 E0.01010

G1 X84.737 Y33.953 E0.01011

G1 X84.450 Y34.214 E0.01010

G1 X84.189 Y34.501 E0.01010

G1 X83.958 Y34.813 E0.01011

G1 X83.759 Y35.145 E0.01010

G1 X83.593 Y35.496 E0.01010

G1 X83.462 Y35.861 E0.01011

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G1 X83.311 Y36.621 E0.01010

G1 X83.292 Y37.008 E0.01010

G1 X83.311 Y37.395 E0.01010

G1 X83.368 Y37.779 E0.01010

G1 X83.462 Y38.156 E0.01011

G1 X83.593 Y38.521 E0.01011

G1 X83.759 Y38.871 E0.01010

G1 X83.958 Y39.204 E0.01010

G1 X84.189 Y39.516 E0.01011

G1 X84.450 Y39.803 E0.01010

G1 X84.737 Y40.063 E0.01010

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G1 X85.381 Y40.493 E0.01010

G1 X85.732 Y40.659 E0.01010

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G1 X86.473 Y40.884 E0.01011

G1 X86.857 Y40.941 E0.01010

G1 X87.244 Y40.960 E0.01010

G1 X87.631 Y40.941 E0.01010

G1 X88.015 Y40.884 E0.01010

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G1 X89.107 Y40.493 E0.01010

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G1 X90.895 Y38.521 E0.01010

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G1 X91.177 Y37.396 E0.01010

G1 X91.196 Y37.008 E0.01010

G1 X91.177 Y36.621 E0.01010

G1 X91.120 Y36.238 E0.01010

G1 X91.026 Y35.861 E0.01011

G1 X90.895 Y35.496 E0.01011

G1 X90.729 Y35.145 E0.01010

G1 X90.530 Y34.813 E0.01010

G1 X90.299 Y34.501 E0.01011

G1 X90.039 Y34.214 E0.01010

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G1 X89.440 Y33.722 E0.01011

G1 X89.107 Y33.523 E0.01010

G1 X88.757 Y33.357 E0.01010

G1 X88.343 Y33.214 E0.01140

G1 X92.231 Y33.214 E0.10130

G1 X92.939 Y33.303 E0.01859

G1 X93.428 Y33.478 E0.01355

G1 X94.025 Y33.855 E0.01838

G1 X94.395 Y34.223 E0.01360

G1 X94.738 Y34.747 E0.01633

G1 X94.923 Y35.228 E0.01343

G1 X95.044 Y36.030 E0.02113

G1 X95.043 Y125.007 E2.31837

G1 X94.973 Y125.623 E0.01615

G1 X94.903 Y125.881 E0.00696

G1 X94.695 Y126.361 E0.01364

G1 X94.507 Y126.656 E0.00912

G1 X94.220 Y126.988 E0.01142

G1 X93.668 Y127.415 E0.01819

G1 X93.352 Y127.577 E0.00926

G1 X92.771 Y127.757 E0.01584

G1 X92.233 Y127.808 E0.01408

G1 X88.379 Y127.808 E0.10043

M204 S1250

G1 X88.709 Y127.720 F9000.000

G1 X89.410 Y127.584

G1 F2400.000

G1 X89.815 Y127.461 E0.00384

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.410 Y127.584 E-0.23462

G1 E-0.72538 F4200.00000

G1 Z3.250 F9000.000

G1 X92.438 Y127.246

G1 Z3.050

G1 E3.20000 F2400.00000

M204 S1000

G1 X94.289 Y125.395 E0.06024

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G1 X92.059 Y127.102 E0.07413

G1 X91.538 Y127.102 E0.01201

G1 X94.337 Y124.303 E0.09111

G1 X94.337 Y123.781 E0.01201

G1 X91.016 Y127.102 E0.10810

G1 X90.720 Y127.102 E0.00679

G1 X90.846 Y126.964 E0.00429

G1 X91.118 Y126.596 E0.01053

G1 X91.295 Y126.301 E0.00793

G1 X94.337 Y123.259 E0.09900

G1 X94.337 Y122.737 E0.01201

G1 X91.697 Y125.377 E0.08593

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G1 X91.845 Y124.708 E0.00487

G1 X94.337 Y122.215 E0.08112

G1 X94.337 Y121.693 E0.01201

G1 X91.897 Y124.133 E0.07941

G1 X91.884 Y123.624 E0.01172

G1 X94.337 Y121.171 E0.07984

G1 X94.337 Y120.649 E0.01201

G1 X91.823 Y123.163 E0.08183

G1 X91.724 Y122.741 E0.00999

G1 X94.337 Y120.127 E0.08505

G1 X94.337 Y119.606 E0.01201

G1 X91.593 Y122.350 E0.08931

G1 X91.435 Y121.986 E0.00913

G1 X94.337 Y119.084 E0.09445

G1 X94.337 Y118.562 E0.01201

G1 X91.253 Y121.646 E0.10037

G1 X91.049 Y121.327 E0.00869

G1 X94.337 Y118.040 E0.10700

G1 X94.337 Y117.518 E0.01201

G1 X90.825 Y121.030 E0.11430

G1 X90.577 Y120.756 E0.00850

G1 X94.337 Y116.996 E0.12238

G1 X94.337 Y116.474 E0.01201

G1 X90.307 Y120.504 E0.13116

G1 X90.018 Y120.272 E0.00854

G1 X94.337 Y115.952 E0.14058

G1 X94.337 Y115.430 E0.01201

G1 X89.708 Y120.060 E0.15067

G1 X89.376 Y119.869 E0.00880

G1 X94.337 Y114.908 E0.16146

G1 X94.337 Y114.387 E0.01201

G1 X89.022 Y119.702 E0.17300

G1 X88.637 Y119.564 E0.00939

G1 X94.337 Y113.865 E0.18551

G1 X94.337 Y113.343 E0.01201

G1 X88.223 Y119.457 E0.19898

G1 X87.775 Y119.383 E0.01045

G1 X94.337 Y112.821 E0.21357

G1 X94.337 Y112.299 E0.01201

G1 X87.284 Y119.352 E0.22955

G1 X86.735 Y119.380 E0.01267

G1 X94.337 Y111.777 E0.24744

G1 X94.337 Y111.255 E0.01201

G1 X86.093 Y119.500 E0.26832

G1 X85.892 Y119.550 E0.00477

G1 X85.461 Y119.704 E0.01053

G1 X85.281 Y119.789 E0.00457

G1 X94.337 Y110.733 E0.29473

G1 X94.337 Y110.211 E0.01201

G1 X80.150 Y124.398 E0.46173

G1 X80.150 Y124.920 E0.01201

G1 X83.025 Y122.046 E0.09356

G1 X82.940 Y122.225 E0.00457

G1 X82.786 Y122.656 E0.01053

G1 X82.735 Y122.857 E0.00477

G1 X80.199 Y125.393 E0.08254

G1 X80.253 Y125.646 E0.00596

G1 X80.318 Y125.796 E0.00376

G1 X82.616 Y123.499 E0.07477

G1 X82.587 Y124.049 E0.01268

G1 X80.492 Y126.144 E0.06819

G1 X80.723 Y126.435 E0.00855

G1 X82.619 Y124.539 E0.06169

G1 X82.692 Y124.988 E0.01045

G1 X81.011 Y126.669 E0.05473

G1 X81.208 Y126.822 E0.00575

G1 X81.322 Y126.880 E0.00294

G1 X82.800 Y125.402 E0.04810

G1 X82.938 Y125.786 E0.00939

G1 X81.710 Y127.014 E0.03996

G1 X81.871 Y127.063 E0.00387

G1 X82.156 Y127.090 E0.00659

G1 X83.105 Y126.140 E0.03089

G1 X83.296 Y126.472 E0.00880

G1 X82.665 Y127.102 E0.02051

G1 X83.187 Y127.102 E0.01201

G1 X83.508 Y126.782 E0.01042

G1 X83.740 Y127.071 E0.00854

G1 X83.544 Y127.268 E0.00639

M204 S1250

G1 X84.673 Y127.461 F9000.000

G1 F2400.000

G1 X85.079 Y127.584 E0.00384

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.673 Y127.461 E-0.23462

G1 E-0.72538 F4200.00000

G1 Z3.250 F9000.000

G1 X79.985 Y124.042

G1 Z3.050

G1 E3.20000 F2400.00000

M204 S1000

G1 X94.337 Y109.690 E0.46712

G1 X94.337 Y109.168 E0.01201

G1 X80.150 Y123.355 E0.46173

G1 X80.150 Y122.833 E0.01201

G1 X94.337 Y108.646 E0.46173

G1 X94.337 Y108.124 E0.01201

G1 X80.150 Y122.311 E0.46173

G1 X80.150 Y121.789 E0.01201

G1 X94.337 Y107.602 E0.46173

G1 X94.337 Y107.080 E0.01201

G1 X80.150 Y121.267 E0.46173

G1 X80.150 Y120.745 E0.01201

G1 X94.337 Y106.558 E0.46173

G1 X94.337 Y106.036 E0.01201

G1 X80.150 Y120.223 E0.46173

G1 X80.150 Y119.701 E0.01201

G1 X94.337 Y105.514 E0.46173

G1 X94.337 Y104.992 E0.01201

G1 X80.150 Y119.179 E0.46173

G1 X80.150 Y118.657 E0.01201

G1 X94.337 Y104.471 E0.46173

G1 X94.337 Y103.949 E0.01201

G1 X80.150 Y118.136 E0.46173

G1 X80.150 Y117.614 E0.01201

G1 X94.337 Y103.427 E0.46173

G1 X94.337 Y102.905 E0.01201

G1 X80.150 Y117.092 E0.46173

G1 X80.150 Y116.570 E0.01201

G1 X94.337 Y102.383 E0.46173

G1 X94.337 Y101.861 E0.01201

G1 X80.150 Y116.048 E0.46173

G1 X80.150 Y115.526 E0.01201

G1 X94.337 Y101.339 E0.46173

G1 X94.337 Y100.817 E0.01201

G1 X80.150 Y115.004 E0.46173

G1 X80.150 Y114.482 E0.01201

G1 X94.337 Y100.295 E0.46173

G1 X94.337 Y99.774 E0.01201

G1 X80.150 Y113.960 E0.46173

G1 X80.150 Y113.439 E0.01201

G1 X94.337 Y99.252 E0.46173

G1 X94.337 Y98.730 E0.01201

G1 X80.150 Y112.917 E0.46173

G1 X80.150 Y112.395 E0.01201

G1 X94.337 Y98.208 E0.46173

G1 X94.337 Y97.686 E0.01201

G1 X80.150 Y111.873 E0.46173

G1 X80.150 Y111.351 E0.01201

G1 X94.337 Y97.164 E0.46173

G1 X94.337 Y96.642 E0.01201

G1 X80.150 Y110.829 E0.46173

G1 X80.150 Y110.307 E0.01201

G1 X94.337 Y96.120 E0.46173

M73 P41 R41

G1 X94.337 Y95.598 E0.01201

G1 X80.150 Y109.785 E0.46173

G1 X80.150 Y109.263 E0.01201

G1 X94.337 Y95.076 E0.46173

G1 X94.337 Y94.555 E0.01201

G1 X80.150 Y108.741 E0.46173

G1 X80.150 Y108.220 E0.01201

G1 X94.337 Y94.033 E0.46173

G1 X94.337 Y93.511 E0.01201

G1 X80.150 Y107.698 E0.46173

G1 X80.150 Y107.176 E0.01201

G1 X94.337 Y92.989 E0.46173

G1 X94.337 Y92.467 E0.01201

G1 X80.150 Y106.654 E0.46173

G1 X80.150 Y106.132 E0.01201

G1 X94.337 Y91.945 E0.46173

G1 X94.337 Y91.423 E0.01201

G1 X80.150 Y105.610 E0.46173

G1 X80.150 Y105.088 E0.01201

G1 X94.337 Y90.901 E0.46173

G1 X94.337 Y90.379 E0.01201

G1 X80.150 Y104.566 E0.46173

G1 X80.150 Y104.044 E0.01201

G1 X94.337 Y89.858 E0.46173

G1 X94.337 Y89.336 E0.01201

G1 X80.150 Y103.523 E0.46173

G1 X80.150 Y103.001 E0.01201

G1 X94.337 Y88.814 E0.46173

G1 X94.337 Y88.292 E0.01201

G1 X80.150 Y102.479 E0.46173

G1 X80.150 Y101.957 E0.01201

G1 X94.337 Y87.770 E0.46173

G1 X94.337 Y87.248 E0.01201

G1 X80.151 Y101.435 E0.46173

G1 X80.151 Y100.913 E0.01201

G1 X94.337 Y86.726 E0.46173

G1 X94.337 Y86.204 E0.01201

G1 X80.151 Y100.391 E0.46173

G1 X80.151 Y99.869 E0.01201

G1 X94.337 Y85.682 E0.46173

G1 X94.337 Y85.160 E0.01201

G1 X80.151 Y99.347 E0.46173

G1 X80.151 Y98.825 E0.01201

G1 X94.337 Y84.639 E0.46173

G1 X94.337 Y84.117 E0.01201

G1 X80.151 Y98.304 E0.46173

G1 X80.151 Y97.782 E0.01201

G1 X94.337 Y83.595 E0.46173

G1 X94.337 Y83.073 E0.01201

G1 X80.151 Y97.260 E0.46173

G1 X80.151 Y96.738 E0.01201

G1 X94.337 Y82.551 E0.46173

G1 X94.337 Y82.029 E0.01201

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G1 X80.151 Y94.650 E0.01201

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G1 X94.337 Y79.941 E0.01201

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G1 X80.151 Y93.085 E0.46173

G1 X80.151 Y92.563 E0.01201

G1 X94.338 Y78.376 E0.46173

G1 X94.338 Y77.854 E0.01201

G1 X80.151 Y92.041 E0.46173

G1 X80.151 Y91.519 E0.01201

G1 X94.338 Y77.332 E0.46173

G1 X94.338 Y76.810 E0.01201

G1 X80.151 Y90.997 E0.46173

G1 X80.151 Y90.475 E0.01201

G1 X94.338 Y76.288 E0.46173

G1 X94.338 Y75.766 E0.01201

G1 X80.151 Y89.953 E0.46173

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G1 X94.338 Y75.244 E0.46173

G1 X94.338 Y74.723 E0.01201

G1 X80.151 Y88.909 E0.46173

G1 X80.151 Y88.388 E0.01201

G1 X94.338 Y74.201 E0.46173

G1 X94.338 Y73.679 E0.01201

G1 X80.151 Y87.866 E0.46173

G1 X80.151 Y87.344 E0.01201

G1 X94.338 Y73.157 E0.46173

G1 X94.338 Y72.635 E0.01201

G1 X80.151 Y86.822 E0.46173

G1 X80.151 Y86.300 E0.01201

G1 X94.338 Y72.113 E0.46173

G1 X94.338 Y71.591 E0.01201

G1 X80.151 Y85.778 E0.46173

G1 X80.151 Y85.256 E0.01201

G1 X94.338 Y71.069 E0.46173

G1 X94.338 Y70.547 E0.01201

G1 X80.151 Y84.734 E0.46173

G1 X80.151 Y84.212 E0.01201

G1 X94.338 Y70.025 E0.46173

G1 X94.338 Y69.504 E0.01201

G1 X80.151 Y83.690 E0.46173

G1 X80.151 Y83.169 E0.01201

G1 X94.338 Y68.982 E0.46173

G1 X94.338 Y68.460 E0.01201

G1 X80.151 Y82.647 E0.46173

G1 X80.151 Y82.125 E0.01201

G1 X94.338 Y67.938 E0.46173

G1 X94.338 Y67.416 E0.01201

G1 X80.151 Y81.603 E0.46173

G1 X80.151 Y81.081 E0.01201

G1 X94.338 Y66.894 E0.46173

G1 X94.338 Y66.372 E0.01201

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G1 X80.151 Y80.037 E0.01201

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G1 X94.338 Y65.328 E0.01201

G1 X80.151 Y79.515 E0.46173

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G1 X80.151 Y77.428 E0.46173

G1 X80.151 Y76.906 E0.01201

G1 X94.338 Y62.719 E0.46173

G1 X94.338 Y62.197 E0.01201

G1 X80.151 Y76.384 E0.46173

G1 X80.151 Y75.862 E0.01201

G1 X94.338 Y61.675 E0.46173

G1 X94.338 Y61.153 E0.01201

G1 X80.151 Y75.340 E0.46173

G1 X80.151 Y74.818 E0.01201

G1 X94.338 Y60.631 E0.46173

G1 X94.338 Y60.109 E0.01201

G1 X80.151 Y74.296 E0.46173

G1 X80.151 Y73.774 E0.01201

G1 X94.338 Y59.588 E0.46173

G1 X94.338 Y59.066 E0.01201

G1 X80.151 Y73.253 E0.46173

G1 X80.151 Y72.731 E0.01201

G1 X94.338 Y58.544 E0.46173

G1 X94.338 Y58.022 E0.01201

G1 X80.151 Y72.209 E0.46173

G1 X80.151 Y71.687 E0.01201

G1 X94.338 Y57.500 E0.46173

G1 X94.338 Y56.978 E0.01201

G1 X80.151 Y71.165 E0.46173

G1 X80.151 Y70.643 E0.01201

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G1 X80.151 Y69.077 E0.46173

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G1 X94.338 Y54.369 E0.46173

G1 X94.338 Y53.847 E0.01201

G1 X80.151 Y68.034 E0.46173

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G1 X94.338 Y53.325 E0.46173

G1 X94.338 Y52.803 E0.01201

G1 X80.151 Y66.990 E0.46173

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G1 X94.338 Y52.281 E0.46173

G1 X94.338 Y51.759 E0.01201

G1 X80.151 Y65.946 E0.46173

G1 X80.151 Y65.424 E0.01201

G1 X94.338 Y51.237 E0.46173

G1 X94.338 Y50.715 E0.01201

G1 X80.151 Y64.902 E0.46173

G1 X80.151 Y64.380 E0.01201

G1 X94.338 Y50.193 E0.46173

G1 X94.338 Y49.672 E0.01201

G1 X80.151 Y63.858 E0.46173

G1 X80.151 Y63.337 E0.01201

G1 X94.338 Y49.150 E0.46173

G1 X94.338 Y48.628 E0.01201

G1 X80.151 Y62.815 E0.46173

G1 X80.151 Y62.293 E0.01201

G1 X94.338 Y48.106 E0.46173

G1 X94.338 Y47.584 E0.01201

G1 X80.151 Y61.771 E0.46173

G1 X80.151 Y61.249 E0.01201

G1 X94.338 Y47.062 E0.46173

G1 X94.338 Y46.540 E0.01201

G1 X80.151 Y60.727 E0.46173

G1 X80.151 Y60.205 E0.01201

G1 X94.338 Y46.018 E0.46173

G1 X94.338 Y45.496 E0.01201

G1 X80.151 Y59.683 E0.46173

G1 X80.151 Y59.161 E0.01201

G1 X94.338 Y44.974 E0.46173

G1 X94.338 Y44.453 E0.01201

G1 X80.151 Y58.639 E0.46173

G1 X80.151 Y58.118 E0.01201

G1 X94.338 Y43.931 E0.46173

G1 X94.338 Y43.409 E0.01201

G1 X80.151 Y57.596 E0.46173

G1 X80.151 Y57.074 E0.01201

G1 X94.338 Y42.887 E0.46173

G1 X94.338 Y42.365 E0.01201

G1 X80.151 Y56.552 E0.46173

G1 X80.151 Y56.030 E0.01201

G1 X94.338 Y41.843 E0.46173

G1 X94.338 Y41.321 E0.01201

G1 X80.151 Y55.508 E0.46173

G1 X80.151 Y54.986 E0.01201

G1 X94.338 Y40.799 E0.46173

G1 X94.338 Y40.277 E0.01201

G1 X80.151 Y54.464 E0.46173

G1 X80.151 Y53.942 E0.01201

G1 X94.338 Y39.756 E0.46173

G1 X94.338 Y39.234 E0.01201

G1 X80.151 Y53.421 E0.46173

M73 P42 R40

G1 X80.151 Y52.899 E0.01201

G1 X94.338 Y38.712 E0.46173

G1 X94.338 Y38.190 E0.01201

G1 X80.151 Y52.377 E0.46173

G1 X80.151 Y51.855 E0.01201

G1 X94.338 Y37.668 E0.46173

G1 X94.338 Y37.146 E0.01201

G1 X80.151 Y51.333 E0.46173

G1 X80.151 Y50.811 E0.01201

G1 X94.338 Y36.624 E0.46173

G1 X94.338 Y36.102 E0.01201

G1 X91.458 Y38.982 E0.09373

G1 X91.548 Y38.792 E0.00485

G1 X91.703 Y38.361 E0.01053

G1 X91.751 Y38.167 E0.00458

G1 X94.272 Y35.646 E0.08206

G1 X94.236 Y35.410 E0.00551

G1 X94.167 Y35.229 E0.00445

G1 X91.872 Y37.525 E0.07471

G1 X91.902 Y36.973 E0.01272

G1 X93.986 Y34.888 E0.06786

G1 X93.845 Y34.672 E0.00594

G1 X93.762 Y34.590 E0.00267

G1 X91.870 Y36.482 E0.06159

G1 X91.797 Y36.034 E0.01046

G1 X93.483 Y34.348 E0.05486

G1 X93.163 Y34.146 E0.00871

G1 X91.690 Y35.619 E0.04795

G1 X91.552 Y35.235 E0.00939

G1 X92.788 Y33.999 E0.04022

G1 X92.327 Y33.938 E0.01070

G1 X91.385 Y34.880 E0.03066

G1 X91.195 Y34.548 E0.00880

G1 X91.823 Y33.921 E0.02043

G1 X91.301 Y33.920 E0.01201

G1 X90.983 Y34.238 E0.01034

G1 X90.751 Y33.948 E0.00854

G1 X90.944 Y33.755 E0.00629

M204 S1250

G1 X89.533 Y33.506 F9000.000

G1 F2400.000

G1 X89.419 Y33.443 E0.00053

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.533 Y33.506 E-0.07233

G1 E-0.88767 F4200.00000

G1 Z3.250 F9000.000

G1 X85.070 Y33.443

G1 Z3.050

G1 E3.20000 F2400.00000

G1 X84.955 Y33.506 E0.00053

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.070 Y33.443 E-0.07237

G1 E-0.88763 F4200.00000

G1 Z3.250 F9000.000

G1 X82.040 Y33.787

G1 Z3.050

G1 E3.20000 F2400.00000

M204 S1000

G1 X80.201 Y35.627 E0.05988

G1 X80.151 Y36.198 E0.01320

G1 X82.429 Y33.920 E0.07413

G1 X82.951 Y33.920 E0.01201

G1 X80.151 Y36.720 E0.09111

G1 X80.151 Y37.242 E0.01201

G1 X83.473 Y33.920 E0.10810

G1 X83.762 Y33.920 E0.00667

G1 X83.643 Y34.052 E0.00410

G1 X83.370 Y34.420 E0.01053

G1 X83.184 Y34.731 E0.00833

G1 X80.151 Y37.764 E0.09871

G1 X80.151 Y38.286 E0.01201

G1 X82.788 Y35.649 E0.08583

G1 X82.675 Y36.100 E0.01071

G1 X82.643 Y36.316 E0.00503

G1 X80.151 Y38.807 E0.08109

G1 X80.151 Y39.329 E0.01201

G1 X82.591 Y36.889 E0.07941

G1 X82.604 Y37.398 E0.01171

G1 X80.151 Y39.851 E0.07984

G1 X80.151 Y40.373 E0.01201

G1 X82.666 Y37.858 E0.08185

G1 X82.766 Y38.281 E0.00999

G1 X80.151 Y40.895 E0.08509

G1 X80.151 Y41.417 E0.01201

G1 X82.897 Y38.671 E0.08936

G1 X83.055 Y39.035 E0.00913

G1 X80.151 Y41.939 E0.09452

G1 X80.151 Y42.461 E0.01201

G1 X83.237 Y39.375 E0.10044

G1 X83.441 Y39.692 E0.00869

G1 X80.151 Y42.983 E0.10708

G1 X80.151 Y43.505 E0.01201

G1 X83.666 Y39.990 E0.11439

G1 X83.914 Y40.263 E0.00850

G1 X80.151 Y44.026 E0.12247

G1 X80.151 Y44.548 E0.01201

G1 X84.184 Y40.515 E0.13126

G1 X84.474 Y40.747 E0.00854

G1 X80.151 Y45.070 E0.14069

G1 X80.151 Y45.592 E0.01201

G1 X84.784 Y40.959 E0.15079

G1 X85.116 Y41.149 E0.00880

G1 X80.151 Y46.114 E0.16159

G1 X80.151 Y46.636 E0.01201

G1 X85.471 Y41.316 E0.17314

G1 X85.855 Y41.454 E0.00939

G1 X80.151 Y47.158 E0.18565

G1 X80.151 Y47.680 E0.01201

G1 X86.270 Y41.561 E0.19914

G1 X86.718 Y41.634 E0.01046

G1 X80.151 Y48.202 E0.21374

G1 X80.151 Y48.723 E0.01201

G1 X87.209 Y41.665 E0.22972

G1 X87.761 Y41.636 E0.01271

G1 X80.151 Y49.245 E0.24767

G1 X80.151 Y49.767 E0.01201

G1 X88.403 Y41.515 E0.26858

G1 X88.597 Y41.467 E0.00458

G1 X89.027 Y41.312 E0.01053

G1 X89.218 Y41.222 E0.00485

G1 X79.986 Y50.455 E0.30049

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;3.2

G1 Z3.200 F9000.000

;AFTER\_LAYER\_CHANGE

;3.2

G1 E-3.20000 F4200.00000

G1 Z3.400 F9000.000

G1 X81.937 Y49.946

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.890 Y49.643 E0.00798

G1 X81.885 Y47.101 E0.06624

G1 X81.912 Y46.502 E0.01563

G1 X81.959 Y46.263 E0.00634

G1 X92.514 Y46.285 E0.27502

G1 X92.573 Y46.474 E0.00517

G1 X92.592 Y46.765 E0.00759

G1 X92.590 Y49.604 E0.07398

G1 X92.575 Y49.796 E0.00503

G1 X92.531 Y50.001 E0.00546

G1 X88.124 Y50.029 E0.11484

G1 X82.885 Y50.019 E0.13651

G1 X81.965 Y50.032 E0.02397

G1 X81.955 Y50.003 E0.00081

M204 S1250

G1 X81.668 Y50.351 F9000.000

M204 S800

G1 F1500.000

G1 X81.609 Y50.287 E0.00226

G1 X81.529 Y50.043 E0.00670

G1 X81.472 Y49.676 E0.00969

G1 X81.467 Y47.087 E0.06744

G1 X81.501 Y46.586 E0.01308

G1 X81.492 Y46.492 E0.00248

G1 X81.532 Y46.203 E0.00759

G1 X81.617 Y45.996 E0.00583

G1 X81.686 Y45.898 E0.00313

G1 X81.794 Y45.845 E0.00313

G1 X92.725 Y45.867 E0.28481

G1 X92.747 Y45.870 E0.00059

G1 X92.862 Y46.000 E0.00452

G1 X92.987 Y46.397 E0.01084

G1 X93.010 Y46.751 E0.00925

G1 X93.008 Y49.620 E0.07476

G1 X92.990 Y49.857 E0.00619

G1 X92.914 Y50.209 E0.00939

G1 X92.832 Y50.352 E0.00430

G1 X92.776 Y50.408 E0.00205

G1 X88.125 Y50.447 E0.12120

G1 X82.887 Y50.436 E0.13646

G1 X81.794 Y50.452 E0.02850

G1 X81.714 Y50.389 E0.00265

M204 S1250

G1 X81.672 Y50.265 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.609 Y50.287 E-0.08110

G1 X81.529 Y50.043 E-0.14246

G1 X81.472 Y49.676 E-0.20600

G1 X81.470 Y48.805 E-0.48244

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X84.608 Y46.585

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S1000

G1 F3594

G1 X84.653 Y46.890 E0.00803

G1 X84.621 Y47.338 E0.01171

G1 X84.447 Y47.786 E0.01253

G1 X84.068 Y48.235 E0.01529

G1 X83.152 Y49.131 E0.03340

G1 X82.883 Y49.579 E0.01363

G1 X82.839 Y49.706 E0.00349

G1 X86.269 Y49.712 E0.08935

G1 X86.249 Y49.579 E0.00349

G1 X86.281 Y49.131 E0.01171

G1 X86.455 Y48.683 E0.01253

G1 X86.834 Y48.235 E0.01529

G1 X87.750 Y47.338 E0.03340

G1 X88.019 Y46.890 E0.01363

G1 X88.121 Y46.596 E0.00810

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.019 Y46.890 E-0.17237

G1 X87.750 Y47.338 E-0.28978

G1 X87.169 Y47.906 E-0.44985

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X90.013 Y49.704

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S1000

G1 F3594

G1 X90.056 Y49.579 E0.00343

G1 X90.325 Y49.131 E0.01363

G1 X91.241 Y48.235 E0.03340

G1 X91.620 Y47.786 E0.01529

G1 X91.794 Y47.338 E0.01253

G1 X91.825 Y46.890 E0.01171

G1 X91.783 Y46.599 E0.00765

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.825 Y46.890 E-0.16266

G1 X91.794 Y47.338 E-0.24904

G1 X91.620 Y47.786 E-0.26645

G1 X91.347 Y48.109 E-0.23385

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X92.514 Y59.283

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.573 Y59.471 E0.00514

G1 X92.592 Y59.763 E0.00761

G1 X92.590 Y62.602 E0.07399

G1 X92.575 Y62.794 E0.00503

G1 X92.531 Y62.999 E0.00546

G1 X88.124 Y63.026 E0.11484

G1 X82.885 Y63.017 E0.13651

G1 X81.965 Y63.030 E0.02396

G1 X81.890 Y62.641 E0.01033

G1 X81.885 Y60.099 E0.06624

G1 X81.912 Y59.500 E0.01563

G1 X81.959 Y59.261 E0.00634

G1 X92.454 Y59.283 E0.27346

M204 S1250

G1 X92.725 Y58.865 F9000.000

M204 S800

G1 F1500.000

G1 X92.747 Y58.868 E0.00059

G1 X92.862 Y58.998 E0.00452

G1 X92.987 Y59.394 E0.01082

G1 X93.010 Y59.749 E0.00928

G1 X93.008 Y62.618 E0.07476

G1 X92.990 Y62.855 E0.00619

G1 X92.914 Y63.207 E0.00938

G1 X92.832 Y63.350 E0.00429

G1 X92.776 Y63.406 E0.00206

G1 X88.125 Y63.444 E0.12120

G1 X82.887 Y63.434 E0.13646

G1 X81.794 Y63.450 E0.02850

G1 X81.609 Y63.285 E0.00647

G1 X81.529 Y63.041 E0.00669

G1 X81.472 Y62.674 E0.00969

G1 X81.467 Y60.085 E0.06744

G1 X81.501 Y59.584 E0.01308

G1 X81.492 Y59.490 E0.00248

G1 X81.532 Y59.201 E0.00759

G1 X81.617 Y58.994 E0.00583

G1 X81.686 Y58.896 E0.00313

G1 X81.794 Y58.843 E0.00313

G1 X92.665 Y58.865 E0.28325

M204 S1250

G1 X92.734 Y58.885 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.747 Y58.868 E-0.04561

G1 X92.862 Y58.998 E-0.09616

G1 X92.987 Y59.394 E-0.23011

G1 X93.010 Y59.749 E-0.19732

G1 X93.010 Y60.368 E-0.34280

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X83.847 Y59.580

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S1000

G1 F3594

G1 X84.163 Y59.890 E0.01154

G1 X84.433 Y60.338 E0.01363

G1 X84.588 Y60.787 E0.01236

G1 X84.653 Y61.235 E0.01180

G1 X84.621 Y61.683 E0.01171

G1 X84.447 Y62.131 E0.01253

G1 X84.068 Y62.580 E0.01529

G1 X83.929 Y62.705 E0.00489

G1 X86.726 Y62.710 E0.07289

G1 X86.834 Y62.580 E0.00440

G1 X87.750 Y61.683 E0.03340

G1 X88.019 Y61.235 E0.01363

G1 X88.174 Y60.787 E0.01236

G1 X88.239 Y60.338 E0.01180

G1 X88.207 Y59.890 E0.01171

G1 X88.092 Y59.594 E0.00828

G1 X91.038 Y59.598 E0.07675

G1 X91.336 Y59.890 E0.01087

G1 X91.605 Y60.338 E0.01363

G1 X91.760 Y60.787 E0.01236

G1 X91.825 Y61.235 E0.01180

G1 X91.794 Y61.683 E0.01171

G1 X91.620 Y62.131 E0.01253

G1 X91.241 Y62.580 E0.01529

G1 X91.113 Y62.694 E0.00447

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.241 Y62.580 E-0.09512

G1 X91.620 Y62.131 E-0.32524

G1 X91.794 Y61.683 E-0.26645

G1 X91.822 Y61.278 E-0.22520

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X92.514 Y72.280

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.573 Y72.469 E0.00517

G1 X92.592 Y72.760 E0.00761

G1 X92.590 Y75.600 E0.07398

G1 X92.575 Y75.792 E0.00502

G1 X92.531 Y75.997 E0.00547

G1 X88.124 Y76.024 E0.11484

G1 X81.965 Y76.027 E0.16047

G1 X81.890 Y75.639 E0.01031

G1 X81.885 Y73.096 E0.06626

G1 X81.912 Y72.497 E0.01562

G1 X81.959 Y72.258 E0.00635

G1 X92.454 Y72.280 E0.27345

M204 S1250

G1 X92.724 Y71.862 F9000.000

M204 S800

G1 F1500.000

G1 X92.746 Y71.865 E0.00059

G1 X92.862 Y71.995 E0.00454

G1 X92.987 Y72.392 E0.01083

G1 X93.010 Y72.747 E0.00928

G1 X93.008 Y75.616 E0.07476

G1 X92.990 Y75.852 E0.00618

G1 X92.914 Y76.205 E0.00940

G1 X92.832 Y76.348 E0.00429

G1 X92.776 Y76.404 E0.00206

G1 X88.125 Y76.442 E0.12120

G1 X82.887 Y76.432 E0.13646

G1 X81.794 Y76.448 E0.02850

G1 X81.609 Y76.283 E0.00645

G1 X81.529 Y76.039 E0.00669

G1 X81.472 Y75.672 E0.00969

G1 X81.467 Y73.082 E0.06746

G1 X81.501 Y72.583 E0.01305

G1 X81.492 Y72.487 E0.00249

G1 X81.532 Y72.198 E0.00760

G1 X81.617 Y71.991 E0.00582

G1 X81.686 Y71.893 E0.00314

G1 X81.794 Y71.840 E0.00313

G1 X92.664 Y71.862 E0.28324

M204 S1250

G1 X92.733 Y71.882 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.746 Y71.865 E-0.04566

G1 X92.862 Y71.995 E-0.09654

G1 X92.987 Y72.392 E-0.23028

G1 X93.010 Y72.747 E-0.19734

G1 X93.010 Y73.364 E-0.34219

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X82.746 Y72.574

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S1000

G1 F3594

G1 X82.868 Y72.890 E0.00885

G1 X83.247 Y73.339 E0.01529

G1 X84.163 Y74.235 E0.03340

G1 X84.433 Y74.684 E0.01363

G1 X84.588 Y75.132 E0.01236

G1 X84.653 Y75.580 E0.01180

G1 X84.643 Y75.713 E0.00346

G1 X87.940 Y75.711 E0.08591

G1 X88.019 Y75.580 E0.00397

G1 X88.174 Y75.132 E0.01236

G1 X88.239 Y74.684 E0.01180

G1 X88.207 Y74.235 E0.01171

G1 X88.033 Y73.787 E0.01253

G1 X87.655 Y73.339 E0.01529

G1 X86.887 Y72.587 E0.02800

G1 X89.927 Y72.597 E0.07922

G1 X90.041 Y72.890 E0.00821

G1 X90.420 Y73.339 E0.01529

G1 X91.336 Y74.235 E0.03340

G1 X91.605 Y74.684 E0.01363

G1 X91.760 Y75.132 E0.01236

G1 X91.825 Y75.580 E0.01180

G1 X91.818 Y75.688 E0.00282

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.825 Y75.580 E-0.06000

G1 X91.760 Y75.132 E-0.25101

G1 X91.605 Y74.684 E-0.26289

G1 X91.336 Y74.235 E-0.28979

G1 X91.274 Y74.174 E-0.04831

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X92.514 Y85.278

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.573 Y85.467 E0.00517

G1 X92.592 Y85.758 E0.00760

G1 X92.590 Y88.597 E0.07398

G1 X92.575 Y88.790 E0.00502

G1 X92.531 Y88.995 E0.00548

G1 X88.124 Y89.022 E0.11484

G1 X81.965 Y89.025 E0.16047

G1 X81.890 Y88.637 E0.01031

G1 X81.885 Y86.094 E0.06626

G1 X81.912 Y85.495 E0.01564

G1 X81.959 Y85.256 E0.00634

G1 X92.454 Y85.278 E0.27345

M204 S1250

G1 X92.724 Y84.860 F9000.000

M204 S800

G1 F1500.000

G1 X92.746 Y84.863 E0.00059

G1 X92.862 Y84.993 E0.00454

G1 X92.987 Y85.390 E0.01083

G1 X93.010 Y85.745 E0.00927

G1 X93.008 Y88.614 E0.07475

G1 X92.990 Y88.850 E0.00618

G1 X92.914 Y89.203 E0.00941

G1 X92.832 Y89.346 E0.00429

G1 X92.776 Y89.402 E0.00206

G1 X88.125 Y89.440 E0.12120

G1 X82.887 Y89.430 E0.13646

G1 X81.794 Y89.446 E0.02850

G1 X81.609 Y89.281 E0.00645

G1 X81.529 Y89.037 E0.00669

G1 X81.472 Y88.670 E0.00969

G1 X81.467 Y86.080 E0.06746

G1 X81.501 Y85.580 E0.01308

G1 X81.492 Y85.485 E0.00249

G1 X81.532 Y85.196 E0.00759

G1 X81.617 Y84.989 E0.00582

G1 X81.686 Y84.891 E0.00314

G1 X81.794 Y84.838 E0.00313

G1 X92.664 Y84.860 E0.28324

M204 S1250

G1 X92.733 Y84.880 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.746 Y84.863 E-0.04567

G1 X92.862 Y84.993 E-0.09654

G1 X92.987 Y85.390 E-0.23028

G1 X93.010 Y85.745 E-0.19718

G1 X93.010 Y86.362 E-0.34234

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X84.242 Y88.711

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S1000

G1 F3594

G1 X84.163 Y88.580 E0.00396

G1 X83.247 Y87.684 E0.03340

G1 X82.868 Y87.236 E0.01529

G1 X82.695 Y86.787 E0.01253

G1 X82.663 Y86.339 E0.01171

G1 X82.728 Y85.891 E0.01180

G1 X82.838 Y85.572 E0.00879

G1 X86.270 Y85.583 E0.08941

G1 X86.314 Y85.891 E0.00810

G1 X86.469 Y86.339 E0.01236

G1 X86.739 Y86.787 E0.01363

G1 X87.655 Y87.684 E0.03340

G1 X88.033 Y88.132 E0.01529

G1 X88.207 Y88.580 E0.01253

G1 X88.216 Y88.708 E0.00334

G1 X91.401 Y88.689 E0.08298

G1 X91.336 Y88.580 E0.00329

G1 X90.420 Y87.684 E0.03340

G1 X90.041 Y87.236 E0.01529

G1 X89.867 Y86.787 E0.01253

G1 X89.836 Y86.339 E0.01171

G1 X89.901 Y85.891 E0.01180

G1 X90.003 Y85.595 E0.00816

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.901 Y85.891 E-0.17360

G1 X89.836 Y86.339 E-0.25101

G1 X89.867 Y86.787 E-0.24904

G1 X90.023 Y87.188 E-0.23835

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X92.514 Y98.276

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.573 Y98.465 E0.00517

G1 X92.592 Y98.756 E0.00760

G1 X92.590 Y101.595 E0.07397

G1 X92.575 Y101.788 E0.00503

G1 X92.531 Y101.993 E0.00548

G1 X88.124 Y102.020 E0.11484

G1 X81.965 Y102.023 E0.16047

G1 X81.890 Y101.635 E0.01032

G1 X81.885 Y99.092 E0.06626

G1 X81.912 Y98.493 E0.01563

G1 X81.959 Y98.254 E0.00634

G1 X92.454 Y98.276 E0.27345

M204 S1250

G1 X92.725 Y97.858 F9000.000

M204 S800

G1 F1500.000

G1 X92.747 Y97.861 E0.00058

G1 X92.862 Y97.991 E0.00453

G1 X92.987 Y98.388 E0.01083

G1 X93.010 Y98.743 E0.00927

G1 X93.008 Y101.611 E0.07474

G1 X92.990 Y101.848 E0.00619

G1 X92.914 Y102.200 E0.00940

G1 X92.832 Y102.343 E0.00429

G1 X92.776 Y102.400 E0.00207

G1 X88.125 Y102.438 E0.12119

G1 X82.887 Y102.428 E0.13646

G1 X81.794 Y102.444 E0.02850

G1 X81.609 Y102.279 E0.00645

G1 X81.529 Y102.034 E0.00671

G1 X81.472 Y101.668 E0.00966

G1 X81.467 Y99.078 E0.06747

G1 X81.501 Y98.577 E0.01308

G1 X81.492 Y98.483 E0.00248

G1 X81.532 Y98.194 E0.00759

G1 X81.617 Y97.987 E0.00582

G1 X81.686 Y97.889 E0.00314

G1 X81.794 Y97.836 E0.00313

G1 X92.665 Y97.858 E0.28325

M204 S1250

G1 X92.734 Y97.878 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.747 Y97.861 E-0.04550

G1 X92.862 Y97.991 E-0.09644

G1 X92.987 Y98.388 E-0.23036

G1 X93.010 Y98.743 E-0.19718

G1 X93.010 Y99.361 E-0.34252

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X82.977 Y101.710

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S1000

G1 F3594

G1 X82.868 Y101.581 E0.00439

G1 X82.695 Y101.133 E0.01253

G1 X82.663 Y100.684 E0.01171

G1 X82.728 Y100.236 E0.01180

G1 X82.883 Y99.788 E0.01236

G1 X83.152 Y99.339 E0.01363

G1 X83.935 Y98.573 E0.02853

G1 X86.716 Y98.582 E0.07246

G1 X86.455 Y98.891 E0.01053

G1 X86.281 Y99.339 E0.01253

G1 X86.249 Y99.788 E0.01171

G1 X86.314 Y100.236 E0.01180

G1 X86.469 Y100.684 E0.01236

G1 X86.739 Y101.133 E0.01363

G1 X87.326 Y101.707 E0.02141

G1 X90.137 Y101.694 E0.07325

G1 X90.041 Y101.581 E0.00388

G1 X89.867 Y101.133 E0.01253

G1 X89.836 Y100.684 E0.01171

G1 X89.901 Y100.236 E0.01180

G1 X90.056 Y99.788 E0.01236

G1 X90.325 Y99.339 E0.01363

G1 X91.089 Y98.591 E0.02787

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.325 Y99.339 E-0.59277

G1 X90.056 Y99.788 E-0.28978

G1 X90.038 Y99.838 E-0.02944

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X92.514 Y111.274

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.573 Y111.463 E0.00517

G1 X92.592 Y111.754 E0.00761

G1 X92.590 Y114.593 E0.07397

G1 X92.575 Y114.786 E0.00503

G1 X92.531 Y114.991 E0.00548

G1 X88.124 Y115.018 E0.11483

G1 X82.885 Y115.008 E0.13650

G1 X81.965 Y115.021 E0.02397

G1 X81.890 Y114.632 E0.01034

G1 X81.885 Y112.090 E0.06624

G1 X81.912 Y111.491 E0.01563

G1 X81.959 Y111.252 E0.00634

G1 X92.454 Y111.274 E0.27346

M204 S1250

G1 X92.725 Y110.856 F9000.000

M204 S800

G1 F1500.000

G1 X92.747 Y110.859 E0.00059

G1 X92.862 Y110.989 E0.00452

G1 X92.987 Y111.386 E0.01084

G1 X93.010 Y111.741 E0.00927

G1 X93.008 Y114.609 E0.07474

G1 X92.990 Y114.846 E0.00619

G1 X92.914 Y115.198 E0.00940

G1 X92.832 Y115.341 E0.00428

G1 X92.776 Y115.397 E0.00208

G1 X88.125 Y115.436 E0.12119

G1 X82.887 Y115.426 E0.13646

G1 X81.794 Y115.442 E0.02849

G1 X81.609 Y115.276 E0.00647

G1 X81.529 Y115.032 E0.00670

G1 X81.472 Y114.665 E0.00969

G1 X81.467 Y112.076 E0.06744

G1 X81.501 Y111.575 E0.01308

G1 X81.492 Y111.481 E0.00248

G1 X81.532 Y111.192 E0.00759

G1 X81.617 Y110.985 E0.00583

G1 X81.686 Y110.887 E0.00313

G1 X81.794 Y110.834 E0.00313

G1 X92.665 Y110.856 E0.28325

M204 S1250

G1 X92.734 Y110.876 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.747 Y110.859 E-0.04561

G1 X92.862 Y110.989 E-0.09612

G1 X92.987 Y111.386 E-0.23064

G1 X93.010 Y111.741 E-0.19720

G1 X93.010 Y112.359 E-0.34243

G1 E-0.04800 F4200.00000

G1 Z3.400 F9000.000

G1 X82.708 Y114.697

G1 Z3.200

G1 E3.20000 F2400.00000

M204 S1000

G1 F3594

G1 X82.728 Y114.581 E0.00307

G1 X82.883 Y114.133 E0.01236

G1 X83.152 Y113.685 E0.01363

G1 X84.068 Y112.788 E0.03340

G1 X84.447 Y112.340 E0.01529

G1 X84.621 Y111.891 E0.01253

G1 X84.643 Y111.574 E0.00830

G1 X87.934 Y111.584 E0.08574

G1 X87.750 Y111.891 E0.00934

G1 X86.834 Y112.788 E0.03340

G1 X86.455 Y113.236 E0.01529

G1 X86.281 Y113.685 E0.01253

G1 X86.249 Y114.133 E0.01171

G1 X86.314 Y114.581 E0.01180

G1 X86.352 Y114.701 E0.00328

G1 X89.881 Y114.694 E0.09195

G1 X89.901 Y114.581 E0.00298

G1 X90.056 Y114.133 E0.01236

G1 X90.325 Y113.685 E0.01363

G1 X91.241 Y112.788 E0.03340

G1 X91.620 Y112.340 E0.01529

G1 X91.794 Y111.891 E0.01253

G1 X91.815 Y111.588 E0.00792

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;3.35

G1 Z3.350 F9000.000

;AFTER\_LAYER\_CHANGE

;3.35

G1 E-3.20000 F4200.00000

G1 Z3.550 F9000.000

G1 X92.546 Y50.220

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.200 Y50.264 E0.16536

G1 X81.948 Y50.260 E0.11079

G1 X81.900 Y50.061 E0.00534

G1 X81.884 Y47.151 E0.07582

G1 X81.914 Y46.548 E0.01572

G1 X81.896 Y46.347 E0.00528

G1 X81.926 Y46.107 E0.00628

G1 X81.953 Y46.032 E0.00208

G1 X86.714 Y46.058 E0.12406

G1 X92.543 Y46.050 E0.15187

G1 X92.584 Y46.219 E0.00452

G1 X92.598 Y46.720 E0.01308

G1 X92.584 Y46.883 E0.00425

G1 X92.588 Y50.024 E0.08184

G1 X92.559 Y50.162 E0.00366

M204 S1250

G1 X92.968 Y50.249 F9000.000

M204 S800

G1 F1500.000

G1 X92.935 Y50.400 E0.00404

G1 X92.852 Y50.601 E0.00567

G1 X92.834 Y50.620 E0.00067

G1 X92.723 Y50.637 E0.00291

G1 X86.202 Y50.682 E0.16994

G1 X81.747 Y50.678 E0.11606

G1 X81.575 Y50.494 E0.00656

G1 X81.482 Y50.112 E0.01025

G1 X81.466 Y47.142 E0.07739

G1 X81.495 Y46.557 E0.01526

G1 X81.476 Y46.339 E0.00570

G1 X81.517 Y46.011 E0.00862

G1 X81.622 Y45.714 E0.00820

G1 X81.670 Y45.668 E0.00172

G1 X81.790 Y45.613 E0.00344

G1 X86.715 Y45.640 E0.12833

G1 X92.710 Y45.632 E0.15622

G1 X92.770 Y45.649 E0.00161

G1 X92.893 Y45.791 E0.00491

G1 X92.967 Y45.996 E0.00567

G1 X93.001 Y46.174 E0.00474

G1 X93.016 Y46.732 E0.01455

G1 X93.002 Y46.900 E0.00439

G1 X93.006 Y50.068 E0.08253

G1 X92.980 Y50.190 E0.00325

M204 S1250

G1 X92.823 Y50.306 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.935 Y50.400 E-0.11928

G1 X92.852 Y50.601 E-0.12062

G1 X92.834 Y50.620 E-0.01429

G1 X92.723 Y50.637 E-0.06198

G1 X91.648 Y50.644 E-0.59583

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X82.014 Y47.052

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.717 Y46.350 E0.02636

G1 X83.315 Y46.353 E0.01587

G1 X82.199 Y47.469 E0.04187

G1 X82.202 Y48.067 E0.01587

G1 X83.914 Y46.356 E0.06418

G1 X84.512 Y46.360 E0.01587

G1 X82.206 Y48.666 E0.08650

G1 X82.209 Y49.264 E0.01587

G1 X85.110 Y46.363 E0.10881

G1 X85.708 Y46.366 E0.01587

G1 X82.212 Y49.862 E0.13113

G1 X82.213 Y49.947 E0.00225

G1 X82.728 Y49.947 E0.01368

G1 X86.306 Y46.369 E0.13421

G1 X86.906 Y46.371 E0.01590

G1 X83.329 Y49.948 E0.13415

G1 X83.930 Y49.948 E0.01594

G1 X87.508 Y46.370 E0.13420

G1 X88.111 Y46.370 E0.01598

G1 X84.531 Y49.949 E0.13426

G1 X85.132 Y49.949 E0.01594

G1 X88.713 Y46.369 E0.13431

G1 X89.315 Y46.368 E0.01598

G1 X85.733 Y49.950 E0.13436

G1 X86.335 Y49.949 E0.01597

G1 X89.917 Y46.367 E0.13437

G1 X90.520 Y46.366 E0.01598

G1 X86.941 Y49.945 E0.13425

G1 X87.546 Y49.941 E0.01606

G1 X91.122 Y46.365 E0.13413

G1 X91.724 Y46.365 E0.01598

G1 X88.152 Y49.937 E0.13400

G1 X88.758 Y49.933 E0.01606

G1 X92.276 Y46.415 E0.13197

G1 X92.271 Y47.021 E0.01609

G1 X89.363 Y49.929 E0.10906

G1 X89.969 Y49.925 E0.01606

G1 X92.272 Y47.622 E0.08638

G1 X92.272 Y48.223 E0.01593

G1 X90.574 Y49.920 E0.06369

G1 X91.180 Y49.916 E0.01606

G1 X92.273 Y48.823 E0.04100

G1 X92.274 Y49.424 E0.01593

G1 X91.596 Y50.102 E0.02542

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y49.424 E-0.53107

G1 X92.273 Y48.823 E-0.33288

G1 X92.212 Y48.885 E-0.04805

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X92.543 Y59.048

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.584 Y59.217 E0.00452

G1 X92.598 Y59.718 E0.01308

G1 X92.584 Y59.881 E0.00425

G1 X92.588 Y63.022 E0.08184

G1 X92.546 Y63.218 E0.00521

G1 X86.200 Y63.261 E0.16536

G1 X81.948 Y63.257 E0.11079

G1 X81.900 Y63.058 E0.00533

G1 X81.884 Y60.149 E0.07581

G1 X81.914 Y59.546 E0.01572

G1 X81.896 Y59.345 E0.00528

G1 X81.926 Y59.105 E0.00628

G1 X81.953 Y59.030 E0.00208

G1 X86.714 Y59.056 E0.12406

G1 X92.483 Y59.048 E0.15031

M204 S1250

G1 X92.967 Y58.994 F9000.000

M204 S800

G1 F1500.000

G1 X93.001 Y59.172 E0.00473

G1 X93.016 Y59.730 E0.01455

G1 X93.002 Y59.898 E0.00439

G1 X93.006 Y63.066 E0.08253

G1 X92.935 Y63.398 E0.00886

G1 X92.867 Y63.563 E0.00464

G1 X92.822 Y63.619 E0.00187

G1 X92.723 Y63.635 E0.00262

G1 X86.202 Y63.679 E0.16993

G1 X81.747 Y63.675 E0.11606

G1 X81.575 Y63.491 E0.00656

G1 X81.482 Y63.109 E0.01023

G1 X81.466 Y60.140 E0.07738

G1 X81.495 Y59.555 E0.01526

G1 X81.476 Y59.337 E0.00570

G1 X81.517 Y59.009 E0.00862

G1 X81.622 Y58.712 E0.00820

G1 X81.670 Y58.666 E0.00172

G1 X81.790 Y58.611 E0.00344

G1 X86.715 Y58.638 E0.12833

G1 X92.710 Y58.630 E0.15622

G1 X92.770 Y58.647 E0.00161

G1 X92.893 Y58.789 E0.00491

G1 X92.947 Y58.937 E0.00410

M204 S1250

G1 X92.843 Y59.126 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.001 Y59.172 E-0.13362

G1 X93.016 Y59.730 E-0.30942

G1 X93.002 Y59.898 E-0.09345

G1 X93.003 Y60.576 E-0.37551

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X82.014 Y60.050

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.717 Y59.348 E0.02636

G1 X83.315 Y59.351 E0.01587

G1 X82.199 Y60.467 E0.04187

G1 X82.202 Y61.065 E0.01587

G1 X83.913 Y59.354 E0.06418

G1 X84.512 Y59.358 E0.01587

G1 X82.206 Y61.664 E0.08649

G1 X82.209 Y62.262 E0.01587

G1 X85.110 Y59.361 E0.10881

G1 X85.708 Y59.364 E0.01587

G1 X82.212 Y62.860 E0.13112

G1 X82.213 Y62.944 E0.00223

G1 X82.729 Y62.945 E0.01369

G1 X86.306 Y59.367 E0.13418

G1 X86.906 Y59.369 E0.01590

G1 X83.330 Y62.945 E0.13413

G1 X83.931 Y62.946 E0.01594

G1 X87.508 Y59.368 E0.13418

G1 X88.110 Y59.368 E0.01597

G1 X84.532 Y62.946 E0.13423

G1 X85.132 Y62.947 E0.01594

G1 X88.713 Y59.367 E0.13429

G1 X89.315 Y59.366 E0.01597

G1 X85.733 Y62.948 E0.13434

G1 X86.335 Y62.947 E0.01596

G1 X89.917 Y59.365 E0.13436

G1 X90.520 Y59.364 E0.01597

G1 X86.941 Y62.943 E0.13424

G1 X87.546 Y62.939 E0.01606

G1 X91.122 Y59.363 E0.13411

G1 X91.724 Y59.363 E0.01597

G1 X88.152 Y62.935 E0.13399

G1 X88.758 Y62.931 E0.01606

G1 X92.276 Y59.412 E0.13197

G1 X92.271 Y60.019 E0.01609

G1 X89.363 Y62.926 E0.10906

G1 X89.969 Y62.922 E0.01606

G1 X92.272 Y60.620 E0.08637

G1 X92.272 Y61.220 E0.01593

G1 X90.574 Y62.918 E0.06369

G1 X91.180 Y62.914 E0.01606

G1 X92.273 Y61.821 E0.04100

G1 X92.274 Y62.422 E0.01593

G1 X91.596 Y63.099 E0.02542

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y62.422 E-0.53106

G1 X92.273 Y61.821 E-0.33287

G1 X92.212 Y61.882 E-0.04807

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X92.542 Y72.045

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.584 Y72.214 E0.00453

G1 X92.598 Y72.716 E0.01310

G1 X92.584 Y72.879 E0.00426

G1 X92.588 Y76.020 E0.08184

G1 X92.546 Y76.216 E0.00521

G1 X86.200 Y76.259 E0.16536

G1 X81.948 Y76.255 E0.11079

G1 X81.900 Y76.056 E0.00532

G1 X81.884 Y73.147 E0.07581

G1 X81.914 Y72.544 E0.01571

G1 X81.896 Y72.342 E0.00530

G1 X81.926 Y72.103 E0.00628

G1 X81.953 Y72.027 E0.00209

G1 X86.714 Y72.054 E0.12406

G1 X92.482 Y72.045 E0.15030

M204 S1250

G1 X92.967 Y71.992 F9000.000

M204 S800

G1 F1500.000

G1 X93.001 Y72.169 E0.00471

G1 X93.016 Y72.728 E0.01457

G1 X93.002 Y72.896 E0.00439

G1 X93.006 Y76.064 E0.08253

G1 X92.935 Y76.396 E0.00886

G1 X92.867 Y76.561 E0.00464

G1 X92.822 Y76.617 E0.00187

G1 X92.723 Y76.633 E0.00262

G1 X86.202 Y76.677 E0.16993

G1 X81.747 Y76.673 E0.11606

G1 X81.575 Y76.489 E0.00656

G1 X81.482 Y76.107 E0.01023

G1 X81.466 Y73.138 E0.07738

G1 X81.495 Y72.553 E0.01525

G1 X81.476 Y72.334 E0.00572

G1 X81.517 Y72.006 E0.00862

G1 X81.622 Y71.710 E0.00818

G1 X81.670 Y71.664 E0.00174

G1 X81.790 Y71.609 E0.00343

G1 X86.715 Y71.636 E0.12833

G1 X92.710 Y71.627 E0.15620

G1 X92.771 Y71.644 E0.00166

G1 X92.893 Y71.787 E0.00488

G1 X92.947 Y71.935 E0.00412

M204 S1250

G1 X92.844 Y72.124 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.001 Y72.169 E-0.13314

G1 X93.016 Y72.728 E-0.30991

G1 X93.002 Y72.896 E-0.09345

G1 X93.003 Y73.574 E-0.37550

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X82.014 Y73.048

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.717 Y72.345 E0.02636

G1 X83.315 Y72.348 E0.01587

G1 X82.199 Y73.465 E0.04187

G1 X82.202 Y74.063 E0.01587

G1 X83.913 Y72.352 E0.06418

G1 X84.512 Y72.355 E0.01587

G1 X82.206 Y74.661 E0.08650

G1 X82.209 Y75.259 E0.01587

G1 X85.110 Y72.358 E0.10881

G1 X85.708 Y72.362 E0.01587

G1 X82.212 Y75.857 E0.13113

G1 X82.213 Y75.942 E0.00224

G1 X82.729 Y75.942 E0.01368

G1 X86.306 Y72.365 E0.13419

G1 X86.906 Y72.367 E0.01590

G1 X83.330 Y75.943 E0.13414

G1 X83.930 Y75.944 E0.01594

G1 X87.508 Y72.366 E0.13420

G1 X88.111 Y72.365 E0.01598

G1 X84.531 Y75.944 E0.13426

G1 X85.132 Y75.945 E0.01594

G1 X88.713 Y72.364 E0.13432

G1 X89.315 Y72.363 E0.01598

G1 X85.733 Y75.946 E0.13438

G1 X86.335 Y75.945 E0.01597

G1 X89.918 Y72.362 E0.13439

G1 X90.520 Y72.361 E0.01598

G1 X86.941 Y75.941 E0.13427

G1 X87.546 Y75.937 E0.01606

G1 X91.122 Y72.361 E0.13415

G1 X91.725 Y72.360 E0.01598

G1 X88.152 Y75.933 E0.13403

G1 X88.757 Y75.929 E0.01606

G1 X92.276 Y72.410 E0.13198

G1 X92.271 Y73.017 E0.01609

G1 X89.363 Y75.924 E0.10907

G1 X89.969 Y75.920 E0.01606

G1 X92.272 Y73.617 E0.08638

G1 X92.272 Y74.218 E0.01593

G1 X90.574 Y75.916 E0.06369

G1 X91.180 Y75.912 E0.01606

G1 X92.273 Y74.819 E0.04101

G1 X92.274 Y75.419 E0.01593

G1 X91.596 Y76.097 E0.02542

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y75.419 E-0.53110

G1 X92.273 Y74.819 E-0.33288

G1 X92.212 Y74.880 E-0.04802

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X92.542 Y85.043

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.584 Y85.212 E0.00452

G1 X92.598 Y85.714 E0.01311

G1 X92.584 Y85.876 E0.00424

G1 X92.588 Y89.017 E0.08184

G1 X92.546 Y89.214 E0.00523

G1 X86.200 Y89.257 E0.16536

G1 X81.948 Y89.253 E0.11079

G1 X81.900 Y89.054 E0.00532

G1 X81.884 Y86.145 E0.07581

G1 X81.914 Y85.542 E0.01574

G1 X81.896 Y85.340 E0.00528

G1 X81.926 Y85.101 E0.00627

G1 X81.953 Y85.025 E0.00209

G1 X86.714 Y85.051 E0.12405

G1 X92.482 Y85.043 E0.15031

M204 S1250

G1 X92.967 Y84.989 F9000.000

M204 S800

G1 F1500.000

G1 X93.001 Y85.167 E0.00473

G1 X93.016 Y85.726 E0.01457

G1 X93.002 Y85.894 E0.00438

G1 X93.006 Y89.061 E0.08253

G1 X92.935 Y89.394 E0.00888

G1 X92.867 Y89.559 E0.00464

G1 X92.822 Y89.615 E0.00187

G1 X92.723 Y89.631 E0.00262

G1 X86.202 Y89.675 E0.16993

G1 X81.747 Y89.671 E0.11606

G1 X81.575 Y89.487 E0.00656

G1 X81.482 Y89.105 E0.01023

G1 X81.466 Y86.136 E0.07738

G1 X81.495 Y85.550 E0.01527

G1 X81.476 Y85.332 E0.00570

G1 X81.517 Y85.004 E0.00862

G1 X81.622 Y84.708 E0.00818

G1 X81.670 Y84.662 E0.00174

G1 X81.790 Y84.606 E0.00344

G1 X86.715 Y84.633 E0.12832

G1 X92.710 Y84.625 E0.15620

G1 X92.771 Y84.642 E0.00166

G1 X92.893 Y84.785 E0.00488

G1 X92.947 Y84.932 E0.00410

M204 S1250

G1 X92.843 Y85.121 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.001 Y85.167 E-0.13355

G1 X93.016 Y85.726 E-0.30994

G1 X93.002 Y85.894 E-0.09308

G1 X93.003 Y86.571 E-0.37543

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X82.014 Y86.046

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.717 Y85.343 E0.02636

G1 X83.315 Y85.346 E0.01587

G1 X82.199 Y86.462 E0.04187

G1 X82.202 Y87.061 E0.01587

G1 X83.914 Y85.349 E0.06419

G1 X84.512 Y85.353 E0.01587

G1 X82.206 Y87.659 E0.08651

G1 X82.209 Y88.257 E0.01587

G1 X85.110 Y85.356 E0.10882

G1 X85.708 Y85.359 E0.01587

G1 X82.212 Y88.855 E0.13114

G1 X82.213 Y88.940 E0.00225

G1 X82.728 Y88.940 E0.01368

G1 X86.307 Y85.362 E0.13422

G1 X86.906 Y85.364 E0.01590

G1 X83.329 Y88.941 E0.13417

G1 X83.930 Y88.942 E0.01594

G1 X87.508 Y85.363 E0.13422

G1 X88.111 Y85.363 E0.01598

G1 X84.531 Y88.942 E0.13428

G1 X85.132 Y88.943 E0.01594

G1 X88.713 Y85.362 E0.13433

G1 X89.315 Y85.361 E0.01598

G1 X85.733 Y88.944 E0.13439

G1 X86.335 Y88.943 E0.01597

G1 X89.918 Y85.360 E0.13441

G1 X90.520 Y85.359 E0.01598

G1 X86.940 Y88.939 E0.13428

M73 P44 R39

G1 X87.546 Y88.935 E0.01606

G1 X91.123 Y85.358 E0.13416

G1 X91.725 Y85.358 E0.01598

G1 X88.152 Y88.931 E0.13403

G1 X88.757 Y88.927 E0.01606

G1 X92.276 Y85.408 E0.13199

G1 X92.271 Y86.015 E0.01609

G1 X89.363 Y88.922 E0.10907

G1 X89.969 Y88.918 E0.01606

G1 X92.272 Y86.615 E0.08639

G1 X92.272 Y87.216 E0.01593

G1 X90.574 Y88.914 E0.06370

G1 X91.180 Y88.910 E0.01606

G1 X92.273 Y87.817 E0.04101

G1 X92.274 Y88.417 E0.01593

G1 X91.596 Y89.095 E0.02542

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y88.417 E-0.53111

G1 X92.273 Y87.817 E-0.33289

G1 X92.212 Y87.878 E-0.04800

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X92.542 Y98.041

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.584 Y98.210 E0.00452

G1 X92.598 Y98.712 E0.01311

G1 X92.584 Y98.874 E0.00424

G1 X92.588 Y102.015 E0.08184

G1 X92.546 Y102.212 E0.00523

G1 X86.200 Y102.255 E0.16536

G1 X81.948 Y102.251 E0.11079

G1 X81.900 Y102.052 E0.00534

G1 X81.884 Y99.143 E0.07580

G1 X81.914 Y98.539 E0.01574

G1 X81.896 Y98.338 E0.00528

G1 X81.926 Y98.098 E0.00628

G1 X81.953 Y98.023 E0.00208

G1 X86.714 Y98.049 E0.12406

G1 X92.482 Y98.041 E0.15031

M204 S1250

G1 X92.967 Y97.987 F9000.000

M204 S800

G1 F1500.000

G1 X93.001 Y98.165 E0.00473

G1 X93.016 Y98.724 E0.01457

G1 X93.002 Y98.892 E0.00438

G1 X93.006 Y102.059 E0.08253

G1 X92.935 Y102.392 E0.00888

G1 X92.834 Y102.612 E0.00629

G1 X92.723 Y102.629 E0.00291

G1 X86.202 Y102.673 E0.16993

G1 X81.747 Y102.669 E0.11606

G1 X81.575 Y102.485 E0.00656

G1 X81.482 Y102.103 E0.01025

G1 X81.466 Y99.133 E0.07737

G1 X81.495 Y98.548 E0.01527

G1 X81.476 Y98.330 E0.00570

G1 X81.517 Y98.002 E0.00862

G1 X81.622 Y97.705 E0.00819

G1 X81.670 Y97.660 E0.00172

G1 X81.790 Y97.604 E0.00345

G1 X86.715 Y97.631 E0.12832

G1 X92.710 Y97.623 E0.15622

G1 X92.770 Y97.640 E0.00161

G1 X92.893 Y97.783 E0.00492

G1 X92.947 Y97.930 E0.00410

M204 S1250

G1 X92.843 Y98.119 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.001 Y98.165 E-0.13355

G1 X93.016 Y98.724 E-0.30994

G1 X93.002 Y98.892 E-0.09308

G1 X93.003 Y99.569 E-0.37543

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X82.014 Y99.043

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.717 Y98.341 E0.02636

G1 X83.315 Y98.344 E0.01587

G1 X82.199 Y99.460 E0.04187

G1 X82.202 Y100.058 E0.01587

G1 X83.914 Y98.347 E0.06419

G1 X84.512 Y98.351 E0.01587

G1 X82.206 Y100.657 E0.08651

G1 X82.209 Y101.255 E0.01587

G1 X85.110 Y98.354 E0.10882

G1 X85.708 Y98.357 E0.01587

G1 X82.212 Y101.853 E0.13114

G1 X82.213 Y101.938 E0.00225

G1 X82.728 Y101.938 E0.01368

G1 X86.307 Y98.360 E0.13422

G1 X86.906 Y98.362 E0.01590

G1 X83.329 Y101.939 E0.13417

G1 X83.930 Y101.940 E0.01594

G1 X87.508 Y98.361 E0.13422

G1 X88.111 Y98.361 E0.01598

G1 X84.531 Y101.940 E0.13428

G1 X85.132 Y101.941 E0.01594

G1 X88.713 Y98.360 E0.13433

G1 X89.315 Y98.359 E0.01598

G1 X85.733 Y101.942 E0.13439

G1 X86.335 Y101.941 E0.01597

G1 X89.918 Y98.358 E0.13441

G1 X90.520 Y98.357 E0.01598

G1 X86.940 Y101.937 E0.13428

G1 X87.546 Y101.933 E0.01606

G1 X91.123 Y98.356 E0.13416

G1 X91.725 Y98.356 E0.01598

G1 X88.152 Y101.929 E0.13404

G1 X88.757 Y101.925 E0.01606

G1 X92.276 Y98.406 E0.13199

G1 X92.271 Y99.013 E0.01609

G1 X89.363 Y101.920 E0.10908

G1 X89.969 Y101.916 E0.01606

G1 X92.272 Y99.613 E0.08639

G1 X92.272 Y100.214 E0.01593

G1 X90.574 Y101.912 E0.06370

G1 X91.180 Y101.908 E0.01606

G1 X92.273 Y100.815 E0.04101

G1 X92.274 Y101.415 E0.01593

G1 X91.596 Y102.093 E0.02542

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y101.415 E-0.53111

G1 X92.273 Y100.815 E-0.33289

G1 X92.212 Y100.876 E-0.04799

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X92.543 Y111.039

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.584 Y111.208 E0.00452

G1 X92.598 Y111.710 E0.01310

G1 X92.584 Y111.872 E0.00423

G1 X92.588 Y115.013 E0.08185

G1 X92.546 Y115.210 E0.00524

G1 X86.200 Y115.253 E0.16535

G1 X81.948 Y115.249 E0.11079

G1 X81.900 Y115.050 E0.00534

G1 X81.884 Y112.140 E0.07582

G1 X81.914 Y111.537 E0.01572

G1 X81.896 Y111.336 E0.00528

G1 X81.926 Y111.096 E0.00628

G1 X81.953 Y111.021 E0.00208

G1 X86.714 Y111.047 E0.12406

G1 X92.483 Y111.039 E0.15031

M204 S1250

G1 X92.967 Y110.985 F9000.000

M204 S800

G1 F1500.000

G1 X93.001 Y111.163 E0.00474

G1 X93.016 Y111.722 E0.01457

G1 X93.002 Y111.889 E0.00437

G1 X93.006 Y115.057 E0.08254

G1 X92.935 Y115.390 E0.00887

G1 X92.834 Y115.609 E0.00630

G1 X92.723 Y115.627 E0.00292

G1 X86.202 Y115.671 E0.16993

G1 X81.747 Y115.667 E0.11606

G1 X81.575 Y115.483 E0.00656

G1 X81.482 Y115.101 E0.01025

G1 X81.466 Y112.131 E0.07739

G1 X81.495 Y111.546 E0.01526

G1 X81.476 Y111.328 E0.00570

G1 X81.517 Y111.000 E0.00862

G1 X81.622 Y110.703 E0.00820

G1 X81.670 Y110.657 E0.00172

G1 X81.790 Y110.602 E0.00344

G1 X86.715 Y110.629 E0.12833

G1 X92.710 Y110.621 E0.15622

G1 X92.770 Y110.638 E0.00161

G1 X92.893 Y110.780 E0.00491

G1 X92.947 Y110.928 E0.00410

M204 S1250

G1 X92.843 Y111.117 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.001 Y111.163 E-0.13363

G1 X93.016 Y111.722 E-0.30986

G1 X93.002 Y111.889 E-0.09298

G1 X93.003 Y112.567 E-0.37553

G1 E-0.04800 F4200.00000

G1 Z3.550 F9000.000

G1 X82.014 Y112.042

G1 Z3.350

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.717 Y111.339 E0.02636

G1 X83.315 Y111.342 E0.01587

G1 X82.199 Y112.458 E0.04187

G1 X82.202 Y113.056 E0.01587

G1 X83.914 Y111.345 E0.06419

G1 X84.512 Y111.349 E0.01587

G1 X82.206 Y113.655 E0.08651

G1 X82.209 Y114.253 E0.01587

G1 X85.110 Y111.352 E0.10882

G1 X85.708 Y111.355 E0.01587

G1 X82.212 Y114.851 E0.13114

G1 X82.213 Y114.936 E0.00225

G1 X82.729 Y114.936 E0.01368

G1 X86.307 Y111.358 E0.13421

G1 X86.906 Y111.360 E0.01590

G1 X83.330 Y114.937 E0.13416

G1 X83.931 Y114.937 E0.01594

G1 X87.508 Y111.359 E0.13421

G1 X88.111 Y111.359 E0.01598

G1 X84.532 Y114.938 E0.13426

G1 X85.132 Y114.938 E0.01594

G1 X88.713 Y111.358 E0.13431

G1 X89.315 Y111.357 E0.01598

G1 X85.733 Y114.939 E0.13437

G1 X86.335 Y114.938 E0.01597

G1 X89.918 Y111.356 E0.13438

G1 X90.520 Y111.355 E0.01598

G1 X86.941 Y114.934 E0.13426

G1 X87.547 Y114.930 E0.01606

G1 X91.123 Y111.354 E0.13414

G1 X91.725 Y111.354 E0.01598

G1 X88.152 Y114.926 E0.13402

G1 X88.758 Y114.922 E0.01606

G1 X92.276 Y111.404 E0.13197

G1 X92.271 Y112.011 E0.01609

G1 X89.363 Y114.918 E0.10906

G1 X89.969 Y114.914 E0.01606

G1 X92.272 Y112.611 E0.08638

G1 X92.272 Y113.212 E0.01593

G1 X90.574 Y114.910 E0.06369

G1 X91.180 Y114.906 E0.01606

G1 X92.273 Y113.813 E0.04100

G1 X92.274 Y114.413 E0.01593

G1 X91.596 Y115.091 E0.02542

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;3.5

G1 Z3.500 F9000.000

;AFTER\_LAYER\_CHANGE

;3.5

G1 X92.542 Y115.429

M204 S800

G1 F1500.000

G1 X86.695 Y115.470 E0.15236

G1 X81.930 Y115.458 E0.12415

G1 X81.900 Y115.337 E0.00326

G1 X81.885 Y114.364 E0.02537

G1 X81.923 Y114.191 E0.00461

G1 X81.891 Y113.968 E0.00585

G1 X81.884 Y113.639 E0.00859

G1 X81.884 Y112.831 E0.02105

G1 X81.909 Y112.644 E0.00492

G1 X81.884 Y112.469 E0.00461

G1 X81.884 Y112.011 E0.01193

G1 X81.908 Y111.521 E0.01278

G1 X81.886 Y111.116 E0.01057

G1 X81.939 Y110.808 E0.00815

G1 X92.552 Y110.803 E0.27653

G1 X92.588 Y110.987 E0.00489

G1 X92.598 Y111.798 E0.02114

G1 X92.589 Y115.304 E0.09135

G1 X92.565 Y115.373 E0.00190

M204 S1250

G1 X92.952 Y115.530 F9000.000

M204 S800

G1 F1500.000

G1 X92.831 Y115.829 E0.00840

G1 X92.723 Y115.845 E0.00282

G1 X86.696 Y115.887 E0.15706

G1 X81.724 Y115.876 E0.12956

G1 X81.555 Y115.681 E0.00672

G1 X81.483 Y115.391 E0.00777

G1 X81.467 Y114.322 E0.02786

G1 X81.499 Y114.176 E0.00390

G1 X81.474 Y114.003 E0.00456

G1 X81.466 Y113.643 E0.00937

G1 X81.466 Y112.803 E0.02188

G1 X81.487 Y112.646 E0.00414

G1 X81.466 Y112.498 E0.00388

G1 X81.466 Y112.000 E0.01297

G1 X81.490 Y111.522 E0.01248

G1 X81.467 Y111.103 E0.01093

G1 X81.498 Y110.838 E0.00696

G1 X81.580 Y110.538 E0.00811

G1 X81.679 Y110.416 E0.00407

G1 X81.772 Y110.390 E0.00252

G1 X92.714 Y110.385 E0.28511

G1 X92.818 Y110.438 E0.00302

G1 X92.915 Y110.561 E0.00409

G1 X92.976 Y110.759 E0.00541

G1 X93.005 Y110.953 E0.00510

G1 X93.007 Y115.346 E0.11446

G1 X92.975 Y115.475 E0.00347

M204 S1250

G1 X92.641 Y115.614 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.831 Y115.829 E-0.21196

G1 X92.723 Y115.845 E-0.06006

G1 X91.569 Y115.853 E-0.63997

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X82.012 Y114.466

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.693 Y115.147 E0.02534

G1 X83.291 Y115.148 E0.01575

G1 X82.224 Y114.081 E0.03975

G1 X82.204 Y113.943 E0.00367

G1 X82.197 Y113.457 E0.01278

G1 X83.890 Y115.150 E0.06301

G1 X84.488 Y115.151 E0.01575

G1 X82.197 Y112.860 E0.08528

G1 X82.225 Y112.642 E0.00578

G1 X82.197 Y112.446 E0.00521

G1 X82.197 Y112.263 E0.00482

G1 X85.086 Y115.152 E0.10756

G1 X85.685 Y115.154 E0.01575

G1 X82.214 Y111.683 E0.12921

G1 X82.203 Y111.121 E0.01480

G1 X82.249 Y111.121 E0.00121

G1 X86.283 Y115.155 E0.15019

G1 X86.880 Y115.155 E0.01571

G1 X82.846 Y111.121 E0.15019

G1 X83.442 Y111.120 E0.01571

G1 X87.473 Y115.151 E0.15004

G1 X88.065 Y115.147 E0.01561

G1 X84.039 Y111.120 E0.14990

G1 X84.636 Y111.120 E0.01571

G1 X88.658 Y115.143 E0.14975

G1 X89.251 Y115.138 E0.01561

G1 X85.232 Y111.120 E0.14961

G1 X85.829 Y111.119 E0.01571

G1 X89.844 Y115.134 E0.14947

G1 X90.437 Y115.130 E0.01561

G1 X86.426 Y111.119 E0.14932

G1 X87.022 Y111.119 E0.01571

G1 X91.030 Y115.126 E0.14918

G1 X91.622 Y115.122 E0.01561

G1 X87.619 Y111.119 E0.14904

G1 X88.216 Y111.118 E0.01571

G1 X92.215 Y115.118 E0.14889

G1 X92.276 Y115.117 E0.00161

G1 X92.278 Y114.583 E0.01406

G1 X88.812 Y111.118 E0.12900

G1 X89.409 Y111.118 E0.01571

G1 X92.279 Y113.988 E0.10685

G1 X92.281 Y113.392 E0.01567

G1 X90.006 Y111.117 E0.08469

G1 X90.603 Y111.117 E0.01571

G1 X92.282 Y112.797 E0.06254

G1 X92.284 Y112.202 E0.01567

G1 X91.199 Y111.117 E0.04038

G1 X91.796 Y111.117 E0.01571

G1 X92.473 Y111.794 E0.02520

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.796 Y111.117 E-0.53056

G1 X91.199 Y111.117 E-0.33066

G1 X91.264 Y111.182 E-0.05077

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X92.543 Y102.431

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.695 Y102.472 E0.15237

G1 X81.930 Y102.461 E0.12415

G1 X81.900 Y102.339 E0.00326

G1 X81.885 Y101.366 E0.02536

G1 X81.923 Y101.192 E0.00462

G1 X81.891 Y100.970 E0.00585

G1 X81.884 Y100.641 E0.00859

G1 X81.884 Y99.833 E0.02104

G1 X81.909 Y99.646 E0.00492

G1 X81.884 Y99.471 E0.00461

G1 X81.884 Y99.013 E0.01192

G1 X81.908 Y98.523 E0.01280

G1 X81.886 Y98.119 E0.01055

G1 X81.939 Y97.810 E0.00816

G1 X92.552 Y97.805 E0.27653

G1 X92.588 Y97.989 E0.00489

G1 X92.598 Y98.801 E0.02115

G1 X92.589 Y102.307 E0.09135

G1 X92.565 Y102.375 E0.00189

M204 S1250

G1 X92.952 Y102.533 F9000.000

M204 S800

G1 F1500.000

G1 X92.831 Y102.832 E0.00840

G1 X92.724 Y102.847 E0.00282

G1 X86.696 Y102.890 E0.15706

G1 X81.724 Y102.878 E0.12956

G1 X81.555 Y102.683 E0.00672

G1 X81.483 Y102.393 E0.00777

G1 X81.467 Y101.324 E0.02786

G1 X81.499 Y101.178 E0.00391

G1 X81.474 Y101.005 E0.00456

G1 X81.466 Y100.645 E0.00937

G1 X81.466 Y99.806 E0.02187

G1 X81.487 Y99.648 E0.00414

G1 X81.466 Y99.501 E0.00389

G1 X81.466 Y99.003 E0.01296

G1 X81.490 Y98.524 E0.01250

G1 X81.467 Y98.106 E0.01091

G1 X81.498 Y97.840 E0.00698

G1 X81.580 Y97.540 E0.00810

G1 X81.679 Y97.419 E0.00407

G1 X81.773 Y97.392 E0.00254

G1 X92.714 Y97.387 E0.28509

G1 X92.818 Y97.440 E0.00302

G1 X92.915 Y97.563 E0.00410

G1 X92.976 Y97.761 E0.00541

G1 X93.005 Y97.955 E0.00510

G1 X93.007 Y102.348 E0.11447

G1 X92.975 Y102.477 E0.00347

M204 S1250

G1 X92.641 Y102.616 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.831 Y102.832 E-0.21201

G1 X92.724 Y102.847 E-0.05989

G1 X91.569 Y102.856 E-0.64011

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X82.012 Y101.468

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.693 Y102.149 E0.02534

G1 X83.292 Y102.151 E0.01575

G1 X82.224 Y101.083 E0.03976

G1 X82.204 Y100.945 E0.00367

G1 X82.197 Y100.459 E0.01277

G1 X83.890 Y102.152 E0.06302

G1 X84.488 Y102.154 E0.01575

G1 X82.197 Y99.862 E0.08530

G1 X82.225 Y99.645 E0.00577

G1 X82.197 Y99.449 E0.00521

G1 X82.197 Y99.265 E0.00483

G1 X85.087 Y102.155 E0.10758

G1 X85.685 Y102.157 E0.01575

G1 X82.214 Y98.685 E0.12924

G1 X82.203 Y98.123 E0.01480

G1 X82.249 Y98.123 E0.00120

G1 X86.284 Y102.158 E0.15021

G1 X86.880 Y102.158 E0.01571

G1 X82.846 Y98.123 E0.15021

G1 X83.442 Y98.122 E0.01571

G1 X87.473 Y102.153 E0.15007

G1 X88.066 Y102.149 E0.01560

G1 X84.039 Y98.122 E0.14992

G1 X84.636 Y98.122 E0.01571

G1 X88.659 Y102.145 E0.14977

G1 X89.252 Y102.141 E0.01560

G1 X85.232 Y98.122 E0.14963

G1 X85.829 Y98.121 E0.01571

G1 X89.844 Y102.137 E0.14948

G1 X90.437 Y102.132 E0.01560

G1 X86.426 Y98.121 E0.14934

G1 X87.022 Y98.121 E0.01571

G1 X91.030 Y102.128 E0.14919

G1 X91.623 Y102.124 E0.01560

G1 X87.619 Y98.121 E0.14904

G1 X88.216 Y98.120 E0.01571

G1 X92.215 Y102.120 E0.14890

G1 X92.276 Y102.119 E0.00160

G1 X92.278 Y101.585 E0.01406

G1 X88.812 Y98.120 E0.12900

G1 X89.409 Y98.120 E0.01571

G1 X92.279 Y100.990 E0.10685

G1 X92.281 Y100.394 E0.01567

G1 X90.006 Y98.119 E0.08469

G1 X90.603 Y98.119 E0.01571

G1 X92.282 Y99.799 E0.06254

G1 X92.284 Y99.204 E0.01567

G1 X91.199 Y98.119 E0.04038

G1 X91.796 Y98.119 E0.01571

G1 X92.473 Y98.796 E0.02520

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.796 Y98.119 E-0.53056

G1 X91.199 Y98.119 E-0.33067

G1 X91.264 Y98.184 E-0.05077

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X92.543 Y89.433

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.695 Y89.474 E0.15237

G1 X81.930 Y89.463 E0.12415

G1 X81.900 Y89.342 E0.00324

G1 X81.885 Y88.368 E0.02538

G1 X81.923 Y88.194 E0.00463

G1 X81.891 Y87.973 E0.00583

G1 X81.884 Y87.643 E0.00860

G1 X81.884 Y86.835 E0.02104

G1 X81.909 Y86.648 E0.00492

G1 X81.884 Y86.473 E0.00460

G1 X81.884 Y86.016 E0.01192

G1 X81.908 Y85.525 E0.01280

G1 X81.886 Y85.121 E0.01056

G1 X81.939 Y84.812 E0.00817

G1 X92.552 Y84.807 E0.27652

G1 X92.588 Y84.991 E0.00489

G1 X92.598 Y85.803 E0.02115

G1 X92.589 Y89.309 E0.09135

G1 X92.565 Y89.377 E0.00189

M204 S1250

G1 X92.952 Y89.535 F9000.000

M204 S800

G1 F1500.000

G1 X92.831 Y89.833 E0.00841

G1 X92.724 Y89.849 E0.00282

G1 X86.696 Y89.892 E0.15706

G1 X81.724 Y89.880 E0.12956

G1 X81.555 Y89.685 E0.00671

G1 X81.483 Y89.396 E0.00776

G1 X81.467 Y88.326 E0.02787

G1 X81.499 Y88.180 E0.00391

G1 X81.474 Y88.007 E0.00455

G1 X81.466 Y87.647 E0.00938

G1 X81.466 Y86.808 E0.02187

G1 X81.487 Y86.650 E0.00414

G1 X81.466 Y86.503 E0.00387

G1 X81.466 Y86.005 E0.01297

G1 X81.490 Y85.526 E0.01250

G1 X81.467 Y85.108 E0.01092

G1 X81.498 Y84.842 E0.00697

G1 X81.580 Y84.542 E0.00811

G1 X81.679 Y84.421 E0.00407

G1 X81.773 Y84.394 E0.00253

G1 X92.714 Y84.389 E0.28509

G1 X92.818 Y84.442 E0.00302

G1 X92.915 Y84.565 E0.00410

G1 X92.976 Y84.763 E0.00541

G1 X93.005 Y84.957 E0.00510

G1 X93.007 Y89.350 E0.11447

G1 X92.975 Y89.479 E0.00346

M204 S1250

G1 X92.641 Y89.618 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.831 Y89.833 E-0.21205

G1 X92.724 Y89.849 E-0.05998

G1 X91.569 Y89.858 E-0.63996

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X82.012 Y88.470

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.693 Y89.151 E0.02534

G1 X83.292 Y89.153 E0.01575

G1 X82.224 Y88.085 E0.03976

G1 X82.204 Y87.947 E0.00367

G1 X82.197 Y87.461 E0.01278

G1 X83.890 Y89.154 E0.06302

G1 X84.488 Y89.156 E0.01575

G1 X82.197 Y86.864 E0.08530

G1 X82.225 Y86.647 E0.00578

G1 X82.197 Y86.451 E0.00520

G1 X82.197 Y86.267 E0.00484

G1 X85.087 Y89.157 E0.10758

G1 X85.685 Y89.159 E0.01575

G1 X82.214 Y85.687 E0.12923

G1 X82.203 Y85.125 E0.01480

G1 X82.249 Y85.125 E0.00120

G1 X86.284 Y89.160 E0.15022

G1 X86.880 Y89.160 E0.01571

G1 X82.846 Y85.125 E0.15021

G1 X83.442 Y85.124 E0.01571

G1 X87.473 Y89.155 E0.15007

G1 X88.066 Y89.151 E0.01560

G1 X84.039 Y85.124 E0.14992

G1 X84.636 Y85.124 E0.01571

G1 X88.659 Y89.147 E0.14977

G1 X89.252 Y89.143 E0.01560

G1 X85.232 Y85.124 E0.14963

G1 X85.829 Y85.123 E0.01571

G1 X89.844 Y89.139 E0.14948

G1 X90.437 Y89.134 E0.01560

G1 X86.426 Y85.123 E0.14934

G1 X87.022 Y85.123 E0.01571

G1 X91.030 Y89.130 E0.14919

G1 X91.623 Y89.126 E0.01560

G1 X87.619 Y85.123 E0.14904

G1 X88.216 Y85.122 E0.01571

G1 X92.215 Y89.122 E0.14890

G1 X92.276 Y89.121 E0.00160

G1 X92.278 Y88.587 E0.01406

G1 X88.812 Y85.122 E0.12900

G1 X89.409 Y85.122 E0.01571

G1 X92.279 Y87.992 E0.10685

G1 X92.281 Y87.396 E0.01567

G1 X90.006 Y85.121 E0.08469

G1 X90.603 Y85.121 E0.01571

G1 X92.282 Y86.801 E0.06254

G1 X92.284 Y86.206 E0.01567

G1 X91.199 Y85.121 E0.04038

G1 X91.796 Y85.121 E0.01571

G1 X92.473 Y85.798 E0.02520

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.796 Y85.121 E-0.53056

G1 X91.199 Y85.121 E-0.33067

G1 X91.264 Y85.186 E-0.05077

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X92.543 Y76.435

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.695 Y76.476 E0.15237

G1 X81.930 Y76.465 E0.12415

G1 X81.900 Y76.344 E0.00324

G1 X81.885 Y75.370 E0.02538

G1 X81.923 Y75.196 E0.00463

G1 X81.891 Y74.975 E0.00583

G1 X81.884 Y74.646 E0.00857

G1 X81.884 Y73.837 E0.02106

G1 X81.909 Y73.650 E0.00492

G1 X81.884 Y73.475 E0.00460

G1 X81.884 Y73.018 E0.01192

G1 X81.908 Y72.528 E0.01278

G1 X81.886 Y72.123 E0.01057

G1 X81.939 Y71.815 E0.00815

G1 X92.552 Y71.809 E0.27653

G1 X92.588 Y71.993 E0.00489

G1 X92.598 Y72.805 E0.02115

G1 X92.589 Y76.311 E0.09136

G1 X92.565 Y76.379 E0.00188

M204 S1250

G1 X92.952 Y76.537 F9000.000

M204 S800

G1 F1500.000

G1 X92.831 Y76.835 E0.00841

G1 X92.724 Y76.851 E0.00282

G1 X86.696 Y76.894 E0.15706

G1 X81.724 Y76.882 E0.12956

G1 X81.555 Y76.687 E0.00671

G1 X81.483 Y76.398 E0.00776

G1 X81.467 Y75.328 E0.02787

G1 X81.499 Y75.182 E0.00391

G1 X81.474 Y75.009 E0.00455

G1 X81.466 Y74.650 E0.00936

G1 X81.466 Y73.810 E0.02190

G1 X81.487 Y73.652 E0.00414

G1 X81.466 Y73.505 E0.00387

G1 X81.466 Y73.007 E0.01296

G1 X81.490 Y72.529 E0.01248

G1 X81.467 Y72.110 E0.01094

G1 X81.498 Y71.844 E0.00697

G1 X81.580 Y71.544 E0.00811

G1 X81.679 Y71.423 E0.00406

G1 X81.772 Y71.397 E0.00252

G1 X92.714 Y71.391 E0.28510

G1 X92.818 Y71.444 E0.00304

G1 X92.915 Y71.567 E0.00409

G1 X92.976 Y71.765 E0.00541

G1 X93.005 Y71.959 E0.00510

G1 X93.007 Y76.353 E0.11449

G1 X92.975 Y76.481 E0.00345

M204 S1250

G1 X92.641 Y76.620 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.831 Y76.835 E-0.21205

G1 X92.724 Y76.851 E-0.05998

G1 X91.569 Y76.860 E-0.63996

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X82.012 Y75.472

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.693 Y76.153 E0.02534

G1 X83.292 Y76.155 E0.01575

G1 X82.224 Y75.087 E0.03976

G1 X82.204 Y74.949 E0.00367

G1 X82.197 Y74.463 E0.01278

G1 X83.890 Y76.156 E0.06302

G1 X84.488 Y76.158 E0.01575

G1 X82.197 Y73.866 E0.08530

G1 X82.225 Y73.649 E0.00578

G1 X82.197 Y73.453 E0.00520

G1 X82.197 Y73.269 E0.00484

G1 X85.087 Y76.159 E0.10758

G1 X85.685 Y76.161 E0.01575

G1 X82.214 Y72.689 E0.12923

G1 X82.203 Y72.128 E0.01478

G1 X82.250 Y72.128 E0.00122

G1 X86.284 Y76.162 E0.15019

G1 X86.880 Y76.162 E0.01571

G1 X82.846 Y72.127 E0.15019

G1 X83.443 Y72.127 E0.01571

G1 X87.473 Y76.157 E0.15004

G1 X88.066 Y76.153 E0.01560

G1 X84.040 Y72.127 E0.14990

G1 X84.636 Y72.127 E0.01571

G1 X88.659 Y76.149 E0.14975

G1 X89.251 Y76.145 E0.01560

G1 X85.233 Y72.126 E0.14961

G1 X85.829 Y72.126 E0.01571

G1 X89.844 Y76.141 E0.14946

G1 X90.437 Y76.136 E0.01560

G1 X86.426 Y72.126 E0.14932

G1 X87.023 Y72.125 E0.01571

G1 X91.030 Y76.132 E0.14917

G1 X91.623 Y76.128 E0.01560

G1 X87.619 Y72.125 E0.14903

G1 X88.216 Y72.125 E0.01571

G1 X92.215 Y76.124 E0.14888

G1 X92.276 Y76.123 E0.00161

G1 X92.278 Y75.589 E0.01406

G1 X88.813 Y72.124 E0.12899

G1 X89.409 Y72.124 E0.01571

G1 X92.279 Y74.994 E0.10684

G1 X92.281 Y74.398 E0.01567

G1 X90.006 Y72.124 E0.08469

G1 X90.603 Y72.123 E0.01571

G1 X92.282 Y73.803 E0.06253

G1 X92.284 Y73.208 E0.01567

G1 X91.199 Y72.123 E0.04038

G1 X91.796 Y72.123 E0.01571

G1 X92.473 Y72.800 E0.02520

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.796 Y72.123 E-0.53053

G1 X91.199 Y72.123 E-0.33064

G1 X91.264 Y72.188 E-0.05083

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X92.543 Y63.437

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.695 Y63.478 E0.15237

G1 X81.930 Y63.467 E0.12415

G1 X81.900 Y63.346 E0.00324

G1 X81.885 Y62.372 E0.02538

G1 X81.923 Y62.198 E0.00463

G1 X81.891 Y61.977 E0.00583

G1 X81.884 Y61.648 E0.00857

G1 X81.884 Y60.839 E0.02106

G1 X81.909 Y60.652 E0.00492

G1 X81.884 Y60.477 E0.00460

G1 X81.884 Y60.020 E0.01192

G1 X81.908 Y59.530 E0.01278

G1 X81.886 Y59.125 E0.01057

G1 X81.939 Y58.817 E0.00815

G1 X92.552 Y58.812 E0.27653

G1 X92.588 Y58.996 E0.00488

G1 X92.598 Y59.807 E0.02113

G1 X92.589 Y63.313 E0.09136

G1 X92.565 Y63.381 E0.00188

M204 S1250

G1 X92.952 Y63.539 F9000.000

M204 S800

G1 F1500.000

G1 X92.831 Y63.837 E0.00841

G1 X92.724 Y63.853 E0.00282

G1 X86.696 Y63.896 E0.15706

G1 X81.724 Y63.884 E0.12956

G1 X81.555 Y63.689 E0.00671

G1 X81.483 Y63.400 E0.00776

G1 X81.467 Y62.330 E0.02787

G1 X81.499 Y62.184 E0.00391

G1 X81.474 Y62.011 E0.00455

G1 X81.466 Y61.652 E0.00936

G1 X81.466 Y60.812 E0.02190

G1 X81.487 Y60.654 E0.00414

G1 X81.466 Y60.507 E0.00387

G1 X81.466 Y60.009 E0.01296

G1 X81.490 Y59.531 E0.01248

G1 X81.467 Y59.112 E0.01093

G1 X81.498 Y58.847 E0.00697

G1 X81.580 Y58.546 E0.00812

G1 X81.679 Y58.425 E0.00405

G1 X81.772 Y58.399 E0.00253

G1 X92.714 Y58.394 E0.28511

G1 X92.818 Y58.447 E0.00302

G1 X92.915 Y58.570 E0.00409

G1 X92.976 Y58.768 E0.00541

G1 X93.005 Y58.961 E0.00509

G1 X93.007 Y63.355 E0.11447

G1 X92.975 Y63.483 E0.00345

M204 S1250

G1 X92.641 Y63.622 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.831 Y63.837 E-0.21205

G1 X92.724 Y63.853 E-0.05998

G1 X91.569 Y63.862 E-0.63996

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X82.012 Y62.474

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.693 Y63.155 E0.02534

G1 X83.291 Y63.157 E0.01575

G1 X82.224 Y62.089 E0.03975

G1 X82.204 Y61.951 E0.00367

G1 X82.197 Y61.465 E0.01278

G1 X83.890 Y63.158 E0.06301

G1 X84.488 Y63.160 E0.01575

G1 X82.197 Y60.869 E0.08529

G1 X82.225 Y60.651 E0.00578

G1 X82.197 Y60.455 E0.00520

G1 X82.197 Y60.272 E0.00483

G1 X85.087 Y63.161 E0.10756

G1 X85.685 Y63.163 E0.01575

G1 X82.214 Y59.691 E0.12922

G1 X82.203 Y59.130 E0.01478

G1 X82.250 Y59.130 E0.00122

G1 X86.284 Y63.164 E0.15017

G1 X86.880 Y63.164 E0.01570

G1 X82.846 Y59.130 E0.15017

G1 X83.443 Y59.129 E0.01571

G1 X87.473 Y63.159 E0.15002

G1 X88.066 Y63.155 E0.01560

G1 X84.040 Y59.129 E0.14987

G1 X84.636 Y59.129 E0.01571

G1 X88.658 Y63.151 E0.14973

G1 X89.251 Y63.147 E0.01560

G1 X85.233 Y59.129 E0.14958

G1 X85.829 Y59.128 E0.01571

G1 X89.844 Y63.143 E0.14944

G1 X90.436 Y63.138 E0.01560

G1 X86.426 Y59.128 E0.14929

G1 X87.023 Y59.128 E0.01571

G1 X91.029 Y63.134 E0.14914

G1 X91.622 Y63.130 E0.01560

G1 X87.619 Y59.128 E0.14900

G1 X88.216 Y59.127 E0.01571

G1 X92.215 Y63.126 E0.14885

G1 X92.276 Y63.125 E0.00162

G1 X92.278 Y62.592 E0.01404

G1 X88.813 Y59.127 E0.12899

G1 X89.409 Y59.127 E0.01571

G1 X92.279 Y61.997 E0.10683

G1 X92.281 Y61.401 E0.01567

G1 X90.006 Y59.126 E0.08468

G1 X90.603 Y59.126 E0.01571

G1 X92.282 Y60.806 E0.06253

G1 X92.284 Y60.210 E0.01567

G1 X91.199 Y59.126 E0.04037

G1 X91.796 Y59.126 E0.01571

G1 X92.473 Y59.803 E0.02520

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.796 Y59.126 E-0.53052

G1 X91.199 Y59.126 E-0.33064

G1 X91.264 Y59.191 E-0.05083

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X92.542 Y50.439

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.695 Y50.481 E0.15236

G1 X81.930 Y50.469 E0.12415

G1 X81.900 Y50.348 E0.00324

G1 X81.885 Y49.374 E0.02537

G1 X81.923 Y49.201 E0.00462

G1 X81.891 Y48.979 E0.00584

G1 X81.884 Y48.650 E0.00858

G1 X81.884 Y47.842 E0.02106

G1 X81.909 Y47.655 E0.00490

G1 X81.884 Y47.480 E0.00462

G1 X81.884 Y47.022 E0.01193

G1 X81.908 Y46.532 E0.01278

G1 X81.886 Y46.127 E0.01057

G1 X81.939 Y45.819 E0.00815

G1 X92.552 Y45.814 E0.27653

G1 X92.588 Y45.998 E0.00489

G1 X92.598 Y46.809 E0.02112

G1 X92.589 Y50.315 E0.09136

G1 X92.565 Y50.384 E0.00190

M204 S1250

G1 X92.952 Y50.541 F9000.000

M204 S800

G1 F1500.000

G1 X92.831 Y50.840 E0.00841

G1 X92.724 Y50.856 E0.00282

G1 X86.696 Y50.898 E0.15706

G1 X81.723 Y50.886 E0.12957

G1 X81.555 Y50.692 E0.00669

G1 X81.483 Y50.402 E0.00777

G1 X81.467 Y49.333 E0.02787

G1 X81.499 Y49.186 E0.00391

G1 X81.474 Y49.014 E0.00455

G1 X81.466 Y48.654 E0.00937

G1 X81.466 Y47.814 E0.02190

G1 X81.487 Y47.657 E0.00413

G1 X81.466 Y47.509 E0.00388

G1 X81.466 Y47.011 E0.01297

G1 X81.490 Y46.533 E0.01248

G1 X81.467 Y46.114 E0.01093

G1 X81.498 Y45.849 E0.00696

G1 X81.580 Y45.549 E0.00811

G1 X81.679 Y45.427 E0.00407

G1 X81.772 Y45.401 E0.00252

G1 X92.714 Y45.396 E0.28511

G1 X92.818 Y45.449 E0.00302

G1 X92.915 Y45.572 E0.00409

G1 X92.976 Y45.770 E0.00541

G1 X93.005 Y45.964 E0.00510

G1 X93.007 Y50.357 E0.11446

G1 X92.975 Y50.485 E0.00346

M204 S1250

G1 X92.640 Y50.625 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.831 Y50.840 E-0.21210

G1 X92.724 Y50.856 E-0.05998

G1 X91.569 Y50.864 E-0.63992

G1 E-0.04800 F4200.00000

G1 Z3.700 F9000.000

G1 X82.012 Y49.477

G1 Z3.500

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.693 Y50.157 E0.02534

G1 X83.291 Y50.159 E0.01575

G1 X82.224 Y49.091 E0.03976

G1 X82.204 Y48.953 E0.00366

G1 X82.197 Y48.468 E0.01279

G1 X83.890 Y50.160 E0.06301

G1 X84.488 Y50.162 E0.01575

G1 X82.197 Y47.871 E0.08529

G1 X82.225 Y47.654 E0.00576

G1 X82.197 Y47.457 E0.00522

G1 X82.197 Y47.274 E0.00484

G1 X85.087 Y50.163 E0.10757

G1 X85.685 Y50.165 E0.01575

G1 X82.214 Y46.693 E0.12922

G1 X82.203 Y46.132 E0.01478

G1 X82.249 Y46.132 E0.00122

G1 X86.284 Y50.166 E0.15018

G1 X86.880 Y50.166 E0.01571

G1 X82.846 Y46.132 E0.15018

G1 X83.443 Y46.131 E0.01571

G1 X87.473 Y50.162 E0.15003

G1 X88.066 Y50.158 E0.01560

G1 X84.039 Y46.131 E0.14989

G1 X84.636 Y46.131 E0.01571

G1 X88.659 Y50.153 E0.14974

G1 X89.251 Y50.149 E0.01560

G1 X85.233 Y46.131 E0.14960

G1 X85.829 Y46.130 E0.01571

G1 X89.844 Y50.145 E0.14945

G1 X90.437 Y50.141 E0.01560

G1 X86.426 Y46.130 E0.14931

G1 X87.023 Y46.130 E0.01571

G1 X91.030 Y50.137 E0.14916

G1 X91.622 Y50.133 E0.01560

G1 X87.619 Y46.130 E0.14902

G1 X88.216 Y46.129 E0.01571

G1 X92.215 Y50.128 E0.14887

G1 X92.276 Y50.128 E0.00161

G1 X92.278 Y49.594 E0.01406

G1 X88.813 Y46.129 E0.12899

G1 X89.409 Y46.129 E0.01571

G1 X92.279 Y48.999 E0.10684

G1 X92.281 Y48.403 E0.01567

G1 X90.006 Y46.128 E0.08468

G1 X90.603 Y46.128 E0.01571

G1 X92.282 Y47.808 E0.06253

G1 X92.284 Y47.213 E0.01567

G1 X91.199 Y46.128 E0.04038

G1 X91.796 Y46.128 E0.01571

G1 X92.473 Y46.805 E0.02520

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;3.65

G1 Z3.650 F9000.000

;AFTER\_LAYER\_CHANGE

;3.65

G1 X92.592 Y45.791

M204 S800

G1 F1500.000

G1 X92.585 Y50.581 E0.12481

G1 X92.571 Y50.658 E0.00205

G1 X81.916 Y50.668 E0.27762

G1 X81.898 Y50.596 E0.00192

G1 X81.885 Y49.438 E0.03017

G1 X81.933 Y49.217 E0.00590

G1 X81.893 Y48.943 E0.00722

G1 X81.884 Y48.555 E0.01009

G1 X81.884 Y47.991 E0.01472

G1 X81.915 Y47.754 E0.00621

G1 X81.884 Y47.532 E0.00584

G1 X81.884 Y46.795 E0.01921

G1 X81.904 Y46.498 E0.00774

G1 X81.884 Y46.276 E0.00582

G1 X81.887 Y45.831 E0.01159

G1 X81.928 Y45.625 E0.00546

G1 X92.551 Y45.619 E0.27679

G1 X92.579 Y45.732 E0.00304

M204 S1250

G1 X92.928 Y45.407 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y45.758 E0.00937

G1 X93.003 Y50.619 E0.12666

G1 X92.971 Y50.796 E0.00469

G1 X92.910 Y50.944 E0.00416

G1 X92.820 Y51.052 E0.00365

G1 X92.715 Y51.075 E0.00280

G1 X90.621 Y51.090 E0.05458

G1 X81.722 Y51.085 E0.23187

G1 X81.586 Y50.958 E0.00485

G1 X81.531 Y50.848 E0.00321

G1 X81.481 Y50.650 E0.00533

G1 X81.467 Y49.396 E0.03267

G1 X81.508 Y49.202 E0.00516

G1 X81.476 Y48.978 E0.00592

G1 X81.466 Y48.560 E0.01088

G1 X81.466 Y47.963 E0.01557

G1 X81.494 Y47.756 E0.00544

G1 X81.466 Y47.562 E0.00512

G1 X81.467 Y46.781 E0.02035

G1 X81.485 Y46.503 E0.00725

G1 X81.466 Y46.293 E0.00549

G1 X81.470 Y45.789 E0.01315

G1 X81.542 Y45.424 E0.00968

G1 X81.684 Y45.231 E0.00626

G1 X81.771 Y45.208 E0.00233

G1 X92.687 Y45.201 E0.28442

G1 X92.861 Y45.288 E0.00509

G1 X92.899 Y45.355 E0.00199

M204 S1250

G1 X92.723 Y45.703 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y45.758 E-0.23151

G1 X93.008 Y46.986 E-0.68049

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X82.891 Y45.750

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.213 Y46.428 E0.02590

G1 X82.198 Y47.056 E0.01695

G1 X83.315 Y45.938 E0.04270

G1 X83.928 Y45.938 E0.01655

G1 X82.217 Y47.649 E0.06536

G1 X82.232 Y47.753 E0.00284

G1 X82.197 Y48.011 E0.00705

G1 X82.197 Y48.281 E0.00728

G1 X84.541 Y45.937 E0.08953

G1 X85.154 Y45.937 E0.01655

G1 X82.205 Y48.886 E0.11264

G1 X82.251 Y49.228 E0.00932

G1 X82.199 Y49.504 E0.00759

G1 X85.767 Y45.936 E0.13628

G1 X86.380 Y45.936 E0.01655

G1 X82.206 Y50.110 E0.15942

G1 X82.209 Y50.354 E0.00660

G1 X82.575 Y50.354 E0.00987

G1 X86.993 Y45.936 E0.16876

G1 X87.606 Y45.935 E0.01655

G1 X83.188 Y50.353 E0.16875

G1 X83.801 Y50.353 E0.01656

G1 X88.218 Y45.935 E0.16875

G1 X88.831 Y45.935 E0.01655

G1 X84.414 Y50.352 E0.16874

G1 X85.027 Y50.352 E0.01656

G1 X89.444 Y45.934 E0.16873

G1 X90.057 Y45.934 E0.01655

G1 X85.640 Y50.351 E0.16873

M73 P45 R38

G1 X86.253 Y50.351 E0.01656

G1 X90.670 Y45.933 E0.16872

G1 X91.283 Y45.933 E0.01655

G1 X86.866 Y50.350 E0.16871

G1 X87.479 Y50.349 E0.01656

G1 X91.896 Y45.933 E0.16871

G1 X92.276 Y45.932 E0.01028

G1 X92.278 Y46.163 E0.00621

G1 X88.092 Y50.349 E0.15991

G1 X88.705 Y50.348 E0.01656

G1 X92.284 Y46.769 E0.13671

G1 X92.283 Y47.383 E0.01657

G1 X89.318 Y50.348 E0.11326

G1 X89.931 Y50.347 E0.01656

G1 X92.281 Y47.997 E0.08976

G1 X92.279 Y48.612 E0.01660

G1 X90.544 Y50.347 E0.06626

G1 X91.157 Y50.346 E0.01656

G1 X92.277 Y49.227 E0.04276

G1 X92.274 Y49.842 E0.01660

G1 X91.582 Y50.534 E0.02645

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y49.842 E-0.54260

G1 X92.277 Y49.227 E-0.34064

G1 X92.240 Y49.264 E-0.02876

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X92.551 Y58.617

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y58.788 E0.00459

G1 X92.598 Y59.871 E0.02821

G1 X92.585 Y63.579 E0.09661

G1 X92.571 Y63.655 E0.00203

G1 X81.916 Y63.666 E0.27762

G1 X81.898 Y63.593 E0.00194

G1 X81.885 Y62.436 E0.03016

G1 X81.933 Y62.214 E0.00590

G1 X81.893 Y61.940 E0.00722

G1 X81.884 Y61.553 E0.01008

G1 X81.884 Y60.989 E0.01472

G1 X81.915 Y60.751 E0.00624

G1 X81.884 Y60.530 E0.00582

G1 X81.884 Y59.793 E0.01921

G1 X81.904 Y59.496 E0.00774

G1 X81.884 Y59.274 E0.00582

G1 X81.887 Y58.829 E0.01159

G1 X81.928 Y58.623 E0.00546

G1 X92.491 Y58.617 E0.27523

M204 S1250

G1 X92.928 Y58.405 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y58.755 E0.00936

G1 X93.003 Y63.617 E0.12668

G1 X92.971 Y63.794 E0.00469

G1 X92.910 Y63.942 E0.00416

G1 X92.821 Y64.049 E0.00363

G1 X92.716 Y64.072 E0.00280

G1 X90.621 Y64.087 E0.05459

G1 X81.722 Y64.083 E0.23186

G1 X81.586 Y63.955 E0.00488

G1 X81.531 Y63.846 E0.00320

G1 X81.481 Y63.647 E0.00534

G1 X81.467 Y62.394 E0.03266

G1 X81.508 Y62.200 E0.00516

G1 X81.476 Y61.975 E0.00592

G1 X81.466 Y61.558 E0.01087

G1 X81.466 Y60.961 E0.01557

G1 X81.494 Y60.753 E0.00546

G1 X81.466 Y60.560 E0.00510

G1 X81.467 Y59.779 E0.02035

G1 X81.485 Y59.501 E0.00725

G1 X81.466 Y59.291 E0.00549

G1 X81.470 Y58.787 E0.01315

G1 X81.542 Y58.422 E0.00969

G1 X81.684 Y58.229 E0.00625

G1 X81.771 Y58.206 E0.00233

G1 X92.687 Y58.199 E0.28442

G1 X92.861 Y58.286 E0.00509

G1 X92.899 Y58.353 E0.00200

M204 S1250

G1 X92.723 Y58.700 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y58.755 E-0.23112

G1 X93.008 Y59.984 E-0.68088

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X82.891 Y58.748

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.213 Y59.426 E0.02590

G1 X82.198 Y60.054 E0.01695

G1 X83.315 Y58.936 E0.04269

G1 X83.928 Y58.936 E0.01655

G1 X82.217 Y60.647 E0.06535

G1 X82.232 Y60.750 E0.00282

G1 X82.197 Y61.009 E0.00707

G1 X82.197 Y61.279 E0.00728

G1 X84.541 Y58.935 E0.08952

G1 X85.154 Y58.935 E0.01655

G1 X82.205 Y61.884 E0.11263

G1 X82.251 Y62.225 E0.00931

G1 X82.199 Y62.502 E0.00760

G1 X85.767 Y58.934 E0.13626

G1 X86.379 Y58.934 E0.01655

G1 X82.206 Y63.107 E0.15940

G1 X82.209 Y63.352 E0.00661

G1 X82.574 Y63.352 E0.00987

G1 X86.992 Y58.934 E0.16875

G1 X87.605 Y58.933 E0.01655

G1 X83.187 Y63.351 E0.16874

G1 X83.800 Y63.350 E0.01656

G1 X88.218 Y58.933 E0.16873

G1 X88.831 Y58.933 E0.01655

G1 X84.414 Y63.350 E0.16872

G1 X85.027 Y63.349 E0.01656

G1 X89.444 Y58.932 E0.16871

G1 X90.057 Y58.932 E0.01655

G1 X85.640 Y63.349 E0.16871

G1 X86.253 Y63.348 E0.01656

G1 X90.669 Y58.931 E0.16870

G1 X91.282 Y58.931 E0.01655

G1 X86.866 Y63.348 E0.16869

G1 X87.479 Y63.347 E0.01656

G1 X91.895 Y58.931 E0.16868

G1 X92.276 Y58.930 E0.01029

G1 X92.278 Y59.160 E0.00620

G1 X88.092 Y63.346 E0.15990

G1 X88.705 Y63.346 E0.01656

G1 X92.284 Y59.767 E0.13670

G1 X92.283 Y60.380 E0.01656

G1 X89.318 Y63.345 E0.11325

G1 X89.931 Y63.345 E0.01656

G1 X92.281 Y60.995 E0.08976

G1 X92.279 Y61.609 E0.01660

G1 X90.544 Y63.344 E0.06626

G1 X91.157 Y63.343 E0.01656

G1 X92.277 Y62.224 E0.04276

G1 X92.274 Y62.839 E0.01660

G1 X91.582 Y63.531 E0.02645

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y62.839 E-0.54262

G1 X92.277 Y62.224 E-0.34062

G1 X92.240 Y62.261 E-0.02876

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X92.551 Y71.614

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y71.786 E0.00460

G1 X92.598 Y72.869 E0.02822

G1 X92.585 Y76.577 E0.09661

G1 X92.571 Y76.653 E0.00203

G1 X81.916 Y76.664 E0.27762

G1 X81.898 Y76.591 E0.00194

G1 X81.885 Y75.434 E0.03016

G1 X81.933 Y75.212 E0.00590

G1 X81.893 Y74.938 E0.00722

G1 X81.884 Y74.551 E0.01008

G1 X81.884 Y73.987 E0.01472

G1 X81.915 Y73.749 E0.00624

G1 X81.884 Y73.528 E0.00582

G1 X81.884 Y72.790 E0.01922

G1 X81.904 Y72.494 E0.00773

G1 X81.884 Y72.271 E0.00584

G1 X81.887 Y71.827 E0.01158

G1 X81.928 Y71.621 E0.00546

G1 X92.491 Y71.614 E0.27523

M204 S1250

G1 X92.928 Y71.403 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y71.753 E0.00937

G1 X93.003 Y76.615 E0.12669

G1 X92.971 Y76.792 E0.00469

G1 X92.910 Y76.940 E0.00416

G1 X92.821 Y77.047 E0.00363

G1 X92.716 Y77.070 E0.00280

G1 X90.621 Y77.085 E0.05459

G1 X81.722 Y77.081 E0.23186

G1 X81.586 Y76.953 E0.00488

G1 X81.531 Y76.844 E0.00320

G1 X81.481 Y76.645 E0.00534

G1 X81.467 Y75.392 E0.03266

G1 X81.508 Y75.198 E0.00516

G1 X81.476 Y74.973 E0.00592

G1 X81.466 Y74.556 E0.01087

G1 X81.466 Y73.959 E0.01557

G1 X81.494 Y73.751 E0.00546

G1 X81.466 Y73.558 E0.00510

G1 X81.467 Y72.776 E0.02036

G1 X81.485 Y72.499 E0.00723

G1 X81.466 Y72.289 E0.00551

G1 X81.470 Y71.784 E0.01313

G1 X81.542 Y71.420 E0.00969

G1 X81.684 Y71.227 E0.00626

G1 X81.770 Y71.204 E0.00232

G1 X92.686 Y71.196 E0.28442

G1 X92.861 Y71.284 E0.00511

G1 X92.899 Y71.350 E0.00198

M204 S1250

G1 X92.723 Y71.698 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y71.753 E-0.23137

G1 X93.008 Y72.981 E-0.68063

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X82.891 Y71.746

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.213 Y72.424 E0.02590

G1 X82.198 Y73.052 E0.01695

G1 X83.315 Y71.934 E0.04270

G1 X83.928 Y71.933 E0.01655

G1 X82.217 Y73.645 E0.06536

G1 X82.232 Y73.748 E0.00282

G1 X82.197 Y74.007 E0.00707

G1 X82.197 Y74.277 E0.00728

G1 X84.541 Y71.933 E0.08953

G1 X85.154 Y71.933 E0.01655

G1 X82.205 Y74.882 E0.11264

G1 X82.251 Y75.223 E0.00931

G1 X82.199 Y75.500 E0.00760

G1 X85.767 Y71.932 E0.13627

G1 X86.380 Y71.932 E0.01655

G1 X82.206 Y76.105 E0.15942

G1 X82.209 Y76.350 E0.00661

G1 X82.574 Y76.350 E0.00987

G1 X86.993 Y71.931 E0.16876

G1 X87.606 Y71.931 E0.01655

G1 X83.187 Y76.349 E0.16876

G1 X83.800 Y76.349 E0.01656

G1 X88.219 Y71.930 E0.16875

G1 X88.831 Y71.930 E0.01655

G1 X84.414 Y76.348 E0.16875

G1 X85.027 Y76.347 E0.01656

G1 X89.444 Y71.930 E0.16874

G1 X90.057 Y71.929 E0.01655

G1 X85.640 Y76.347 E0.16874

G1 X86.253 Y76.346 E0.01656

G1 X90.670 Y71.929 E0.16873

G1 X91.283 Y71.928 E0.01655

G1 X86.866 Y76.346 E0.16872

G1 X87.479 Y76.345 E0.01656

G1 X91.896 Y71.928 E0.16872

G1 X92.276 Y71.928 E0.01027

G1 X92.278 Y72.158 E0.00622

G1 X88.092 Y76.344 E0.15990

G1 X88.705 Y76.344 E0.01656

G1 X92.284 Y72.765 E0.13670

G1 X92.283 Y73.378 E0.01656

G1 X89.318 Y76.343 E0.11326

G1 X89.931 Y76.343 E0.01656

G1 X92.281 Y73.993 E0.08976

G1 X92.279 Y74.607 E0.01660

G1 X90.544 Y76.342 E0.06626

G1 X91.157 Y76.341 E0.01656

G1 X92.277 Y75.222 E0.04276

G1 X92.274 Y75.837 E0.01660

G1 X91.582 Y76.529 E0.02645

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y75.837 E-0.54262

G1 X92.277 Y75.222 E-0.34063

G1 X92.240 Y75.259 E-0.02875

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X92.551 Y84.612

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y84.784 E0.00460

G1 X92.598 Y85.867 E0.02822

G1 X92.585 Y89.575 E0.09661

G1 X92.571 Y89.651 E0.00204

G1 X81.916 Y89.662 E0.27762

G1 X81.898 Y89.589 E0.00194

G1 X81.885 Y88.432 E0.03016

G1 X81.933 Y88.210 E0.00590

G1 X81.893 Y87.936 E0.00722

G1 X81.884 Y87.548 E0.01011

G1 X81.884 Y86.985 E0.01469

G1 X81.915 Y86.747 E0.00624

G1 X81.884 Y86.526 E0.00582

G1 X81.884 Y85.788 E0.01922

G1 X81.904 Y85.492 E0.00774

G1 X81.884 Y85.269 E0.00583

G1 X81.887 Y84.825 E0.01158

G1 X81.928 Y84.619 E0.00548

G1 X92.491 Y84.612 E0.27522

M204 S1250

G1 X92.928 Y84.401 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y84.751 E0.00937

G1 X93.003 Y89.613 E0.12668

G1 X92.971 Y89.790 E0.00469

G1 X92.910 Y89.938 E0.00417

G1 X92.821 Y90.045 E0.00364

G1 X92.716 Y90.068 E0.00280

G1 X90.621 Y90.083 E0.05459

G1 X81.722 Y90.079 E0.23186

G1 X81.586 Y89.951 E0.00488

G1 X81.531 Y89.842 E0.00320

G1 X81.481 Y89.643 E0.00534

G1 X81.467 Y88.390 E0.03266

G1 X81.508 Y88.196 E0.00516

G1 X81.476 Y87.971 E0.00592

G1 X81.466 Y87.553 E0.01089

G1 X81.466 Y86.957 E0.01554

G1 X81.494 Y86.749 E0.00546

G1 X81.466 Y86.556 E0.00510

G1 X81.467 Y85.774 E0.02036

G1 X81.485 Y85.497 E0.00725

G1 X81.466 Y85.287 E0.00550

G1 X81.470 Y84.782 E0.01313

G1 X81.542 Y84.418 E0.00969

G1 X81.685 Y84.224 E0.00627

G1 X81.771 Y84.201 E0.00233

G1 X92.687 Y84.194 E0.28442

G1 X92.861 Y84.281 E0.00509

G1 X92.899 Y84.348 E0.00200

M204 S1250

G1 X92.723 Y84.696 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y84.751 E-0.23144

G1 X93.008 Y85.979 E-0.68056

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X82.891 Y84.743

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.212 Y85.422 E0.02590

G1 X82.198 Y86.049 E0.01695

G1 X83.315 Y84.931 E0.04270

G1 X83.928 Y84.931 E0.01655

G1 X82.217 Y86.642 E0.06537

G1 X82.232 Y86.746 E0.00283

G1 X82.197 Y87.005 E0.00707

G1 X82.197 Y87.274 E0.00726

G1 X84.541 Y84.930 E0.08953

G1 X85.154 Y84.930 E0.01655

G1 X82.205 Y87.879 E0.11264

G1 X82.251 Y88.221 E0.00933

G1 X82.199 Y88.497 E0.00759

G1 X85.767 Y84.930 E0.13628

G1 X86.380 Y84.929 E0.01655

G1 X82.206 Y89.103 E0.15942

G1 X82.209 Y89.348 E0.00662

G1 X82.574 Y89.348 E0.00985

G1 X86.993 Y84.929 E0.16879

G1 X87.606 Y84.928 E0.01655

G1 X83.187 Y89.347 E0.16878

G1 X83.800 Y89.347 E0.01656

G1 X88.218 Y84.928 E0.16877

G1 X88.831 Y84.928 E0.01655

G1 X84.413 Y89.346 E0.16877

G1 X85.026 Y89.345 E0.01656

G1 X89.444 Y84.927 E0.16876

G1 X90.057 Y84.927 E0.01655

G1 X85.639 Y89.345 E0.16875

G1 X86.252 Y89.344 E0.01656

G1 X90.670 Y84.926 E0.16874

G1 X91.283 Y84.926 E0.01655

G1 X86.865 Y89.344 E0.16874

G1 X87.479 Y89.343 E0.01656

G1 X91.896 Y84.926 E0.16873

G1 X92.276 Y84.925 E0.01027

G1 X92.278 Y85.156 E0.00622

G1 X88.092 Y89.342 E0.15992

G1 X88.705 Y89.342 E0.01656

G1 X92.284 Y85.763 E0.13672

G1 X92.283 Y86.376 E0.01657

G1 X89.318 Y89.341 E0.11327

G1 X89.931 Y89.341 E0.01656

G1 X92.281 Y86.991 E0.08977

G1 X92.279 Y87.605 E0.01660

G1 X90.544 Y89.340 E0.06626

G1 X91.157 Y89.339 E0.01656

G1 X92.277 Y88.220 E0.04276

G1 X92.274 Y88.835 E0.01660

G1 X91.582 Y89.527 E0.02645

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y88.835 E-0.54266

G1 X92.277 Y88.220 E-0.34064

G1 X92.240 Y88.257 E-0.02870

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X92.551 Y97.610

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y97.782 E0.00460

G1 X92.598 Y98.865 E0.02822

G1 X92.585 Y102.572 E0.09660

G1 X92.571 Y102.649 E0.00204

G1 X81.917 Y102.660 E0.27761

G1 X81.898 Y102.587 E0.00195

G1 X81.885 Y101.430 E0.03016

G1 X81.933 Y101.209 E0.00590

G1 X81.893 Y100.934 E0.00723

G1 X81.884 Y100.546 E0.01010

G1 X81.884 Y99.983 E0.01469

G1 X81.915 Y99.746 E0.00623

G1 X81.884 Y99.523 E0.00584

G1 X81.884 Y98.786 E0.01922

G1 X81.904 Y98.489 E0.00774

G1 X81.884 Y98.267 E0.00582

G1 X81.887 Y97.823 E0.01157

G1 X81.928 Y97.617 E0.00548

G1 X92.491 Y97.610 E0.27522

M204 S1250

G1 X92.928 Y97.399 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y97.749 E0.00937

G1 X93.003 Y102.611 E0.12668

G1 X92.971 Y102.787 E0.00467

G1 X92.910 Y102.935 E0.00416

G1 X92.820 Y103.043 E0.00366

G1 X92.716 Y103.066 E0.00279

G1 X90.621 Y103.081 E0.05459

G1 X81.722 Y103.077 E0.23186

G1 X81.586 Y102.949 E0.00487

G1 X81.531 Y102.839 E0.00322

G1 X81.481 Y102.641 E0.00533

G1 X81.467 Y101.388 E0.03265

G1 X81.508 Y101.194 E0.00516

G1 X81.476 Y100.969 E0.00593

G1 X81.466 Y100.551 E0.01088

G1 X81.466 Y99.955 E0.01554

G1 X81.494 Y99.747 E0.00545

G1 X81.466 Y99.553 E0.00512

G1 X81.467 Y98.772 E0.02035

G1 X81.485 Y98.494 E0.00725

G1 X81.466 Y98.284 E0.00549

G1 X81.470 Y97.780 E0.01313

G1 X81.542 Y97.416 E0.00969

G1 X81.685 Y97.222 E0.00627

G1 X81.771 Y97.199 E0.00233

G1 X92.687 Y97.192 E0.28442

G1 X92.861 Y97.279 E0.00509

G1 X92.899 Y97.346 E0.00200

M204 S1250

G1 X92.723 Y97.694 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y97.749 E-0.23144

G1 X93.008 Y98.977 E-0.68056

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X82.891 Y97.741

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.213 Y98.419 E0.02590

G1 X82.198 Y99.047 E0.01695

G1 X83.315 Y97.929 E0.04270

G1 X83.928 Y97.929 E0.01655

G1 X82.217 Y99.640 E0.06537

G1 X82.232 Y99.744 E0.00284

G1 X82.197 Y100.003 E0.00706

G1 X82.197 Y100.272 E0.00726

G1 X84.541 Y97.928 E0.08953

G1 X85.154 Y97.928 E0.01655

G1 X82.205 Y100.877 E0.11264

G1 X82.251 Y101.219 E0.00933

G1 X82.199 Y101.495 E0.00758

G1 X85.767 Y97.928 E0.13628

G1 X86.380 Y97.927 E0.01655

G1 X82.206 Y102.101 E0.15942

G1 X82.209 Y102.346 E0.00662

G1 X82.574 Y102.346 E0.00985

G1 X86.993 Y97.927 E0.16879

G1 X87.606 Y97.926 E0.01655

G1 X83.187 Y102.345 E0.16878

G1 X83.800 Y102.344 E0.01656

G1 X88.218 Y97.926 E0.16877

G1 X88.831 Y97.926 E0.01655

G1 X84.413 Y102.344 E0.16877

G1 X85.026 Y102.343 E0.01656

G1 X89.444 Y97.925 E0.16876

G1 X90.057 Y97.925 E0.01655

G1 X85.639 Y102.343 E0.16875

G1 X86.252 Y102.342 E0.01656

G1 X90.670 Y97.924 E0.16874

G1 X91.283 Y97.924 E0.01655

G1 X86.865 Y102.342 E0.16874

G1 X87.479 Y102.341 E0.01656

G1 X91.896 Y97.924 E0.16873

G1 X92.276 Y97.923 E0.01027

G1 X92.278 Y98.154 E0.00622

G1 X88.092 Y102.340 E0.15992

G1 X88.705 Y102.340 E0.01656

G1 X92.284 Y98.761 E0.13672

G1 X92.283 Y99.374 E0.01657

G1 X89.318 Y102.339 E0.11327

G1 X89.931 Y102.339 E0.01656

G1 X92.281 Y99.989 E0.08977

G1 X92.279 Y100.603 E0.01660

G1 X90.544 Y102.338 E0.06626

G1 X91.157 Y102.337 E0.01656

G1 X92.277 Y101.218 E0.04276

G1 X92.274 Y101.833 E0.01660

G1 X91.582 Y102.525 E0.02645

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y101.833 E-0.54266

G1 X92.277 Y101.218 E-0.34064

G1 X92.240 Y101.255 E-0.02870

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X92.551 Y110.608

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y110.780 E0.00460

G1 X92.598 Y111.862 E0.02821

G1 X92.585 Y115.570 E0.09660

G1 X92.571 Y115.647 E0.00206

G1 X81.916 Y115.657 E0.27762

G1 X81.898 Y115.585 E0.00194

G1 X81.885 Y114.427 E0.03017

G1 X81.933 Y114.207 E0.00588

G1 X81.893 Y113.932 E0.00724

G1 X81.884 Y113.544 E0.01010

G1 X81.884 Y112.980 E0.01470

G1 X81.915 Y112.743 E0.00624

G1 X81.884 Y112.521 E0.00584

G1 X81.884 Y111.784 E0.01921

G1 X81.904 Y111.487 E0.00774

G1 X81.884 Y111.265 E0.00582

G1 X81.887 Y110.821 E0.01157

G1 X81.928 Y110.614 E0.00548

G1 X92.491 Y110.608 E0.27522

M204 S1250

G1 X92.928 Y110.397 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y110.747 E0.00937

G1 X93.003 Y115.608 E0.12666

G1 X92.971 Y115.785 E0.00469

G1 X92.910 Y115.933 E0.00416

G1 X92.820 Y116.041 E0.00365

G1 X92.715 Y116.064 E0.00280

G1 X90.621 Y116.079 E0.05458

G1 X81.722 Y116.075 E0.23187

G1 X81.586 Y115.947 E0.00485

G1 X81.531 Y115.837 E0.00322

G1 X81.481 Y115.639 E0.00533

G1 X81.467 Y114.385 E0.03267

G1 X81.508 Y114.192 E0.00514

G1 X81.476 Y113.967 E0.00593

G1 X81.466 Y113.549 E0.01088

G1 X81.466 Y112.953 E0.01555

G1 X81.494 Y112.745 E0.00546

G1 X81.466 Y112.551 E0.00511

G1 X81.467 Y111.770 E0.02035

G1 X81.485 Y111.492 E0.00725

G1 X81.466 Y111.282 E0.00549

G1 X81.470 Y110.778 E0.01313

G1 X81.542 Y110.413 E0.00970

G1 X81.684 Y110.220 E0.00626

G1 X81.771 Y110.197 E0.00233

G1 X92.687 Y110.190 E0.28442

G1 X92.861 Y110.277 E0.00509

G1 X92.899 Y110.344 E0.00200

M204 S1250

G1 X92.723 Y110.692 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y110.747 E-0.23144

G1 X93.008 Y111.975 E-0.68056

G1 E-0.04800 F4200.00000

G1 Z3.850 F9000.000

G1 X82.891 Y110.739

G1 Z3.650

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.213 Y111.417 E0.02590

G1 X82.198 Y112.045 E0.01695

G1 X83.315 Y110.927 E0.04270

G1 X83.928 Y110.927 E0.01655

G1 X82.217 Y112.638 E0.06537

G1 X82.232 Y112.742 E0.00283

G1 X82.197 Y113.001 E0.00707

G1 X82.197 Y113.270 E0.00727

G1 X84.541 Y110.926 E0.08953

G1 X85.154 Y110.926 E0.01655

G1 X82.205 Y113.875 E0.11264

G1 X82.251 Y114.218 E0.00935

G1 X82.199 Y114.493 E0.00757

G1 X85.767 Y110.925 E0.13628

G1 X86.380 Y110.925 E0.01655

G1 X82.206 Y115.099 E0.15942

G1 X82.209 Y115.344 E0.00661

G1 X82.574 Y115.343 E0.00986

G1 X86.993 Y110.925 E0.16878

G1 X87.606 Y110.924 E0.01655

G1 X83.187 Y115.343 E0.16877

G1 X83.800 Y115.342 E0.01656

G1 X88.218 Y110.924 E0.16876

G1 X88.831 Y110.924 E0.01655

G1 X84.413 Y115.342 E0.16876

G1 X85.026 Y115.341 E0.01656

G1 X89.444 Y110.923 E0.16875

G1 X90.057 Y110.923 E0.01655

G1 X85.640 Y115.340 E0.16874

G1 X86.253 Y115.340 E0.01656

G1 X90.670 Y110.922 E0.16873

G1 X91.283 Y110.922 E0.01655

G1 X86.866 Y115.339 E0.16873

G1 X87.479 Y115.339 E0.01656

G1 X91.896 Y110.922 E0.16872

G1 X92.276 Y110.921 E0.01028

G1 X92.278 Y111.152 E0.00622

G1 X88.092 Y115.338 E0.15992

G1 X88.705 Y115.338 E0.01656

G1 X92.284 Y111.759 E0.13671

G1 X92.283 Y112.372 E0.01657

G1 X89.318 Y115.337 E0.11326

G1 X89.931 Y115.337 E0.01656

G1 X92.281 Y112.987 E0.08976

G1 X92.279 Y113.601 E0.01660

G1 X90.544 Y115.336 E0.06626

G1 X91.157 Y115.335 E0.01656

G1 X92.277 Y114.216 E0.04276

G1 X92.274 Y114.831 E0.01660

G1 X91.582 Y115.523 E0.02645

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;3.8

G1 Z3.800 F9000.000

;AFTER\_LAYER\_CHANGE

;3.8

G1 X92.567 Y115.837

M204 S800

G1 F1500.000

G1 X81.918 Y115.847 E0.27747

G1 X81.895 Y115.772 E0.00203

G1 X81.885 Y114.491 E0.03338

G1 X81.939 Y114.239 E0.00673

G1 X81.889 Y113.716 E0.01369

G1 X81.889 Y113.116 E0.01563

G1 X81.921 Y112.838 E0.00728

G1 X81.884 Y112.570 E0.00704

G1 X81.890 Y110.532 E0.05310

G1 X81.912 Y110.441 E0.00246

G1 X92.565 Y110.433 E0.27757

G1 X92.595 Y110.559 E0.00336

G1 X92.579 Y115.778 E0.13599

M204 S1250

G1 X92.908 Y116.122 F9000.000

M204 S800

G1 F1500.000

G1 X92.810 Y116.215 E0.00350

G1 X92.701 Y116.255 E0.00303

G1 X81.775 Y116.265 E0.28468

G1 X81.671 Y116.232 E0.00284

G1 X81.577 Y116.104 E0.00414

G1 X81.505 Y115.948 E0.00449

G1 X81.478 Y115.816 E0.00352

G1 X81.467 Y114.448 E0.03564

G1 X81.517 Y114.214 E0.00625

G1 X81.471 Y113.736 E0.01252

G1 X81.471 Y113.092 E0.01678

G1 X81.500 Y112.843 E0.00653

G1 X81.466 Y112.598 E0.00643

G1 X81.472 Y110.486 E0.05503

G1 X81.507 Y110.326 E0.00427

G1 X81.583 Y110.141 E0.00523

G1 X81.669 Y110.051 E0.00324

G1 X81.771 Y110.023 E0.00276

G1 X92.692 Y110.016 E0.28454

G1 X92.845 Y110.087 E0.00441

G1 X92.952 Y110.267 E0.00546

G1 X93.012 Y110.535 E0.00716

G1 X93.007 Y115.773 E0.13647

G1 X92.936 Y116.069 E0.00794

M204 S1250

G1 X92.774 Y116.119 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.810 Y116.215 E-0.10646

G1 X92.701 Y116.255 E-0.06449

G1 X91.364 Y116.256 E-0.74105

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X82.883 Y115.721

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.203 Y115.040 E0.02561

G1 X82.198 Y114.523 E0.01376

G1 X82.214 Y114.448 E0.00203

G1 X83.298 Y115.532 E0.04079

G1 X83.901 Y115.532 E0.01605

G1 X82.217 Y113.847 E0.06340

G1 X82.203 Y113.230 E0.01644

G1 X84.504 Y115.531 E0.08662

G1 X85.107 Y115.530 E0.01605

G1 X82.209 Y112.633 E0.10906

G1 X82.199 Y112.019 E0.01633

G1 X85.710 Y115.530 E0.13213

G1 X86.313 Y115.529 E0.01605

G1 X82.201 Y111.417 E0.15476

G1 X82.202 Y110.815 E0.01602

G1 X86.916 Y115.529 E0.17740

G1 X87.519 Y115.528 E0.01605

G1 X82.744 Y110.754 E0.17969

G1 X83.348 Y110.754 E0.01606

G1 X88.122 Y115.528 E0.17967

G1 X88.725 Y115.527 E0.01605

G1 X83.951 Y110.753 E0.17966

G1 X84.554 Y110.753 E0.01606

G1 X89.328 Y115.527 E0.17965

G1 X89.931 Y115.526 E0.01605

G1 X85.158 Y110.753 E0.17963

G1 X85.761 Y110.753 E0.01606

G1 X90.533 Y115.525 E0.17962

G1 X91.136 Y115.525 E0.01605

G1 X86.364 Y110.753 E0.17961

G1 X86.968 Y110.752 E0.01606

G1 X91.739 Y115.524 E0.17959

G1 X92.276 Y115.524 E0.01429

G1 X92.276 Y115.458 E0.00176

G1 X87.571 Y110.752 E0.17709

G1 X88.174 Y110.752 E0.01606

G1 X92.277 Y114.855 E0.15441

G1 X92.277 Y114.252 E0.01604

G1 X88.777 Y110.752 E0.13173

G1 X89.381 Y110.752 E0.01606

G1 X92.278 Y113.649 E0.10904

G1 X92.279 Y113.046 E0.01604

G1 X89.984 Y110.752 E0.08636

G1 X90.587 Y110.751 E0.01606

G1 X92.279 Y112.443 E0.06368

G1 X92.280 Y111.840 E0.01604

G1 X91.191 Y110.751 E0.04100

G1 X91.794 Y110.751 E0.01606

G1 X92.468 Y111.425 E0.02538

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.794 Y110.751 E-0.52853

G1 X91.191 Y110.751 E-0.33433

G1 X91.253 Y110.814 E-0.04914

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X92.567 Y102.839

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.919 Y102.850 E0.27746

G1 X81.895 Y102.774 E0.00205

G1 X81.885 Y101.494 E0.03337

G1 X81.939 Y101.240 E0.00675

G1 X81.889 Y100.718 E0.01368

G1 X81.889 Y100.118 E0.01563

G1 X81.921 Y99.840 E0.00727

G1 X81.884 Y99.572 E0.00705

G1 X81.890 Y97.535 E0.05310

G1 X81.912 Y97.443 E0.00245

G1 X92.565 Y97.435 E0.27757

G1 X92.595 Y97.561 E0.00336

G1 X92.579 Y102.780 E0.13600

M204 S1250

G1 X92.908 Y103.125 F9000.000

M204 S800

G1 F1500.000

G1 X92.810 Y103.217 E0.00351

G1 X92.701 Y103.257 E0.00302

G1 X81.776 Y103.268 E0.28467

G1 X81.672 Y103.234 E0.00285

G1 X81.577 Y103.106 E0.00415

G1 X81.505 Y102.950 E0.00449

G1 X81.478 Y102.818 E0.00351

G1 X81.467 Y101.451 E0.03562

G1 X81.517 Y101.216 E0.00627

G1 X81.471 Y100.738 E0.01252

G1 X81.471 Y100.094 E0.01678

G1 X81.500 Y99.845 E0.00652

G1 X81.466 Y99.600 E0.00643

G1 X81.472 Y97.488 E0.05503

G1 X81.507 Y97.329 E0.00425

G1 X81.583 Y97.143 E0.00523

G1 X81.669 Y97.053 E0.00325

G1 X81.771 Y97.026 E0.00275

G1 X92.692 Y97.018 E0.28454

G1 X92.845 Y97.089 E0.00441

G1 X92.952 Y97.269 E0.00546

G1 X93.012 Y97.537 E0.00716

G1 X93.007 Y102.775 E0.13648

G1 X92.936 Y103.071 E0.00794

M204 S1250

G1 X92.774 Y103.121 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.810 Y103.217 E-0.10658

G1 X92.701 Y103.257 E-0.06427

G1 X91.364 Y103.258 E-0.74115

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X82.883 Y102.723

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.203 Y102.043 E0.02561

G1 X82.198 Y101.526 E0.01377

G1 X82.214 Y101.451 E0.00203

G1 X83.298 Y102.535 E0.04079

G1 X83.901 Y102.534 E0.01605

G1 X82.217 Y100.850 E0.06340

G1 X82.203 Y100.232 E0.01644

G1 X84.504 Y102.534 E0.08662

G1 X85.107 Y102.533 E0.01605

G1 X82.209 Y99.635 E0.10906

G1 X82.199 Y99.022 E0.01633

G1 X85.710 Y102.532 E0.13214

G1 X86.313 Y102.532 E0.01605

G1 X82.201 Y98.420 E0.15477

G1 X82.202 Y97.818 E0.01602

G1 X86.916 Y102.531 E0.17741

G1 X87.519 Y102.531 E0.01605

G1 X82.744 Y97.756 E0.17969

G1 X83.348 Y97.756 E0.01606

G1 X88.122 Y102.530 E0.17968

G1 X88.725 Y102.530 E0.01605

G1 X83.951 Y97.756 E0.17967

G1 X84.554 Y97.756 E0.01606

G1 X89.328 Y102.529 E0.17965

G1 X89.930 Y102.528 E0.01605

G1 X85.158 Y97.755 E0.17964

G1 X85.761 Y97.755 E0.01606

G1 X90.533 Y102.528 E0.17963

G1 X91.136 Y102.527 E0.01605

G1 X86.364 Y97.755 E0.17961

G1 X86.968 Y97.755 E0.01606

G1 X91.739 Y102.527 E0.17960

G1 X92.276 Y102.526 E0.01429

G1 X92.276 Y102.460 E0.00176

G1 X87.571 Y97.755 E0.17710

G1 X88.174 Y97.754 E0.01606

G1 X92.277 Y101.857 E0.15442

G1 X92.277 Y101.254 E0.01605

G1 X88.777 Y97.754 E0.13173

G1 X89.381 Y97.754 E0.01606

G1 X92.278 Y100.651 E0.10905

G1 X92.279 Y100.048 E0.01605

G1 X89.984 Y97.754 E0.08636

G1 X90.587 Y97.753 E0.01606

G1 X92.279 Y99.445 E0.06368

G1 X92.280 Y98.842 E0.01605

G1 X91.191 Y97.753 E0.04100

G1 X91.794 Y97.753 E0.01606

G1 X92.468 Y98.427 E0.02538

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.794 Y97.753 E-0.52853

G1 X91.191 Y97.753 E-0.33433

G1 X91.253 Y97.816 E-0.04914

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X92.567 Y89.841

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.918 Y89.852 E0.27746

G1 X81.895 Y89.776 E0.00205

G1 X81.885 Y88.496 E0.03338

G1 X81.939 Y88.242 E0.00675

G1 X81.889 Y87.720 E0.01368

G1 X81.889 Y87.120 E0.01563

G1 X81.921 Y86.842 E0.00727

G1 X81.884 Y86.575 E0.00703

G1 X81.890 Y84.537 E0.05310

G1 X81.912 Y84.445 E0.00246

G1 X92.565 Y84.437 E0.27757

G1 X92.595 Y84.563 E0.00336

G1 X92.579 Y89.782 E0.13600

M204 S1250

G1 X92.908 Y90.127 F9000.000

M204 S800

G1 F1500.000

G1 X92.811 Y90.219 E0.00349

G1 X92.702 Y90.259 E0.00302

G1 X81.776 Y90.270 E0.28468

G1 X81.672 Y90.236 E0.00285

G1 X81.577 Y90.108 E0.00416

G1 X81.505 Y89.953 E0.00447

G1 X81.478 Y89.820 E0.00352

G1 X81.467 Y88.453 E0.03563

G1 X81.517 Y88.218 E0.00627

G1 X81.471 Y87.740 E0.01252

G1 X81.471 Y87.096 E0.01678

G1 X81.500 Y86.847 E0.00652

G1 X81.466 Y86.603 E0.00641

G1 X81.472 Y84.491 E0.05504

G1 X81.507 Y84.331 E0.00426

G1 X81.583 Y84.145 E0.00523

G1 X81.669 Y84.055 E0.00325

G1 X81.771 Y84.028 E0.00274

G1 X92.692 Y84.020 E0.28454

G1 X92.845 Y84.091 E0.00442

G1 X92.952 Y84.271 E0.00546

G1 X93.012 Y84.539 E0.00716

G1 X93.007 Y89.777 E0.13648

G1 X92.936 Y90.074 E0.00796

M204 S1250

G1 X92.774 Y90.124 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.811 Y90.219 E-0.10611

G1 X92.702 Y90.259 E-0.06430

G1 X91.363 Y90.260 E-0.74159

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X82.883 Y89.725

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.203 Y89.045 E0.02561

G1 X82.198 Y88.528 E0.01377

G1 X82.214 Y88.453 E0.00203

G1 X83.298 Y89.537 E0.04079

G1 X83.901 Y89.536 E0.01605

G1 X82.217 Y87.852 E0.06340

G1 X82.203 Y87.234 E0.01644

G1 X84.504 Y89.536 E0.08662

G1 X85.107 Y89.535 E0.01605

G1 X82.209 Y86.637 E0.10906

G1 X82.199 Y86.024 E0.01633

G1 X85.710 Y89.534 E0.13214

G1 X86.313 Y89.534 E0.01605

G1 X82.201 Y85.422 E0.15477

G1 X82.202 Y84.820 E0.01602

G1 X86.916 Y89.533 E0.17740

G1 X87.519 Y89.533 E0.01605

G1 X82.744 Y84.758 E0.17969

G1 X83.348 Y84.758 E0.01606

G1 X88.122 Y89.532 E0.17968

G1 X88.725 Y89.532 E0.01605

G1 X83.951 Y84.758 E0.17967

G1 X84.554 Y84.758 E0.01606

G1 X89.328 Y89.531 E0.17965

G1 X89.930 Y89.530 E0.01605

G1 X85.158 Y84.758 E0.17964

G1 X85.761 Y84.757 E0.01606

G1 X90.533 Y89.530 E0.17962

G1 X91.136 Y89.529 E0.01605

G1 X86.364 Y84.757 E0.17961

G1 X86.968 Y84.757 E0.01606

G1 X91.739 Y89.529 E0.17960

G1 X92.276 Y89.528 E0.01429

G1 X92.276 Y89.462 E0.00176

G1 X87.571 Y84.757 E0.17710

G1 X88.174 Y84.756 E0.01606

G1 X92.277 Y88.859 E0.15441

G1 X92.277 Y88.256 E0.01605

G1 X88.777 Y84.756 E0.13173

G1 X89.381 Y84.756 E0.01606

G1 X92.278 Y87.653 E0.10905

G1 X92.279 Y87.050 E0.01605

G1 X89.984 Y84.756 E0.08636

G1 X90.587 Y84.756 E0.01606

G1 X92.279 Y86.447 E0.06368

G1 X92.280 Y85.845 E0.01605

G1 X91.191 Y84.755 E0.04100

G1 X91.794 Y84.755 E0.01606

G1 X92.468 Y85.429 E0.02538

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.794 Y84.755 E-0.52854

G1 X91.191 Y84.755 E-0.33433

G1 X91.253 Y84.818 E-0.04913

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X92.567 Y76.843

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.918 Y76.854 E0.27747

G1 X81.895 Y76.779 E0.00204

G1 X81.885 Y75.498 E0.03338

G1 X81.939 Y75.244 E0.00675

G1 X81.889 Y74.722 E0.01368

G1 X81.889 Y74.122 E0.01563

G1 X81.921 Y73.844 E0.00727

G1 X81.884 Y73.577 E0.00703

G1 X81.890 Y71.539 E0.05310

G1 X81.912 Y71.448 E0.00245

G1 X92.565 Y71.440 E0.27757

G1 X92.595 Y71.565 E0.00336

G1 X92.579 Y76.784 E0.13600

M204 S1250

G1 X92.908 Y77.129 F9000.000

M204 S800

G1 F1500.000

G1 X92.811 Y77.221 E0.00349

G1 X92.702 Y77.261 E0.00302

G1 X81.776 Y77.272 E0.28468

M73 P47 R37

G1 X81.672 Y77.238 E0.00285

G1 X81.577 Y77.110 E0.00415

G1 X81.505 Y76.955 E0.00446

G1 X81.478 Y76.822 E0.00353

G1 X81.467 Y75.455 E0.03563

G1 X81.517 Y75.220 E0.00627

G1 X81.471 Y74.742 E0.01251

G1 X81.471 Y74.098 E0.01678

G1 X81.500 Y73.849 E0.00652

G1 X81.466 Y73.605 E0.00641

G1 X81.472 Y71.493 E0.05504

G1 X81.507 Y71.333 E0.00426

G1 X81.583 Y71.147 E0.00523

G1 X81.669 Y71.057 E0.00325

G1 X81.771 Y71.030 E0.00274

G1 X92.692 Y71.022 E0.28455

G1 X92.845 Y71.093 E0.00442

G1 X92.952 Y71.273 E0.00546

G1 X93.012 Y71.541 E0.00716

G1 X93.007 Y76.780 E0.13650

G1 X92.936 Y77.076 E0.00794

M204 S1250

G1 X92.774 Y77.126 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.811 Y77.221 E-0.10624

G1 X92.702 Y77.261 E-0.06430

G1 X91.364 Y77.262 E-0.74146

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X82.883 Y76.727

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.203 Y76.047 E0.02561

G1 X82.198 Y75.530 E0.01377

G1 X82.214 Y75.455 E0.00203

G1 X83.298 Y76.539 E0.04079

G1 X83.901 Y76.538 E0.01605

G1 X82.217 Y74.854 E0.06340

G1 X82.203 Y74.236 E0.01644

G1 X84.504 Y76.538 E0.08662

G1 X85.107 Y76.537 E0.01605

G1 X82.209 Y73.639 E0.10906

G1 X82.199 Y73.026 E0.01633

G1 X85.710 Y76.536 E0.13214

G1 X86.313 Y76.536 E0.01605

G1 X82.201 Y72.424 E0.15477

G1 X82.202 Y71.822 E0.01602

G1 X86.916 Y76.535 E0.17740

G1 X87.519 Y76.535 E0.01605

G1 X82.745 Y71.761 E0.17968

G1 X83.348 Y71.760 E0.01606

G1 X88.122 Y76.534 E0.17967

G1 X88.725 Y76.534 E0.01605

G1 X83.951 Y71.760 E0.17965

G1 X84.555 Y71.760 E0.01606

G1 X89.328 Y76.533 E0.17964

G1 X89.930 Y76.532 E0.01605

G1 X85.158 Y71.760 E0.17963

G1 X85.761 Y71.760 E0.01606

G1 X90.533 Y76.532 E0.17961

G1 X91.136 Y76.531 E0.01605

G1 X86.364 Y71.759 E0.17960

G1 X86.968 Y71.759 E0.01606

G1 X91.739 Y76.531 E0.17959

G1 X92.276 Y76.530 E0.01429

G1 X92.276 Y76.464 E0.00176

G1 X87.571 Y71.759 E0.17709

G1 X88.174 Y71.759 E0.01606

G1 X92.277 Y75.861 E0.15441

G1 X92.277 Y75.258 E0.01605

G1 X88.778 Y71.758 E0.13173

G1 X89.381 Y71.758 E0.01606

G1 X92.278 Y74.655 E0.10904

G1 X92.279 Y74.052 E0.01605

G1 X89.984 Y71.758 E0.08636

G1 X90.587 Y71.758 E0.01606

G1 X92.279 Y73.449 E0.06368

G1 X92.280 Y72.847 E0.01605

G1 X91.191 Y71.757 E0.04100

G1 X91.794 Y71.757 E0.01606

G1 X92.468 Y72.431 E0.02538

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.794 Y71.757 E-0.52852

G1 X91.191 Y71.757 E-0.33432

G1 X91.253 Y71.820 E-0.04916

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X92.567 Y63.845

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.918 Y63.856 E0.27747

G1 X81.895 Y63.781 E0.00204

G1 X81.885 Y62.500 E0.03338

G1 X81.939 Y62.246 E0.00675

G1 X81.889 Y61.724 E0.01368

G1 X81.889 Y61.124 E0.01563

G1 X81.921 Y60.846 E0.00727

G1 X81.884 Y60.579 E0.00702

G1 X81.890 Y58.541 E0.05310

G1 X81.912 Y58.450 E0.00246

G1 X92.565 Y58.442 E0.27757

G1 X92.595 Y58.567 E0.00334

G1 X92.579 Y63.786 E0.13599

M204 S1250

G1 X92.908 Y64.131 F9000.000

M204 S800

G1 F1500.000

G1 X92.811 Y64.223 E0.00349

G1 X92.702 Y64.263 E0.00302

G1 X81.776 Y64.274 E0.28468

G1 X81.672 Y64.240 E0.00285

G1 X81.577 Y64.112 E0.00415

G1 X81.505 Y63.957 E0.00446

G1 X81.478 Y63.824 E0.00353

G1 X81.467 Y62.457 E0.03563

G1 X81.517 Y62.222 E0.00627

G1 X81.471 Y61.744 E0.01251

G1 X81.471 Y61.100 E0.01678

G1 X81.500 Y60.851 E0.00652

G1 X81.466 Y60.607 E0.00641

G1 X81.472 Y58.495 E0.05503

G1 X81.507 Y58.335 E0.00427

G1 X81.583 Y58.149 E0.00523

G1 X81.669 Y58.060 E0.00324

G1 X81.771 Y58.032 E0.00275

G1 X92.692 Y58.025 E0.28455

G1 X92.845 Y58.095 E0.00440

G1 X92.952 Y58.276 E0.00547

G1 X93.012 Y58.543 E0.00714

G1 X93.007 Y63.782 E0.13649

G1 X92.936 Y64.078 E0.00794

M204 S1250

G1 X92.774 Y64.128 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.811 Y64.223 E-0.10622

G1 X92.702 Y64.263 E-0.06433

G1 X91.364 Y64.264 E-0.74145

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X82.883 Y63.729

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.203 Y63.049 E0.02561

G1 X82.198 Y62.532 E0.01377

G1 X82.214 Y62.457 E0.00203

G1 X83.298 Y63.541 E0.04079

G1 X83.901 Y63.540 E0.01605

G1 X82.217 Y61.856 E0.06339

G1 X82.203 Y61.238 E0.01644

G1 X84.504 Y63.540 E0.08662

G1 X85.107 Y63.539 E0.01605

G1 X82.209 Y60.641 E0.10906

G1 X82.199 Y60.028 E0.01633

G1 X85.710 Y63.538 E0.13213

G1 X86.313 Y63.538 E0.01605

G1 X82.201 Y59.426 E0.15476

G1 X82.202 Y58.824 E0.01602

G1 X86.916 Y63.537 E0.17739

G1 X87.519 Y63.537 E0.01605

G1 X82.745 Y58.763 E0.17967

G1 X83.348 Y58.763 E0.01606

G1 X88.121 Y63.536 E0.17966

G1 X88.724 Y63.536 E0.01605

G1 X83.951 Y58.762 E0.17964

G1 X84.555 Y58.762 E0.01606

G1 X89.327 Y63.535 E0.17963

G1 X89.930 Y63.534 E0.01605

G1 X85.158 Y58.762 E0.17962

G1 X85.761 Y58.762 E0.01606

G1 X90.533 Y63.534 E0.17960

G1 X91.136 Y63.533 E0.01605

G1 X86.364 Y58.761 E0.17959

G1 X86.968 Y58.761 E0.01606

G1 X91.739 Y63.533 E0.17957

G1 X92.276 Y63.532 E0.01430

G1 X92.276 Y63.466 E0.00175

G1 X87.571 Y58.761 E0.17709

G1 X88.174 Y58.761 E0.01606

G1 X92.277 Y62.863 E0.15441

G1 X92.277 Y62.261 E0.01604

G1 X88.778 Y58.761 E0.13172

G1 X89.381 Y58.760 E0.01606

G1 X92.278 Y61.658 E0.10904

G1 X92.279 Y61.055 E0.01604

G1 X89.984 Y58.760 E0.08636

G1 X90.587 Y58.760 E0.01606

G1 X92.279 Y60.452 E0.06368

G1 X92.280 Y59.849 E0.01604

G1 X91.191 Y58.760 E0.04099

G1 X91.794 Y58.760 E0.01606

G1 X92.468 Y59.434 E0.02538

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.794 Y58.760 E-0.52852

G1 X91.191 Y58.760 E-0.33432

G1 X91.253 Y58.822 E-0.04916

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X92.567 Y50.848

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.918 Y50.858 E0.27747

G1 X81.895 Y50.783 E0.00203

G1 X81.885 Y49.502 E0.03339

G1 X81.939 Y49.249 E0.00675

G1 X81.889 Y48.727 E0.01367

G1 X81.889 Y48.126 E0.01565

G1 X81.921 Y47.849 E0.00726

G1 X81.884 Y47.581 E0.00705

G1 X81.890 Y45.543 E0.05310

G1 X81.912 Y45.452 E0.00246

G1 X92.565 Y45.444 E0.27757

G1 X92.595 Y45.570 E0.00336

G1 X92.579 Y50.789 E0.13599

M204 S1250

G1 X92.908 Y51.133 F9000.000

M204 S800

G1 F1500.000

G1 X92.810 Y51.226 E0.00350

G1 X92.701 Y51.266 E0.00303

G1 X81.775 Y51.276 E0.28468

G1 X81.671 Y51.243 E0.00284

G1 X81.577 Y51.115 E0.00413

G1 X81.505 Y50.959 E0.00449

G1 X81.478 Y50.827 E0.00352

G1 X81.467 Y49.459 E0.03564

G1 X81.517 Y49.224 E0.00626

G1 X81.471 Y48.747 E0.01250

G1 X81.471 Y48.102 E0.01679

G1 X81.500 Y47.854 E0.00651

G1 X81.466 Y47.609 E0.00643

G1 X81.472 Y45.497 E0.05503

G1 X81.507 Y45.337 E0.00427

G1 X81.583 Y45.151 E0.00523

G1 X81.669 Y45.062 E0.00324

G1 X81.771 Y45.034 E0.00275

G1 X92.692 Y45.027 E0.28455

G1 X92.845 Y45.097 E0.00440

G1 X92.952 Y45.278 E0.00547

G1 X93.012 Y45.546 E0.00716

G1 X93.007 Y50.784 E0.13647

G1 X92.936 Y51.080 E0.00794

M204 S1250

G1 X92.774 Y51.130 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.810 Y51.226 E-0.10646

G1 X92.701 Y51.266 E-0.06449

G1 X91.364 Y51.267 E-0.74105

G1 E-0.04800 F4200.00000

G1 Z4.000 F9000.000

G1 X82.883 Y50.731

G1 Z3.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.203 Y50.051 E0.02561

G1 X82.198 Y49.534 E0.01376

G1 X82.214 Y49.459 E0.00203

G1 X83.298 Y50.543 E0.04079

G1 X83.901 Y50.542 E0.01605

G1 X82.217 Y48.858 E0.06340

G1 X82.203 Y48.240 E0.01644

G1 X84.504 Y50.542 E0.08662

G1 X85.107 Y50.541 E0.01605

G1 X82.209 Y47.643 E0.10907

G1 X82.199 Y47.030 E0.01633

G1 X85.710 Y50.541 E0.13214

G1 X86.313 Y50.540 E0.01605

G1 X82.201 Y46.428 E0.15477

G1 X82.202 Y45.826 E0.01602

G1 X86.916 Y50.540 E0.17741

G1 X87.519 Y50.539 E0.01605

G1 X82.745 Y45.765 E0.17969

G1 X83.348 Y45.765 E0.01606

G1 X88.122 Y50.539 E0.17968

G1 X88.725 Y50.538 E0.01605

G1 X83.951 Y45.764 E0.17966

G1 X84.554 Y45.764 E0.01606

G1 X89.328 Y50.537 E0.17965

G1 X89.931 Y50.537 E0.01605

G1 X85.158 Y45.764 E0.17964

G1 X85.761 Y45.764 E0.01606

G1 X90.534 Y50.536 E0.17963

G1 X91.137 Y50.536 E0.01605

G1 X86.364 Y45.763 E0.17961

G1 X86.968 Y45.763 E0.01606

G1 X91.740 Y50.535 E0.17960

G1 X92.276 Y50.535 E0.01428

G1 X92.276 Y50.468 E0.00177

G1 X87.571 Y45.763 E0.17709

G1 X88.174 Y45.763 E0.01606

G1 X92.277 Y49.865 E0.15441

G1 X92.277 Y49.263 E0.01604

G1 X88.778 Y45.763 E0.13172

G1 X89.381 Y45.762 E0.01606

G1 X92.278 Y48.660 E0.10904

G1 X92.279 Y48.057 E0.01604

G1 X89.984 Y45.762 E0.08636

G1 X90.587 Y45.762 E0.01606

G1 X92.279 Y47.454 E0.06368

G1 X92.280 Y46.851 E0.01604

G1 X91.191 Y45.762 E0.04099

G1 X91.794 Y45.762 E0.01606

G1 X92.468 Y46.436 E0.02538

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;3.95

G1 Z3.950 F9000.000

;AFTER\_LAYER\_CHANGE

;3.95

G1 X92.591 Y45.383

M204 S800

G1 F1500.000

G1 X92.598 Y46.970 E0.04133

G1 X92.545 Y48.296 E0.03459

G1 X92.557 Y48.679 E0.00999

G1 X92.591 Y48.929 E0.00656

G1 X92.593 Y50.907 E0.05155

G1 X92.573 Y51.005 E0.00260

G1 X81.935 Y51.015 E0.27717

G1 X81.892 Y50.927 E0.00256

G1 X81.884 Y49.565 E0.03549

G1 X81.952 Y49.251 E0.00837

G1 X81.901 Y48.883 E0.00968

G1 X81.941 Y48.354 E0.01383

G1 X81.884 Y46.605 E0.04562

G1 X81.889 Y45.369 E0.03219

G1 X81.913 Y45.281 E0.00236

G1 X92.574 Y45.301 E0.27779

G1 X92.579 Y45.324 E0.00063

M204 S1250

G1 X92.988 Y45.241 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y45.340 E0.00263

G1 X93.016 Y46.977 E0.04264

G1 X92.963 Y48.298 E0.03444

G1 X92.974 Y48.645 E0.00904

G1 X93.009 Y48.900 E0.00672

G1 X93.011 Y50.951 E0.05342

G1 X92.956 Y51.210 E0.00690

G1 X92.817 Y51.385 E0.00585

G1 X92.705 Y51.423 E0.00308

G1 X81.773 Y51.433 E0.28483

G1 X81.678 Y51.406 E0.00259

G1 X81.639 Y51.359 E0.00158

G1 X81.478 Y51.032 E0.00949

G1 X81.474 Y50.991 E0.00108

G1 X81.466 Y49.522 E0.03828

G1 X81.528 Y49.235 E0.00764

G1 X81.481 Y48.896 E0.00892

G1 X81.523 Y48.345 E0.01440

G1 X81.466 Y46.610 E0.04523

G1 X81.472 Y45.313 E0.03381

G1 X81.539 Y45.062 E0.00678

G1 X81.680 Y44.891 E0.00576

G1 X81.774 Y44.863 E0.00255

G1 X92.736 Y44.883 E0.28562

G1 X92.849 Y44.942 E0.00332

G1 X92.967 Y45.134 E0.00585

G1 X92.977 Y45.183 E0.00130

M204 S1250

G1 X92.918 Y45.314 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y45.340 E-0.08922

G1 X93.015 Y46.825 E-0.82278

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X82.859 Y45.411

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.200 Y46.070 E0.02437

G1 X82.199 Y46.663 E0.01551

G1 X83.262 Y45.600 E0.03930

G1 X83.853 Y45.602 E0.01544

G1 X82.218 Y47.237 E0.06044

G1 X82.237 Y47.811 E0.01502

G1 X84.443 Y45.605 E0.08159

G1 X85.034 Y45.607 E0.01545

G1 X82.253 Y48.388 E0.10284

G1 X82.216 Y48.874 E0.01274

G1 X82.234 Y49.000 E0.00334

G1 X85.627 Y45.607 E0.12547

G1 X86.219 Y45.608 E0.01549

G1 X82.198 Y49.629 E0.14869

G1 X82.201 Y50.219 E0.01542

G1 X86.811 Y45.608 E0.17048

G1 X87.404 Y45.609 E0.01549

G1 X82.311 Y50.702 E0.18832

G1 X82.905 Y50.701 E0.01552

G1 X87.996 Y45.610 E0.18828

G1 X88.589 Y45.610 E0.01549

G1 X83.498 Y50.701 E0.18824

G1 X84.092 Y50.700 E0.01552

G1 X89.181 Y45.611 E0.18819

G1 X89.773 Y45.611 E0.01549

G1 X84.685 Y50.699 E0.18815

G1 X85.279 Y50.699 E0.01552

G1 X90.366 Y45.612 E0.18811

G1 X90.958 Y45.612 E0.01549

G1 X85.872 Y50.698 E0.18807

G1 X86.466 Y50.698 E0.01552

G1 X91.551 Y45.613 E0.18802

G1 X92.143 Y45.613 E0.01549

G1 X87.059 Y50.697 E0.18798

G1 X87.653 Y50.697 E0.01552

G1 X92.281 Y46.069 E0.17112

G1 X92.283 Y46.659 E0.01544

G1 X88.246 Y50.696 E0.14927

G1 X88.840 Y50.695 E0.01552

G1 X92.273 Y47.263 E0.12693

G1 X92.248 Y47.880 E0.01616

G1 X89.434 Y50.695 E0.10408

G1 X90.027 Y50.694 E0.01552

G1 X92.238 Y48.484 E0.08174

G1 X92.278 Y49.036 E0.01449

G1 X90.621 Y50.694 E0.06128

G1 X91.214 Y50.693 E0.01552

G1 X92.279 Y49.629 E0.03936

G1 X92.279 Y50.221 E0.01549

G1 X91.620 Y50.881 E0.02440

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.279 Y50.221 E-0.51706

G1 X92.279 Y49.629 E-0.32821

G1 X92.193 Y49.714 E-0.06673

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X92.574 Y58.299

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y58.381 E0.00219

G1 X92.598 Y59.968 E0.04135

G1 X92.545 Y61.294 E0.03459

G1 X92.557 Y61.677 E0.00998

G1 X92.591 Y61.926 E0.00656

G1 X92.593 Y63.905 E0.05156

G1 X92.573 Y64.003 E0.00259

G1 X81.935 Y64.013 E0.27717

G1 X81.892 Y63.925 E0.00257

G1 X81.884 Y62.563 E0.03548

G1 X81.952 Y62.249 E0.00838

G1 X81.901 Y61.881 E0.00967

G1 X81.941 Y61.352 E0.01383

G1 X81.884 Y59.603 E0.04561

G1 X81.889 Y58.367 E0.03219

G1 X81.913 Y58.279 E0.00236

G1 X92.514 Y58.298 E0.27623

M204 S1250

G1 X92.849 Y57.940 F9000.000

M204 S800

G1 F1500.000

G1 X92.967 Y58.132 E0.00586

G1 X93.009 Y58.338 E0.00548

G1 X93.016 Y59.975 E0.04266

G1 X92.963 Y61.296 E0.03444

G1 X92.974 Y61.642 E0.00903

G1 X93.009 Y61.898 E0.00673

G1 X93.011 Y63.949 E0.05343

G1 X92.956 Y64.208 E0.00690

G1 X92.817 Y64.383 E0.00584

G1 X92.705 Y64.420 E0.00307

G1 X81.773 Y64.431 E0.28483

G1 X81.678 Y64.403 E0.00258

G1 X81.639 Y64.356 E0.00160

G1 X81.478 Y64.030 E0.00947

G1 X81.474 Y63.989 E0.00108

G1 X81.466 Y62.520 E0.03827

G1 X81.528 Y62.233 E0.00764

G1 X81.481 Y61.894 E0.00891

G1 X81.523 Y61.343 E0.01441

G1 X81.466 Y59.608 E0.04522

G1 X81.472 Y58.311 E0.03381

G1 X81.539 Y58.060 E0.00678

G1 X81.680 Y57.889 E0.00576

G1 X81.774 Y57.861 E0.00255

G1 X92.736 Y57.881 E0.28562

G1 X92.796 Y57.912 E0.00176

M204 S1250

G1 X92.813 Y58.162 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.967 Y58.132 E-0.15410

G1 X93.009 Y58.338 E-0.11662

G1 X93.014 Y59.495 E-0.64128

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X82.859 Y58.409

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.200 Y59.068 E0.02437

G1 X82.199 Y59.661 E0.01551

G1 X83.262 Y58.598 E0.03930

G1 X83.853 Y58.600 E0.01544

G1 X82.218 Y60.235 E0.06044

G1 X82.237 Y60.809 E0.01502

G1 X84.443 Y58.603 E0.08158

G1 X85.034 Y58.605 E0.01545

G1 X82.253 Y61.386 E0.10284

G1 X82.216 Y61.872 E0.01274

G1 X82.234 Y61.998 E0.00334

G1 X85.627 Y58.605 E0.12546

G1 X86.219 Y58.606 E0.01549

G1 X82.198 Y62.627 E0.14868

G1 X82.201 Y63.216 E0.01542

G1 X86.811 Y58.606 E0.17047

G1 X87.404 Y58.607 E0.01549

G1 X82.311 Y63.700 E0.18831

G1 X82.905 Y63.699 E0.01552

G1 X87.996 Y58.608 E0.18827

G1 X88.588 Y58.608 E0.01549

G1 X83.498 Y63.699 E0.18823

G1 X84.092 Y63.698 E0.01552

G1 X89.181 Y58.609 E0.18819

G1 X89.773 Y58.609 E0.01549

G1 X84.685 Y63.697 E0.18814

G1 X85.279 Y63.697 E0.01552

G1 X90.366 Y58.610 E0.18810

G1 X90.958 Y58.610 E0.01549

G1 X85.872 Y63.696 E0.18806

G1 X86.466 Y63.695 E0.01552

G1 X91.550 Y58.611 E0.18801

G1 X92.143 Y58.611 E0.01549

G1 X87.059 Y63.695 E0.18797

G1 X87.653 Y63.694 E0.01552

G1 X92.281 Y59.067 E0.17112

G1 X92.283 Y59.657 E0.01544

G1 X88.246 Y63.694 E0.14927

G1 X88.840 Y63.693 E0.01552

G1 X92.273 Y60.260 E0.12693

G1 X92.248 Y60.878 E0.01616

G1 X89.434 Y63.692 E0.10408

G1 X90.027 Y63.692 E0.01552

G1 X92.238 Y61.481 E0.08174

G1 X92.278 Y62.034 E0.01449

G1 X90.621 Y63.691 E0.06128

G1 X91.214 Y63.691 E0.01552

G1 X92.279 Y62.626 E0.03936

G1 X92.279 Y63.218 E0.01549

G1 X91.620 Y63.878 E0.02440

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.279 Y63.218 E-0.51707

G1 X92.279 Y62.626 E-0.32820

G1 X92.193 Y62.711 E-0.06673

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X92.574 Y71.296

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y71.378 E0.00219

G1 X92.598 Y72.966 E0.04135

G1 X92.545 Y74.292 E0.03459

G1 X92.557 Y74.675 E0.00998

G1 X92.591 Y74.924 E0.00656

G1 X92.593 Y76.903 E0.05156

G1 X92.573 Y77.001 E0.00260

G1 X81.935 Y77.011 E0.27716

G1 X81.892 Y76.923 E0.00257

G1 X81.884 Y75.561 E0.03548

G1 X81.952 Y75.247 E0.00838

G1 X81.901 Y74.879 E0.00967

G1 X81.941 Y74.349 E0.01385

G1 X81.884 Y72.601 E0.04559

G1 X81.889 Y71.364 E0.03221

G1 X81.913 Y71.277 E0.00234

G1 X92.514 Y71.296 E0.27623

M204 S1250

G1 X92.849 Y70.938 F9000.000

M204 S800

G1 F1500.000

G1 X92.967 Y71.129 E0.00584

G1 X93.009 Y71.336 E0.00550

G1 X93.016 Y72.973 E0.04266

G1 X92.963 Y74.294 E0.03444

G1 X92.974 Y74.640 E0.00903

G1 X93.009 Y74.896 E0.00673

G1 X93.011 Y76.947 E0.05343

G1 X92.956 Y77.205 E0.00688

G1 X92.817 Y77.381 E0.00586

G1 X92.705 Y77.418 E0.00307

G1 X81.773 Y77.429 E0.28483

G1 X81.678 Y77.401 E0.00258

G1 X81.639 Y77.354 E0.00160

G1 X81.478 Y77.028 E0.00947

G1 X81.474 Y76.987 E0.00108

G1 X81.466 Y75.518 E0.03827

G1 X81.528 Y75.231 E0.00764

G1 X81.481 Y74.892 E0.00891

G1 X81.523 Y74.340 E0.01442

G1 X81.466 Y72.606 E0.04520

G1 X81.472 Y71.308 E0.03383

G1 X81.539 Y71.058 E0.00676

G1 X81.680 Y70.887 E0.00576

G1 X81.774 Y70.859 E0.00255

G1 X92.736 Y70.878 E0.28561

G1 X92.796 Y70.910 E0.00177

M204 S1250

G1 X92.814 Y71.159 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.967 Y71.129 E-0.15377

G1 X93.009 Y71.336 E-0.11706

G1 X93.014 Y72.493 E-0.64117

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X82.859 Y71.407

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.200 Y72.066 E0.02437

G1 X82.199 Y72.659 E0.01551

G1 X83.262 Y71.596 E0.03930

G1 X83.853 Y71.598 E0.01544

G1 X82.218 Y73.233 E0.06044

G1 X82.237 Y73.807 E0.01502

G1 X84.443 Y71.601 E0.08158

G1 X85.034 Y71.603 E0.01545

G1 X82.253 Y74.384 E0.10284

G1 X82.216 Y74.870 E0.01273

G1 X82.234 Y74.996 E0.00334

G1 X85.627 Y71.603 E0.12546

G1 X86.219 Y71.604 E0.01549

G1 X82.198 Y75.625 E0.14868

G1 X82.201 Y76.215 E0.01542

G1 X86.811 Y71.604 E0.17047

G1 X87.404 Y71.605 E0.01549

G1 X82.311 Y76.698 E0.18832

G1 X82.905 Y76.697 E0.01552

G1 X87.996 Y71.605 E0.18828

G1 X88.589 Y71.606 E0.01549

G1 X83.498 Y76.697 E0.18824

G1 X84.092 Y76.696 E0.01552

G1 X89.181 Y71.606 E0.18820

G1 X89.774 Y71.607 E0.01549

G1 X84.685 Y76.695 E0.18816

G1 X85.279 Y76.695 E0.01552

G1 X90.366 Y71.607 E0.18811

G1 X90.958 Y71.608 E0.01549

G1 X85.872 Y76.694 E0.18807

G1 X86.466 Y76.693 E0.01552

G1 X91.551 Y71.608 E0.18803

G1 X92.143 Y71.609 E0.01549

G1 X87.059 Y76.693 E0.18799

G1 X87.653 Y76.692 E0.01552

G1 X92.281 Y72.065 E0.17112

G1 X92.283 Y72.655 E0.01544

G1 X88.246 Y76.692 E0.14927

G1 X88.840 Y76.691 E0.01552

G1 X92.273 Y73.258 E0.12693

G1 X92.248 Y73.876 E0.01616

G1 X89.434 Y76.690 E0.10408

G1 X90.027 Y76.690 E0.01552

G1 X92.238 Y74.479 E0.08174

G1 X92.278 Y75.032 E0.01449

G1 X90.621 Y76.689 E0.06128

G1 X91.214 Y76.689 E0.01552

G1 X92.279 Y75.624 E0.03936

G1 X92.279 Y76.216 E0.01549

G1 X91.620 Y76.876 E0.02440

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.279 Y76.216 E-0.51707

G1 X92.279 Y75.624 E-0.32820

G1 X92.193 Y75.709 E-0.06673

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X92.574 Y84.294

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y84.376 E0.00219

G1 X92.598 Y85.964 E0.04136

G1 X92.545 Y87.290 E0.03459

G1 X92.557 Y87.673 E0.00998

G1 X92.591 Y87.922 E0.00656

G1 X92.593 Y89.900 E0.05154

G1 X92.573 Y89.999 E0.00262

G1 X81.936 Y90.009 E0.27716

G1 X81.892 Y89.920 E0.00259

G1 X81.884 Y88.559 E0.03546

G1 X81.952 Y88.245 E0.00838

G1 X81.901 Y87.877 E0.00967

G1 X81.941 Y87.347 E0.01385

G1 X81.884 Y85.599 E0.04559

G1 X81.889 Y84.362 E0.03221

G1 X81.913 Y84.275 E0.00234

G1 X92.514 Y84.294 E0.27623

M204 S1250

G1 X92.849 Y83.936 F9000.000

M204 S800

G1 F1500.000

G1 X92.967 Y84.127 E0.00584

G1 X93.009 Y84.333 E0.00549

G1 X93.016 Y85.971 E0.04267

G1 X92.963 Y87.292 E0.03444

G1 X92.974 Y87.638 E0.00903

G1 X93.009 Y87.894 E0.00673

G1 X93.011 Y89.944 E0.05341

G1 X92.956 Y90.203 E0.00690

G1 X92.817 Y90.379 E0.00586

G1 X92.705 Y90.416 E0.00307

G1 X81.773 Y90.427 E0.28483

G1 X81.678 Y90.399 E0.00258

G1 X81.639 Y90.353 E0.00160

G1 X81.478 Y90.025 E0.00950

G1 X81.474 Y89.985 E0.00106

G1 X81.466 Y88.516 E0.03827

G1 X81.528 Y88.229 E0.00764

G1 X81.481 Y87.890 E0.00891

G1 X81.523 Y87.338 E0.01442

G1 X81.466 Y85.604 E0.04520

G1 X81.472 Y84.306 E0.03383

G1 X81.539 Y84.056 E0.00676

G1 X81.680 Y83.885 E0.00576

G1 X81.774 Y83.857 E0.00255

G1 X92.736 Y83.876 E0.28561

G1 X92.796 Y83.908 E0.00177

M204 S1250

G1 X92.814 Y84.158 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.967 Y84.127 E-0.15379

G1 X93.009 Y84.333 E-0.11686

G1 X93.014 Y85.491 E-0.64134

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X82.859 Y84.405

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.200 Y85.064 E0.02437

G1 X82.199 Y85.657 E0.01551

G1 X83.262 Y84.594 E0.03930

G1 X83.853 Y84.596 E0.01544

G1 X82.218 Y86.231 E0.06044

G1 X82.237 Y86.805 E0.01502

G1 X84.443 Y84.599 E0.08158

G1 X85.034 Y84.601 E0.01545

G1 X82.253 Y87.382 E0.10284

G1 X82.216 Y87.868 E0.01273

G1 X82.234 Y87.994 E0.00334

G1 X85.627 Y84.601 E0.12546

G1 X86.219 Y84.602 E0.01549

G1 X82.198 Y88.623 E0.14868

G1 X82.201 Y89.212 E0.01542

G1 X86.811 Y84.602 E0.17047

G1 X87.404 Y84.603 E0.01549

G1 X82.311 Y89.696 E0.18832

G1 X82.905 Y89.695 E0.01552

G1 X87.996 Y84.603 E0.18828

G1 X88.589 Y84.604 E0.01549

G1 X83.498 Y89.695 E0.18824

G1 X84.092 Y89.694 E0.01552

G1 X89.181 Y84.604 E0.18820

G1 X89.774 Y84.605 E0.01549

G1 X84.685 Y89.693 E0.18815

G1 X85.279 Y89.693 E0.01552

G1 X90.366 Y84.605 E0.18811

G1 X90.958 Y84.606 E0.01549

G1 X85.872 Y89.692 E0.18807

G1 X86.466 Y89.691 E0.01552

G1 X91.551 Y84.606 E0.18803

G1 X92.143 Y84.607 E0.01549

G1 X87.059 Y89.691 E0.18799

G1 X87.653 Y89.690 E0.01552

G1 X92.281 Y85.063 E0.17112

G1 X92.283 Y85.653 E0.01544

G1 X88.246 Y89.690 E0.14927

G1 X88.840 Y89.689 E0.01552

G1 X92.273 Y86.256 E0.12693

G1 X92.248 Y86.874 E0.01616

G1 X89.434 Y89.688 E0.10408

G1 X90.027 Y89.688 E0.01552

G1 X92.238 Y87.477 E0.08174

G1 X92.278 Y88.030 E0.01449

G1 X90.621 Y89.687 E0.06128

G1 X91.214 Y89.687 E0.01552

G1 X92.279 Y88.622 E0.03936

G1 X92.279 Y89.214 E0.01549

G1 X91.620 Y89.874 E0.02440

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.279 Y89.214 E-0.51707

G1 X92.279 Y88.622 E-0.32820

G1 X92.193 Y88.707 E-0.06673

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X92.574 Y97.292

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y97.374 E0.00220

G1 X92.598 Y98.962 E0.04136

G1 X92.545 Y100.288 E0.03458

G1 X92.557 Y100.670 E0.00997

G1 X92.591 Y100.920 E0.00656

G1 X92.593 Y102.898 E0.05155

G1 X92.573 Y102.997 E0.00262

G1 X81.936 Y103.007 E0.27716

G1 X81.892 Y102.918 E0.00259

G1 X81.884 Y101.557 E0.03546

G1 X81.952 Y101.243 E0.00837

G1 X81.901 Y100.875 E0.00970

G1 X81.941 Y100.345 E0.01383

G1 X81.884 Y98.596 E0.04561

G1 X81.889 Y97.360 E0.03219

G1 X81.913 Y97.273 E0.00234

G1 X92.514 Y97.291 E0.27623

M204 S1250

G1 X92.849 Y96.934 F9000.000

M204 S800

G1 F1500.000

G1 X92.967 Y97.125 E0.00585

G1 X93.009 Y97.331 E0.00550

G1 X93.016 Y98.969 E0.04267

G1 X92.963 Y100.289 E0.03444

G1 X92.974 Y100.636 E0.00903

G1 X93.009 Y100.891 E0.00672

G1 X93.011 Y102.942 E0.05342

G1 X92.956 Y103.201 E0.00690

G1 X92.816 Y103.377 E0.00587

G1 X92.705 Y103.414 E0.00307

G1 X81.774 Y103.425 E0.28481

G1 X81.678 Y103.397 E0.00259

G1 X81.639 Y103.350 E0.00160

G1 X81.478 Y103.023 E0.00949

G1 X81.474 Y102.983 E0.00106

G1 X81.466 Y101.514 E0.03827

G1 X81.528 Y101.227 E0.00764

G1 X81.481 Y100.887 E0.00894

G1 X81.523 Y100.336 E0.01440

G1 X81.466 Y98.602 E0.04522

G1 X81.472 Y97.304 E0.03381

G1 X81.539 Y97.053 E0.00677

G1 X81.680 Y96.883 E0.00574

G1 X81.774 Y96.855 E0.00256

G1 X92.736 Y96.874 E0.28561

G1 X92.796 Y96.906 E0.00177

M204 S1250

G1 X92.814 Y97.155 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.967 Y97.125 E-0.15398

G1 X93.009 Y97.331 E-0.11691

G1 X93.014 Y98.488 E-0.64110

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X82.859 Y97.402

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.200 Y98.062 E0.02438

G1 X82.199 Y98.655 E0.01551

G1 X83.262 Y97.592 E0.03930

G1 X83.853 Y97.594 E0.01545

G1 X82.218 Y99.229 E0.06045

G1 X82.237 Y99.803 E0.01502

G1 X84.444 Y97.596 E0.08160

G1 X85.035 Y97.598 E0.01545

G1 X82.253 Y100.380 E0.10286

G1 X82.216 Y100.865 E0.01272

G1 X82.234 Y100.992 E0.00336

G1 X85.627 Y97.599 E0.12548

G1 X86.220 Y97.599 E0.01549

G1 X82.198 Y101.621 E0.14871

G1 X82.201 Y102.210 E0.01542

G1 X86.812 Y97.600 E0.17049

G1 X87.404 Y97.600 E0.01549

G1 X82.311 Y102.694 E0.18834

G1 X82.905 Y102.693 E0.01552

G1 X87.997 Y97.601 E0.18830

G1 X88.589 Y97.601 E0.01549

G1 X83.498 Y102.693 E0.18826

G1 X84.092 Y102.692 E0.01552

G1 X89.182 Y97.602 E0.18822

G1 X89.774 Y97.602 E0.01549

G1 X84.685 Y102.691 E0.18817

G1 X85.279 Y102.691 E0.01552

G1 X90.366 Y97.603 E0.18813

G1 X90.959 Y97.603 E0.01549

G1 X85.872 Y102.690 E0.18809

G1 X86.466 Y102.689 E0.01552

G1 X91.551 Y97.604 E0.18805

G1 X92.144 Y97.605 E0.01549

G1 X87.059 Y102.689 E0.18801

G1 X87.653 Y102.688 E0.01552

G1 X92.281 Y98.061 E0.17112

G1 X92.283 Y98.651 E0.01544

G1 X88.246 Y102.688 E0.14927

G1 X88.840 Y102.687 E0.01552

G1 X92.273 Y99.254 E0.12693

G1 X92.248 Y99.872 E0.01616

G1 X89.434 Y102.686 E0.10408

G1 X90.027 Y102.686 E0.01552

G1 X92.238 Y100.475 E0.08174

G1 X92.278 Y101.028 E0.01449

G1 X90.621 Y102.685 E0.06128

G1 X91.214 Y102.685 E0.01552

G1 X92.279 Y101.620 E0.03936

G1 X92.279 Y102.212 E0.01549

G1 X91.620 Y102.872 E0.02440

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.279 Y102.212 E-0.51707

G1 X92.279 Y101.620 E-0.32820

G1 X92.193 Y101.705 E-0.06673

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X92.574 Y110.290

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y110.372 E0.00220

G1 X92.598 Y111.959 E0.04133

G1 X92.545 Y113.285 E0.03459

G1 X92.557 Y113.668 E0.00999

G1 X92.591 Y113.918 E0.00656

G1 X92.593 Y115.896 E0.05155

G1 X92.573 Y115.994 E0.00260

G1 X81.936 Y116.005 E0.27716

G1 X81.892 Y115.916 E0.00259

G1 X81.884 Y114.555 E0.03548

G1 X81.952 Y114.241 E0.00835

G1 X81.901 Y113.873 E0.00970

G1 X81.941 Y113.343 E0.01383

G1 X81.884 Y111.594 E0.04562

G1 X81.889 Y110.358 E0.03219

G1 X81.913 Y110.270 E0.00236

G1 X92.514 Y110.289 E0.27622

M204 S1250

G1 X92.849 Y109.932 F9000.000

M204 S800

G1 F1500.000

G1 X92.967 Y110.123 E0.00585

G1 X93.009 Y110.329 E0.00550

G1 X93.016 Y111.966 E0.04264

G1 X92.963 Y113.287 E0.03444

G1 X92.974 Y113.634 E0.00904

G1 X93.009 Y113.889 E0.00672

G1 X93.011 Y115.940 E0.05342

G1 X92.956 Y116.199 E0.00690

G1 X92.817 Y116.374 E0.00585

G1 X92.705 Y116.412 E0.00308

G1 X81.774 Y116.423 E0.28481

G1 X81.678 Y116.395 E0.00259

G1 X81.639 Y116.348 E0.00160

G1 X81.478 Y116.021 E0.00949

G1 X81.474 Y115.980 E0.00108

G1 X81.466 Y114.511 E0.03828

G1 X81.528 Y114.225 E0.00762

G1 X81.481 Y113.885 E0.00894

G1 X81.523 Y113.334 E0.01440

G1 X81.466 Y111.599 E0.04523

G1 X81.472 Y110.302 E0.03381

G1 X81.539 Y110.051 E0.00678

G1 X81.680 Y109.881 E0.00575

G1 X81.774 Y109.852 E0.00257

G1 X92.736 Y109.872 E0.28560

G1 X92.796 Y109.904 E0.00177

M204 S1250

G1 X92.814 Y110.153 F9000.000

G1 E-2.24000 F4200.00000

M73 P48 R36

G1 F7200.000

G1 X92.967 Y110.123 E-0.15398

G1 X93.009 Y110.329 E-0.11691

G1 X93.014 Y111.486 E-0.64110

G1 E-0.04800 F4200.00000

G1 Z4.150 F9000.000

G1 X82.859 Y110.400

G1 Z3.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.200 Y111.059 E0.02437

G1 X82.199 Y111.652 E0.01551

G1 X83.262 Y110.589 E0.03930

G1 X83.853 Y110.591 E0.01544

G1 X82.218 Y112.226 E0.06044

G1 X82.237 Y112.800 E0.01502

G1 X84.443 Y110.594 E0.08159

G1 X85.034 Y110.596 E0.01545

G1 X82.253 Y113.377 E0.10284

G1 X82.216 Y113.863 E0.01274

G1 X82.234 Y113.989 E0.00334

G1 X85.627 Y110.596 E0.12547

G1 X86.219 Y110.597 E0.01549

G1 X82.198 Y114.618 E0.14869

G1 X82.201 Y115.208 E0.01542

G1 X86.811 Y110.597 E0.17048

G1 X87.404 Y110.598 E0.01549

G1 X82.310 Y115.692 E0.18835

G1 X82.904 Y115.691 E0.01552

G1 X87.996 Y110.599 E0.18831

G1 X88.589 Y110.599 E0.01549

G1 X83.497 Y115.690 E0.18827

G1 X84.091 Y115.690 E0.01552

G1 X89.181 Y110.600 E0.18822

G1 X89.773 Y110.600 E0.01549

G1 X84.685 Y115.689 E0.18818

G1 X85.278 Y115.689 E0.01552

G1 X90.366 Y110.601 E0.18813

G1 X90.958 Y110.601 E0.01549

G1 X85.872 Y115.688 E0.18809

G1 X86.465 Y115.687 E0.01552

G1 X91.551 Y110.602 E0.18805

G1 X92.143 Y110.602 E0.01549

G1 X87.059 Y115.687 E0.18800

G1 X87.653 Y115.686 E0.01552

G1 X92.281 Y111.058 E0.17114

G1 X92.283 Y111.648 E0.01544

G1 X88.246 Y115.685 E0.14928

G1 X88.840 Y115.685 E0.01552

G1 X92.273 Y112.252 E0.12694

G1 X92.248 Y112.869 E0.01616

G1 X89.433 Y115.684 E0.10409

G1 X90.027 Y115.683 E0.01552

G1 X92.238 Y113.473 E0.08175

G1 X92.278 Y114.025 E0.01449

G1 X90.620 Y115.683 E0.06129

G1 X91.214 Y115.682 E0.01552

G1 X92.279 Y114.618 E0.03936

G1 X92.279 Y115.210 E0.01549

G1 X91.619 Y115.870 E0.02440

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;4.1

G1 Z4.100 F9000.000

;AFTER\_LAYER\_CHANGE

;4.1

G1 X92.573 Y116.150

M204 S800

G1 F1500.000

G1 X85.771 Y116.128 E0.17723

G1 X81.896 Y116.137 E0.10097

G1 X81.886 Y114.653 E0.03867

G1 X81.966 Y114.245 E0.01084

G1 X81.945 Y114.133 E0.00299

G1 X82.013 Y113.757 E0.00994

G1 X82.026 Y112.712 E0.02723

G1 X81.991 Y112.537 E0.00466

G1 X81.986 Y112.299 E0.00618

G1 X81.933 Y112.109 E0.00516

G1 X81.890 Y111.729 E0.00995

G1 X81.890 Y110.271 E0.03799

G1 X81.904 Y110.129 E0.00373

G1 X89.224 Y110.127 E0.19072

G1 X92.586 Y110.155 E0.08760

G1 X92.596 Y111.621 E0.03820

G1 X92.427 Y113.215 E0.04178

G1 X92.449 Y113.502 E0.00750

G1 X92.432 Y113.653 E0.00396

G1 X92.536 Y114.016 E0.00984

G1 X92.588 Y114.379 E0.00955

G1 X92.585 Y116.092 E0.04462

M204 S1250

G1 X92.994 Y116.181 F9000.000

M204 S800

G1 F1500.000

G1 X92.958 Y116.342 E0.00430

G1 X92.799 Y116.542 E0.00665

G1 X92.709 Y116.569 E0.00246

G1 X85.771 Y116.546 E0.18077

G1 X81.770 Y116.555 E0.10423

G1 X81.667 Y116.528 E0.00280

G1 X81.527 Y116.370 E0.00549

G1 X81.471 Y116.124 E0.00658

G1 X81.468 Y114.641 E0.03863

G1 X81.476 Y114.515 E0.00329

G1 X81.539 Y114.237 E0.00744

G1 X81.517 Y114.120 E0.00309

G1 X81.570 Y113.911 E0.00562

G1 X81.572 Y113.768 E0.00372

G1 X81.596 Y113.692 E0.00207

G1 X81.607 Y112.750 E0.02456

G1 X81.575 Y112.582 E0.00446

G1 X81.569 Y112.361 E0.00576

G1 X81.522 Y112.188 E0.00467

G1 X81.472 Y111.753 E0.01142

G1 X81.479 Y110.073 E0.04377

G1 X81.564 Y109.843 E0.00639

G1 X81.667 Y109.740 E0.00379

G1 X81.772 Y109.711 E0.00283

G1 X89.226 Y109.710 E0.19421

G1 X92.781 Y109.735 E0.09265

G1 X92.852 Y109.777 E0.00215

G1 X92.972 Y109.962 E0.00574

G1 X93.005 Y110.115 E0.00407

G1 X93.014 Y111.641 E0.03979

G1 X92.846 Y113.224 E0.04148

G1 X92.876 Y113.445 E0.00579

G1 X92.856 Y113.618 E0.00454

G1 X92.946 Y113.929 E0.00844

G1 X93.006 Y114.349 E0.01105

G1 X93.006 Y116.122 E0.04622

M204 S1250

G1 X92.841 Y116.243 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.958 Y116.342 E-0.12468

G1 X92.799 Y116.542 E-0.14150

G1 X92.709 Y116.569 E-0.05236

G1 X91.638 Y116.565 E-0.59347

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X82.015 Y115.145

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.692 Y115.822 E0.02544

G1 X83.293 Y115.821 E0.01595

G1 X82.200 Y114.728 E0.04104

G1 X82.285 Y114.247 E0.01298

G1 X82.277 Y114.203 E0.00118

G1 X83.893 Y115.819 E0.06069

G1 X84.494 Y115.818 E0.01595

G1 X82.327 Y113.651 E0.08136

G1 X82.335 Y113.056 E0.01579

G1 X85.095 Y115.816 E0.10364

G1 X85.695 Y115.815 E0.01595

G1 X82.302 Y112.422 E0.12742

G1 X82.298 Y112.253 E0.00447

G1 X82.242 Y112.049 E0.00563

G1 X82.204 Y111.722 E0.00874

G1 X86.299 Y115.816 E0.15377

G1 X86.903 Y115.818 E0.01604

G1 X82.203 Y111.119 E0.17648

G1 X82.204 Y110.517 E0.01598

G1 X87.507 Y115.820 E0.19915

G1 X88.111 Y115.822 E0.01604

G1 X82.731 Y110.442 E0.20204

G1 X83.333 Y110.442 E0.01598

G1 X88.716 Y115.824 E0.20212

G1 X89.320 Y115.826 E0.01604

G1 X83.935 Y110.442 E0.20219

G1 X84.537 Y110.442 E0.01598

G1 X89.924 Y115.828 E0.20227

G1 X90.528 Y115.830 E0.01604

G1 X85.139 Y110.441 E0.20235

G1 X85.741 Y110.441 E0.01598

G1 X91.132 Y115.832 E0.20243

G1 X91.736 Y115.834 E0.01604

G1 X86.343 Y110.441 E0.20251

G1 X86.945 Y110.441 E0.01598

G1 X92.281 Y115.777 E0.20036

G1 X92.278 Y115.172 E0.01606

G1 X87.547 Y110.441 E0.17766

G1 X88.149 Y110.441 E0.01598

G1 X92.276 Y114.567 E0.15495

G1 X92.275 Y114.402 E0.00438

G1 X92.229 Y114.082 E0.00859

G1 X92.163 Y113.853 E0.00632

G1 X88.751 Y110.441 E0.12813

G1 X89.354 Y110.442 E0.01601

G1 X92.114 Y113.201 E0.10362

G1 X92.171 Y112.657 E0.01454

G1 X89.961 Y110.447 E0.08298

G1 X90.568 Y110.452 E0.01612

G1 X92.229 Y112.112 E0.06235

G1 X92.282 Y111.563 E0.01464

G1 X91.175 Y110.457 E0.04156

G1 X91.782 Y110.461 E0.01612

G1 X92.467 Y111.146 E0.02572

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.782 Y110.461 E-0.53680

G1 X91.175 Y110.457 E-0.33641

G1 X91.225 Y110.506 E-0.03879

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X92.495 Y103.153

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.771 Y103.130 E0.17519

G1 X81.896 Y103.139 E0.10098

G1 X81.886 Y101.656 E0.03866

G1 X81.966 Y101.247 E0.01085

G1 X81.945 Y101.135 E0.00298

G1 X82.013 Y100.759 E0.00994

G1 X82.026 Y99.716 E0.02719

G1 X81.991 Y99.539 E0.00468

G1 X81.986 Y99.302 E0.00617

G1 X81.933 Y99.112 E0.00516

G1 X81.890 Y98.732 E0.00996

G1 X81.904 Y97.132 E0.04169

G1 X89.224 Y97.130 E0.19074

G1 X92.586 Y97.157 E0.08760

G1 X92.596 Y98.623 E0.03820

G1 X92.427 Y100.218 E0.04179

G1 X92.449 Y100.504 E0.00748

G1 X92.432 Y100.655 E0.00396

G1 X92.536 Y101.018 E0.00984

G1 X92.588 Y101.381 E0.00955

G1 X92.596 Y103.048 E0.04342

G1 X92.572 Y103.153 E0.00281

G1 X92.555 Y103.153 E0.00047

M204 S1250

G1 X92.958 Y103.344 F9000.000

M204 S800

G1 F1500.000

G1 X92.799 Y103.544 E0.00667

G1 X92.708 Y103.572 E0.00247

G1 X85.771 Y103.548 E0.18076

G1 X81.770 Y103.557 E0.10423

G1 X81.667 Y103.530 E0.00280

G1 X81.527 Y103.372 E0.00549

G1 X81.471 Y103.127 E0.00656

G1 X81.468 Y101.644 E0.03864

G1 X81.476 Y101.518 E0.00327

G1 X81.539 Y101.239 E0.00746

G1 X81.517 Y101.122 E0.00309

G1 X81.570 Y100.913 E0.00562

G1 X81.572 Y100.770 E0.00372

G1 X81.596 Y100.694 E0.00207

G1 X81.607 Y99.753 E0.02453

G1 X81.575 Y99.584 E0.00448

G1 X81.569 Y99.364 E0.00574

G1 X81.522 Y99.191 E0.00467

G1 X81.472 Y98.755 E0.01144

G1 X81.479 Y97.075 E0.04378

G1 X81.564 Y96.845 E0.00639

G1 X81.667 Y96.743 E0.00377

G1 X81.772 Y96.714 E0.00283

G1 X89.226 Y96.713 E0.19422

G1 X92.782 Y96.737 E0.09266

G1 X92.852 Y96.779 E0.00213

G1 X92.972 Y96.964 E0.00574

G1 X93.005 Y97.117 E0.00407

G1 X93.014 Y98.644 E0.03980

G1 X92.846 Y100.227 E0.04148

G1 X92.876 Y100.447 E0.00577

G1 X92.856 Y100.620 E0.00454

G1 X92.946 Y100.931 E0.00844

G1 X93.006 Y101.351 E0.01105

G1 X93.014 Y103.092 E0.04537

G1 X92.971 Y103.285 E0.00516

M204 S1250

G1 X92.703 Y103.361 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.799 Y103.544 E-0.17227

G1 X92.708 Y103.572 E-0.05252

G1 X91.468 Y103.567 E-0.68721

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X82.014 Y102.147

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.692 Y102.824 E0.02544

G1 X83.293 Y102.823 E0.01595

G1 X82.200 Y101.730 E0.04103

G1 X82.285 Y101.248 E0.01299

G1 X82.277 Y101.205 E0.00116

G1 X83.893 Y102.821 E0.06069

G1 X84.494 Y102.820 E0.01595

G1 X82.327 Y100.653 E0.08136

G1 X82.335 Y100.058 E0.01579

G1 X85.095 Y102.818 E0.10363

G1 X85.695 Y102.817 E0.01595

G1 X82.302 Y99.424 E0.12741

G1 X82.298 Y99.256 E0.00445

G1 X82.242 Y99.052 E0.00563

G1 X82.204 Y98.724 E0.00877

G1 X86.299 Y102.819 E0.15376

G1 X86.903 Y102.821 E0.01604

G1 X82.208 Y98.126 E0.17629

G1 X82.214 Y97.529 E0.01585

G1 X87.507 Y102.823 E0.19878

G1 X88.112 Y102.825 E0.01604

G1 X82.732 Y97.445 E0.20201

G1 X83.334 Y97.445 E0.01598

G1 X88.716 Y102.827 E0.20209

G1 X89.320 Y102.829 E0.01604

G1 X83.936 Y97.445 E0.20217

G1 X84.538 Y97.445 E0.01598

G1 X89.924 Y102.831 E0.20225

G1 X90.528 Y102.833 E0.01604

G1 X85.140 Y97.444 E0.20234

G1 X85.742 Y97.444 E0.01598

G1 X91.132 Y102.835 E0.20242

G1 X91.737 Y102.837 E0.01604

G1 X86.344 Y97.444 E0.20250

G1 X86.946 Y97.444 E0.01598

G1 X92.281 Y102.779 E0.20033

G1 X92.278 Y102.175 E0.01606

G1 X87.548 Y97.444 E0.17763

G1 X88.150 Y97.444 E0.01598

G1 X92.276 Y101.570 E0.15492

G1 X92.275 Y101.404 E0.00439

G1 X92.229 Y101.084 E0.00859

G1 X92.164 Y100.856 E0.00631

G1 X88.752 Y97.444 E0.12811

G1 X89.355 Y97.445 E0.01601

G1 X92.114 Y100.204 E0.10359

G1 X92.171 Y99.659 E0.01454

G1 X89.962 Y97.450 E0.08296

G1 X90.569 Y97.454 E0.01612

G1 X92.229 Y99.114 E0.06233

G1 X92.282 Y98.566 E0.01464

G1 X91.176 Y97.459 E0.04154

G1 X91.782 Y97.464 E0.01612

G1 X92.467 Y98.149 E0.02571

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.782 Y97.464 E-0.53666

G1 X91.176 Y97.459 E-0.33635

G1 X91.225 Y97.509 E-0.03898

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X92.495 Y90.155

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.771 Y90.132 E0.17519

G1 X81.896 Y90.141 E0.10098

G1 X81.886 Y88.658 E0.03866

G1 X81.966 Y88.249 E0.01085

G1 X81.945 Y88.137 E0.00297

G1 X82.013 Y87.761 E0.00995

G1 X82.026 Y86.717 E0.02721

G1 X81.991 Y86.542 E0.00466

G1 X81.986 Y86.304 E0.00618

G1 X81.933 Y86.114 E0.00516

G1 X81.890 Y85.734 E0.00995

G1 X81.904 Y84.134 E0.04170

G1 X89.224 Y84.132 E0.19073

G1 X92.586 Y84.159 E0.08760

G1 X92.596 Y85.625 E0.03820

G1 X92.427 Y87.220 E0.04179

G1 X92.449 Y87.506 E0.00748

G1 X92.432 Y87.657 E0.00396

G1 X92.536 Y88.020 E0.00984

G1 X92.588 Y88.384 E0.00956

G1 X92.596 Y90.050 E0.04342

G1 X92.572 Y90.155 E0.00281

G1 X92.555 Y90.155 E0.00047

M204 S1250

G1 X92.958 Y90.346 F9000.000

M204 S800

G1 F1500.000

G1 X92.799 Y90.547 E0.00667

G1 X92.709 Y90.574 E0.00246

G1 X85.771 Y90.550 E0.18077

G1 X81.770 Y90.559 E0.10425

G1 X81.666 Y90.532 E0.00279

G1 X81.527 Y90.374 E0.00549

G1 X81.471 Y90.129 E0.00656

G1 X81.468 Y88.646 E0.03864

G1 X81.476 Y88.520 E0.00327

G1 X81.539 Y88.241 E0.00746

G1 X81.517 Y88.125 E0.00309

G1 X81.570 Y87.916 E0.00560

G1 X81.572 Y87.773 E0.00374

G1 X81.596 Y87.696 E0.00207

G1 X81.607 Y86.755 E0.02453

G1 X81.575 Y86.587 E0.00446

G1 X81.569 Y86.366 E0.00576

G1 X81.522 Y86.193 E0.00467

G1 X81.472 Y85.758 E0.01142

G1 X81.479 Y84.077 E0.04379

G1 X81.564 Y83.847 E0.00639

G1 X81.667 Y83.745 E0.00377

G1 X81.772 Y83.716 E0.00284

G1 X89.226 Y83.715 E0.19421

G1 X92.781 Y83.740 E0.09264

G1 X92.852 Y83.782 E0.00216

G1 X92.972 Y83.966 E0.00572

G1 X93.005 Y84.119 E0.00406

G1 X93.014 Y85.646 E0.03980

G1 X92.846 Y87.229 E0.04148

G1 X92.876 Y87.449 E0.00577

G1 X92.856 Y87.622 E0.00454

G1 X92.946 Y87.933 E0.00844

G1 X93.006 Y88.353 E0.01105

G1 X93.014 Y90.094 E0.04537

G1 X92.971 Y90.288 E0.00517

M204 S1250

G1 X92.703 Y90.364 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.799 Y90.547 E-0.17239

G1 X92.709 Y90.574 E-0.05223

G1 X91.468 Y90.569 E-0.68738

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X82.014 Y89.149

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.692 Y89.826 E0.02544

G1 X83.293 Y89.825 E0.01595

G1 X82.200 Y88.732 E0.04103

G1 X82.285 Y88.250 E0.01299

G1 X82.277 Y88.207 E0.00116

G1 X83.893 Y89.823 E0.06069

G1 X84.494 Y89.822 E0.01595

G1 X82.327 Y87.655 E0.08136

G1 X82.335 Y87.060 E0.01579

G1 X85.095 Y89.820 E0.10363

G1 X85.695 Y89.819 E0.01595

G1 X82.302 Y86.426 E0.12741

G1 X82.298 Y86.258 E0.00445

G1 X82.242 Y86.054 E0.00563

G1 X82.204 Y85.726 E0.00877

G1 X86.299 Y89.821 E0.15376

G1 X86.903 Y89.823 E0.01604

G1 X82.208 Y85.128 E0.17629

G1 X82.214 Y84.531 E0.01585

G1 X87.507 Y89.825 E0.19877

G1 X88.112 Y89.827 E0.01604

G1 X82.732 Y84.447 E0.20201

G1 X83.334 Y84.447 E0.01598

G1 X88.716 Y89.829 E0.20209

G1 X89.320 Y89.831 E0.01604

G1 X83.936 Y84.447 E0.20217

G1 X84.538 Y84.447 E0.01598

G1 X89.924 Y89.833 E0.20225

G1 X90.528 Y89.835 E0.01604

G1 X85.140 Y84.446 E0.20234

G1 X85.742 Y84.446 E0.01598

G1 X91.132 Y89.837 E0.20242

G1 X91.737 Y89.839 E0.01604

G1 X86.344 Y84.446 E0.20250

G1 X86.946 Y84.446 E0.01598

G1 X92.281 Y89.781 E0.20033

G1 X92.278 Y89.177 E0.01606

G1 X87.548 Y84.446 E0.17763

G1 X88.150 Y84.446 E0.01598

G1 X92.276 Y88.572 E0.15492

G1 X92.275 Y88.407 E0.00439

G1 X92.229 Y88.086 E0.00860

G1 X92.164 Y87.858 E0.00631

G1 X88.752 Y84.446 E0.12811

G1 X89.355 Y84.447 E0.01601

G1 X92.114 Y87.206 E0.10359

G1 X92.171 Y86.661 E0.01454

G1 X89.962 Y84.452 E0.08296

G1 X90.569 Y84.456 E0.01612

G1 X92.229 Y86.116 E0.06233

G1 X92.282 Y85.568 E0.01464

G1 X91.176 Y84.461 E0.04154

G1 X91.782 Y84.466 E0.01612

G1 X92.467 Y85.151 E0.02571

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.782 Y84.466 E-0.53666

G1 X91.176 Y84.461 E-0.33635

G1 X91.225 Y84.511 E-0.03898

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X92.495 Y77.157

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.771 Y77.134 E0.17519

G1 X81.896 Y77.144 E0.10097

G1 X81.886 Y75.660 E0.03866

G1 X81.966 Y75.251 E0.01085

G1 X81.945 Y75.139 E0.00297

G1 X82.013 Y74.763 E0.00995

G1 X82.026 Y73.719 E0.02721

G1 X81.991 Y73.544 E0.00466

G1 X81.986 Y73.306 E0.00618

G1 X81.933 Y73.116 E0.00516

G1 X81.890 Y72.736 E0.00995

G1 X81.904 Y71.136 E0.04170

G1 X89.224 Y71.134 E0.19073

G1 X92.586 Y71.161 E0.08760

G1 X92.596 Y72.627 E0.03820

G1 X92.427 Y74.223 E0.04180

G1 X92.449 Y74.509 E0.00749

G1 X92.432 Y74.660 E0.00395

G1 X92.536 Y75.023 E0.00983

G1 X92.588 Y75.386 E0.00956

G1 X92.595 Y77.052 E0.04343

G1 X92.573 Y77.157 E0.00280

G1 X92.555 Y77.157 E0.00047

M204 S1250

G1 X92.958 Y77.348 F9000.000

M204 S800

G1 F1500.000

G1 X92.799 Y77.549 E0.00667

G1 X92.709 Y77.576 E0.00246

G1 X85.771 Y77.552 E0.18077

G1 X81.770 Y77.562 E0.10424

G1 X81.666 Y77.534 E0.00279

G1 X81.527 Y77.376 E0.00550

G1 X81.471 Y77.131 E0.00657

G1 X81.468 Y75.648 E0.03864

G1 X81.476 Y75.522 E0.00327

G1 X81.539 Y75.243 E0.00746

G1 X81.517 Y75.127 E0.00309

G1 X81.570 Y74.918 E0.00560

G1 X81.572 Y74.775 E0.00374

G1 X81.596 Y74.698 E0.00207

G1 X81.607 Y73.757 E0.02453

G1 X81.575 Y73.589 E0.00446

G1 X81.569 Y73.368 E0.00576

G1 X81.522 Y73.195 E0.00467

G1 X81.472 Y72.760 E0.01142

G1 X81.479 Y71.079 E0.04379

G1 X81.564 Y70.849 E0.00639

G1 X81.667 Y70.747 E0.00377

G1 X81.772 Y70.718 E0.00284

G1 X89.226 Y70.717 E0.19421

G1 X92.781 Y70.742 E0.09264

G1 X92.852 Y70.784 E0.00216

G1 X92.972 Y70.968 E0.00572

G1 X93.005 Y71.121 E0.00407

G1 X93.014 Y72.648 E0.03978

G1 X92.846 Y74.231 E0.04149

G1 X92.876 Y74.451 E0.00577

G1 X92.857 Y74.624 E0.00454

G1 X92.946 Y74.935 E0.00842

G1 X93.006 Y75.355 E0.01105

G1 X93.014 Y77.097 E0.04539

G1 X92.971 Y77.290 E0.00514

M204 S1250

G1 X92.703 Y77.366 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.799 Y77.549 E-0.17243

G1 X92.709 Y77.576 E-0.05223

G1 X91.468 Y77.571 E-0.68734

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X82.015 Y76.151

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.692 Y76.828 E0.02544

G1 X83.293 Y76.827 E0.01595

G1 X82.200 Y75.734 E0.04103

G1 X82.285 Y75.252 E0.01299

G1 X82.277 Y75.209 E0.00116

G1 X83.893 Y76.825 E0.06068

G1 X84.494 Y76.824 E0.01595

G1 X82.327 Y74.657 E0.08136

G1 X82.335 Y74.063 E0.01579

G1 X85.095 Y76.822 E0.10363

G1 X85.695 Y76.821 E0.01595

G1 X82.302 Y73.428 E0.12741

G1 X82.298 Y73.260 E0.00446

G1 X82.242 Y73.056 E0.00563

G1 X82.204 Y72.728 E0.00876

G1 X86.299 Y76.823 E0.15376

G1 X86.903 Y76.825 E0.01604

G1 X82.208 Y72.130 E0.17628

G1 X82.214 Y71.533 E0.01585

G1 X87.507 Y76.827 E0.19877

G1 X88.111 Y76.829 E0.01604

G1 X82.732 Y71.449 E0.20201

G1 X83.334 Y71.449 E0.01598

G1 X88.716 Y76.831 E0.20209

G1 X89.320 Y76.833 E0.01604

G1 X83.936 Y71.449 E0.20217

G1 X84.538 Y71.449 E0.01598

G1 X89.924 Y76.835 E0.20226

G1 X90.528 Y76.837 E0.01604

G1 X85.140 Y71.448 E0.20234

G1 X85.742 Y71.448 E0.01598

G1 X91.132 Y76.839 E0.20242

G1 X91.736 Y76.841 E0.01604

G1 X86.344 Y71.448 E0.20250

G1 X86.946 Y71.448 E0.01598

G1 X92.281 Y76.784 E0.20034

G1 X92.278 Y76.179 E0.01606

G1 X87.548 Y71.448 E0.17764

G1 X88.150 Y71.448 E0.01598

G1 X92.276 Y75.574 E0.15493

G1 X92.275 Y75.409 E0.00439

G1 X92.229 Y75.088 E0.00859

G1 X92.163 Y74.860 E0.00631

G1 X88.752 Y71.448 E0.12811

G1 X89.355 Y71.449 E0.01601

G1 X92.114 Y74.208 E0.10360

G1 X92.171 Y73.663 E0.01454

G1 X89.962 Y71.454 E0.08297

G1 X90.568 Y71.458 E0.01612

G1 X92.229 Y73.119 E0.06234

G1 X92.282 Y72.570 E0.01464

G1 X91.175 Y71.463 E0.04155

G1 X91.782 Y71.468 E0.01612

G1 X92.467 Y72.153 E0.02572

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.782 Y71.468 E-0.53672

G1 X91.175 Y71.463 E-0.33636

G1 X91.225 Y71.513 E-0.03892

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X92.494 Y64.159

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.771 Y64.136 E0.17518

G1 X81.896 Y64.146 E0.10098

G1 X81.886 Y62.662 E0.03865

G1 X81.966 Y62.253 E0.01088

G1 X81.945 Y62.141 E0.00296

G1 X82.013 Y61.766 E0.00993

G1 X82.026 Y60.721 E0.02723

G1 X81.991 Y60.546 E0.00466

G1 X81.986 Y60.308 E0.00618

G1 X81.933 Y60.118 E0.00516

G1 X81.890 Y59.738 E0.00995

G1 X81.904 Y58.138 E0.04170

G1 X89.224 Y58.136 E0.19073

G1 X92.586 Y58.164 E0.08760

G1 X92.596 Y59.630 E0.03820

G1 X92.427 Y61.225 E0.04179

G1 X92.449 Y61.511 E0.00748

G1 X92.432 Y61.663 E0.00399

G1 X92.536 Y62.025 E0.00981

G1 X92.588 Y62.388 E0.00955

G1 X92.596 Y64.055 E0.04344

G1 X92.573 Y64.159 E0.00279

G1 X92.554 Y64.159 E0.00048

M204 S1250

G1 X92.958 Y64.351 F9000.000

M204 S800

G1 F1500.000

G1 X92.799 Y64.551 E0.00666

G1 X92.709 Y64.578 E0.00246

G1 X85.771 Y64.554 E0.18077

G1 X81.770 Y64.564 E0.10424

G1 X81.666 Y64.536 E0.00279

G1 X81.527 Y64.378 E0.00550

G1 X81.471 Y64.133 E0.00656

G1 X81.468 Y62.650 E0.03863

G1 X81.476 Y62.524 E0.00329

G1 X81.539 Y62.245 E0.00747

G1 X81.517 Y62.129 E0.00307

G1 X81.570 Y61.920 E0.00561

G1 X81.572 Y61.777 E0.00372

G1 X81.596 Y61.701 E0.00207

G1 X81.607 Y60.759 E0.02456

G1 X81.575 Y60.591 E0.00446

G1 X81.569 Y60.370 E0.00576

G1 X81.522 Y60.197 E0.00467

G1 X81.472 Y59.762 E0.01142

G1 X81.479 Y58.081 E0.04379

G1 X81.564 Y57.851 E0.00639

G1 X81.667 Y57.749 E0.00377

G1 X81.772 Y57.720 E0.00284

G1 X89.226 Y57.719 E0.19421

G1 X92.782 Y57.744 E0.09265

G1 X92.852 Y57.786 E0.00214

G1 X92.972 Y57.971 E0.00574

G1 X93.005 Y58.123 E0.00406

G1 X93.014 Y59.650 E0.03979

G1 X92.846 Y61.233 E0.04148

G1 X92.876 Y61.453 E0.00577

G1 X92.856 Y61.627 E0.00456

G1 X92.946 Y61.937 E0.00841

G1 X93.006 Y62.357 E0.01105

G1 X93.014 Y64.099 E0.04539

G1 X92.971 Y64.292 E0.00516

M204 S1250

G1 X92.704 Y64.368 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.799 Y64.551 E-0.17200

G1 X92.709 Y64.578 E-0.05233

G1 X91.468 Y64.573 E-0.68767

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X82.014 Y63.153

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.692 Y63.830 E0.02544

G1 X83.293 Y63.829 E0.01595

G1 X82.200 Y62.736 E0.04103

G1 X82.285 Y62.254 E0.01302

G1 X82.277 Y62.212 E0.00113

G1 X83.893 Y63.828 E0.06067

G1 X84.494 Y63.826 E0.01595

G1 X82.327 Y61.659 E0.08136

G1 X82.335 Y61.065 E0.01579

G1 X85.095 Y63.825 E0.10363

G1 X85.695 Y63.823 E0.01595

G1 X82.302 Y60.430 E0.12741

G1 X82.298 Y60.262 E0.00446

G1 X82.242 Y60.058 E0.00563

G1 X82.204 Y59.730 E0.00876

G1 X86.299 Y63.825 E0.15376

G1 X86.903 Y63.827 E0.01604

G1 X82.208 Y59.132 E0.17628

G1 X82.214 Y58.535 E0.01585

G1 X87.507 Y63.829 E0.19877

G1 X88.111 Y63.831 E0.01604

G1 X82.731 Y58.451 E0.20201

G1 X83.333 Y58.451 E0.01598

G1 X88.716 Y63.833 E0.20209

G1 X89.320 Y63.835 E0.01604

G1 X83.935 Y58.451 E0.20218

G1 X84.537 Y58.451 E0.01598

G1 X89.924 Y63.837 E0.20226

G1 X90.528 Y63.839 E0.01604

G1 X85.139 Y58.450 E0.20234

G1 X85.741 Y58.450 E0.01598

G1 X91.132 Y63.841 E0.20242

G1 X91.736 Y63.843 E0.01604

G1 X86.343 Y58.450 E0.20250

G1 X86.945 Y58.450 E0.01598

G1 X92.281 Y63.786 E0.20035

G1 X92.278 Y63.181 E0.01606

G1 X87.547 Y58.450 E0.17764

G1 X88.149 Y58.450 E0.01598

G1 X92.276 Y62.576 E0.15494

G1 X92.275 Y62.411 E0.00440

G1 X92.229 Y62.090 E0.00859

G1 X92.163 Y61.862 E0.00631

G1 X88.751 Y58.450 E0.12812

G1 X89.354 Y58.451 E0.01601

G1 X92.114 Y61.210 E0.10361

G1 X92.171 Y60.666 E0.01454

G1 X89.961 Y58.456 E0.08298

G1 X90.568 Y58.461 E0.01612

G1 X92.229 Y60.121 E0.06234

G1 X92.282 Y59.572 E0.01464

G1 X91.175 Y58.466 E0.04155

G1 X91.782 Y58.470 E0.01612

G1 X92.467 Y59.155 E0.02572

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.782 Y58.470 E-0.53675

G1 X91.175 Y58.466 E-0.33639

G1 X91.225 Y58.515 E-0.03885

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X92.494 Y51.161

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.771 Y51.138 E0.17518

G1 X81.896 Y51.148 E0.10098

G1 X81.886 Y49.664 E0.03865

G1 X81.966 Y49.255 E0.01088

G1 X81.945 Y49.143 E0.00296

G1 X82.013 Y48.768 E0.00993

G1 X82.026 Y47.723 E0.02723

G1 X81.991 Y47.548 E0.00466

G1 X81.986 Y47.310 E0.00618

G1 X81.933 Y47.120 E0.00516

G1 X81.890 Y46.740 E0.00995

G1 X81.904 Y45.140 E0.04170

G1 X89.224 Y45.138 E0.19073

G1 X92.586 Y45.166 E0.08760

G1 X92.596 Y46.632 E0.03820

G1 X92.427 Y48.227 E0.04179

G1 X92.449 Y48.513 E0.00748

G1 X92.432 Y48.664 E0.00398

G1 X92.536 Y49.027 E0.00984

G1 X92.588 Y49.390 E0.00955

G1 X92.596 Y51.057 E0.04342

G1 X92.573 Y51.161 E0.00279

G1 X92.554 Y51.161 E0.00048

M204 S1250

G1 X92.958 Y51.353 F9000.000

M204 S800

G1 F1500.000

G1 X92.799 Y51.553 E0.00665

G1 X92.709 Y51.580 E0.00246

G1 X85.771 Y51.556 E0.18077

G1 X81.770 Y51.566 E0.10424

G1 X81.666 Y51.538 E0.00279

G1 X81.527 Y51.381 E0.00548

G1 X81.471 Y51.135 E0.00658

G1 X81.468 Y49.652 E0.03863

G1 X81.476 Y49.526 E0.00329

G1 X81.539 Y49.247 E0.00746

G1 X81.517 Y49.131 E0.00307

G1 X81.570 Y48.922 E0.00562

G1 X81.572 Y48.779 E0.00372

G1 X81.596 Y48.703 E0.00207

G1 X81.607 Y47.761 E0.02456

G1 X81.575 Y47.593 E0.00446

G1 X81.569 Y47.372 E0.00576

G1 X81.522 Y47.199 E0.00467

G1 X81.472 Y46.764 E0.01142

G1 X81.479 Y45.083 E0.04379

G1 X81.564 Y44.853 E0.00639

G1 X81.667 Y44.751 E0.00377

G1 X81.772 Y44.722 E0.00284

G1 X89.226 Y44.721 E0.19421

G1 X92.782 Y44.746 E0.09265

G1 X92.852 Y44.788 E0.00214

G1 X92.972 Y44.973 E0.00574

G1 X93.005 Y45.126 E0.00407

G1 X93.014 Y46.652 E0.03979

G1 X92.846 Y48.235 E0.04148

G1 X92.876 Y48.455 E0.00577

G1 X92.857 Y48.629 E0.00455

G1 X92.946 Y48.940 E0.00844

G1 X93.006 Y49.360 E0.01105

G1 X93.014 Y51.101 E0.04537

G1 X92.971 Y51.294 E0.00516

M204 S1250

G1 X92.704 Y51.370 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.799 Y51.553 E-0.17194

G1 X92.709 Y51.580 E-0.05235

G1 X91.468 Y51.575 E-0.68771

G1 E-0.04800 F4200.00000

G1 Z4.300 F9000.000

G1 X82.014 Y50.155

G1 Z4.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.692 Y50.832 E0.02544

G1 X83.293 Y50.831 E0.01595

G1 X82.200 Y49.738 E0.04103

G1 X82.285 Y49.256 E0.01301

G1 X82.277 Y49.214 E0.00113

G1 X83.893 Y50.830 E0.06067

G1 X84.494 Y50.828 E0.01595

G1 X82.327 Y48.661 E0.08136

G1 X82.335 Y48.067 E0.01579

G1 X85.095 Y50.827 E0.10363

G1 X85.695 Y50.825 E0.01595

G1 X82.302 Y47.432 E0.12741

G1 X82.298 Y47.264 E0.00446

G1 X82.242 Y47.060 E0.00563

G1 X82.204 Y46.732 E0.00876

G1 X86.299 Y50.827 E0.15376

G1 X86.903 Y50.829 E0.01604

G1 X82.208 Y46.134 E0.17628

G1 X82.214 Y45.537 E0.01585

G1 X87.507 Y50.831 E0.19877

G1 X88.111 Y50.833 E0.01604

G1 X82.731 Y45.453 E0.20201

G1 X83.333 Y45.453 E0.01598

G1 X88.716 Y50.835 E0.20209

G1 X89.320 Y50.837 E0.01604

G1 X83.935 Y45.453 E0.20218

G1 X84.537 Y45.453 E0.01598

G1 X89.924 Y50.839 E0.20226

G1 X90.528 Y50.841 E0.01604

G1 X85.139 Y45.452 E0.20234

G1 X85.741 Y45.452 E0.01598

G1 X91.132 Y50.843 E0.20242

G1 X91.736 Y50.845 E0.01604

G1 X86.343 Y45.452 E0.20250

G1 X86.945 Y45.452 E0.01598

G1 X92.281 Y50.788 E0.20035

G1 X92.278 Y50.183 E0.01606

G1 X87.547 Y45.452 E0.17764

G1 X88.149 Y45.452 E0.01598

G1 X92.276 Y49.578 E0.15494

G1 X92.275 Y49.413 E0.00438

G1 X92.229 Y49.093 E0.00859

G1 X92.163 Y48.864 E0.00633

G1 X88.751 Y45.452 E0.12812

G1 X89.354 Y45.453 E0.01601

G1 X92.114 Y48.212 E0.10361

G1 X92.171 Y47.668 E0.01454

G1 X89.961 Y45.458 E0.08298

G1 X90.568 Y45.463 E0.01612

G1 X92.229 Y47.123 E0.06234

G1 X92.282 Y46.574 E0.01464

G1 X91.175 Y45.468 E0.04155

G1 X91.782 Y45.472 E0.01612

G1 X92.467 Y46.157 E0.02572

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;4.25

G1 Z4.250 F9000.000

;AFTER\_LAYER\_CHANGE

;4.25

G1 E-3.20000 F4200.00000

G1 Z4.450 F9000.000

G1 X92.584 Y110.008

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y111.323 E0.03427

G1 X92.573 Y111.507 E0.00484

G1 X92.539 Y111.594 E0.00244

G1 X92.491 Y111.915 E0.00846

G1 X92.349 Y112.197 E0.00822

G1 X92.357 Y112.360 E0.00426

G1 X92.323 Y112.475 E0.00313

G1 X92.142 Y112.924 E0.01260

G1 X92.142 Y113.219 E0.00770

G1 X92.275 Y113.533 E0.00888

G1 X92.295 Y113.699 E0.00434

G1 X92.410 Y114.185 E0.01302

G1 X92.542 Y114.529 E0.00960

G1 X92.586 Y114.804 E0.00726

G1 X92.596 Y116.184 E0.03595

G1 X92.577 Y116.269 E0.00226

G1 X90.128 Y116.285 E0.06381

G1 X86.218 Y116.263 E0.10188

G1 X81.901 Y116.269 E0.11249

G1 X81.887 Y116.215 E0.00147

G1 X81.891 Y114.890 E0.03453

G1 X81.945 Y114.524 E0.00962

G1 X82.147 Y113.830 E0.01883

G1 X82.198 Y113.739 E0.00273

G1 X82.328 Y112.871 E0.02285

G1 X82.171 Y112.508 E0.01031

G1 X82.106 Y112.154 E0.00938

G1 X82.014 Y112.020 E0.00423

G1 X81.928 Y111.664 E0.00955

G1 X81.885 Y111.286 E0.00992

G1 X81.898 Y109.994 E0.03365

G1 X92.524 Y110.008 E0.27688

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.596 Y111.323 E-0.73000

G1 X92.573 Y111.507 E-0.10292

G1 X92.539 Y111.594 E-0.05186

G1 X92.532 Y111.643 E-0.02722

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.560 Y113.135

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.682 Y113.424 E0.00819

G1 X92.707 Y113.625 E0.00526

G1 X92.810 Y114.062 E0.01170

G1 X92.948 Y114.420 E0.01001

G1 X93.004 Y114.770 E0.00921

G1 X93.014 Y116.229 E0.03802

G1 X92.955 Y116.492 E0.00704

G1 X92.911 Y116.577 E0.00249

G1 X92.831 Y116.659 E0.00300

G1 X92.735 Y116.685 E0.00259

G1 X90.129 Y116.703 E0.06791

G1 X86.218 Y116.680 E0.10191

G1 X81.776 Y116.687 E0.11574

G1 X81.651 Y116.648 E0.00340

G1 X81.537 Y116.530 E0.00429

G1 X81.469 Y116.267 E0.00708

G1 X81.473 Y114.858 E0.03671

G1 X81.536 Y114.435 E0.01115

G1 X81.759 Y113.669 E0.02078

G1 X81.796 Y113.602 E0.00198

G1 X81.897 Y112.927 E0.01778

G1 X81.769 Y112.629 E0.00844

G1 X81.711 Y112.317 E0.00828

G1 X81.626 Y112.193 E0.00392

G1 X81.516 Y111.736 E0.01224

G1 X81.467 Y111.309 E0.01121

G1 X81.472 Y109.955 E0.03528

G1 X81.538 Y109.746 E0.00570

G1 X81.671 Y109.601 E0.00512

G1 X81.769 Y109.576 E0.00264

G1 X92.777 Y109.590 E0.28683

G1 X92.861 Y109.634 E0.00245

G1 X92.961 Y109.772 E0.00445

G1 X92.999 Y109.897 E0.00340

G1 X93.014 Y111.349 E0.03784

G1 X92.925 Y111.911 E0.01482

G1 X92.883 Y112.066 E0.00419

G1 X92.771 Y112.287 E0.00645

G1 X92.777 Y112.410 E0.00322

G1 X92.718 Y112.612 E0.00549

G1 X92.560 Y113.005 E0.01103

G1 X92.560 Y113.075 E0.00183

M204 S1250

G1 X92.318 Y113.335 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.682 Y113.424 E-0.20520

G1 X92.707 Y113.625 E-0.11189

G1 X92.810 Y114.062 E-0.24883

G1 X92.948 Y114.420 E-0.21283

G1 X92.986 Y114.658 E-0.13326

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X82.783 Y110.118

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S1000

G1 X82.179 Y110.722 E0.02011

G1 X82.174 Y111.261 E0.01270

G1 X83.151 Y110.284 E0.03254

G1 X83.684 Y110.285 E0.01256

G1 X82.240 Y111.729 E0.04809

G1 X82.282 Y111.900 E0.00416

G1 X82.379 Y112.041 E0.00402

G1 X82.392 Y112.112 E0.00169

G1 X84.218 Y110.285 E0.06082

G1 X84.751 Y110.286 E0.01256

G1 X82.498 Y112.539 E0.07503

G1 X82.625 Y112.832 E0.00753

G1 X82.605 Y112.966 E0.00319

G1 X85.284 Y110.287 E0.08925

G1 X85.818 Y110.287 E0.01256

G1 X82.511 Y113.594 E0.11014

G1 X82.476 Y113.833 E0.00568

G1 X82.415 Y113.942 E0.00294

G1 X82.299 Y114.340 E0.00977

G1 X86.351 Y110.288 E0.13496

G1 X86.885 Y110.289 E0.01256

G1 X82.179 Y114.995 E0.15674

G1 X82.177 Y115.530 E0.01261

G1 X87.418 Y110.290 E0.17455

G1 X87.951 Y110.290 E0.01256

G1 X82.261 Y115.981 E0.18953

G1 X82.796 Y115.980 E0.01260

G1 X88.485 Y110.291 E0.18948

G1 X89.018 Y110.292 E0.01256

G1 X83.331 Y115.979 E0.18942

G1 X83.866 Y115.978 E0.01260

G1 X89.552 Y110.292 E0.18937

G1 X90.085 Y110.293 E0.01256

G1 X84.401 Y115.977 E0.18932

G1 X84.936 Y115.976 E0.01260

G1 X90.618 Y110.294 E0.18927

G1 X91.152 Y110.294 E0.01256

G1 X85.471 Y115.975 E0.18922

G1 X86.006 Y115.975 E0.01260

G1 X91.685 Y110.295 E0.18917

G1 X92.219 Y110.296 E0.01256

G1 X86.538 Y115.976 E0.18919

G1 X87.069 Y115.979 E0.01251

G1 X92.302 Y110.746 E0.17430

G1 X92.307 Y111.275 E0.01246

G1 X87.600 Y115.982 E0.15677

G1 X88.131 Y115.985 E0.01251

G1 X92.134 Y111.982 E0.13332

G1 X92.057 Y112.135 E0.00403

G1 X92.066 Y112.326 E0.00450

G1 X92.050 Y112.381 E0.00135

G1 X91.902 Y112.749 E0.00935

G1 X88.662 Y115.988 E0.10789

G1 X89.193 Y115.991 E0.01251

G1 X91.870 Y113.315 E0.08914

G1 X91.993 Y113.609 E0.00750

G1 X92.006 Y113.712 E0.00246

G1 X89.724 Y115.994 E0.07601

G1 X90.257 Y115.996 E0.01254

G1 X92.105 Y114.148 E0.06156

G1 X92.240 Y114.547 E0.00992

G1 X90.795 Y115.992 E0.04814

G1 X91.332 Y115.989 E0.01266

G1 X92.299 Y115.022 E0.03221

G1 X92.303 Y115.552 E0.01249

G1 X91.703 Y116.152 E0.01998

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.303 Y115.552 E-0.47002

G1 X92.299 Y115.022 E-0.29384

G1 X92.110 Y115.211 E-0.14815

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.577 Y103.271

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.128 Y103.287 E0.06380

G1 X86.219 Y103.265 E0.10188

M73 P49 R35

G1 X81.901 Y103.271 E0.11250

G1 X81.887 Y103.218 E0.00145

G1 X81.891 Y101.892 E0.03455

G1 X81.945 Y101.531 E0.00950

G1 X82.208 Y100.673 E0.02338

G1 X82.328 Y99.873 E0.02108

G1 X82.171 Y99.509 E0.01031

G1 X82.106 Y99.157 E0.00935

G1 X82.014 Y99.023 E0.00423

G1 X81.928 Y98.666 E0.00955

G1 X81.885 Y98.288 E0.00993

G1 X81.897 Y96.997 E0.03363

G1 X92.584 Y97.010 E0.27845

G1 X92.596 Y98.325 E0.03426

G1 X92.573 Y98.509 E0.00484

G1 X92.539 Y98.596 E0.00244

G1 X92.491 Y98.917 E0.00846

G1 X92.349 Y99.199 E0.00822

G1 X92.357 Y99.362 E0.00426

G1 X92.323 Y99.478 E0.00313

G1 X92.142 Y99.927 E0.01262

G1 X92.142 Y100.223 E0.00770

G1 X92.275 Y100.536 E0.00886

G1 X92.295 Y100.701 E0.00433

G1 X92.410 Y101.187 E0.01302

G1 X92.542 Y101.531 E0.00960

G1 X92.586 Y101.806 E0.00726

G1 X92.590 Y103.213 E0.03665

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.945 Y103.263 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.560 Y100.008

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.560 Y100.138 E0.00338

G1 X92.682 Y100.427 E0.00817

G1 X92.707 Y100.627 E0.00526

G1 X92.810 Y101.064 E0.01170

G1 X92.948 Y101.422 E0.01001

G1 X93.004 Y101.772 E0.00921

G1 X93.014 Y103.231 E0.03802

G1 X92.955 Y103.494 E0.00704

G1 X92.911 Y103.579 E0.00249

G1 X92.831 Y103.662 E0.00301

G1 X92.734 Y103.688 E0.00260

G1 X90.129 Y103.705 E0.06790

G1 X86.218 Y103.682 E0.10191

G1 X81.776 Y103.689 E0.11574

G1 X81.651 Y103.650 E0.00340

G1 X81.537 Y103.532 E0.00429

G1 X81.469 Y103.270 E0.00706

G1 X81.473 Y101.860 E0.03674

G1 X81.536 Y101.438 E0.01111

G1 X81.800 Y100.580 E0.02338

G1 X81.897 Y99.929 E0.01716

G1 X81.769 Y99.631 E0.00844

G1 X81.711 Y99.320 E0.00826

G1 X81.626 Y99.196 E0.00392

G1 X81.516 Y98.739 E0.01224

G1 X81.467 Y98.311 E0.01123

G1 X81.472 Y96.957 E0.03527

G1 X81.538 Y96.749 E0.00569

G1 X81.671 Y96.604 E0.00512

G1 X81.769 Y96.579 E0.00263

G1 X92.777 Y96.593 E0.28684

G1 X92.861 Y96.636 E0.00244

G1 X92.961 Y96.774 E0.00445

G1 X92.999 Y96.899 E0.00340

G1 X93.014 Y98.351 E0.03784

G1 X92.925 Y98.913 E0.01482

G1 X92.883 Y99.068 E0.00419

G1 X92.771 Y99.289 E0.00645

G1 X92.777 Y99.412 E0.00322

G1 X92.718 Y99.614 E0.00549

G1 X92.582 Y99.952 E0.00949

M204 S1250

G1 X92.441 Y100.059 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.560 Y100.138 E-0.10354

G1 X92.682 Y100.427 E-0.17377

G1 X92.707 Y100.627 E-0.11182

G1 X92.810 Y101.064 E-0.24883

G1 X92.948 Y101.422 E-0.21283

G1 X92.965 Y101.531 E-0.06121

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X82.783 Y97.121

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S1000

G1 X82.179 Y97.724 E0.02011

G1 X82.174 Y98.264 E0.01270

G1 X83.151 Y97.287 E0.03254

G1 X83.684 Y97.287 E0.01256

G1 X82.240 Y98.731 E0.04809

G1 X82.282 Y98.903 E0.00417

G1 X82.379 Y99.044 E0.00402

G1 X82.391 Y99.114 E0.00168

G1 X84.218 Y97.288 E0.06082

G1 X84.751 Y97.289 E0.01256

G1 X82.499 Y99.541 E0.07502

G1 X82.625 Y99.834 E0.00752

G1 X82.605 Y99.969 E0.00321

G1 X85.284 Y97.289 E0.08926

G1 X85.818 Y97.290 E0.01256

G1 X82.511 Y100.597 E0.11014

G1 X82.490 Y100.737 E0.00334

G1 X82.306 Y101.336 E0.01475

G1 X86.351 Y97.291 E0.13473

G1 X86.885 Y97.291 E0.01256

G1 X82.179 Y101.997 E0.15675

G1 X82.177 Y102.533 E0.01261

G1 X87.418 Y97.292 E0.17456

G1 X87.952 Y97.293 E0.01256

G1 X82.262 Y102.983 E0.18951

G1 X82.797 Y102.982 E0.01260

G1 X88.485 Y97.293 E0.18946

G1 X89.019 Y97.294 E0.01256

G1 X83.332 Y102.981 E0.18941

G1 X83.867 Y102.980 E0.01260

G1 X89.552 Y97.295 E0.18936

G1 X90.085 Y97.295 E0.01256

G1 X84.402 Y102.979 E0.18931

G1 X84.937 Y102.978 E0.01260

G1 X90.619 Y97.296 E0.18926

G1 X91.152 Y97.297 E0.01256

G1 X85.471 Y102.977 E0.18921

G1 X86.006 Y102.977 E0.01260

G1 X91.686 Y97.297 E0.18916

G1 X92.219 Y97.298 E0.01256

G1 X86.539 Y102.978 E0.18919

G1 X87.070 Y102.981 E0.01251

G1 X92.302 Y97.749 E0.17428

G1 X92.307 Y98.278 E0.01247

G1 X87.601 Y102.984 E0.15676

G1 X88.132 Y102.987 E0.01251

G1 X92.133 Y98.986 E0.13328

G1 X92.057 Y99.137 E0.00399

G1 X92.066 Y99.328 E0.00450

G1 X92.050 Y99.383 E0.00136

G1 X91.902 Y99.751 E0.00935

G1 X88.663 Y102.990 E0.10789

G1 X89.194 Y102.994 E0.01251

G1 X91.869 Y100.318 E0.08912

G1 X91.994 Y100.611 E0.00750

G1 X92.006 Y100.715 E0.00247

G1 X89.725 Y102.997 E0.07599

G1 X90.257 Y102.998 E0.01254

G1 X92.105 Y101.150 E0.06155

G1 X92.240 Y101.549 E0.00992

G1 X90.795 Y102.995 E0.04814

G1 X91.333 Y102.991 E0.01266

G1 X92.299 Y102.024 E0.03220

G1 X92.303 Y102.555 E0.01249

G1 X91.704 Y103.154 E0.01997

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.303 Y102.555 E-0.46991

G1 X92.299 Y102.024 E-0.29384

G1 X92.110 Y102.214 E-0.14825

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.577 Y90.273

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.128 Y90.289 E0.06380

G1 X86.219 Y90.267 E0.10188

G1 X81.901 Y90.273 E0.11250

G1 X81.887 Y90.220 E0.00145

G1 X81.891 Y88.894 E0.03455

G1 X81.945 Y88.533 E0.00950

G1 X82.208 Y87.676 E0.02336

G1 X82.327 Y86.877 E0.02106

G1 X82.171 Y86.512 E0.01034

G1 X82.106 Y86.159 E0.00934

G1 X82.014 Y86.025 E0.00424

G1 X81.928 Y85.668 E0.00956

G1 X81.885 Y85.290 E0.00992

G1 X81.898 Y83.999 E0.03364

G1 X92.584 Y84.013 E0.27844

G1 X92.596 Y85.327 E0.03424

G1 X92.573 Y85.511 E0.00484

G1 X92.539 Y85.598 E0.00244

G1 X92.491 Y85.920 E0.00847

G1 X92.349 Y86.201 E0.00821

G1 X92.357 Y86.364 E0.00425

G1 X92.323 Y86.480 E0.00313

G1 X92.142 Y86.929 E0.01262

G1 X92.142 Y87.225 E0.00770

G1 X92.275 Y87.538 E0.00886

G1 X92.295 Y87.703 E0.00433

G1 X92.410 Y88.189 E0.01301

G1 X92.542 Y88.534 E0.00963

G1 X92.586 Y88.808 E0.00725

G1 X92.590 Y90.215 E0.03664

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.945 Y90.265 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.560 Y87.010

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.560 Y87.140 E0.00338

G1 X92.682 Y87.429 E0.00817

G1 X92.707 Y87.629 E0.00526

G1 X92.810 Y88.066 E0.01170

G1 X92.948 Y88.425 E0.01003

G1 X93.004 Y88.774 E0.00920

G1 X93.014 Y90.233 E0.03802

G1 X92.955 Y90.496 E0.00704

G1 X92.911 Y90.581 E0.00249

G1 X92.831 Y90.664 E0.00301

G1 X92.735 Y90.690 E0.00259

G1 X90.129 Y90.707 E0.06791

G1 X86.218 Y90.684 E0.10191

G1 X81.775 Y90.691 E0.11575

G1 X81.651 Y90.653 E0.00338

G1 X81.537 Y90.534 E0.00429

G1 X81.469 Y90.272 E0.00707

G1 X81.473 Y88.862 E0.03674

G1 X81.536 Y88.440 E0.01111

G1 X81.800 Y87.583 E0.02336

G1 X81.897 Y86.932 E0.01715

G1 X81.769 Y86.634 E0.00847

G1 X81.711 Y86.322 E0.00825

G1 X81.626 Y86.198 E0.00393

G1 X81.516 Y85.741 E0.01224

G1 X81.467 Y85.313 E0.01121

G1 X81.472 Y83.960 E0.03527

G1 X81.538 Y83.751 E0.00571

G1 X81.671 Y83.606 E0.00512

G1 X81.769 Y83.581 E0.00265

G1 X92.777 Y83.595 E0.28682

G1 X92.861 Y83.639 E0.00245

G1 X92.962 Y83.776 E0.00443

G1 X92.999 Y83.901 E0.00339

G1 X93.014 Y85.353 E0.03784

G1 X92.925 Y85.915 E0.01482

G1 X92.883 Y86.070 E0.00420

G1 X92.771 Y86.291 E0.00645

G1 X92.777 Y86.414 E0.00321

G1 X92.718 Y86.617 E0.00549

G1 X92.582 Y86.954 E0.00948

M204 S1250

G1 X92.441 Y87.061 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.560 Y87.140 E-0.10354

G1 X92.682 Y87.429 E-0.17377

G1 X92.707 Y87.629 E-0.11182

G1 X92.810 Y88.066 E-0.24879

G1 X92.948 Y88.425 E-0.21322

G1 X92.965 Y88.534 E-0.06085

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X82.783 Y84.123

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S1000

G1 X82.179 Y84.727 E0.02011

G1 X82.174 Y85.266 E0.01270

G1 X83.151 Y84.289 E0.03254

G1 X83.684 Y84.290 E0.01256

G1 X82.240 Y85.733 E0.04809

G1 X82.282 Y85.906 E0.00418

G1 X82.379 Y86.047 E0.00402

G1 X82.391 Y86.116 E0.00167

G1 X84.218 Y84.290 E0.06082

G1 X84.751 Y84.291 E0.01256

G1 X82.498 Y86.544 E0.07503

G1 X82.625 Y86.838 E0.00755

G1 X82.605 Y86.971 E0.00317

G1 X85.284 Y84.292 E0.08925

G1 X85.818 Y84.292 E0.01256

G1 X82.511 Y87.599 E0.11013

G1 X82.490 Y87.740 E0.00336

G1 X82.306 Y88.338 E0.01473

G1 X86.351 Y84.293 E0.13472

G1 X86.885 Y84.294 E0.01256

G1 X82.179 Y89.000 E0.15674

G1 X82.177 Y89.535 E0.01261

G1 X87.418 Y84.294 E0.17455

G1 X87.951 Y84.295 E0.01256

G1 X82.262 Y89.985 E0.18950

G1 X82.797 Y89.984 E0.01260

G1 X88.485 Y84.296 E0.18945

G1 X89.018 Y84.297 E0.01256

G1 X83.332 Y89.983 E0.18939

G1 X83.867 Y89.982 E0.01260

G1 X89.551 Y84.297 E0.18934

G1 X90.085 Y84.298 E0.01256

G1 X84.402 Y89.981 E0.18929

G1 X84.937 Y89.980 E0.01260

G1 X90.618 Y84.299 E0.18924

G1 X91.152 Y84.299 E0.01256

G1 X85.472 Y89.979 E0.18919

G1 X86.006 Y89.979 E0.01260

G1 X91.685 Y84.300 E0.18913

G1 X92.218 Y84.301 E0.01256

G1 X86.539 Y89.980 E0.18916

G1 X87.070 Y89.983 E0.01251

G1 X92.302 Y84.751 E0.17428

G1 X92.307 Y85.280 E0.01247

G1 X87.601 Y89.986 E0.15675

G1 X88.132 Y89.989 E0.01251

G1 X92.134 Y85.988 E0.13329

G1 X92.057 Y86.139 E0.00400

G1 X92.066 Y86.330 E0.00449

G1 X92.050 Y86.385 E0.00136

G1 X91.902 Y86.753 E0.00935

G1 X88.663 Y89.992 E0.10788

G1 X89.194 Y89.996 E0.01251

G1 X91.869 Y87.320 E0.08912

G1 X91.994 Y87.613 E0.00750

G1 X92.006 Y87.717 E0.00247

G1 X89.725 Y89.999 E0.07599

G1 X90.257 Y90.000 E0.01254

G1 X92.105 Y88.152 E0.06155

G1 X92.240 Y88.552 E0.00993

G1 X90.795 Y89.997 E0.04813

G1 X91.333 Y89.993 E0.01266

G1 X92.299 Y89.026 E0.03220

G1 X92.303 Y89.557 E0.01249

G1 X91.704 Y90.156 E0.01997

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.303 Y89.557 E-0.46991

G1 X92.299 Y89.026 E-0.29383

G1 X92.110 Y89.216 E-0.14826

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.577 Y77.275

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.128 Y77.291 E0.06380

G1 X86.218 Y77.269 E0.10188

G1 X81.901 Y77.276 E0.11249

G1 X81.887 Y77.222 E0.00146

G1 X81.891 Y75.896 E0.03455

G1 X81.945 Y75.535 E0.00950

G1 X82.208 Y74.678 E0.02336

G1 X82.327 Y73.879 E0.02106

G1 X82.171 Y73.514 E0.01034

G1 X82.106 Y73.161 E0.00936

G1 X82.014 Y73.027 E0.00422

G1 X81.928 Y72.670 E0.00956

G1 X81.885 Y72.292 E0.00992

G1 X81.898 Y71.001 E0.03364

G1 X92.584 Y71.015 E0.27844

G1 X92.596 Y72.329 E0.03424

G1 X92.573 Y72.513 E0.00484

G1 X92.539 Y72.600 E0.00244

G1 X92.491 Y72.922 E0.00847

G1 X92.349 Y73.203 E0.00821

G1 X92.357 Y73.367 E0.00426

G1 X92.323 Y73.481 E0.00312

G1 X92.142 Y73.931 E0.01263

G1 X92.142 Y74.226 E0.00770

G1 X92.275 Y74.540 E0.00888

G1 X92.295 Y74.706 E0.00435

G1 X92.410 Y75.191 E0.01299

G1 X92.542 Y75.536 E0.00962

G1 X92.586 Y75.811 E0.00725

G1 X92.590 Y77.217 E0.03664

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.945 Y77.267 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.560 Y74.012

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.560 Y74.142 E0.00339

G1 X92.682 Y74.431 E0.00818

G1 X92.707 Y74.632 E0.00527

G1 X92.810 Y75.068 E0.01167

G1 X92.948 Y75.427 E0.01002

G1 X93.004 Y75.776 E0.00920

G1 X93.014 Y77.235 E0.03803

G1 X92.955 Y77.498 E0.00703

G1 X92.911 Y77.583 E0.00249

G1 X92.831 Y77.666 E0.00301

G1 X92.735 Y77.692 E0.00259

G1 X90.129 Y77.709 E0.06791

G1 X86.218 Y77.686 E0.10191

G1 X81.775 Y77.694 E0.11575

G1 X81.651 Y77.655 E0.00339

G1 X81.537 Y77.537 E0.00429

G1 X81.469 Y77.274 E0.00708

G1 X81.473 Y75.864 E0.03673

G1 X81.536 Y75.442 E0.01112

G1 X81.800 Y74.585 E0.02336

G1 X81.897 Y73.934 E0.01715

G1 X81.769 Y73.636 E0.00847

G1 X81.711 Y73.324 E0.00826

G1 X81.626 Y73.200 E0.00392

G1 X81.516 Y72.743 E0.01225

G1 X81.467 Y72.315 E0.01122

G1 X81.472 Y70.962 E0.03527

G1 X81.538 Y70.753 E0.00571

G1 X81.671 Y70.608 E0.00512

G1 X81.769 Y70.583 E0.00265

G1 X92.777 Y70.597 E0.28682

G1 X92.861 Y70.641 E0.00245

G1 X92.961 Y70.779 E0.00446

G1 X92.999 Y70.904 E0.00340

G1 X93.014 Y72.355 E0.03782

G1 X92.925 Y72.917 E0.01483

G1 X92.883 Y73.072 E0.00419

G1 X92.771 Y73.293 E0.00645

G1 X92.777 Y73.417 E0.00322

G1 X92.718 Y73.618 E0.00548

G1 X92.582 Y73.956 E0.00949

M204 S1250

G1 X92.441 Y74.063 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.560 Y74.142 E-0.10362

G1 X92.682 Y74.431 E-0.17407

G1 X92.707 Y74.632 E-0.11199

G1 X92.810 Y75.068 E-0.24826

G1 X92.948 Y75.427 E-0.21319

G1 X92.965 Y75.536 E-0.06087

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X82.783 Y71.125

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S1000

G1 X82.179 Y71.729 E0.02011

G1 X82.174 Y72.268 E0.01270

G1 X83.151 Y71.291 E0.03254

G1 X83.684 Y71.292 E0.01256

G1 X82.240 Y72.735 E0.04809

G1 X82.282 Y72.907 E0.00417

G1 X82.378 Y73.048 E0.00401

G1 X82.391 Y73.118 E0.00169

G1 X84.218 Y71.292 E0.06082

G1 X84.751 Y71.293 E0.01256

G1 X82.498 Y73.546 E0.07503

G1 X82.625 Y73.840 E0.00755

G1 X82.605 Y73.973 E0.00317

G1 X85.284 Y71.294 E0.08924

G1 X85.818 Y71.294 E0.01256

G1 X82.511 Y74.601 E0.11013

G1 X82.490 Y74.742 E0.00336

G1 X82.306 Y75.340 E0.01473

G1 X86.351 Y71.295 E0.13472

G1 X86.885 Y71.296 E0.01256

G1 X82.179 Y76.002 E0.15674

G1 X82.177 Y76.537 E0.01261

G1 X87.418 Y71.296 E0.17455

G1 X87.951 Y71.297 E0.01256

G1 X82.261 Y76.987 E0.18951

G1 X82.796 Y76.986 E0.01260

G1 X88.485 Y71.298 E0.18946

G1 X89.018 Y71.299 E0.01256

G1 X83.331 Y76.985 E0.18941

G1 X83.866 Y76.984 E0.01260

G1 X89.551 Y71.299 E0.18935

G1 X90.085 Y71.300 E0.01256

G1 X84.401 Y76.983 E0.18930

G1 X84.936 Y76.982 E0.01260

G1 X90.618 Y71.301 E0.18924

G1 X91.152 Y71.301 E0.01256

G1 X85.471 Y76.981 E0.18919

G1 X86.006 Y76.981 E0.01260

G1 X91.685 Y71.302 E0.18914

G1 X92.218 Y71.303 E0.01256

G1 X86.539 Y76.982 E0.18916

G1 X87.070 Y76.985 E0.01251

G1 X92.302 Y71.753 E0.17428

G1 X92.307 Y72.282 E0.01246

G1 X87.601 Y76.988 E0.15675

G1 X88.132 Y76.991 E0.01251

G1 X92.134 Y72.990 E0.13329

G1 X92.057 Y73.141 E0.00400

G1 X92.066 Y73.332 E0.00450

G1 X92.050 Y73.387 E0.00135

G1 X91.902 Y73.755 E0.00935

G1 X88.663 Y76.994 E0.10788

G1 X89.194 Y76.998 E0.01251

G1 X91.869 Y74.322 E0.08912

G1 X91.993 Y74.616 E0.00751

G1 X92.006 Y74.719 E0.00246

G1 X89.725 Y77.001 E0.07599

G1 X90.257 Y77.002 E0.01254

G1 X92.105 Y75.154 E0.06155

G1 X92.240 Y75.554 E0.00992

G1 X90.795 Y76.999 E0.04813

G1 X91.333 Y76.995 E0.01266

G1 X92.299 Y76.028 E0.03220

G1 X92.303 Y76.559 E0.01249

G1 X91.704 Y77.158 E0.01997

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.303 Y76.559 E-0.46991

G1 X92.299 Y76.028 E-0.29384

G1 X92.110 Y76.218 E-0.14826

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.577 Y64.277

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.128 Y64.293 E0.06381

G1 X86.218 Y64.271 E0.10188

G1 X81.901 Y64.278 E0.11249

G1 X81.887 Y64.224 E0.00146

G1 X81.891 Y62.898 E0.03453

G1 X81.945 Y62.537 E0.00952

G1 X82.208 Y61.680 E0.02336

G1 X82.327 Y60.881 E0.02106

G1 X82.171 Y60.516 E0.01034

G1 X82.106 Y60.163 E0.00936

G1 X82.014 Y60.029 E0.00422

G1 X81.928 Y59.672 E0.00956

G1 X81.885 Y59.294 E0.00991

G1 X81.898 Y58.003 E0.03365

G1 X92.584 Y58.017 E0.27844

G1 X92.596 Y59.332 E0.03427

G1 X92.574 Y59.516 E0.00483

G1 X92.539 Y59.602 E0.00243

G1 X92.491 Y59.924 E0.00847

G1 X92.349 Y60.205 E0.00821

G1 X92.357 Y60.368 E0.00426

G1 X92.323 Y60.483 E0.00312

G1 X92.142 Y60.933 E0.01263

G1 X92.142 Y61.228 E0.00770

G1 X92.275 Y61.542 E0.00888

G1 X92.295 Y61.708 E0.00435

G1 X92.410 Y62.194 E0.01301

G1 X92.542 Y62.538 E0.00961

G1 X92.586 Y62.813 E0.00724

G1 X92.590 Y64.219 E0.03664

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.945 Y64.269 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.560 Y61.014

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.560 Y61.144 E0.00339

G1 X92.682 Y61.433 E0.00818

G1 X92.707 Y61.634 E0.00526

G1 X92.810 Y62.070 E0.01169

G1 X92.948 Y62.429 E0.01001

G1 X93.004 Y62.778 E0.00920

G1 X93.014 Y64.237 E0.03803

G1 X92.955 Y64.501 E0.00705

G1 X92.911 Y64.586 E0.00249

G1 X92.831 Y64.668 E0.00299

G1 X92.735 Y64.694 E0.00259

G1 X90.129 Y64.711 E0.06791

G1 X86.218 Y64.689 E0.10191

G1 X81.775 Y64.696 E0.11574

G1 X81.651 Y64.657 E0.00339

G1 X81.537 Y64.539 E0.00429

G1 X81.469 Y64.276 E0.00708

G1 X81.473 Y62.867 E0.03671

G1 X81.536 Y62.444 E0.01113

G1 X81.800 Y61.587 E0.02336

G1 X81.897 Y60.936 E0.01715

G1 X81.769 Y60.638 E0.00847

G1 X81.711 Y60.326 E0.00826

G1 X81.626 Y60.202 E0.00392

G1 X81.516 Y59.745 E0.01225

G1 X81.467 Y59.318 E0.01120

G1 X81.472 Y57.964 E0.03528

G1 X81.538 Y57.755 E0.00571

G1 X81.671 Y57.610 E0.00512

G1 X81.769 Y57.585 E0.00265

G1 X92.777 Y57.599 E0.28682

G1 X92.861 Y57.643 E0.00245

G1 X92.961 Y57.781 E0.00445

G1 X92.999 Y57.906 E0.00340

G1 X93.014 Y59.358 E0.03784

G1 X92.925 Y59.919 E0.01480

G1 X92.883 Y60.074 E0.00419

G1 X92.771 Y60.295 E0.00645

G1 X92.777 Y60.419 E0.00322

G1 X92.718 Y60.620 E0.00548

G1 X92.582 Y60.958 E0.00949

M204 S1250

G1 X92.441 Y61.065 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.560 Y61.144 E-0.10362

G1 X92.682 Y61.433 E-0.17407

G1 X92.707 Y61.634 E-0.11197

G1 X92.810 Y62.070 E-0.24862

G1 X92.948 Y62.429 E-0.21290

G1 X92.965 Y62.538 E-0.06083

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X82.783 Y58.127

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S1000

G1 X82.179 Y58.731 E0.02011

G1 X82.174 Y59.270 E0.01270

G1 X83.151 Y58.293 E0.03254

G1 X83.684 Y58.294 E0.01256

G1 X82.240 Y59.737 E0.04809

G1 X82.282 Y59.909 E0.00417

G1 X82.378 Y60.050 E0.00401

G1 X82.391 Y60.120 E0.00169

G1 X84.218 Y58.294 E0.06082

G1 X84.751 Y58.295 E0.01256

G1 X82.498 Y60.548 E0.07503

G1 X82.625 Y60.842 E0.00755

G1 X82.605 Y60.975 E0.00317

G1 X85.284 Y58.296 E0.08924

G1 X85.818 Y58.296 E0.01256

G1 X82.511 Y61.603 E0.11013

G1 X82.490 Y61.744 E0.00336

G1 X82.306 Y62.342 E0.01473

G1 X86.351 Y58.297 E0.13472

G1 X86.885 Y58.298 E0.01256

G1 X82.179 Y63.004 E0.15674

G1 X82.177 Y63.539 E0.01261

G1 X87.418 Y58.298 E0.17455

G1 X87.951 Y58.299 E0.01256

G1 X82.261 Y63.989 E0.18951

G1 X82.796 Y63.988 E0.01260

G1 X88.485 Y58.300 E0.18946

G1 X89.018 Y58.301 E0.01256

G1 X83.331 Y63.987 E0.18941

G1 X83.866 Y63.987 E0.01260

G1 X89.551 Y58.301 E0.18936

G1 X90.085 Y58.302 E0.01256

G1 X84.401 Y63.986 E0.18931

G1 X84.936 Y63.985 E0.01260

G1 X90.618 Y58.303 E0.18926

G1 X91.152 Y58.303 E0.01256

G1 X85.471 Y63.984 E0.18920

G1 X86.006 Y63.983 E0.01260

G1 X91.685 Y58.304 E0.18915

G1 X92.218 Y58.305 E0.01256

G1 X86.538 Y63.985 E0.18918

G1 X87.070 Y63.988 E0.01251

G1 X92.302 Y58.755 E0.17429

G1 X92.307 Y59.284 E0.01246

G1 X87.601 Y63.991 E0.15676

G1 X88.132 Y63.994 E0.01251

G1 X92.134 Y59.992 E0.13330

G1 X92.057 Y60.143 E0.00400

G1 X92.066 Y60.334 E0.00450

G1 X92.050 Y60.389 E0.00135

G1 X91.902 Y60.757 E0.00935

G1 X88.663 Y63.997 E0.10789

G1 X89.194 Y64.000 E0.01251

G1 X91.869 Y61.324 E0.08912

G1 X91.993 Y61.618 E0.00751

G1 X92.006 Y61.721 E0.00246

G1 X89.725 Y64.003 E0.07599

G1 X90.257 Y64.004 E0.01254

G1 X92.105 Y62.156 E0.06154

G1 X92.240 Y62.556 E0.00992

G1 X90.795 Y64.001 E0.04813

G1 X91.333 Y63.997 E0.01266

G1 X92.299 Y63.030 E0.03220

G1 X92.303 Y63.561 E0.01249

G1 X91.704 Y64.160 E0.01997

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.303 Y63.561 E-0.46991

G1 X92.299 Y63.030 E-0.29383

G1 X92.110 Y63.220 E-0.14826

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.577 Y51.280

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.128 Y51.296 E0.06381

G1 X86.219 Y51.273 E0.10188

G1 X81.901 Y51.280 E0.11250

G1 X81.887 Y51.226 E0.00146

G1 X81.891 Y49.900 E0.03453

G1 X81.945 Y49.539 E0.00952

G1 X82.208 Y48.682 E0.02336

G1 X82.328 Y47.882 E0.02108

G1 X82.171 Y47.519 E0.01031

G1 X82.106 Y47.165 E0.00938

G1 X82.014 Y47.031 E0.00423

G1 X81.928 Y46.674 E0.00956

G1 X81.885 Y46.296 E0.00991

G1 X81.898 Y45.005 E0.03365

G1 X92.584 Y45.019 E0.27845

G1 X92.596 Y46.334 E0.03427

G1 X92.573 Y46.518 E0.00484

G1 X92.539 Y46.605 E0.00243

G1 X92.491 Y46.927 E0.00847

G1 X92.349 Y47.208 E0.00821

G1 X92.357 Y47.371 E0.00425

G1 X92.323 Y47.485 E0.00311

G1 X92.142 Y47.935 E0.01263

G1 X92.142 Y48.230 E0.00770

G1 X92.275 Y48.544 E0.00888

G1 X92.295 Y48.710 E0.00434

G1 X92.410 Y49.196 E0.01302

G1 X92.542 Y49.540 E0.00960

G1 X92.586 Y49.815 E0.00726

G1 X92.590 Y51.221 E0.03663

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.945 Y51.271 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X92.560 Y48.016

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.560 Y48.146 E0.00339

G1 X92.682 Y48.435 E0.00819

G1 X92.707 Y48.636 E0.00526

G1 X92.810 Y49.073 E0.01170

G1 X92.948 Y49.431 E0.01001

G1 X93.004 Y49.781 E0.00921

G1 X93.014 Y51.239 E0.03801

G1 X92.955 Y51.503 E0.00705

G1 X92.911 Y51.588 E0.00248

G1 X92.831 Y51.670 E0.00300

G1 X92.735 Y51.696 E0.00259

G1 X90.129 Y51.714 E0.06791

G1 X86.218 Y51.691 E0.10191

G1 X81.775 Y51.698 E0.11575

G1 X81.651 Y51.659 E0.00339

G1 X81.537 Y51.541 E0.00428

G1 X81.469 Y51.278 E0.00708

G1 X81.473 Y49.869 E0.03671

G1 X81.536 Y49.446 E0.01113

G1 X81.800 Y48.589 E0.02336

G1 X81.897 Y47.938 E0.01716

G1 X81.769 Y47.640 E0.00844

G1 X81.711 Y47.328 E0.00828

G1 X81.626 Y47.204 E0.00392

G1 X81.516 Y46.747 E0.01225

G1 X81.467 Y46.320 E0.01120

G1 X81.472 Y44.966 E0.03528

G1 X81.538 Y44.757 E0.00570

G1 X81.671 Y44.612 E0.00512

G1 X81.769 Y44.587 E0.00265

G1 X92.777 Y44.601 E0.28683

G1 X92.861 Y44.645 E0.00245

G1 X92.961 Y44.783 E0.00445

G1 X92.999 Y44.908 E0.00340

G1 X93.014 Y46.360 E0.03784

G1 X92.925 Y46.921 E0.01480

G1 X92.883 Y47.077 E0.00421

G1 X92.771 Y47.298 E0.00644

G1 X92.777 Y47.421 E0.00321

G1 X92.718 Y47.622 E0.00547

G1 X92.582 Y47.960 E0.00949

M204 S1250

G1 X92.441 Y48.067 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.560 Y48.146 E-0.10360

G1 X92.682 Y48.435 E-0.17416

G1 X92.707 Y48.636 E-0.11189

G1 X92.810 Y49.073 E-0.24883

G1 X92.948 Y49.431 E-0.21283

G1 X92.965 Y49.540 E-0.06069

G1 E-0.04800 F4200.00000

G1 Z4.450 F9000.000

G1 X82.783 Y45.129

G1 Z4.250

G1 E3.20000 F2400.00000

M204 S1000

G1 X82.179 Y45.733 E0.02011

G1 X82.174 Y46.272 E0.01270

G1 X83.151 Y45.295 E0.03254

G1 X83.684 Y45.296 E0.01256

G1 X82.240 Y46.739 E0.04809

G1 X82.282 Y46.911 E0.00417

G1 X82.379 Y47.052 E0.00402

G1 X82.392 Y47.122 E0.00169

G1 X84.218 Y45.296 E0.06082

G1 X84.751 Y45.297 E0.01256

G1 X82.498 Y47.550 E0.07503

G1 X82.625 Y47.843 E0.00753

G1 X82.605 Y47.977 E0.00319

G1 X85.284 Y45.298 E0.08925

G1 X85.818 Y45.298 E0.01256

G1 X82.511 Y48.605 E0.11013

G1 X82.490 Y48.746 E0.00336

G1 X82.306 Y49.344 E0.01473

G1 X86.351 Y45.299 E0.13472

G1 X86.885 Y45.300 E0.01256

G1 X82.179 Y50.006 E0.15674

G1 X82.177 Y50.541 E0.01261

G1 X87.418 Y45.301 E0.17455

G1 X87.951 Y45.301 E0.01256

G1 X82.261 Y50.991 E0.18951

G1 X82.796 Y50.990 E0.01260

G1 X88.485 Y45.302 E0.18946

G1 X89.018 Y45.303 E0.01256

G1 X83.331 Y50.989 E0.18941

G1 X83.866 Y50.989 E0.01260

G1 X89.552 Y45.303 E0.18936

G1 X90.085 Y45.304 E0.01256

G1 X84.401 Y50.988 E0.18931

G1 X84.936 Y50.987 E0.01260

G1 X90.618 Y45.305 E0.18926

G1 X91.152 Y45.305 E0.01256

G1 X85.471 Y50.986 E0.18921

G1 X86.006 Y50.985 E0.01260

G1 X91.685 Y45.306 E0.18915

G1 X92.219 Y45.307 E0.01256

G1 X86.539 Y50.987 E0.18918

G1 X87.070 Y50.990 E0.01251

G1 X92.302 Y45.757 E0.17429

G1 X92.307 Y46.286 E0.01247

G1 X87.601 Y50.993 E0.15677

G1 X88.132 Y50.996 E0.01251

G1 X92.134 Y46.993 E0.13332

G1 X92.057 Y47.146 E0.00403

G1 X92.066 Y47.336 E0.00448

G1 X92.050 Y47.391 E0.00134

G1 X91.902 Y47.760 E0.00937

G1 X88.662 Y50.999 E0.10789

G1 X89.193 Y51.002 E0.01251

G1 X91.870 Y48.326 E0.08913

G1 X91.993 Y48.620 E0.00750

G1 X92.006 Y48.723 E0.00246

G1 X89.724 Y51.005 E0.07600

G1 X90.257 Y51.007 E0.01254

G1 X92.105 Y49.159 E0.06156

G1 X92.240 Y49.558 E0.00992

G1 X90.795 Y51.003 E0.04814

G1 X91.332 Y51.000 E0.01266

G1 X92.299 Y50.033 E0.03221

G1 X92.303 Y50.563 E0.01249

G1 X91.703 Y51.163 E0.01998

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;4.4

G1 Z4.400 F9000.000

;AFTER\_LAYER\_CHANGE

;4.4

G1 E-3.20000 F4200.00000

G1 Z4.600 F9000.000

G1 X92.470 Y46.583

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.042 Y46.583 E0.27170

G1 X81.939 Y46.380 E0.00593

G1 X81.889 Y46.095 E0.00755

G1 X81.896 Y44.887 E0.03148

G1 X87.597 Y44.906 E0.14854

G1 X92.585 Y44.890 E0.12996

G1 X92.596 Y46.106 E0.03169

G1 X92.549 Y46.359 E0.00672

G1 X92.485 Y46.525 E0.00462

M204 S1250

G1 X92.759 Y46.948 F9000.000

M204 S800

G1 F1500.000

G1 X92.676 Y47.001 E0.00257

G1 X81.811 Y47.001 E0.28309

G1 X81.708 Y46.891 E0.00391

G1 X81.657 Y46.747 E0.00400

G1 X81.534 Y46.506 E0.00704

G1 X81.471 Y46.136 E0.00977

G1 X81.479 Y44.794 E0.03498

G1 X81.558 Y44.595 E0.00558

G1 X81.662 Y44.490 E0.00384

G1 X81.765 Y44.468 E0.00273

G1 X87.597 Y44.488 E0.15197

G1 X92.714 Y44.472 E0.13332

G1 X92.831 Y44.501 E0.00315

G1 X92.952 Y44.654 E0.00508

G1 X93.001 Y44.779 E0.00350

G1 X93.013 Y46.128 E0.03516

G1 X92.942 Y46.514 E0.01023

G1 X92.903 Y46.580 E0.00199

G1 X92.853 Y46.764 E0.00496

G1 X92.786 Y46.895 E0.00382

M204 S1250

G1 X92.664 Y46.922 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.676 Y47.001 E-0.08493

G1 X91.183 Y47.001 E-0.82707

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.975 Y46.458

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y45.688 E0.02847

G1 X82.208 Y45.201 E0.01273

G1 X82.311 Y45.201 E0.00271

G1 X83.380 Y46.270 E0.03951

G1 X83.973 Y46.270 E0.01550

G1 X82.906 Y45.203 E0.03944

G1 X83.501 Y45.205 E0.01556

G1 X84.566 Y46.270 E0.03936

G1 X85.158 Y46.270 E0.01550

G1 X84.096 Y45.207 E0.03929

G1 X84.691 Y45.209 E0.01556

G1 X85.751 Y46.270 E0.03921

G1 X86.344 Y46.270 E0.01550

G1 X85.286 Y45.211 E0.03914

G1 X85.881 Y45.213 E0.01556

G1 X86.937 Y46.270 E0.03907

G1 X87.530 Y46.270 E0.01550

G1 X86.476 Y45.215 E0.03899

G1 X87.071 Y45.217 E0.01556

G1 X88.123 Y46.270 E0.03892

G1 X88.716 Y46.270 E0.01550

G1 X87.665 Y45.219 E0.03886

G1 X88.256 Y45.217 E0.01545

G1 X89.309 Y46.270 E0.03893

G1 X89.902 Y46.270 E0.01550

G1 X88.847 Y45.215 E0.03900

G1 X89.438 Y45.213 E0.01545

G1 X90.495 Y46.270 E0.03907

G1 X91.088 Y46.270 E0.01550

G1 X90.030 Y45.211 E0.03914

G1 X90.621 Y45.209 E0.01545

G1 X91.681 Y46.270 E0.03921

G1 X92.247 Y46.270 E0.01479

G1 X92.251 Y46.247 E0.00061

G1 X91.212 Y45.208 E0.03843

G1 X91.803 Y45.206 E0.01545

G1 X92.468 Y45.871 E0.02461

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.803 Y45.206 E-0.52154

G1 X91.212 Y45.208 E-0.32755

G1 X91.292 Y45.288 E-0.06291

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.430 Y49.704

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.569 Y50.011 E0.00879

G1 X92.588 Y50.097 E0.00230

G1 X92.597 Y51.332 E0.03217

G1 X92.583 Y51.394 E0.00166

G1 X88.070 Y51.420 E0.11758

G1 X81.891 Y51.413 E0.16101

G1 X81.886 Y51.381 E0.00085

G1 X81.895 Y50.105 E0.03324

G1 X81.928 Y49.945 E0.00426

G1 X82.028 Y49.887 E0.00300

G1 X82.086 Y49.652 E0.00632

G1 X91.268 Y49.726 E0.23927

G1 X92.370 Y49.707 E0.02870

M204 S1250

G1 X92.601 Y49.276 F9000.000

M204 S800

G1 F1500.000

G1 X92.748 Y49.357 E0.00438

G1 X92.863 Y49.675 E0.00880

G1 X92.965 Y49.865 E0.00561

G1 X93.006 Y50.050 E0.00494

G1 X93.015 Y51.377 E0.03459

G1 X92.957 Y51.631 E0.00679

G1 X92.899 Y51.740 E0.00321

G1 X92.836 Y51.790 E0.00210

G1 X92.721 Y51.811 E0.00306

G1 X88.071 Y51.838 E0.12114

G1 X81.780 Y51.830 E0.16392

G1 X81.639 Y51.780 E0.00391

G1 X81.531 Y51.672 E0.00397

G1 X81.498 Y51.596 E0.00218

G1 X81.468 Y51.415 E0.00478

G1 X81.478 Y50.071 E0.03502

G1 X81.566 Y49.690 E0.01018

G1 X81.665 Y49.615 E0.00324

G1 X81.724 Y49.372 E0.00651

G1 X81.757 Y49.307 E0.00192

G1 X81.833 Y49.232 E0.00276

G1 X91.267 Y49.308 E0.24583

G1 X92.541 Y49.280 E0.03319

M204 S1250

G1 X92.632 Y49.442 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.748 Y49.357 E-0.12277

G1 X92.863 Y49.675 E-0.18716

G1 X92.965 Y49.865 E-0.11931

G1 X93.006 Y50.050 E-0.10505

G1 X93.011 Y50.731 E-0.37771

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.866 Y51.289

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y50.630 E0.02438

G1 X82.208 Y50.145 E0.01268

G1 X82.276 Y50.106 E0.00205

G1 X83.272 Y51.101 E0.03683

G1 X83.866 Y51.102 E0.01554

G1 X82.734 Y49.970 E0.04186

G1 X83.332 Y49.975 E0.01565

G1 X84.460 Y51.102 E0.04171

G1 X85.054 Y51.103 E0.01554

G1 X83.930 Y49.980 E0.04156

G1 X84.528 Y49.985 E0.01565

G1 X85.648 Y51.104 E0.04141

G1 X86.242 Y51.105 E0.01554

G1 X85.127 Y49.990 E0.04126

G1 X85.725 Y49.994 E0.01565

G1 X86.836 Y51.105 E0.04111

G1 X87.430 Y51.106 E0.01554

G1 X86.323 Y49.999 E0.04095

G1 X86.921 Y50.004 E0.01565

G1 X88.024 Y51.107 E0.04080

G1 X88.614 Y51.104 E0.01544

G1 X87.519 Y50.009 E0.04051

G1 X88.117 Y50.014 E0.01565

G1 X89.204 Y51.100 E0.04020

G1 X89.793 Y51.097 E0.01543

G1 X88.715 Y50.018 E0.03990

G1 X89.313 Y50.023 E0.01565

G1 X90.383 Y51.093 E0.03959

G1 X90.973 Y51.090 E0.01543

G1 X89.911 Y50.028 E0.03929

G1 X90.509 Y50.033 E0.01565

G1 X91.563 Y51.086 E0.03898

G1 X92.153 Y51.083 E0.01543

G1 X91.108 Y50.038 E0.03867

G1 X91.694 Y50.031 E0.01535

G1 X92.468 Y50.805 E0.02863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.694 Y50.031 E-0.60637

G1 X91.143 Y50.037 E-0.30563

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.491 Y57.888

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.585 Y57.888 E0.00245

G1 X92.596 Y59.104 E0.03169

G1 X92.549 Y59.357 E0.00671

G1 X92.469 Y59.581 E0.00619

G1 X82.042 Y59.581 E0.27169

G1 X81.939 Y59.378 E0.00593

G1 X81.889 Y59.093 E0.00755

G1 X81.896 Y57.884 E0.03150

G1 X87.597 Y57.904 E0.14854

G1 X92.431 Y57.888 E0.12594

M204 S1250

G1 X92.917 Y57.622 F9000.000

M204 S800

G1 F1500.000

G1 X92.953 Y57.652 E0.00121

G1 X93.001 Y57.777 E0.00348

G1 X93.013 Y59.126 E0.03517

G1 X92.942 Y59.512 E0.01022

G1 X92.904 Y59.578 E0.00198

G1 X92.853 Y59.761 E0.00495

G1 X92.759 Y59.946 E0.00540

G1 X92.675 Y59.999 E0.00258

G1 X81.811 Y59.999 E0.28308

G1 X81.708 Y59.889 E0.00391

G1 X81.657 Y59.745 E0.00400

G1 X81.534 Y59.504 E0.00704

G1 X81.471 Y59.134 E0.00977

G1 X81.479 Y57.791 E0.03500

G1 X81.558 Y57.593 E0.00556

G1 X81.663 Y57.488 E0.00385

G1 X81.765 Y57.466 E0.00273

G1 X87.597 Y57.486 E0.15196

G1 X92.714 Y57.470 E0.13332

G1 X92.831 Y57.499 E0.00315

G1 X92.883 Y57.573 E0.00235

M204 S1250

G1 X92.910 Y57.668 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.953 Y57.652 E-0.05841

G1 X93.001 Y57.777 E-0.07408

G1 X93.013 Y59.126 E-0.74805

G1 X93.003 Y59.182 E-0.03146

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.975 Y59.456

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y58.686 E0.02847

G1 X82.208 Y58.198 E0.01274

G1 X82.311 Y58.199 E0.00270

G1 X83.380 Y59.268 E0.03953

G1 X83.973 Y59.268 E0.01550

G1 X82.906 Y58.201 E0.03945

G1 X83.501 Y58.203 E0.01556

G1 X84.566 Y59.268 E0.03938

G1 X85.158 Y59.268 E0.01550

G1 X84.096 Y58.205 E0.03930

G1 X84.691 Y58.207 E0.01556

G1 X85.751 Y59.268 E0.03922

M73 P51 R34

G1 X86.344 Y59.268 E0.01550

G1 X85.286 Y58.209 E0.03915

G1 X85.881 Y58.211 E0.01556

G1 X86.937 Y59.268 E0.03907

G1 X87.530 Y59.268 E0.01550

G1 X86.476 Y58.213 E0.03899

G1 X87.071 Y58.215 E0.01556

G1 X88.123 Y59.268 E0.03892

G1 X88.716 Y59.268 E0.01550

G1 X87.665 Y58.217 E0.03886

G1 X88.256 Y58.215 E0.01545

G1 X89.309 Y59.268 E0.03893

G1 X89.902 Y59.268 E0.01550

G1 X88.847 Y58.213 E0.03900

G1 X89.439 Y58.211 E0.01545

G1 X90.495 Y59.268 E0.03907

G1 X91.088 Y59.268 E0.01550

G1 X90.030 Y58.209 E0.03914

G1 X90.621 Y58.207 E0.01545

G1 X91.681 Y59.268 E0.03921

G1 X92.247 Y59.268 E0.01479

G1 X92.251 Y59.245 E0.00061

G1 X91.212 Y58.206 E0.03843

G1 X91.803 Y58.204 E0.01545

G1 X92.468 Y58.869 E0.02461

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.803 Y58.204 E-0.52153

G1 X91.212 Y58.206 E-0.32755

G1 X91.292 Y58.286 E-0.06292

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.429 Y62.701

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.569 Y63.009 E0.00882

G1 X92.588 Y63.095 E0.00228

G1 X92.597 Y64.330 E0.03217

G1 X92.583 Y64.392 E0.00166

G1 X88.070 Y64.418 E0.11758

G1 X81.891 Y64.411 E0.16101

G1 X81.886 Y64.379 E0.00085

G1 X81.895 Y63.103 E0.03324

G1 X81.928 Y62.945 E0.00420

G1 X82.027 Y62.889 E0.00298

G1 X82.086 Y62.650 E0.00641

G1 X91.268 Y62.723 E0.23927

G1 X92.369 Y62.704 E0.02869

M204 S1250

G1 X92.601 Y62.273 F9000.000

M204 S800

G1 F1500.000

G1 X92.748 Y62.355 E0.00438

G1 X92.863 Y62.673 E0.00881

G1 X92.965 Y62.863 E0.00561

G1 X93.006 Y63.047 E0.00493

G1 X93.015 Y64.375 E0.03460

G1 X92.957 Y64.629 E0.00678

G1 X92.899 Y64.738 E0.00323

G1 X92.836 Y64.788 E0.00209

G1 X92.721 Y64.809 E0.00306

G1 X88.071 Y64.835 E0.12114

G1 X81.780 Y64.828 E0.16392

G1 X81.639 Y64.778 E0.00391

G1 X81.531 Y64.670 E0.00397

G1 X81.498 Y64.594 E0.00218

G1 X81.468 Y64.413 E0.00478

G1 X81.478 Y63.069 E0.03502

G1 X81.566 Y62.688 E0.01019

G1 X81.664 Y62.614 E0.00321

G1 X81.724 Y62.370 E0.00654

G1 X81.757 Y62.305 E0.00192

G1 X81.833 Y62.230 E0.00276

G1 X91.267 Y62.305 E0.24583

G1 X92.541 Y62.277 E0.03320

M204 S1250

G1 X92.632 Y62.439 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.748 Y62.355 E-0.12256

G1 X92.863 Y62.673 E-0.18745

G1 X92.965 Y62.863 E-0.11934

G1 X93.006 Y63.047 E-0.10475

G1 X93.011 Y63.729 E-0.37790

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.866 Y64.287

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y63.628 E0.02438

G1 X82.208 Y63.146 E0.01260

G1 X82.279 Y63.106 E0.00212

G1 X83.272 Y64.099 E0.03673

G1 X83.866 Y64.100 E0.01554

G1 X82.734 Y62.968 E0.04186

G1 X83.332 Y62.973 E0.01565

G1 X84.460 Y64.100 E0.04171

G1 X85.053 Y64.101 E0.01554

G1 X83.930 Y62.978 E0.04156

G1 X84.528 Y62.983 E0.01565

G1 X85.647 Y64.102 E0.04141

G1 X86.241 Y64.102 E0.01554

G1 X85.126 Y62.987 E0.04126

G1 X85.725 Y62.992 E0.01565

G1 X86.835 Y64.103 E0.04110

G1 X87.429 Y64.104 E0.01554

G1 X86.323 Y62.997 E0.04095

G1 X86.921 Y63.001 E0.01565

G1 X88.023 Y64.104 E0.04080

G1 X88.614 Y64.101 E0.01544

G1 X87.519 Y63.006 E0.04051

G1 X88.117 Y63.011 E0.01565

G1 X89.204 Y64.098 E0.04021

G1 X89.794 Y64.094 E0.01544

G1 X88.715 Y63.016 E0.03991

G1 X89.313 Y63.020 E0.01565

G1 X90.383 Y64.091 E0.03961

G1 X90.973 Y64.088 E0.01544

G1 X89.911 Y63.025 E0.03931

G1 X90.509 Y63.030 E0.01565

G1 X91.563 Y64.084 E0.03901

G1 X92.153 Y64.081 E0.01544

G1 X91.107 Y63.035 E0.03870

G1 X91.694 Y63.028 E0.01535

G1 X92.468 Y63.802 E0.02864

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.694 Y63.028 E-0.60665

G1 X91.143 Y63.034 E-0.30535

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.491 Y70.886

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.585 Y70.886 E0.00245

G1 X92.596 Y72.101 E0.03167

G1 X92.549 Y72.354 E0.00671

G1 X92.469 Y72.579 E0.00621

G1 X82.042 Y72.579 E0.27169

G1 X81.939 Y72.376 E0.00593

G1 X81.889 Y72.090 E0.00757

G1 X81.896 Y70.882 E0.03147

G1 X87.597 Y70.902 E0.14854

G1 X92.431 Y70.886 E0.12595

M204 S1250

G1 X92.917 Y70.619 F9000.000

M204 S800

G1 F1500.000

G1 X92.952 Y70.649 E0.00122

G1 X93.001 Y70.775 E0.00350

G1 X93.013 Y72.123 E0.03515

G1 X92.942 Y72.509 E0.01023

G1 X92.904 Y72.575 E0.00199

G1 X92.853 Y72.759 E0.00497

G1 X92.759 Y72.944 E0.00540

G1 X92.675 Y72.997 E0.00258

G1 X81.811 Y72.997 E0.28308

G1 X81.708 Y72.887 E0.00391

G1 X81.657 Y72.743 E0.00400

G1 X81.534 Y72.502 E0.00705

G1 X81.471 Y72.131 E0.00978

G1 X81.479 Y70.789 E0.03498

G1 X81.558 Y70.591 E0.00556

G1 X81.663 Y70.486 E0.00385

G1 X81.765 Y70.464 E0.00273

G1 X87.597 Y70.484 E0.15196

G1 X92.714 Y70.467 E0.13334

G1 X92.831 Y70.496 E0.00314

G1 X92.882 Y70.570 E0.00234

M204 S1250

G1 X92.909 Y70.666 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.952 Y70.649 E-0.05866

G1 X93.001 Y70.775 E-0.07435

G1 X93.013 Y72.123 E-0.74753

G1 X93.003 Y72.179 E-0.03145

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.975 Y72.454

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y71.684 E0.02847

G1 X82.208 Y71.196 E0.01274

G1 X82.311 Y71.197 E0.00270

G1 X83.380 Y72.266 E0.03953

G1 X83.973 Y72.266 E0.01550

G1 X82.906 Y71.199 E0.03945

G1 X83.501 Y71.201 E0.01556

G1 X84.566 Y72.266 E0.03938

G1 X85.159 Y72.266 E0.01550

G1 X84.096 Y71.203 E0.03930

G1 X84.691 Y71.205 E0.01556

G1 X85.751 Y72.266 E0.03922

G1 X86.344 Y72.266 E0.01550

G1 X85.286 Y71.207 E0.03915

G1 X85.881 Y71.209 E0.01556

G1 X86.937 Y72.266 E0.03907

G1 X87.530 Y72.266 E0.01550

G1 X86.476 Y71.211 E0.03899

G1 X87.071 Y71.213 E0.01556

G1 X88.123 Y72.266 E0.03892

G1 X88.716 Y72.266 E0.01550

G1 X87.665 Y71.215 E0.03886

G1 X88.256 Y71.213 E0.01545

G1 X89.309 Y72.266 E0.03893

G1 X89.902 Y72.266 E0.01550

G1 X88.847 Y71.211 E0.03900

G1 X89.439 Y71.209 E0.01545

G1 X90.495 Y72.266 E0.03907

G1 X91.088 Y72.266 E0.01550

G1 X90.030 Y71.207 E0.03914

G1 X90.621 Y71.205 E0.01545

G1 X91.681 Y72.266 E0.03921

G1 X92.246 Y72.266 E0.01478

G1 X92.251 Y72.243 E0.00062

G1 X91.212 Y71.203 E0.03842

G1 X91.803 Y71.202 E0.01545

G1 X92.468 Y71.867 E0.02461

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.803 Y71.202 E-0.52153

G1 X91.212 Y71.203 E-0.32754

G1 X91.292 Y71.284 E-0.06293

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.430 Y75.699

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.569 Y76.006 E0.00879

G1 X92.588 Y76.093 E0.00230

G1 X92.597 Y77.327 E0.03218

G1 X92.583 Y77.390 E0.00166

G1 X88.070 Y77.415 E0.11758

G1 X81.891 Y77.409 E0.16101

G1 X81.886 Y77.377 E0.00085

G1 X81.895 Y76.101 E0.03324

G1 X81.928 Y75.943 E0.00420

G1 X82.027 Y75.887 E0.00298

G1 X82.086 Y75.647 E0.00642

G1 X91.268 Y75.721 E0.23926

G1 X92.370 Y75.702 E0.02870

M204 S1250

G1 X92.601 Y75.271 F9000.000

M204 S800

G1 F1500.000

G1 X92.748 Y75.352 E0.00438

G1 X92.863 Y75.670 E0.00880

G1 X92.965 Y75.860 E0.00562

G1 X93.006 Y76.045 E0.00494

G1 X93.015 Y77.373 E0.03460

G1 X92.957 Y77.626 E0.00677

G1 X92.899 Y77.735 E0.00322

G1 X92.836 Y77.786 E0.00211

G1 X92.720 Y77.807 E0.00306

G1 X88.071 Y77.833 E0.12113

G1 X81.780 Y77.826 E0.16392

G1 X81.639 Y77.776 E0.00391

G1 X81.531 Y77.668 E0.00397

G1 X81.498 Y77.592 E0.00218

G1 X81.468 Y77.411 E0.00478

G1 X81.478 Y76.066 E0.03503

G1 X81.566 Y75.685 E0.01019

G1 X81.664 Y75.612 E0.00320

G1 X81.724 Y75.368 E0.00654

G1 X81.757 Y75.302 E0.00193

G1 X81.833 Y75.228 E0.00277

G1 X91.267 Y75.303 E0.24583

G1 X92.541 Y75.275 E0.03320

M204 S1250

G1 X92.632 Y75.437 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.748 Y75.352 E-0.12269

G1 X92.863 Y75.670 E-0.18709

G1 X92.965 Y75.860 E-0.11958

G1 X93.006 Y76.045 E-0.10507

G1 X93.011 Y76.727 E-0.37757

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.866 Y77.284

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y76.626 E0.02438

G1 X82.208 Y76.144 E0.01260

G1 X82.279 Y76.104 E0.00212

G1 X83.271 Y77.097 E0.03673

G1 X83.865 Y77.097 E0.01554

G1 X82.734 Y75.966 E0.04187

G1 X83.332 Y75.971 E0.01565

G1 X84.459 Y77.098 E0.04171

G1 X85.053 Y77.099 E0.01554

G1 X83.930 Y75.975 E0.04156

G1 X84.528 Y75.980 E0.01565

G1 X85.647 Y77.099 E0.04141

G1 X86.241 Y77.100 E0.01554

G1 X85.126 Y75.985 E0.04125

G1 X85.725 Y75.990 E0.01565

G1 X86.835 Y77.101 E0.04110

G1 X87.429 Y77.101 E0.01554

G1 X86.323 Y75.995 E0.04095

G1 X86.921 Y75.999 E0.01565

G1 X88.023 Y77.102 E0.04079

G1 X88.613 Y77.099 E0.01545

G1 X87.519 Y76.004 E0.04050

G1 X88.117 Y76.009 E0.01565

G1 X89.203 Y77.095 E0.04020

G1 X89.793 Y77.092 E0.01544

G1 X88.715 Y76.014 E0.03990

G1 X89.313 Y76.018 E0.01565

G1 X90.383 Y77.089 E0.03960

G1 X90.973 Y77.085 E0.01544

G1 X89.911 Y76.023 E0.03930

G1 X90.509 Y76.028 E0.01565

G1 X91.564 Y77.082 E0.03900

G1 X92.154 Y77.079 E0.01544

G1 X91.108 Y76.033 E0.03870

G1 X91.694 Y76.026 E0.01535

G1 X92.468 Y76.800 E0.02863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.694 Y76.026 E-0.60639

G1 X91.143 Y76.032 E-0.30561

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.491 Y83.884

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.585 Y83.884 E0.00245

G1 X92.596 Y85.099 E0.03166

G1 X92.549 Y85.352 E0.00672

G1 X92.469 Y85.577 E0.00620

G1 X82.042 Y85.577 E0.27170

G1 X81.939 Y85.374 E0.00592

G1 X81.889 Y85.088 E0.00757

G1 X81.896 Y83.880 E0.03147

G1 X87.597 Y83.900 E0.14854

G1 X92.431 Y83.884 E0.12595

M204 S1250

G1 X92.917 Y83.617 F9000.000

M204 S800

G1 F1500.000

G1 X92.952 Y83.647 E0.00121

G1 X93.001 Y83.772 E0.00350

G1 X93.013 Y85.121 E0.03516

G1 X92.942 Y85.507 E0.01023

G1 X92.903 Y85.573 E0.00199

G1 X92.853 Y85.757 E0.00496

G1 X92.759 Y85.941 E0.00539

G1 X92.675 Y85.995 E0.00257

G1 X81.810 Y85.995 E0.28310

G1 X81.708 Y85.885 E0.00390

G1 X81.534 Y85.500 E0.01102

G1 X81.471 Y85.129 E0.00978

G1 X81.479 Y83.787 E0.03498

G1 X81.558 Y83.589 E0.00556

G1 X81.663 Y83.484 E0.00385

G1 X81.765 Y83.462 E0.00273

G1 X87.597 Y83.482 E0.15196

G1 X92.714 Y83.465 E0.13334

G1 X92.832 Y83.494 E0.00314

G1 X92.882 Y83.568 E0.00233

M204 S1250

G1 X92.910 Y83.663 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.952 Y83.647 E-0.05852

G1 X93.001 Y83.772 E-0.07439

G1 X93.013 Y85.121 E-0.74783

G1 X93.003 Y85.177 E-0.03126

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.975 Y85.451

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y84.682 E0.02847

G1 X82.208 Y84.194 E0.01274

G1 X82.311 Y84.195 E0.00270

G1 X83.379 Y85.263 E0.03951

G1 X83.972 Y85.263 E0.01550

G1 X82.906 Y84.197 E0.03944

G1 X83.501 Y84.199 E0.01556

G1 X84.565 Y85.263 E0.03936

G1 X85.158 Y85.263 E0.01550

G1 X84.096 Y84.201 E0.03928

G1 X84.691 Y84.203 E0.01556

G1 X85.751 Y85.263 E0.03921

G1 X86.344 Y85.263 E0.01550

G1 X85.286 Y84.205 E0.03913

G1 X85.881 Y84.207 E0.01556

G1 X86.937 Y85.263 E0.03906

G1 X87.530 Y85.263 E0.01550

G1 X86.476 Y84.209 E0.03898

G1 X87.071 Y84.211 E0.01556

G1 X88.123 Y85.263 E0.03890

G1 X88.716 Y85.263 E0.01550

G1 X87.665 Y84.213 E0.03884

G1 X88.257 Y84.211 E0.01545

G1 X89.309 Y85.263 E0.03891

G1 X89.902 Y85.263 E0.01550

G1 X88.848 Y84.209 E0.03899

G1 X89.439 Y84.207 E0.01545

G1 X90.495 Y85.263 E0.03906

G1 X91.088 Y85.263 E0.01550

G1 X90.030 Y84.205 E0.03913

G1 X90.621 Y84.203 E0.01545

G1 X91.681 Y85.263 E0.03920

G1 X92.246 Y85.263 E0.01479

G1 X92.251 Y85.240 E0.00061

G1 X91.212 Y84.201 E0.03842

G1 X91.803 Y84.200 E0.01545

G1 X92.468 Y84.865 E0.02461

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.803 Y84.200 E-0.52151

G1 X91.212 Y84.201 E-0.32754

G1 X91.292 Y84.282 E-0.06295

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.430 Y88.697

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.569 Y89.004 E0.00880

G1 X92.588 Y89.090 E0.00229

G1 X92.597 Y90.325 E0.03218

G1 X92.583 Y90.388 E0.00167

G1 X88.070 Y90.413 E0.11757

G1 X81.891 Y90.406 E0.16102

G1 X81.886 Y90.375 E0.00082

G1 X81.895 Y89.098 E0.03326

G1 X81.928 Y88.941 E0.00418

G1 X82.027 Y88.885 E0.00299

G1 X82.086 Y88.645 E0.00641

G1 X91.268 Y88.719 E0.23926

G1 X92.370 Y88.700 E0.02870

M204 S1250

G1 X92.601 Y88.269 F9000.000

M204 S800

G1 F1500.000

G1 X92.748 Y88.350 E0.00438

G1 X92.863 Y88.668 E0.00880

G1 X92.965 Y88.858 E0.00562

G1 X93.006 Y89.043 E0.00493

G1 X93.015 Y90.371 E0.03460

G1 X92.957 Y90.624 E0.00677

G1 X92.899 Y90.733 E0.00322

G1 X92.836 Y90.784 E0.00211

G1 X92.720 Y90.805 E0.00306

G1 X88.071 Y90.831 E0.12113

G1 X81.780 Y90.824 E0.16393

G1 X81.639 Y90.774 E0.00389

G1 X81.531 Y90.666 E0.00398

G1 X81.497 Y90.590 E0.00217

G1 X81.468 Y90.409 E0.00478

G1 X81.478 Y89.064 E0.03505

G1 X81.566 Y88.683 E0.01017

G1 X81.664 Y88.610 E0.00320

G1 X81.724 Y88.366 E0.00654

G1 X81.757 Y88.300 E0.00193

G1 X81.833 Y88.226 E0.00277

G1 X91.267 Y88.301 E0.24583

G1 X92.541 Y88.273 E0.03320

M204 S1250

G1 X92.632 Y88.435 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.748 Y88.350 E-0.12269

G1 X92.863 Y88.668 E-0.18709

G1 X92.965 Y88.858 E-0.11960

G1 X93.006 Y89.043 E-0.10484

G1 X93.011 Y89.725 E-0.37778

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.866 Y90.282

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y89.623 E0.02438

G1 X82.208 Y89.142 E0.01258

G1 X82.279 Y89.102 E0.00213

G1 X83.271 Y90.094 E0.03671

G1 X83.865 Y90.095 E0.01554

G1 X82.735 Y88.964 E0.04184

G1 X83.333 Y88.969 E0.01565

G1 X84.459 Y90.096 E0.04169

G1 X85.053 Y90.096 E0.01554

G1 X83.931 Y88.973 E0.04154

G1 X84.529 Y88.978 E0.01565

G1 X85.647 Y90.097 E0.04139

G1 X86.241 Y90.098 E0.01554

G1 X85.127 Y88.983 E0.04124

G1 X85.725 Y88.988 E0.01565

G1 X86.835 Y90.098 E0.04109

G1 X87.429 Y90.099 E0.01554

G1 X86.323 Y88.993 E0.04094

G1 X86.921 Y88.997 E0.01565

G1 X88.023 Y90.100 E0.04079

G1 X88.614 Y90.097 E0.01544

G1 X87.519 Y89.002 E0.04050

G1 X88.117 Y89.007 E0.01565

G1 X89.204 Y90.093 E0.04020

G1 X89.794 Y90.090 E0.01544

G1 X88.715 Y89.012 E0.03990

G1 X89.313 Y89.016 E0.01565

G1 X90.384 Y90.087 E0.03960

G1 X90.974 Y90.083 E0.01544

G1 X89.911 Y89.021 E0.03930

G1 X90.510 Y89.026 E0.01565

G1 X91.564 Y90.080 E0.03900

G1 X92.154 Y90.077 E0.01544

G1 X91.108 Y89.031 E0.03870

G1 X91.694 Y89.024 E0.01535

G1 X92.468 Y89.798 E0.02863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.694 Y89.024 E-0.60635

G1 X91.143 Y89.030 E-0.30565

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.491 Y96.882

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.585 Y96.882 E0.00245

G1 X92.596 Y98.097 E0.03166

G1 X92.549 Y98.350 E0.00672

G1 X92.470 Y98.574 E0.00618

G1 X82.042 Y98.574 E0.27171

G1 X81.939 Y98.372 E0.00591

G1 X81.889 Y98.086 E0.00757

G1 X81.896 Y96.878 E0.03147

G1 X87.597 Y96.898 E0.14854

G1 X92.431 Y96.882 E0.12595

M204 S1250

G1 X92.917 Y96.615 F9000.000

M204 S800

G1 F1500.000

G1 X92.952 Y96.645 E0.00121

G1 X93.001 Y96.770 E0.00350

G1 X93.013 Y98.119 E0.03516

G1 X92.942 Y98.505 E0.01023

G1 X92.903 Y98.571 E0.00199

G1 X92.853 Y98.755 E0.00496

G1 X92.759 Y98.939 E0.00539

G1 X92.676 Y98.992 E0.00257

G1 X81.810 Y98.992 E0.28311

G1 X81.708 Y98.883 E0.00389

G1 X81.534 Y98.498 E0.01101

G1 X81.471 Y98.127 E0.00978

G1 X81.479 Y96.785 E0.03499

G1 X81.558 Y96.586 E0.00557

G1 X81.662 Y96.482 E0.00384

G1 X81.765 Y96.460 E0.00272

G1 X87.597 Y96.480 E0.15197

G1 X92.714 Y96.463 E0.13334

G1 X92.832 Y96.492 E0.00314

G1 X92.882 Y96.566 E0.00233

M204 S1250

G1 X92.910 Y96.661 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.952 Y96.645 E-0.05852

G1 X93.001 Y96.770 E-0.07439

G1 X93.013 Y98.119 E-0.74783

G1 X93.003 Y98.175 E-0.03126

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.974 Y98.449

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y97.679 E0.02846

G1 X82.208 Y97.192 E0.01273

G1 X82.311 Y97.193 E0.00271

G1 X83.379 Y98.261 E0.03949

G1 X83.972 Y98.261 E0.01550

G1 X82.906 Y97.195 E0.03941

G1 X83.501 Y97.197 E0.01556

G1 X84.565 Y98.261 E0.03934

G1 X85.158 Y98.261 E0.01550

G1 X84.096 Y97.199 E0.03926

G1 X84.691 Y97.201 E0.01556

G1 X85.751 Y98.261 E0.03918

G1 X86.344 Y98.261 E0.01550

G1 X85.286 Y97.203 E0.03911

G1 X85.881 Y97.205 E0.01556

G1 X86.937 Y98.261 E0.03903

G1 X87.530 Y98.261 E0.01550

G1 X86.476 Y97.207 E0.03896

G1 X87.071 Y97.209 E0.01556

G1 X88.123 Y98.261 E0.03888

G1 X88.716 Y98.261 E0.01550

G1 X87.666 Y97.211 E0.03882

G1 X88.257 Y97.209 E0.01545

G1 X89.308 Y98.261 E0.03889

G1 X89.901 Y98.261 E0.01550

G1 X88.848 Y97.207 E0.03896

G1 X89.439 Y97.205 E0.01545

G1 X90.494 Y98.261 E0.03903

G1 X91.087 Y98.261 E0.01550

G1 X90.030 Y97.203 E0.03910

G1 X90.621 Y97.201 E0.01545

G1 X91.680 Y98.261 E0.03917

G1 X92.247 Y98.261 E0.01481

G1 X92.251 Y98.238 E0.00060

G1 X91.212 Y97.199 E0.03842

G1 X91.803 Y97.198 E0.01545

G1 X92.468 Y97.863 E0.02460

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.803 Y97.198 E-0.52149

G1 X91.212 Y97.199 E-0.32753

G1 X91.292 Y97.280 E-0.06298

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.430 Y101.695

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.569 Y102.002 E0.00880

G1 X92.588 Y102.088 E0.00229

G1 X92.597 Y103.323 E0.03218

G1 X92.583 Y103.386 E0.00167

G1 X88.070 Y103.411 E0.11757

G1 X81.891 Y103.404 E0.16101

G1 X81.886 Y103.372 E0.00083

G1 X81.895 Y102.096 E0.03325

G1 X81.928 Y101.939 E0.00418

G1 X82.027 Y101.883 E0.00299

G1 X82.086 Y101.643 E0.00641

G1 X91.268 Y101.717 E0.23926

G1 X92.370 Y101.698 E0.02870

M204 S1250

G1 X92.601 Y101.267 F9000.000

M204 S800

G1 F1500.000

G1 X92.748 Y101.348 E0.00438

G1 X92.863 Y101.666 E0.00880

G1 X92.965 Y101.856 E0.00562

G1 X93.006 Y102.041 E0.00493

G1 X93.015 Y103.369 E0.03460

G1 X92.957 Y103.622 E0.00677

G1 X92.899 Y103.731 E0.00322

G1 X92.836 Y103.781 E0.00211

G1 X92.720 Y103.803 E0.00307

G1 X88.071 Y103.829 E0.12112

G1 X81.780 Y103.822 E0.16392

G1 X81.639 Y103.771 E0.00391

G1 X81.531 Y103.664 E0.00396

G1 X81.498 Y103.587 E0.00219

G1 X81.468 Y103.407 E0.00476

G1 X81.478 Y102.062 E0.03504

G1 X81.566 Y101.681 E0.01017

G1 X81.664 Y101.608 E0.00320

G1 X81.724 Y101.364 E0.00655

G1 X81.758 Y101.298 E0.00194

G1 X81.833 Y101.224 E0.00275

G1 X91.267 Y101.299 E0.24584

G1 X92.541 Y101.271 E0.03320

M204 S1250

G1 X92.632 Y101.433 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.748 Y101.348 E-0.12269

G1 X92.863 Y101.666 E-0.18709

G1 X92.965 Y101.856 E-0.11960

G1 X93.006 Y102.041 E-0.10484

G1 X93.011 Y102.723 E-0.37778

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.866 Y103.280

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y102.621 E0.02438

G1 X82.208 Y102.140 E0.01258

G1 X82.279 Y102.100 E0.00213

G1 X83.271 Y103.092 E0.03671

G1 X83.865 Y103.093 E0.01554

G1 X82.735 Y101.962 E0.04184

G1 X83.333 Y101.967 E0.01565

G1 X84.459 Y103.094 E0.04169

G1 X85.053 Y103.094 E0.01554

G1 X83.931 Y101.971 E0.04154

G1 X84.529 Y101.976 E0.01565

G1 X85.647 Y103.095 E0.04139

G1 X86.241 Y103.096 E0.01554

G1 X85.127 Y101.981 E0.04124

G1 X85.725 Y101.986 E0.01565

G1 X86.835 Y103.096 E0.04109

G1 X87.429 Y103.097 E0.01554

G1 X86.323 Y101.991 E0.04094

G1 X86.921 Y101.995 E0.01565

G1 X88.024 Y103.098 E0.04079

G1 X88.614 Y103.095 E0.01544

G1 X87.519 Y102.000 E0.04050

G1 X88.117 Y102.005 E0.01565

G1 X89.204 Y103.091 E0.04020

G1 X89.794 Y103.088 E0.01544

G1 X88.715 Y102.010 E0.03990

G1 X89.313 Y102.014 E0.01565

G1 X90.384 Y103.085 E0.03960

G1 X90.974 Y103.081 E0.01544

G1 X89.911 Y102.019 E0.03930

G1 X90.510 Y102.024 E0.01565

G1 X91.564 Y103.078 E0.03900

G1 X92.154 Y103.075 E0.01544

G1 X91.108 Y102.029 E0.03870

G1 X91.694 Y102.022 E0.01535

G1 X92.468 Y102.796 E0.02863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.694 Y102.022 E-0.60635

G1 X91.143 Y102.028 E-0.30565

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.491 Y109.879

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.585 Y109.879 E0.00245

G1 X92.596 Y111.095 E0.03169

G1 X92.549 Y111.348 E0.00672

G1 X92.470 Y111.572 E0.00618

G1 X82.042 Y111.572 E0.27170

G1 X81.939 Y111.370 E0.00591

G1 X81.889 Y111.084 E0.00756

G1 X81.896 Y109.876 E0.03149

G1 X87.597 Y109.895 E0.14854

G1 X92.431 Y109.879 E0.12594

M204 S1250

G1 X92.917 Y109.613 F9000.000

M204 S800

G1 F1500.000

G1 X92.952 Y109.643 E0.00121

G1 X93.001 Y109.768 E0.00350

G1 X93.013 Y111.117 E0.03516

G1 X92.942 Y111.503 E0.01023

G1 X92.903 Y111.569 E0.00199

G1 X92.853 Y111.753 E0.00496

G1 X92.759 Y111.937 E0.00539

G1 X92.676 Y111.990 E0.00257

G1 X81.811 Y111.990 E0.28309

G1 X81.708 Y111.880 E0.00391

G1 X81.534 Y111.495 E0.01100

G1 X81.471 Y111.125 E0.00978

G1 X81.479 Y109.783 E0.03499

G1 X81.558 Y109.584 E0.00558

G1 X81.662 Y109.479 E0.00384

G1 X81.765 Y109.457 E0.00273

G1 X87.597 Y109.477 E0.15197

G1 X92.714 Y109.461 E0.13332

G1 X92.831 Y109.490 E0.00315

G1 X92.882 Y109.564 E0.00234

M204 S1250

G1 X92.909 Y109.659 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.952 Y109.643 E-0.05852

G1 X93.001 Y109.768 E-0.07439

G1 X93.013 Y111.117 E-0.74783

G1 X93.003 Y111.173 E-0.03126

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.975 Y111.447

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y110.677 E0.02847

G1 X82.208 Y110.190 E0.01274

G1 X82.311 Y110.190 E0.00270

G1 X83.379 Y111.259 E0.03951

G1 X83.972 Y111.259 E0.01550

G1 X82.906 Y110.192 E0.03944

G1 X83.501 Y110.194 E0.01556

G1 X84.565 Y111.259 E0.03936

G1 X85.158 Y111.259 E0.01550

G1 X84.096 Y110.196 E0.03929

G1 X84.691 Y110.198 E0.01556

G1 X85.751 Y111.259 E0.03921

G1 X86.344 Y111.259 E0.01550

G1 X85.286 Y110.200 E0.03914

G1 X85.881 Y110.202 E0.01556

G1 X86.937 Y111.259 E0.03907

G1 X87.530 Y111.259 E0.01550

G1 X86.476 Y110.204 E0.03899

G1 X87.071 Y110.206 E0.01556

G1 X88.123 Y111.259 E0.03892

G1 X88.716 Y111.259 E0.01550

G1 X87.665 Y110.208 E0.03886

G1 X88.256 Y110.206 E0.01546

G1 X89.309 Y111.259 E0.03893

G1 X89.902 Y111.259 E0.01550

G1 X88.847 Y110.204 E0.03900

G1 X89.438 Y110.202 E0.01546

G1 X90.495 Y111.259 E0.03907

G1 X91.088 Y111.259 E0.01550

G1 X90.030 Y110.200 E0.03914

G1 X90.621 Y110.198 E0.01546

G1 X91.681 Y111.259 E0.03921

G1 X92.247 Y111.259 E0.01479

G1 X92.251 Y111.236 E0.00061

G1 X91.212 Y110.197 E0.03843

G1 X91.803 Y110.195 E0.01546

G1 X92.468 Y110.860 E0.02461

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.803 Y110.195 E-0.52155

G1 X91.212 Y110.197 E-0.32755

G1 X91.292 Y110.277 E-0.06290

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X92.430 Y114.693

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.569 Y115.000 E0.00879

G1 X92.588 Y115.086 E0.00230

G1 X92.597 Y116.321 E0.03218

G1 X92.583 Y116.383 E0.00165

G1 X88.070 Y116.409 E0.11758

G1 X81.891 Y116.402 E0.16101

G1 X81.886 Y116.370 E0.00084

G1 X81.895 Y115.094 E0.03324

G1 X81.928 Y114.937 E0.00418

G1 X82.028 Y114.880 E0.00300

G1 X82.086 Y114.641 E0.00641

G1 X91.268 Y114.715 E0.23926

G1 X92.370 Y114.696 E0.02870

M204 S1250

G1 X92.601 Y114.265 F9000.000

M204 S800

G1 F1500.000

G1 X92.748 Y114.346 E0.00438

G1 X92.863 Y114.664 E0.00880

G1 X92.965 Y114.854 E0.00561

G1 X93.006 Y115.039 E0.00494

G1 X93.015 Y116.367 E0.03460

G1 X92.957 Y116.620 E0.00677

G1 X92.899 Y116.729 E0.00322

G1 X92.836 Y116.779 E0.00210

G1 X92.720 Y116.800 E0.00306

G1 X88.071 Y116.827 E0.12113

G1 X81.780 Y116.820 E0.16392

G1 X81.639 Y116.769 E0.00391

G1 X81.531 Y116.661 E0.00397

G1 X81.498 Y116.585 E0.00218

G1 X81.468 Y116.404 E0.00477

G1 X81.478 Y115.060 E0.03503

G1 X81.566 Y114.679 E0.01017

G1 X81.665 Y114.606 E0.00321

G1 X81.724 Y114.362 E0.00656

G1 X81.757 Y114.296 E0.00192

G1 X81.833 Y114.222 E0.00276

G1 X91.267 Y114.297 E0.24584

G1 X92.541 Y114.269 E0.03319

M204 S1250

G1 X92.632 Y114.431 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.748 Y114.346 E-0.12277

G1 X92.863 Y114.664 E-0.18716

G1 X92.965 Y114.854 E-0.11931

G1 X93.006 Y115.039 E-0.10505

G1 X93.011 Y115.720 E-0.37771

G1 E-0.04800 F4200.00000

G1 Z4.600 F9000.000

G1 X82.866 Y116.278

G1 Z4.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y115.619 E0.02438

G1 X82.208 Y115.138 E0.01258

G1 X82.279 Y115.098 E0.00213

G1 X83.272 Y116.090 E0.03671

G1 X83.866 Y116.091 E0.01554

G1 X82.735 Y114.960 E0.04184

G1 X83.333 Y114.965 E0.01565

G1 X84.460 Y116.092 E0.04169

G1 X85.054 Y116.092 E0.01554

G1 X83.931 Y114.969 E0.04154

G1 X84.529 Y114.974 E0.01565

G1 X85.648 Y116.093 E0.04139

G1 X86.242 Y116.094 E0.01554

G1 X85.127 Y114.979 E0.04124

G1 X85.725 Y114.984 E0.01565

G1 X86.836 Y116.094 E0.04109

G1 X87.430 Y116.095 E0.01554

G1 X86.323 Y114.989 E0.04094

G1 X86.921 Y114.993 E0.01565

G1 X88.024 Y116.096 E0.04079

G1 X88.614 Y116.093 E0.01544

G1 X87.519 Y114.998 E0.04050

G1 X88.117 Y115.003 E0.01565

G1 X89.204 Y116.089 E0.04020

G1 X89.794 Y116.086 E0.01543

G1 X88.715 Y115.008 E0.03989

G1 X89.313 Y115.012 E0.01565

G1 X90.383 Y116.082 E0.03959

G1 X90.973 Y116.079 E0.01543

G1 X89.912 Y115.017 E0.03929

G1 X90.510 Y115.022 E0.01565

G1 X91.563 Y116.076 E0.03898

G1 X92.153 Y116.072 E0.01543

G1 X91.108 Y115.027 E0.03868

G1 X91.694 Y115.020 E0.01535

G1 X92.468 Y115.794 E0.02863

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;4.55

G1 Z4.550 F9000.000

;AFTER\_LAYER\_CHANGE

;4.55

G1 E-3.20000 F4200.00000

G1 Z4.750 F9000.000

G1 X92.508 Y46.180

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.557 Y46.173 E0.20716

G1 X81.990 Y46.196 E0.06690

G1 X81.926 Y46.087 E0.00329

G1 X81.892 Y45.925 E0.00431

G1 X81.896 Y44.768 E0.03014

G1 X86.869 Y44.793 E0.12958

G1 X92.584 Y44.770 E0.14889

G1 X92.592 Y45.915 E0.02985

G1 X92.527 Y46.123 E0.00567

M204 S1250

G1 X92.776 Y46.542 F9000.000

M204 S800

G1 F1500.000

G1 X92.681 Y46.597 E0.00287

G1 X84.559 Y46.591 E0.21163

G1 X81.808 Y46.615 E0.07167

G1 X81.717 Y46.555 E0.00284

G1 X81.556 Y46.285 E0.00818

G1 X81.474 Y45.967 E0.00857

G1 X81.479 Y44.666 E0.03390

G1 X81.569 Y44.461 E0.00583

G1 X81.661 Y44.378 E0.00322

G1 X81.770 Y44.349 E0.00295

G1 X86.869 Y44.376 E0.13287

G1 X92.728 Y44.354 E0.15264

G1 X92.810 Y44.377 E0.00222

G1 X92.919 Y44.484 E0.00399

G1 X93.000 Y44.660 E0.00507

G1 X93.010 Y45.936 E0.03323

G1 X93.000 Y46.033 E0.00254

G1 X92.870 Y46.409 E0.01036

G1 X92.810 Y46.493 E0.00271

M204 S1250

G1 X92.671 Y46.509 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.681 Y46.597 E-0.09223

G1 X91.201 Y46.596 E-0.81977

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.893 Y44.898

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y45.585 E0.02621

G1 X82.206 Y45.881 E0.00799

G1 X82.526 Y45.878 E0.00865

G1 X83.315 Y45.088 E0.03014

G1 X83.924 Y45.091 E0.01645

G1 X83.144 Y45.872 E0.02982

G1 X83.761 Y45.867 E0.01668

G1 X84.533 Y45.095 E0.02949

G1 X85.143 Y45.098 E0.01645

G1 X84.379 Y45.862 E0.02916

G1 X84.992 Y45.860 E0.01656

G1 X85.752 Y45.101 E0.02900

G1 X86.361 Y45.104 E0.01645

G1 X85.604 Y45.861 E0.02889

G1 X86.216 Y45.861 E0.01652

G1 X86.971 Y45.106 E0.02883

G1 X87.586 Y45.104 E0.01660

G1 X86.828 Y45.862 E0.02894

G1 X87.440 Y45.862 E0.01652

G1 X88.201 Y45.101 E0.02906

G1 X88.816 Y45.099 E0.01660

G1 X88.051 Y45.863 E0.02917

G1 X88.663 Y45.863 E0.01652

G1 X89.430 Y45.096 E0.02929

G1 X90.045 Y45.094 E0.01660

G1 X89.275 Y45.864 E0.02940

G1 X89.887 Y45.864 E0.01652

G1 X90.660 Y45.091 E0.02952

G1 X91.275 Y45.089 E0.01660

G1 X90.499 Y45.865 E0.02963

G1 X91.111 Y45.865 E0.01652

G1 X91.890 Y45.086 E0.02975

G1 X92.273 Y45.084 E0.01034

G1 X92.274 Y45.313 E0.00619

G1 X91.534 Y46.053 E0.02825

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y45.313 E-0.57989

G1 X92.273 Y45.084 E-0.12696

G1 X91.902 Y45.086 E-0.20514

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.476 Y50.091

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y50.360 E0.00761

G1 X92.589 Y51.507 E0.02990

G1 X87.595 Y51.534 E0.13014

G1 X81.890 Y51.531 E0.14863

G1 X81.885 Y51.495 E0.00096

G1 X81.898 Y50.354 E0.02973

G1 X81.975 Y50.107 E0.00672

G1 X92.416 Y50.091 E0.27205

M204 S1250

G1 X92.665 Y49.673 F9000.000

M204 S800

G1 F1500.000

G1 X92.779 Y49.752 E0.00362

G1 X92.806 Y49.793 E0.00129

G1 X92.914 Y50.060 E0.00749

G1 X92.974 Y50.158 E0.00299

G1 X93.008 Y50.312 E0.00412

G1 X93.015 Y51.521 E0.03149

G1 X92.959 Y51.760 E0.00641

G1 X92.918 Y51.834 E0.00220

G1 X92.825 Y51.914 E0.00320

G1 X87.596 Y51.951 E0.13624

G1 X81.778 Y51.949 E0.15158

G1 X81.626 Y51.897 E0.00419

G1 X81.540 Y51.809 E0.00321

G1 X81.497 Y51.720 E0.00259

G1 X81.467 Y51.525 E0.00513

G1 X81.481 Y50.288 E0.03224

G1 X81.607 Y49.884 E0.01103

G1 X81.799 Y49.690 E0.00709

G1 X92.605 Y49.673 E0.28156

M204 S1250

G1 X92.682 Y49.811 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.779 Y49.752 E-0.10589

G1 X92.806 Y49.793 E-0.02747

G1 X92.914 Y50.060 E-0.15937

G1 X92.974 Y50.158 E-0.06366

G1 X93.008 Y50.312 E-0.08756

G1 X93.013 Y51.157 E-0.46806

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.950 Y50.231

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.204 Y50.977 E0.02846

G1 X82.201 Y51.218 E0.00650

G1 X82.575 Y51.218 E0.01008

G1 X83.374 Y50.419 E0.03050

G1 X83.987 Y50.418 E0.01653

G1 X83.186 Y51.218 E0.03055

G1 X83.798 Y51.219 E0.01650

G1 X84.600 Y50.417 E0.03060

G1 X85.213 Y50.416 E0.01653

G1 X84.410 Y51.219 E0.03064

G1 X85.021 Y51.219 E0.01650

G1 X85.826 Y50.415 E0.03069

G1 X86.438 Y50.414 E0.01653

G1 X85.633 Y51.219 E0.03074

G1 X86.244 Y51.220 E0.01650

G1 X87.051 Y50.413 E0.03078

G1 X87.664 Y50.412 E0.01653

G1 X86.856 Y51.220 E0.03083

G1 X87.467 Y51.220 E0.01650

G1 X88.277 Y50.411 E0.03088

G1 X88.890 Y50.410 E0.01653

G1 X88.082 Y51.218 E0.03082

G1 X88.697 Y51.214 E0.01660

G1 X89.502 Y50.409 E0.03073

G1 X90.115 Y50.408 E0.01653

G1 X89.312 Y51.211 E0.03064

G1 X89.927 Y51.208 E0.01660

G1 X90.728 Y50.407 E0.03056

G1 X91.341 Y50.406 E0.01653

G1 X90.542 Y51.205 E0.03047

G1 X91.157 Y51.201 E0.01660

G1 X91.954 Y50.405 E0.03038

G1 X92.266 Y50.405 E0.00844

G1 X92.277 Y50.694 E0.00780

G1 X91.583 Y51.387 E0.02646

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.277 Y50.694 E-0.54352

G1 X92.266 Y50.405 E-0.16027

G1 X91.954 Y50.405 E-0.17330

G1 X91.909 Y50.450 E-0.03491

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.584 Y57.768

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y58.913 E0.02984

G1 X92.508 Y59.178 E0.00724

G1 X84.557 Y59.171 E0.20716

G1 X81.990 Y59.194 E0.06690

G1 X81.926 Y59.085 E0.00329

G1 X81.892 Y58.923 E0.00431

G1 X81.896 Y57.765 E0.03017

G1 X86.869 Y57.791 E0.12958

G1 X92.524 Y57.767 E0.14733

M204 S1250

G1 X92.919 Y57.482 F9000.000

M204 S800

G1 F1500.000

G1 X93.000 Y57.658 E0.00505

G1 X93.000 Y59.031 E0.03578

G1 X92.870 Y59.407 E0.01035

G1 X92.776 Y59.540 E0.00427

G1 X92.681 Y59.595 E0.00287

G1 X84.559 Y59.589 E0.21163

G1 X81.808 Y59.613 E0.07167

G1 X81.717 Y59.553 E0.00284

G1 X81.556 Y59.283 E0.00818

G1 X81.474 Y58.965 E0.00857

G1 X81.479 Y57.663 E0.03392

G1 X81.569 Y57.459 E0.00581

G1 X81.661 Y57.376 E0.00323

G1 X81.771 Y57.346 E0.00296

G1 X86.869 Y57.374 E0.13285

G1 X92.311 Y57.347 E0.14179

G1 X92.728 Y57.352 E0.01085

G1 X92.810 Y57.375 E0.00222

G1 X92.873 Y57.443 E0.00243

M204 S1250

G1 X92.838 Y57.658 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.000 Y57.658 E-0.13826

G1 X93.000 Y59.031 E-0.76098

G1 X92.993 Y59.053 E-0.01275

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.893 Y57.895

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y58.582 E0.02621

G1 X82.206 Y58.879 E0.00801

G1 X82.525 Y58.876 E0.00863

G1 X83.315 Y58.086 E0.03017

G1 X83.924 Y58.089 E0.01645

G1 X83.143 Y58.870 E0.02984

G1 X83.761 Y58.865 E0.01668

G1 X84.533 Y58.092 E0.02951

G1 X85.142 Y58.095 E0.01645

G1 X84.378 Y58.860 E0.02918

G1 X84.992 Y58.858 E0.01657

G1 X85.751 Y58.099 E0.02901

G1 X86.360 Y58.102 E0.01645

G1 X85.604 Y58.859 E0.02890

G1 X86.216 Y58.859 E0.01652

G1 X86.971 Y58.104 E0.02883

G1 X87.585 Y58.102 E0.01660

G1 X86.827 Y58.860 E0.02895

G1 X87.439 Y58.860 E0.01652

G1 X88.200 Y58.099 E0.02906

G1 X88.815 Y58.097 E0.01660

G1 X88.051 Y58.861 E0.02918

G1 X88.663 Y58.861 E0.01652

G1 X89.430 Y58.094 E0.02929

G1 X90.045 Y58.092 E0.01660

G1 X89.275 Y58.862 E0.02941

G1 X89.887 Y58.862 E0.01652

G1 X90.660 Y58.089 E0.02952

G1 X91.275 Y58.086 E0.01660

G1 X90.499 Y58.863 E0.02964

G1 X91.110 Y58.863 E0.01652

G1 X91.890 Y58.084 E0.02975

G1 X92.273 Y58.082 E0.01034

G1 X92.274 Y58.311 E0.00619

G1 X91.534 Y59.051 E0.02826

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y58.311 E-0.57995

G1 X92.273 Y58.082 E-0.12695

G1 X91.903 Y58.084 E-0.20509

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.476 Y63.089

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y63.357 E0.00762

G1 X92.589 Y64.505 E0.02991

G1 X87.595 Y64.532 E0.13014

G1 X81.890 Y64.529 E0.14863

G1 X81.885 Y64.493 E0.00096

G1 X81.898 Y63.352 E0.02973

G1 X81.975 Y63.105 E0.00672

G1 X92.416 Y63.089 E0.27205

M204 S1250

G1 X92.664 Y62.670 F9000.000

M204 S800

G1 F1500.000

G1 X92.779 Y62.751 E0.00364

G1 X92.806 Y62.791 E0.00128

G1 X92.914 Y63.057 E0.00748

G1 X92.974 Y63.155 E0.00299

G1 X93.008 Y63.310 E0.00413

G1 X93.015 Y64.519 E0.03149

G1 X92.959 Y64.758 E0.00639

G1 X92.918 Y64.833 E0.00223

G1 X92.825 Y64.912 E0.00319

G1 X87.596 Y64.949 E0.13624

G1 X81.778 Y64.947 E0.15158

G1 X81.626 Y64.895 E0.00419

G1 X81.540 Y64.807 E0.00320

G1 X81.497 Y64.718 E0.00259

G1 X81.467 Y64.523 E0.00513

G1 X81.481 Y63.286 E0.03224

G1 X81.607 Y62.881 E0.01104

G1 X81.799 Y62.688 E0.00709

G1 X92.604 Y62.671 E0.28156

M73 P52 R33

M204 S1250

G1 X92.682 Y62.809 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.779 Y62.751 E-0.10638

G1 X92.806 Y62.791 E-0.02713

G1 X92.914 Y63.057 E-0.15902

G1 X92.974 Y63.155 E-0.06370

G1 X93.008 Y63.310 E-0.08792

G1 X93.013 Y64.154 E-0.46786

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.950 Y63.229

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.204 Y63.975 E0.02846

G1 X82.201 Y64.216 E0.00649

G1 X82.575 Y64.216 E0.01008

G1 X83.374 Y63.417 E0.03050

G1 X83.987 Y63.416 E0.01653

G1 X83.187 Y64.216 E0.03055

G1 X83.798 Y64.217 E0.01650

G1 X84.600 Y63.415 E0.03060

G1 X85.213 Y63.414 E0.01653

G1 X84.410 Y64.217 E0.03065

G1 X85.021 Y64.217 E0.01650

G1 X85.826 Y63.413 E0.03070

G1 X86.439 Y63.412 E0.01653

G1 X85.633 Y64.217 E0.03074

G1 X86.244 Y64.218 E0.01650

G1 X87.051 Y63.411 E0.03079

G1 X87.664 Y63.410 E0.01653

G1 X86.856 Y64.218 E0.03084

G1 X87.467 Y64.218 E0.01650

G1 X88.277 Y63.409 E0.03089

G1 X88.890 Y63.408 E0.01653

G1 X88.082 Y64.216 E0.03083

G1 X88.697 Y64.212 E0.01660

G1 X89.503 Y63.407 E0.03074

G1 X90.115 Y63.406 E0.01653

G1 X89.312 Y64.209 E0.03066

G1 X89.927 Y64.206 E0.01660

G1 X90.728 Y63.405 E0.03057

G1 X91.341 Y63.404 E0.01653

G1 X90.542 Y64.203 E0.03049

G1 X91.157 Y64.199 E0.01660

G1 X91.954 Y63.403 E0.03040

G1 X92.266 Y63.402 E0.00843

G1 X92.277 Y63.692 E0.00781

G1 X91.583 Y64.385 E0.02646

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.277 Y63.692 E-0.54355

G1 X92.266 Y63.402 E-0.16052

G1 X91.954 Y63.403 E-0.17318

G1 X91.910 Y63.447 E-0.03475

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.584 Y70.772

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y71.910 E0.02967

G1 X92.508 Y72.176 E0.00725

G1 X84.557 Y72.169 E0.20716

G1 X81.998 Y72.191 E0.06668

G1 X81.919 Y72.050 E0.00422

G1 X81.891 Y71.916 E0.00357

G1 X81.893 Y70.763 E0.03005

G1 X86.870 Y70.789 E0.12968

G1 X92.524 Y70.771 E0.14732

M204 S1250

G1 X92.919 Y70.479 F9000.000

M204 S800

G1 F1500.000

G1 X93.000 Y70.656 E0.00507

G1 X93.000 Y72.029 E0.03578

G1 X92.870 Y72.404 E0.01035

G1 X92.776 Y72.538 E0.00427

G1 X92.681 Y72.593 E0.00287

G1 X84.559 Y72.587 E0.21163

G1 X81.808 Y72.611 E0.07167

G1 X81.720 Y72.552 E0.00275

G1 X81.523 Y72.197 E0.01058

G1 X81.474 Y71.961 E0.00629

G1 X81.466 Y70.773 E0.03095

G1 X81.499 Y70.595 E0.00473

G1 X81.555 Y70.474 E0.00348

G1 X81.662 Y70.373 E0.00383

G1 X81.770 Y70.344 E0.00291

G1 X86.869 Y70.372 E0.13286

G1 X91.671 Y70.344 E0.12510

G1 X92.765 Y70.356 E0.02852

G1 X92.808 Y70.369 E0.00116

G1 X92.873 Y70.441 E0.00253

M204 S1250

G1 X92.833 Y70.653 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.000 Y70.656 E-0.13858

G1 X93.000 Y72.029 E-0.76102

G1 X92.993 Y72.050 E-0.01241

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.890 Y70.893

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y71.579 E0.02617

G1 X82.205 Y71.876 E0.00804

G1 X82.523 Y71.874 E0.00859

G1 X83.312 Y71.084 E0.03017

G1 X83.922 Y71.087 E0.01646

G1 X83.140 Y71.868 E0.02984

G1 X83.758 Y71.863 E0.01669

G1 X84.531 Y71.090 E0.02951

G1 X85.140 Y71.093 E0.01646

G1 X84.376 Y71.858 E0.02918

G1 X84.990 Y71.856 E0.01658

G1 X85.749 Y71.097 E0.02901

G1 X86.359 Y71.100 E0.01646

G1 X85.602 Y71.857 E0.02891

G1 X86.214 Y71.857 E0.01653

G1 X86.969 Y71.102 E0.02884

G1 X87.585 Y71.099 E0.01664

G1 X86.826 Y71.858 E0.02900

G1 X87.438 Y71.858 E0.01653

G1 X88.201 Y71.095 E0.02915

G1 X88.817 Y71.091 E0.01664

G1 X88.050 Y71.859 E0.02931

G1 X88.662 Y71.859 E0.01653

G1 X89.433 Y71.088 E0.02946

G1 X90.049 Y71.084 E0.01664

G1 X89.274 Y71.860 E0.02961

G1 X89.886 Y71.860 E0.01653

G1 X90.665 Y71.081 E0.02977

G1 X91.281 Y71.077 E0.01664

G1 X90.498 Y71.861 E0.02992

G1 X91.110 Y71.861 E0.01653

G1 X91.894 Y71.077 E0.02993

G1 X92.273 Y71.082 E0.01024

G1 X92.274 Y71.309 E0.00614

G1 X91.534 Y72.049 E0.02828

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y71.309 E-0.58019

G1 X92.273 Y71.082 E-0.12605

G1 X91.901 Y71.078 E-0.20576

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.476 Y76.087

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y76.355 E0.00762

G1 X92.589 Y77.503 E0.02991

G1 X87.595 Y77.529 E0.13013

G1 X81.890 Y77.527 E0.14863

G1 X81.885 Y77.491 E0.00096

G1 X81.898 Y76.349 E0.02974

G1 X81.975 Y76.102 E0.00674

G1 X92.416 Y76.087 E0.27205

M204 S1250

G1 X92.665 Y75.668 F9000.000

M204 S800

G1 F1500.000

G1 X92.779 Y75.748 E0.00361

G1 X92.806 Y75.789 E0.00129

G1 X92.914 Y76.055 E0.00748

G1 X92.974 Y76.153 E0.00299

G1 X93.008 Y76.308 E0.00413

G1 X93.015 Y77.517 E0.03149

G1 X92.959 Y77.755 E0.00639

G1 X92.918 Y77.830 E0.00222

G1 X92.824 Y77.910 E0.00320

G1 X87.596 Y77.947 E0.13623

G1 X81.778 Y77.945 E0.15158

G1 X81.626 Y77.893 E0.00419

G1 X81.540 Y77.805 E0.00321

G1 X81.497 Y77.716 E0.00259

G1 X81.467 Y77.521 E0.00513

G1 X81.481 Y76.283 E0.03225

G1 X81.607 Y75.879 E0.01105

G1 X81.799 Y75.685 E0.00711

G1 X92.605 Y75.669 E0.28155

M204 S1250

G1 X92.682 Y75.806 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.779 Y75.748 E-0.10581

G1 X92.806 Y75.789 E-0.02748

G1 X92.914 Y76.055 E-0.15916

G1 X92.974 Y76.153 E-0.06370

G1 X93.008 Y76.308 E-0.08792

G1 X93.013 Y77.153 E-0.46794

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.950 Y76.226

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.204 Y76.972 E0.02846

G1 X82.201 Y77.214 E0.00651

G1 X82.574 Y77.214 E0.01007

G1 X83.374 Y76.414 E0.03053

G1 X83.987 Y76.413 E0.01653

G1 X83.186 Y77.214 E0.03057

G1 X83.798 Y77.214 E0.01650

G1 X84.600 Y76.412 E0.03062

G1 X85.213 Y76.411 E0.01653

G1 X84.409 Y77.214 E0.03066

G1 X85.021 Y77.215 E0.01650

G1 X85.826 Y76.410 E0.03070

G1 X86.439 Y76.409 E0.01653

G1 X85.633 Y77.215 E0.03074

G1 X86.245 Y77.215 E0.01650

G1 X87.051 Y76.408 E0.03079

G1 X87.664 Y76.407 E0.01653

G1 X86.856 Y77.215 E0.03083

G1 X87.468 Y77.215 E0.01650

G1 X88.277 Y76.406 E0.03087

G1 X88.890 Y76.405 E0.01653

G1 X88.082 Y77.213 E0.03081

G1 X88.697 Y77.210 E0.01659

G1 X89.503 Y76.404 E0.03073

G1 X90.115 Y76.403 E0.01653

G1 X89.312 Y77.207 E0.03065

G1 X89.927 Y77.203 E0.01659

G1 X90.728 Y76.403 E0.03056

G1 X91.341 Y76.402 E0.01653

G1 X90.542 Y77.200 E0.03048

G1 X91.157 Y77.197 E0.01659

G1 X91.954 Y76.401 E0.03039

G1 X92.266 Y76.400 E0.00843

G1 X92.277 Y76.690 E0.00781

G1 X91.583 Y77.383 E0.02646

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.277 Y76.690 E-0.54348

G1 X92.266 Y76.400 E-0.16047

G1 X91.954 Y76.401 E-0.17323

G1 X91.909 Y76.445 E-0.03482

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.584 Y83.770

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y84.908 E0.02966

G1 X92.508 Y85.173 E0.00724

G1 X84.557 Y85.166 E0.20716

G1 X81.997 Y85.189 E0.06669

G1 X81.919 Y85.048 E0.00420

G1 X81.891 Y84.914 E0.00356

G1 X81.893 Y83.761 E0.03005

G1 X86.870 Y83.787 E0.12968

G1 X92.524 Y83.769 E0.14732

M204 S1250

G1 X92.919 Y83.477 F9000.000

M204 S800

G1 F1500.000

G1 X93.000 Y83.653 E0.00507

G1 X93.000 Y85.026 E0.03576

G1 X92.870 Y85.402 E0.01036

G1 X92.776 Y85.535 E0.00427

G1 X92.681 Y85.590 E0.00287

G1 X84.559 Y85.584 E0.21163

G1 X81.808 Y85.608 E0.07167

G1 X81.720 Y85.550 E0.00274

G1 X81.523 Y85.195 E0.01058

G1 X81.474 Y84.959 E0.00628

G1 X81.466 Y83.771 E0.03095

G1 X81.499 Y83.593 E0.00473

G1 X81.555 Y83.472 E0.00348

G1 X81.662 Y83.371 E0.00383

G1 X81.770 Y83.342 E0.00291

G1 X86.869 Y83.370 E0.13286

G1 X91.671 Y83.342 E0.12510

G1 X92.765 Y83.354 E0.02852

G1 X92.808 Y83.367 E0.00116

G1 X92.873 Y83.438 E0.00251

M204 S1250

G1 X92.833 Y83.651 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.000 Y83.653 E-0.13865

G1 X93.000 Y85.026 E-0.76053

G1 X92.993 Y85.048 E-0.01282

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.890 Y83.891

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y84.577 E0.02617

G1 X82.205 Y84.874 E0.00802

G1 X82.523 Y84.871 E0.00861

G1 X83.312 Y84.082 E0.03013

G1 X83.922 Y84.085 E0.01645

G1 X83.141 Y84.865 E0.02980

G1 X83.759 Y84.860 E0.01669

G1 X84.531 Y84.088 E0.02947

G1 X85.140 Y84.091 E0.01645

G1 X84.377 Y84.855 E0.02914

G1 X84.991 Y84.853 E0.01657

G1 X85.749 Y84.095 E0.02897

G1 X86.358 Y84.098 E0.01645

G1 X85.602 Y84.854 E0.02887

G1 X86.214 Y84.854 E0.01653

G1 X86.969 Y84.100 E0.02880

G1 X87.585 Y84.097 E0.01664

G1 X86.826 Y84.855 E0.02896

G1 X87.438 Y84.855 E0.01653

G1 X88.201 Y84.093 E0.02911

G1 X88.817 Y84.089 E0.01664

G1 X88.050 Y84.856 E0.02927

G1 X88.662 Y84.856 E0.01653

G1 X89.433 Y84.086 E0.02942

G1 X90.049 Y84.082 E0.01664

G1 X89.274 Y84.857 E0.02957

G1 X89.886 Y84.857 E0.01653

G1 X90.665 Y84.079 E0.02973

G1 X91.281 Y84.075 E0.01664

G1 X90.498 Y84.858 E0.02988

G1 X91.110 Y84.858 E0.01653

G1 X91.893 Y84.075 E0.02989

G1 X92.273 Y84.080 E0.01026

G1 X92.274 Y84.306 E0.00612

G1 X91.534 Y85.046 E0.02827

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y84.306 E-0.58007

G1 X92.273 Y84.080 E-0.12558

G1 X91.900 Y84.076 E-0.20635

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.476 Y89.084

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y89.353 E0.00761

G1 X92.589 Y90.501 E0.02992

G1 X87.595 Y90.527 E0.13013

G1 X81.890 Y90.524 E0.14864

G1 X81.885 Y90.489 E0.00094

G1 X81.898 Y89.347 E0.02976

G1 X81.975 Y89.100 E0.00672

G1 X92.416 Y89.084 E0.27205

M204 S1250

G1 X92.665 Y88.666 F9000.000

M204 S800

G1 F1500.000

G1 X92.778 Y88.745 E0.00361

G1 X92.806 Y88.787 E0.00131

G1 X92.914 Y89.053 E0.00749

G1 X92.974 Y89.151 E0.00299

G1 X93.008 Y89.305 E0.00412

G1 X93.015 Y90.515 E0.03151

G1 X92.959 Y90.753 E0.00639

G1 X92.918 Y90.828 E0.00222

G1 X92.824 Y90.908 E0.00320

G1 X87.596 Y90.945 E0.13623

G1 X81.778 Y90.942 E0.15159

G1 X81.626 Y90.891 E0.00418

G1 X81.540 Y90.803 E0.00320

G1 X81.497 Y90.713 E0.00258

G1 X81.467 Y90.519 E0.00513

G1 X81.481 Y89.281 E0.03227

G1 X81.607 Y88.877 E0.01103

G1 X81.799 Y88.683 E0.00711

G1 X92.605 Y88.666 E0.28155

M204 S1250

G1 X92.682 Y88.803 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.778 Y88.745 E-0.10573

G1 X92.806 Y88.787 E-0.02776

G1 X92.914 Y89.053 E-0.15922

G1 X92.974 Y89.151 E-0.06362

G1 X93.008 Y89.305 E-0.08756

G1 X93.013 Y90.150 E-0.46811

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.950 Y89.224

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.204 Y89.970 E0.02846

G1 X82.201 Y90.211 E0.00650

G1 X82.575 Y90.211 E0.01008

G1 X83.374 Y89.412 E0.03051

G1 X83.987 Y89.411 E0.01654

G1 X83.187 Y90.211 E0.03055

G1 X83.798 Y90.212 E0.01650

G1 X84.600 Y89.410 E0.03060

G1 X85.213 Y89.409 E0.01654

G1 X84.410 Y90.212 E0.03065

G1 X85.021 Y90.212 E0.01650

G1 X85.826 Y89.408 E0.03069

G1 X86.439 Y89.407 E0.01654

G1 X85.633 Y90.212 E0.03074

G1 X86.245 Y90.213 E0.01650

G1 X87.052 Y89.406 E0.03079

G1 X87.664 Y89.405 E0.01654

G1 X86.856 Y90.213 E0.03084

G1 X87.468 Y90.213 E0.01650

G1 X88.277 Y89.404 E0.03088

G1 X88.890 Y89.403 E0.01654

G1 X88.082 Y90.211 E0.03083

G1 X88.697 Y90.208 E0.01659

G1 X89.503 Y89.402 E0.03074

G1 X90.116 Y89.401 E0.01654

G1 X89.312 Y90.205 E0.03066

G1 X89.927 Y90.201 E0.01659

G1 X90.729 Y89.400 E0.03058

G1 X91.341 Y89.399 E0.01654

G1 X90.542 Y90.198 E0.03050

G1 X91.157 Y90.195 E0.01659

G1 X91.954 Y89.398 E0.03041

G1 X92.266 Y89.398 E0.00842

G1 X92.277 Y89.688 E0.00783

G1 X91.583 Y90.381 E0.02646

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.277 Y89.688 E-0.54349

G1 X92.266 Y89.398 E-0.16073

G1 X91.954 Y89.398 E-0.17289

G1 X91.910 Y89.443 E-0.03489

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.584 Y96.768

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y97.906 E0.02966

G1 X92.508 Y98.171 E0.00724

G1 X84.557 Y98.164 E0.20716

G1 X81.997 Y98.187 E0.06669

G1 X81.919 Y98.046 E0.00420

G1 X81.891 Y97.912 E0.00356

G1 X81.893 Y96.759 E0.03005

G1 X86.870 Y96.785 E0.12968

G1 X92.524 Y96.767 E0.14732

M204 S1250

G1 X92.919 Y96.475 F9000.000

M204 S800

G1 F1500.000

G1 X93.000 Y96.651 E0.00507

G1 X93.000 Y98.024 E0.03576

G1 X92.870 Y98.400 E0.01036

G1 X92.776 Y98.533 E0.00427

G1 X92.681 Y98.588 E0.00287

G1 X84.559 Y98.582 E0.21163

G1 X81.808 Y98.606 E0.07167

G1 X81.720 Y98.548 E0.00274

G1 X81.523 Y98.193 E0.01058

G1 X81.474 Y97.957 E0.00628

G1 X81.466 Y96.769 E0.03095

G1 X81.499 Y96.590 E0.00474

G1 X81.555 Y96.469 E0.00349

G1 X81.662 Y96.369 E0.00381

G1 X81.770 Y96.340 E0.00291

G1 X86.869 Y96.368 E0.13287

G1 X91.671 Y96.340 E0.12510

G1 X92.765 Y96.352 E0.02852

G1 X92.808 Y96.365 E0.00116

G1 X92.873 Y96.436 E0.00251

M204 S1250

G1 X92.833 Y96.649 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.000 Y96.651 E-0.13865

G1 X93.000 Y98.024 E-0.76053

G1 X92.993 Y98.046 E-0.01282

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.890 Y96.889

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y97.575 E0.02617

G1 X82.205 Y97.872 E0.00802

G1 X82.523 Y97.869 E0.00861

G1 X83.312 Y97.080 E0.03013

G1 X83.921 Y97.083 E0.01645

G1 X83.141 Y97.863 E0.02980

G1 X83.759 Y97.858 E0.01669

G1 X84.531 Y97.086 E0.02947

G1 X85.140 Y97.089 E0.01645

G1 X84.377 Y97.853 E0.02914

G1 X84.991 Y97.851 E0.01657

G1 X85.749 Y97.093 E0.02897

G1 X86.358 Y97.096 E0.01645

G1 X85.602 Y97.852 E0.02887

G1 X86.214 Y97.852 E0.01653

G1 X86.969 Y97.098 E0.02880

G1 X87.585 Y97.095 E0.01664

G1 X86.826 Y97.853 E0.02896

G1 X87.438 Y97.853 E0.01653

G1 X88.201 Y97.091 E0.02911

G1 X88.817 Y97.087 E0.01664

G1 X88.050 Y97.854 E0.02927

G1 X88.662 Y97.854 E0.01653

G1 X89.433 Y97.084 E0.02942

G1 X90.049 Y97.080 E0.01664

G1 X89.274 Y97.855 E0.02957

G1 X89.886 Y97.855 E0.01653

G1 X90.665 Y97.077 E0.02973

G1 X91.281 Y97.073 E0.01664

G1 X90.498 Y97.856 E0.02988

G1 X91.110 Y97.856 E0.01653

G1 X91.893 Y97.073 E0.02989

G1 X92.273 Y97.078 E0.01026

G1 X92.274 Y97.304 E0.00612

G1 X91.534 Y98.044 E0.02827

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y97.304 E-0.58007

G1 X92.273 Y97.078 E-0.12558

G1 X91.900 Y97.074 E-0.20635

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.476 Y102.082

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y102.351 E0.00761

G1 X92.589 Y103.499 E0.02992

G1 X87.595 Y103.525 E0.13013

G1 X81.890 Y103.522 E0.14864

G1 X81.885 Y103.487 E0.00094

G1 X81.898 Y102.345 E0.02975

G1 X81.975 Y102.098 E0.00672

G1 X92.416 Y102.082 E0.27205

M204 S1250

G1 X92.665 Y101.664 F9000.000

M204 S800

G1 F1500.000

G1 X92.779 Y101.743 E0.00362

G1 X92.806 Y101.784 E0.00129

G1 X92.914 Y102.051 E0.00749

G1 X92.974 Y102.149 E0.00299

G1 X93.008 Y102.303 E0.00412

G1 X93.015 Y103.513 E0.03151

G1 X92.959 Y103.751 E0.00639

G1 X92.918 Y103.825 E0.00220

G1 X92.824 Y103.906 E0.00322

G1 X87.596 Y103.943 E0.13623

G1 X81.778 Y103.940 E0.15158

G1 X81.626 Y103.888 E0.00420

G1 X81.540 Y103.800 E0.00320

G1 X81.497 Y103.711 E0.00257

G1 X81.467 Y103.517 E0.00513

G1 X81.481 Y102.279 E0.03227

G1 X81.607 Y101.875 E0.01103

G1 X81.799 Y101.681 E0.00711

G1 X92.605 Y101.664 E0.28155

M204 S1250

G1 X92.682 Y101.802 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.779 Y101.743 E-0.10589

G1 X92.806 Y101.784 E-0.02746

G1 X92.914 Y102.051 E-0.15936

G1 X92.974 Y102.149 E-0.06366

G1 X93.008 Y102.303 E-0.08756

G1 X93.013 Y103.148 E-0.46806

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.950 Y102.222

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.204 Y102.968 E0.02846

G1 X82.201 Y103.209 E0.00650

G1 X82.575 Y103.209 E0.01008

G1 X83.374 Y102.410 E0.03051

G1 X83.987 Y102.409 E0.01654

G1 X83.187 Y103.209 E0.03055

G1 X83.798 Y103.210 E0.01650

G1 X84.600 Y102.408 E0.03060

G1 X85.213 Y102.407 E0.01654

G1 X84.410 Y103.210 E0.03065

G1 X85.021 Y103.210 E0.01650

G1 X85.826 Y102.406 E0.03069

G1 X86.439 Y102.405 E0.01654

G1 X85.633 Y103.210 E0.03074

G1 X86.245 Y103.211 E0.01650

G1 X87.052 Y102.404 E0.03079

G1 X87.664 Y102.403 E0.01654

G1 X86.856 Y103.211 E0.03084

G1 X87.468 Y103.211 E0.01650

G1 X88.277 Y102.402 E0.03088

G1 X88.890 Y102.401 E0.01654

G1 X88.082 Y103.209 E0.03083

G1 X88.697 Y103.206 E0.01659

G1 X89.503 Y102.400 E0.03074

G1 X90.116 Y102.399 E0.01654

G1 X89.312 Y103.203 E0.03066

G1 X89.927 Y103.199 E0.01659

G1 X90.729 Y102.398 E0.03058

G1 X91.341 Y102.397 E0.01654

G1 X90.542 Y103.196 E0.03050

G1 X91.157 Y103.193 E0.01659

G1 X91.954 Y102.396 E0.03041

G1 X92.266 Y102.396 E0.00842

G1 X92.277 Y102.686 E0.00783

G1 X91.583 Y103.379 E0.02646

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.277 Y102.686 E-0.54349

G1 X92.266 Y102.396 E-0.16073

G1 X91.954 Y102.396 E-0.17288

G1 X91.910 Y102.441 E-0.03489

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.584 Y109.759

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y110.904 E0.02985

G1 X92.508 Y111.169 E0.00724

G1 X84.557 Y111.162 E0.20716

G1 X81.989 Y111.185 E0.06690

G1 X81.926 Y111.076 E0.00329

G1 X81.892 Y110.914 E0.00431

G1 X81.896 Y109.757 E0.03016

G1 X86.869 Y109.782 E0.12958

G1 X92.524 Y109.758 E0.14733

M204 S1250

G1 X92.919 Y109.473 F9000.000

M204 S800

G1 F1500.000

G1 X93.000 Y109.649 E0.00507

G1 X93.000 Y111.022 E0.03576

G1 X92.870 Y111.398 E0.01036

G1 X92.776 Y111.531 E0.00427

G1 X92.681 Y111.586 E0.00287

G1 X84.559 Y111.580 E0.21163

G1 X81.808 Y111.604 E0.07167

G1 X81.717 Y111.544 E0.00284

G1 X81.557 Y111.275 E0.00817

G1 X81.474 Y110.957 E0.00856

G1 X81.479 Y109.667 E0.03360

G1 X81.562 Y109.455 E0.00595

G1 X81.655 Y109.369 E0.00329

G1 X81.770 Y109.338 E0.00310

G1 X86.869 Y109.365 E0.13287

G1 X92.311 Y109.338 E0.14179

G1 X92.728 Y109.343 E0.01085

G1 X92.810 Y109.366 E0.00222

G1 X92.873 Y109.434 E0.00243

M204 S1250

G1 X92.837 Y109.649 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.000 Y109.649 E-0.13865

G1 X93.000 Y111.022 E-0.76053

G1 X92.993 Y111.044 E-0.01282

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.893 Y109.887

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.207 Y110.574 E0.02621

G1 X82.206 Y110.870 E0.00799

G1 X82.526 Y110.867 E0.00865

G1 X83.315 Y110.077 E0.03014

G1 X83.924 Y110.080 E0.01645

G1 X83.144 Y110.861 E0.02982

G1 X83.761 Y110.856 E0.01668

G1 X84.533 Y110.084 E0.02949

G1 X85.143 Y110.087 E0.01645

G1 X84.379 Y110.850 E0.02916

G1 X84.992 Y110.849 E0.01656

G1 X85.752 Y110.090 E0.02900

G1 X86.361 Y110.093 E0.01645

G1 X85.604 Y110.850 E0.02889

G1 X86.216 Y110.850 E0.01652

G1 X86.971 Y110.095 E0.02883

G1 X87.586 Y110.093 E0.01660

G1 X86.828 Y110.851 E0.02894

G1 X87.440 Y110.851 E0.01652

G1 X88.201 Y110.090 E0.02906

G1 X88.816 Y110.088 E0.01660

G1 X88.051 Y110.852 E0.02917

G1 X88.663 Y110.852 E0.01652

G1 X89.430 Y110.085 E0.02929

G1 X90.045 Y110.083 E0.01660

G1 X89.275 Y110.853 E0.02940

G1 X89.887 Y110.853 E0.01652

G1 X90.660 Y110.080 E0.02952

G1 X91.275 Y110.078 E0.01660

G1 X90.499 Y110.854 E0.02963

G1 X91.111 Y110.854 E0.01652

G1 X91.890 Y110.075 E0.02975

G1 X92.273 Y110.073 E0.01034

G1 X92.274 Y110.302 E0.00619

G1 X91.534 Y111.042 E0.02825

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.274 Y110.302 E-0.57989

G1 X92.273 Y110.073 E-0.12697

G1 X91.902 Y110.075 E-0.20514

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X92.476 Y115.080

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y115.349 E0.00761

G1 X92.589 Y116.497 E0.02991

G1 X87.595 Y116.523 E0.13014

G1 X81.890 Y116.520 E0.14864

G1 X81.885 Y116.485 E0.00094

G1 X81.898 Y115.343 E0.02975

G1 X81.975 Y115.096 E0.00672

G1 X92.416 Y115.080 E0.27205

M204 S1250

G1 X92.665 Y114.662 F9000.000

M204 S800

G1 F1500.000

G1 X92.779 Y114.741 E0.00362

G1 X92.806 Y114.782 E0.00129

G1 X92.914 Y115.049 E0.00749

G1 X92.974 Y115.147 E0.00299

G1 X93.008 Y115.301 E0.00412

G1 X93.015 Y116.511 E0.03151

G1 X92.959 Y116.749 E0.00639

G1 X92.918 Y116.823 E0.00220

G1 X92.824 Y116.903 E0.00321

G1 X87.596 Y116.941 E0.13624

G1 X81.778 Y116.938 E0.15158

G1 X81.626 Y116.886 E0.00419

G1 X81.540 Y116.798 E0.00321

G1 X81.497 Y116.709 E0.00256

G1 X81.467 Y116.515 E0.00512

G1 X81.481 Y115.277 E0.03227

G1 X81.607 Y114.873 E0.01103

G1 X81.799 Y114.679 E0.00711

G1 X92.605 Y114.662 E0.28155

M204 S1250

G1 X92.682 Y114.800 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.779 Y114.741 E-0.10589

G1 X92.806 Y114.782 E-0.02746

G1 X92.914 Y115.049 E-0.15936

G1 X92.974 Y115.147 E-0.06366

G1 X93.008 Y115.301 E-0.08756

G1 X93.013 Y116.146 E-0.46806

G1 E-0.04800 F4200.00000

G1 Z4.750 F9000.000

G1 X82.950 Y115.220

G1 Z4.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.204 Y115.966 E0.02846

G1 X82.201 Y116.207 E0.00650

G1 X82.575 Y116.207 E0.01008

G1 X83.374 Y115.408 E0.03051

G1 X83.987 Y115.407 E0.01653

G1 X83.187 Y116.207 E0.03055

G1 X83.798 Y116.208 E0.01650

G1 X84.600 Y115.406 E0.03060

G1 X85.213 Y115.405 E0.01653

G1 X84.410 Y116.208 E0.03065

G1 X85.021 Y116.208 E0.01650

G1 X85.826 Y115.404 E0.03069

G1 X86.439 Y115.403 E0.01653

G1 X85.633 Y116.208 E0.03074

G1 X86.245 Y116.209 E0.01650

G1 X87.051 Y115.402 E0.03079

G1 X87.664 Y115.401 E0.01653

G1 X86.856 Y116.209 E0.03084

G1 X87.468 Y116.209 E0.01650

G1 X88.277 Y115.400 E0.03088

G1 X88.890 Y115.399 E0.01653

G1 X88.082 Y116.207 E0.03082

G1 X88.697 Y116.204 E0.01660

G1 X89.503 Y115.398 E0.03074

G1 X90.116 Y115.397 E0.01653

G1 X89.312 Y116.200 E0.03065

G1 X89.927 Y116.197 E0.01660

G1 X90.728 Y115.396 E0.03057

G1 X91.341 Y115.395 E0.01653

G1 X90.542 Y116.194 E0.03049

G1 X91.157 Y116.191 E0.01660

G1 X91.954 Y115.394 E0.03040

G1 X92.266 Y115.394 E0.00843

G1 X92.277 Y115.683 E0.00782

G1 X91.583 Y116.377 E0.02646

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;4.7

G1 Z4.700 F9000.000

;AFTER\_LAYER\_CHANGE

;4.7

G1 E-3.20000 F4200.00000

G1 Z4.900 F9000.000

G1 X92.522 Y45.897

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.232 Y45.876 E0.05968

G1 X81.955 Y45.900 E0.21565

G1 X81.893 Y45.700 E0.00547

G1 X81.888 Y44.677 E0.02665

G1 X91.236 Y44.667 E0.24357

G1 X92.586 Y44.681 E0.03517

G1 X92.581 Y45.780 E0.02861

G1 X92.554 Y45.846 E0.00187

M204 S1250

G1 X92.776 Y46.280 F9000.000

M204 S800

G1 F1500.000

G1 X92.694 Y46.317 E0.00236

G1 X90.230 Y46.293 E0.06419

G1 X81.802 Y46.318 E0.21960

G1 X81.722 Y46.271 E0.00244

G1 X81.619 Y46.170 E0.00376

G1 X81.532 Y45.979 E0.00547

G1 X81.476 Y45.778 E0.00542

G1 X81.470 Y44.628 E0.02998

G1 X81.521 Y44.418 E0.00562

G1 X81.663 Y44.272 E0.00532

G1 X81.764 Y44.251 E0.00268

G1 X91.238 Y44.250 E0.24686

G1 X92.840 Y44.279 E0.04176

G1 X92.889 Y44.318 E0.00164

G1 X93.004 Y44.560 E0.00698

G1 X92.998 Y45.835 E0.03321

G1 X92.957 Y45.989 E0.00416

G1 X92.808 Y46.229 E0.00735

M204 S1250

G1 X92.693 Y46.245 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.694 Y46.317 E-0.07995

G1 X91.192 Y46.303 E-0.83205

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.016 Y44.875

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.726 Y45.585 E0.02670

G1 X83.327 Y45.583 E0.01599

G1 X82.728 Y44.984 E0.02254

G1 X83.332 Y44.984 E0.01606

G1 X83.928 Y45.581 E0.02244

G1 X84.530 Y45.579 E0.01599

G1 X83.935 Y44.985 E0.02235

G1 X84.539 Y44.986 E0.01606

G1 X85.131 Y45.577 E0.02226

G1 X85.732 Y45.576 E0.01599

G1 X85.143 Y44.986 E0.02217

G1 X85.747 Y44.987 E0.01606

G1 X86.334 Y45.574 E0.02207

G1 X86.935 Y45.572 E0.01599

G1 X86.350 Y44.988 E0.02198

G1 X86.954 Y44.988 E0.01606

G1 X87.536 Y45.570 E0.02189

G1 X88.137 Y45.568 E0.01599

G1 X87.558 Y44.989 E0.02179

G1 X88.162 Y44.990 E0.01606

G1 X88.739 Y45.567 E0.02170

G1 X89.340 Y45.565 E0.01599

G1 X88.765 Y44.990 E0.02161

G1 X89.369 Y44.991 E0.01606

G1 X89.941 Y45.563 E0.02152

G1 X90.546 Y45.565 E0.01609

G1 X89.973 Y44.992 E0.02157

G1 X90.577 Y44.992 E0.01606

G1 X91.155 Y45.571 E0.02176

G1 X91.764 Y45.577 E0.01619

G1 X91.180 Y44.993 E0.02195

G1 X91.784 Y44.994 E0.01606

G1 X92.456 Y45.665 E0.02526

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.784 Y44.994 E-0.52633

G1 X91.180 Y44.993 E-0.33458

G1 X91.246 Y45.058 E-0.05109

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.539 Y50.425

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y50.568 E0.00395

G1 X92.594 Y51.613 E0.02725

G1 X89.864 Y51.635 E0.07114

G1 X81.885 Y51.631 E0.20788

G1 X81.897 Y50.559 E0.02794

G1 X81.957 Y50.378 E0.00496

G1 X92.479 Y50.425 E0.27417

M204 S1250

G1 X92.700 Y50.007 F9000.000

M204 S800

G1 F1500.000

G1 X92.796 Y50.043 E0.00265

G1 X92.842 Y50.100 E0.00191

G1 X92.967 Y50.344 E0.00714

G1 X93.010 Y50.516 E0.00463

G1 X93.012 Y51.692 E0.03063

G1 X92.964 Y51.879 E0.00504

G1 X92.934 Y51.927 E0.00145

G1 X92.805 Y52.029 E0.00430

G1 X89.865 Y52.053 E0.07661

G1 X81.771 Y52.049 E0.21090

G1 X81.629 Y52.010 E0.00383

G1 X81.552 Y51.938 E0.00276

G1 X81.485 Y51.775 E0.00460

G1 X81.468 Y51.667 E0.00283

G1 X81.481 Y50.489 E0.03070

G1 X81.590 Y50.156 E0.00912

G1 X81.698 Y50.039 E0.00416

G1 X81.811 Y49.960 E0.00361

G1 X92.640 Y50.007 E0.28216

M204 S1250

G1 X92.729 Y50.105 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.796 Y50.043 E-0.08823

G1 X92.842 Y50.100 E-0.04069

G1 X92.967 Y50.344 E-0.15194

G1 X93.010 Y50.516 E-0.09855

G1 X93.011 Y51.478 E-0.53258

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.022 Y50.650

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.690 Y51.318 E0.02520

G1 X83.295 Y51.318 E0.01614

G1 X82.671 Y50.695 E0.02353

G1 X83.279 Y50.698 E0.01621

G1 X83.900 Y51.319 E0.02343

G1 X84.505 Y51.319 E0.01614

G1 X83.887 Y50.700 E0.02334

G1 X84.494 Y50.703 E0.01621

G1 X85.111 Y51.319 E0.02324

G1 X85.716 Y51.320 E0.01614

G1 X85.102 Y50.706 E0.02315

G1 X85.710 Y50.709 E0.01621

G1 X86.321 Y51.320 E0.02305

G1 X86.926 Y51.320 E0.01614

G1 X86.318 Y50.712 E0.02296

G1 X86.925 Y50.715 E0.01621

G1 X87.532 Y51.321 E0.02286

G1 X88.137 Y51.321 E0.01614

G1 X87.533 Y50.718 E0.02277

G1 X88.141 Y50.720 E0.01621

G1 X88.742 Y51.321 E0.02267

G1 X89.347 Y51.322 E0.01614

G1 X88.749 Y50.723 E0.02258

G1 X89.357 Y50.726 E0.01621

G1 X89.952 Y51.321 E0.02246

G1 X90.552 Y51.317 E0.01601

G1 X89.964 Y50.729 E0.02216

G1 X90.572 Y50.732 E0.01621

G1 X91.152 Y51.312 E0.02187

G1 X91.752 Y51.307 E0.01601

G1 X91.180 Y50.735 E0.02158

G1 X91.788 Y50.738 E0.01621

G1 X92.468 Y51.418 E0.02567

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.788 Y50.738 E-0.53328

G1 X91.180 Y50.735 E-0.33681

G1 X91.233 Y50.788 E-0.04191

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.404 Y57.677

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.586 Y57.679 E0.00473

G1 X92.581 Y58.777 E0.02861

G1 X92.522 Y58.895 E0.00343

G1 X90.232 Y58.874 E0.05968

G1 X81.955 Y58.898 E0.21565

G1 X81.893 Y58.698 E0.00547

G1 X81.890 Y57.666 E0.02687

G1 X92.344 Y57.677 E0.27239

M204 S1250

G1 X92.726 Y57.263 F9000.000

M204 S800

G1 F1500.000

G1 X92.841 Y57.277 E0.00301

G1 X92.890 Y57.316 E0.00162

G1 X93.004 Y57.558 E0.00698

G1 X92.998 Y58.832 E0.03321

G1 X92.957 Y58.987 E0.00416

G1 X92.776 Y59.278 E0.00892

G1 X92.694 Y59.315 E0.00236

G1 X90.230 Y59.291 E0.06419

G1 X81.802 Y59.316 E0.21960

G1 X81.722 Y59.269 E0.00244

G1 X81.619 Y59.168 E0.00376

G1 X81.532 Y58.977 E0.00547

G1 X81.476 Y58.776 E0.00542

G1 X81.470 Y57.626 E0.02998

G1 X81.521 Y57.416 E0.00562

G1 X81.664 Y57.270 E0.00534

G1 X81.764 Y57.248 E0.00268

G1 X91.238 Y57.248 E0.24684

G1 X92.666 Y57.262 E0.03721

M204 S1250

G1 X92.775 Y57.367 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.841 Y57.277 E-0.09721

G1 X92.890 Y57.316 E-0.03452

G1 X93.004 Y57.558 E-0.14835

G1 X92.999 Y58.698 E-0.63191

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.016 Y57.873

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.726 Y58.583 E0.02670

G1 X83.327 Y58.581 E0.01599

G1 X82.727 Y57.981 E0.02257

G1 X83.331 Y57.981 E0.01606

G1 X83.928 Y58.579 E0.02248

G1 X84.530 Y58.577 E0.01599

G1 X83.935 Y57.982 E0.02238

G1 X84.538 Y57.983 E0.01606

G1 X85.131 Y58.575 E0.02229

G1 X85.732 Y58.574 E0.01599

G1 X85.142 Y57.984 E0.02219

G1 X85.746 Y57.984 E0.01606

G1 X86.334 Y58.572 E0.02210

G1 X86.935 Y58.570 E0.01599

G1 X86.350 Y57.985 E0.02200

G1 X86.954 Y57.986 E0.01606

G1 X87.536 Y58.568 E0.02191

G1 X88.137 Y58.566 E0.01599

G1 X87.557 Y57.986 E0.02182

G1 X88.161 Y57.987 E0.01606

G1 X88.739 Y58.565 E0.02172

G1 X89.340 Y58.563 E0.01599

G1 X88.765 Y57.988 E0.02163

G1 X89.369 Y57.989 E0.01606

G1 X89.941 Y58.561 E0.02153

G1 X90.547 Y58.563 E0.01609

G1 X89.973 Y57.989 E0.02158

G1 X90.577 Y57.990 E0.01606

G1 X91.155 Y58.569 E0.02177

G1 X91.764 Y58.575 E0.01619

G1 X91.180 Y57.991 E0.02196

G1 X91.784 Y57.992 E0.01606

G1 X92.456 Y58.663 E0.02526

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.784 Y57.992 E-0.52638

G1 X91.180 Y57.991 E-0.33461

G1 X91.245 Y58.056 E-0.05100

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.539 Y63.423

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y63.565 E0.00395

G1 X92.594 Y64.611 E0.02724

G1 X89.864 Y64.633 E0.07114

G1 X81.885 Y64.629 E0.20788

G1 X81.897 Y63.557 E0.02793

G1 X81.957 Y63.376 E0.00496

G1 X92.479 Y63.423 E0.27418

M204 S1250

G1 X92.701 Y63.005 F9000.000

M204 S800

G1 F1500.000

G1 X92.795 Y63.040 E0.00263

G1 X92.842 Y63.097 E0.00192

G1 X92.967 Y63.341 E0.00714

G1 X93.010 Y63.514 E0.00464

G1 X93.012 Y64.690 E0.03063

G1 X92.964 Y64.877 E0.00502

G1 X92.934 Y64.925 E0.00147

G1 X92.806 Y65.027 E0.00427

G1 X89.865 Y65.051 E0.07662

G1 X81.771 Y65.046 E0.21090

G1 X81.629 Y65.008 E0.00383

G1 X81.552 Y64.936 E0.00276

G1 X81.485 Y64.773 E0.00460

G1 X81.468 Y64.665 E0.00283

G1 X81.481 Y63.487 E0.03070

G1 X81.590 Y63.154 E0.00912

G1 X81.698 Y63.037 E0.00416

G1 X81.811 Y62.958 E0.00361

G1 X92.641 Y63.005 E0.28217

M204 S1250

G1 X92.729 Y63.102 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.795 Y63.040 E-0.08794

G1 X92.842 Y63.097 E-0.04081

G1 X92.967 Y63.341 E-0.15182

G1 X93.010 Y63.514 E-0.09879

G1 X93.011 Y64.476 E-0.53265

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.022 Y63.648

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.690 Y64.316 E0.02520

G1 X83.295 Y64.316 E0.01614

G1 X82.672 Y63.693 E0.02351

G1 X83.279 Y63.696 E0.01621

G1 X83.900 Y64.316 E0.02342

G1 X84.505 Y64.317 E0.01614

G1 X83.887 Y63.698 E0.02333

G1 X84.495 Y63.701 E0.01621

G1 X85.111 Y64.317 E0.02323

G1 X85.716 Y64.318 E0.01614

G1 X85.103 Y63.704 E0.02314

G1 X85.710 Y63.707 E0.01621

G1 X86.321 Y64.318 E0.02305

G1 X86.926 Y64.318 E0.01614

G1 X86.318 Y63.710 E0.02295

G1 X86.926 Y63.713 E0.01621

G1 X87.532 Y64.319 E0.02286

G1 X88.137 Y64.319 E0.01614

G1 X87.533 Y63.716 E0.02276

G1 X88.141 Y63.718 E0.01621

G1 X88.742 Y64.319 E0.02267

G1 X89.347 Y64.320 E0.01614

G1 X88.749 Y63.721 E0.02258

G1 X89.357 Y63.724 E0.01621

G1 X89.952 Y64.319 E0.02245

G1 X90.552 Y64.314 E0.01600

G1 X89.964 Y63.727 E0.02216

G1 X90.572 Y63.730 E0.01621

G1 X91.152 Y64.309 E0.02186

G1 X91.752 Y64.304 E0.01600

G1 X91.180 Y63.733 E0.02157

G1 X91.788 Y63.736 E0.01621

G1 X92.468 Y64.416 E0.02567

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.788 Y63.736 E-0.53325

G1 X91.180 Y63.733 E-0.33679

G1 X91.233 Y63.786 E-0.04196

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.404 Y70.675

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.586 Y70.677 E0.00473

G1 X92.581 Y71.775 E0.02861

G1 X92.522 Y71.893 E0.00343

G1 X90.232 Y71.872 E0.05968

G1 X81.955 Y71.895 E0.21566

G1 X81.893 Y71.696 E0.00545

G1 X81.890 Y70.664 E0.02687

G1 X92.344 Y70.675 E0.27239

M204 S1250

G1 X92.727 Y70.261 F9000.000

M204 S800

G1 F1500.000

G1 X92.841 Y70.274 E0.00300

G1 X92.889 Y70.313 E0.00162

G1 X93.004 Y70.556 E0.00699

G1 X92.998 Y71.830 E0.03321

G1 X92.957 Y71.985 E0.00416

G1 X92.776 Y72.276 E0.00892

G1 X92.694 Y72.313 E0.00236

G1 X90.230 Y72.289 E0.06419

G1 X81.802 Y72.314 E0.21961

G1 X81.722 Y72.266 E0.00243

G1 X81.619 Y72.166 E0.00375

G1 X81.532 Y71.975 E0.00547

G1 X81.476 Y71.774 E0.00542

G1 X81.470 Y70.624 E0.02998

G1 X81.521 Y70.414 E0.00562

G1 X81.663 Y70.267 E0.00534

G1 X81.764 Y70.246 E0.00267

G1 X91.238 Y70.246 E0.24685

G1 X92.667 Y70.260 E0.03722

M204 S1250

G1 X92.776 Y70.365 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.841 Y70.274 E-0.09685

G1 X92.889 Y70.313 E-0.03451

G1 X93.004 Y70.556 E-0.14863

G1 X92.999 Y71.696 E-0.63201

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.016 Y70.870

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.726 Y71.580 E0.02669

G1 X83.327 Y71.578 E0.01599

G1 X82.727 Y70.979 E0.02255

G1 X83.331 Y70.979 E0.01606

G1 X83.928 Y71.576 E0.02246

G1 X84.530 Y71.575 E0.01599

G1 X83.935 Y70.980 E0.02236

G1 X84.539 Y70.981 E0.01606

G1 X85.131 Y71.573 E0.02227

G1 X85.732 Y71.571 E0.01599

G1 X85.142 Y70.982 E0.02218

G1 X85.746 Y70.982 E0.01606

G1 X86.334 Y71.570 E0.02209

G1 X86.935 Y71.568 E0.01599

G1 X86.350 Y70.983 E0.02199

G1 X86.954 Y70.984 E0.01606

G1 X87.536 Y71.566 E0.02190

G1 X88.138 Y71.564 E0.01599

G1 X87.558 Y70.984 E0.02181

G1 X88.161 Y70.985 E0.01606

G1 X88.739 Y71.563 E0.02172

G1 X89.340 Y71.561 E0.01599

G1 X88.765 Y70.986 E0.02162

G1 X89.369 Y70.987 E0.01606

G1 X89.942 Y71.559 E0.02153

G1 X90.547 Y71.561 E0.01609

G1 X89.973 Y70.987 E0.02158

G1 X90.577 Y70.988 E0.01606

G1 X91.155 Y71.567 E0.02177

G1 X91.764 Y71.573 E0.01619

G1 X91.180 Y70.989 E0.02196

G1 X91.784 Y70.990 E0.01606

G1 X92.456 Y71.661 E0.02526

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.784 Y70.990 E-0.52636

G1 X91.180 Y70.989 E-0.33460

G1 X91.246 Y71.054 E-0.05104

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.539 Y76.421

G1 Z4.700

G1 E3.20000 F2400.00000

M73 P54 R32

M204 S800

G1 F1500.000

G1 X92.592 Y76.563 E0.00395

G1 X92.594 Y77.608 E0.02723

G1 X89.864 Y77.631 E0.07114

G1 X81.885 Y77.627 E0.20788

G1 X81.897 Y76.554 E0.02795

G1 X81.957 Y76.373 E0.00495

G1 X92.479 Y76.421 E0.27418

M204 S1250

G1 X92.701 Y76.003 F9000.000

M204 S800

G1 F1500.000

G1 X92.795 Y76.038 E0.00263

G1 X92.842 Y76.095 E0.00192

G1 X92.967 Y76.339 E0.00714

G1 X93.010 Y76.512 E0.00464

G1 X93.012 Y77.688 E0.03063

G1 X92.964 Y77.874 E0.00502

G1 X92.934 Y77.922 E0.00147

G1 X92.806 Y78.024 E0.00428

G1 X89.865 Y78.049 E0.07662

G1 X81.771 Y78.044 E0.21090

G1 X81.629 Y78.006 E0.00383

G1 X81.552 Y77.934 E0.00276

G1 X81.485 Y77.771 E0.00460

G1 X81.468 Y77.663 E0.00283

G1 X81.481 Y76.484 E0.03073

G1 X81.590 Y76.152 E0.00911

G1 X81.698 Y76.034 E0.00416

G1 X81.811 Y75.955 E0.00360

G1 X92.641 Y76.003 E0.28217

M204 S1250

G1 X92.729 Y76.100 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.795 Y76.038 E-0.08794

G1 X92.842 Y76.095 E-0.04081

G1 X92.967 Y76.339 E-0.15182

G1 X93.010 Y76.512 E-0.09879

G1 X93.011 Y77.474 E-0.53265

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.022 Y76.646

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.690 Y77.314 E0.02519

G1 X83.295 Y77.314 E0.01614

G1 X82.671 Y76.690 E0.02353

G1 X83.279 Y76.693 E0.01621

G1 X83.900 Y77.314 E0.02343

G1 X84.505 Y77.315 E0.01614

G1 X83.887 Y76.696 E0.02334

G1 X84.494 Y76.699 E0.01621

G1 X85.110 Y77.315 E0.02324

G1 X85.716 Y77.315 E0.01614

G1 X85.102 Y76.702 E0.02314

G1 X85.710 Y76.705 E0.01621

G1 X86.321 Y77.316 E0.02305

G1 X86.926 Y77.316 E0.01614

G1 X86.318 Y76.708 E0.02295

G1 X86.925 Y76.710 E0.01621

G1 X87.531 Y77.316 E0.02286

G1 X88.137 Y77.317 E0.01614

G1 X87.533 Y76.713 E0.02276

G1 X88.141 Y76.716 E0.01621

G1 X88.742 Y77.317 E0.02266

G1 X89.347 Y77.317 E0.01614

G1 X88.749 Y76.719 E0.02257

G1 X89.357 Y76.722 E0.01621

G1 X89.951 Y77.317 E0.02244

G1 X90.551 Y77.312 E0.01600

G1 X89.964 Y76.725 E0.02214

G1 X90.572 Y76.728 E0.01621

G1 X91.151 Y77.307 E0.02185

G1 X91.751 Y77.302 E0.01600

G1 X91.180 Y76.731 E0.02155

G1 X91.788 Y76.734 E0.01621

G1 X92.468 Y77.414 E0.02567

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.788 Y76.734 E-0.53327

G1 X91.180 Y76.731 E-0.33681

G1 X91.233 Y76.784 E-0.04192

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.404 Y83.673

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.586 Y83.675 E0.00473

G1 X92.581 Y84.773 E0.02860

G1 X92.523 Y84.890 E0.00341

G1 X90.232 Y84.869 E0.05969

G1 X81.955 Y84.893 E0.21566

G1 X81.893 Y84.693 E0.00545

G1 X81.890 Y83.662 E0.02687

G1 X92.344 Y83.673 E0.27239

M204 S1250

G1 X92.727 Y83.259 F9000.000

M204 S800

G1 F1500.000

G1 X92.841 Y83.272 E0.00300

G1 X92.889 Y83.311 E0.00162

G1 X93.004 Y83.554 E0.00699

G1 X92.998 Y84.828 E0.03320

G1 X92.957 Y84.983 E0.00417

G1 X92.777 Y85.273 E0.00890

G1 X92.694 Y85.310 E0.00235

G1 X90.230 Y85.287 E0.06419

G1 X81.802 Y85.311 E0.21961

G1 X81.721 Y85.264 E0.00243

G1 X81.619 Y85.164 E0.00374

G1 X81.532 Y84.972 E0.00550

G1 X81.476 Y84.772 E0.00539

G1 X81.470 Y83.622 E0.02998

G1 X81.521 Y83.412 E0.00562

G1 X81.663 Y83.265 E0.00534

G1 X81.764 Y83.244 E0.00267

G1 X91.238 Y83.244 E0.24685

G1 X92.667 Y83.258 E0.03722

M204 S1250

G1 X92.776 Y83.363 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.841 Y83.272 E-0.09687

G1 X92.889 Y83.311 E-0.03449

G1 X93.004 Y83.554 E-0.14864

G1 X92.999 Y84.694 E-0.63200

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.016 Y83.868

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.726 Y84.578 E0.02669

G1 X83.327 Y84.576 E0.01599

G1 X82.728 Y83.977 E0.02254

G1 X83.331 Y83.977 E0.01606

G1 X83.928 Y84.574 E0.02244

G1 X84.529 Y84.572 E0.01599

G1 X83.935 Y83.978 E0.02235

G1 X84.539 Y83.979 E0.01606

G1 X85.131 Y84.571 E0.02226

G1 X85.732 Y84.569 E0.01599

G1 X85.143 Y83.980 E0.02217

G1 X85.746 Y83.980 E0.01606

G1 X86.333 Y84.567 E0.02207

G1 X86.935 Y84.565 E0.01599

G1 X86.350 Y83.981 E0.02198

G1 X86.954 Y83.982 E0.01606

G1 X87.536 Y84.564 E0.02189

G1 X88.137 Y84.562 E0.01599

G1 X87.558 Y83.982 E0.02179

G1 X88.162 Y83.983 E0.01606

G1 X88.739 Y84.560 E0.02170

G1 X89.340 Y84.558 E0.01599

G1 X88.765 Y83.984 E0.02161

G1 X89.369 Y83.985 E0.01606

G1 X89.941 Y84.557 E0.02151

G1 X90.546 Y84.559 E0.01609

G1 X89.973 Y83.985 E0.02156

G1 X90.577 Y83.986 E0.01606

G1 X91.155 Y84.564 E0.02175

G1 X91.764 Y84.570 E0.01619

G1 X91.180 Y83.987 E0.02193

G1 X91.784 Y83.988 E0.01606

G1 X92.456 Y84.659 E0.02526

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.784 Y83.988 E-0.52633

G1 X91.180 Y83.987 E-0.33459

G1 X91.246 Y84.052 E-0.05108

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.539 Y89.418

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y89.561 E0.00395

G1 X92.594 Y90.606 E0.02725

G1 X89.864 Y90.629 E0.07114

G1 X81.885 Y90.624 E0.20788

G1 X81.897 Y89.552 E0.02794

G1 X81.957 Y89.371 E0.00495

G1 X92.479 Y89.418 E0.27417

M204 S1250

G1 X92.700 Y89.000 F9000.000

M204 S800

G1 F1500.000

G1 X92.795 Y89.036 E0.00265

G1 X92.842 Y89.093 E0.00192

G1 X92.967 Y89.337 E0.00714

G1 X93.010 Y89.509 E0.00463

G1 X93.012 Y90.686 E0.03065

G1 X92.964 Y90.872 E0.00502

G1 X92.934 Y90.920 E0.00147

G1 X92.806 Y91.022 E0.00428

G1 X89.865 Y91.047 E0.07662

G1 X81.771 Y91.042 E0.21090

G1 X81.629 Y91.003 E0.00384

G1 X81.551 Y90.932 E0.00275

G1 X81.485 Y90.769 E0.00459

G1 X81.468 Y90.661 E0.00283

G1 X81.481 Y89.482 E0.03073

G1 X81.590 Y89.150 E0.00911

G1 X81.698 Y89.032 E0.00416

G1 X81.811 Y88.953 E0.00361

G1 X92.640 Y89.000 E0.28216

M204 S1250

G1 X92.729 Y89.098 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.795 Y89.036 E-0.08830

G1 X92.842 Y89.093 E-0.04077

G1 X92.967 Y89.337 E-0.15180

G1 X93.010 Y89.509 E-0.09853

G1 X93.011 Y90.471 E-0.53260

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.022 Y89.643

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.690 Y90.311 E0.02520

G1 X83.295 Y90.312 E0.01615

G1 X82.672 Y89.688 E0.02352

G1 X83.279 Y89.691 E0.01621

G1 X83.900 Y90.312 E0.02343

G1 X84.506 Y90.312 E0.01615

G1 X83.887 Y89.694 E0.02333

G1 X84.495 Y89.697 E0.01621

G1 X85.111 Y90.313 E0.02324

G1 X85.716 Y90.313 E0.01615

G1 X85.102 Y89.699 E0.02315

G1 X85.710 Y89.702 E0.01621

G1 X86.321 Y90.313 E0.02305

G1 X86.927 Y90.314 E0.01615

G1 X86.318 Y89.705 E0.02296

G1 X86.926 Y89.708 E0.01621

G1 X87.532 Y90.314 E0.02287

G1 X88.137 Y90.315 E0.01615

G1 X87.533 Y89.711 E0.02278

G1 X88.141 Y89.714 E0.01621

G1 X88.742 Y90.315 E0.02268

G1 X89.348 Y90.315 E0.01615

G1 X88.749 Y89.716 E0.02259

G1 X89.357 Y89.719 E0.01621

G1 X89.952 Y90.315 E0.02247

G1 X90.552 Y90.310 E0.01600

G1 X89.964 Y89.722 E0.02217

G1 X90.572 Y89.725 E0.01621

G1 X91.152 Y90.305 E0.02188

G1 X91.752 Y90.300 E0.01600

G1 X91.180 Y89.728 E0.02159

G1 X91.788 Y89.731 E0.01621

G1 X92.468 Y90.411 E0.02567

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.788 Y89.731 E-0.53325

G1 X91.180 Y89.728 E-0.33679

G1 X91.233 Y89.781 E-0.04195

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.402 Y96.671

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.586 Y96.673 E0.00477

G1 X92.581 Y97.771 E0.02860

G1 X92.523 Y97.888 E0.00341

G1 X90.232 Y97.867 E0.05969

G1 X81.955 Y97.891 E0.21566

G1 X81.893 Y97.691 E0.00545

G1 X81.890 Y96.660 E0.02687

G1 X92.342 Y96.671 E0.27235

M204 S1250

G1 X92.726 Y96.257 F9000.000

M204 S800

G1 F1500.000

G1 X92.841 Y96.270 E0.00300

G1 X92.889 Y96.309 E0.00162

G1 X93.004 Y96.552 E0.00699

G1 X92.998 Y97.826 E0.03320

G1 X92.957 Y97.981 E0.00417

G1 X92.777 Y98.271 E0.00890

G1 X92.694 Y98.308 E0.00235

G1 X90.230 Y98.284 E0.06419

G1 X81.802 Y98.309 E0.21960

G1 X81.722 Y98.262 E0.00245

G1 X81.619 Y98.162 E0.00374

G1 X81.532 Y97.970 E0.00549

G1 X81.476 Y97.770 E0.00540

G1 X81.470 Y96.619 E0.02999

G1 X81.521 Y96.409 E0.00563

G1 X81.663 Y96.263 E0.00532

G1 X81.764 Y96.242 E0.00268

G1 X91.238 Y96.241 E0.24686

G1 X92.666 Y96.256 E0.03722

M204 S1250

G1 X92.776 Y96.361 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.841 Y96.270 E-0.09689

G1 X92.889 Y96.309 E-0.03449

G1 X93.004 Y96.552 E-0.14864

G1 X92.999 Y97.692 E-0.63198

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.016 Y96.866

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.726 Y97.576 E0.02670

G1 X83.327 Y97.574 E0.01599

G1 X82.727 Y96.973 E0.02258

G1 X83.330 Y96.973 E0.01604

G1 X83.928 Y97.572 E0.02251

G1 X84.530 Y97.570 E0.01599

G1 X83.933 Y96.973 E0.02245

G1 X84.536 Y96.973 E0.01604

G1 X85.131 Y97.568 E0.02239

G1 X85.732 Y97.567 E0.01599

G1 X85.139 Y96.973 E0.02232

G1 X85.742 Y96.973 E0.01604

G1 X86.333 Y97.565 E0.02226

G1 X86.935 Y97.563 E0.01599

G1 X86.345 Y96.973 E0.02219

G1 X86.948 Y96.973 E0.01604

G1 X87.536 Y97.561 E0.02213

G1 X88.137 Y97.559 E0.01599

G1 X87.551 Y96.973 E0.02206

G1 X88.154 Y96.973 E0.01604

G1 X88.739 Y97.558 E0.02200

G1 X89.340 Y97.556 E0.01599

G1 X88.757 Y96.973 E0.02194

G1 X89.360 Y96.973 E0.01604

G1 X89.941 Y97.554 E0.02187

G1 X90.547 Y97.556 E0.01610

G1 X89.963 Y96.973 E0.02195

G1 X90.566 Y96.972 E0.01604

G1 X91.155 Y97.562 E0.02217

G1 X91.764 Y97.568 E0.01619

G1 X91.169 Y96.972 E0.02239

G1 X91.234 Y96.972 E0.00175

G1 X91.778 Y96.978 E0.01445

G1 X92.456 Y97.656 E0.02551

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.778 Y96.978 E-0.53150

G1 X91.234 Y96.972 E-0.30102

G1 X91.169 Y96.972 E-0.03637

G1 X91.224 Y97.027 E-0.04312

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.539 Y102.416

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y102.559 E0.00395

G1 X92.594 Y103.604 E0.02725

G1 X89.864 Y103.627 E0.07114

G1 X81.885 Y103.622 E0.20788

G1 X81.897 Y102.550 E0.02794

G1 X81.957 Y102.369 E0.00495

G1 X92.479 Y102.416 E0.27417

M204 S1250

G1 X92.700 Y101.998 F9000.000

M204 S800

G1 F1500.000

G1 X92.796 Y102.034 E0.00265

G1 X92.842 Y102.091 E0.00191

G1 X92.967 Y102.335 E0.00714

G1 X93.010 Y102.507 E0.00463

G1 X93.012 Y103.683 E0.03064

G1 X92.964 Y103.870 E0.00503

G1 X92.934 Y103.918 E0.00145

G1 X92.805 Y104.020 E0.00430

G1 X89.865 Y104.045 E0.07661

G1 X81.771 Y104.040 E0.21090

G1 X81.629 Y104.001 E0.00384

G1 X81.551 Y103.929 E0.00275

G1 X81.485 Y103.766 E0.00459

G1 X81.468 Y103.659 E0.00283

G1 X81.481 Y102.480 E0.03073

G1 X81.590 Y102.148 E0.00911

G1 X81.698 Y102.030 E0.00416

G1 X81.811 Y101.951 E0.00360

G1 X92.640 Y101.998 E0.28217

M204 S1250

G1 X92.729 Y102.096 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.796 Y102.034 E-0.08822

G1 X92.842 Y102.091 E-0.04068

G1 X92.967 Y102.335 E-0.15194

G1 X93.010 Y102.507 E-0.09855

G1 X93.011 Y103.469 E-0.53260

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.022 Y102.641

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.690 Y103.309 E0.02520

G1 X83.295 Y103.310 E0.01615

G1 X82.672 Y102.686 E0.02352

G1 X83.279 Y102.689 E0.01621

G1 X83.900 Y103.310 E0.02343

G1 X84.506 Y103.310 E0.01615

G1 X83.887 Y102.692 E0.02333

G1 X84.495 Y102.695 E0.01621

G1 X85.111 Y103.311 E0.02324

G1 X85.716 Y103.311 E0.01615

G1 X85.102 Y102.697 E0.02315

G1 X85.710 Y102.700 E0.01621

G1 X86.321 Y103.311 E0.02305

G1 X86.927 Y103.312 E0.01615

G1 X86.318 Y102.703 E0.02296

G1 X86.926 Y102.706 E0.01621

G1 X87.532 Y103.312 E0.02287

G1 X88.137 Y103.313 E0.01615

G1 X87.533 Y102.709 E0.02278

G1 X88.141 Y102.712 E0.01621

G1 X88.742 Y103.313 E0.02268

G1 X89.348 Y103.313 E0.01615

G1 X88.749 Y102.714 E0.02259

G1 X89.357 Y102.717 E0.01621

G1 X89.952 Y103.313 E0.02247

G1 X90.552 Y103.308 E0.01600

G1 X89.964 Y102.720 E0.02217

G1 X90.572 Y102.723 E0.01621

G1 X91.152 Y103.303 E0.02188

G1 X91.752 Y103.298 E0.01600

G1 X91.180 Y102.726 E0.02159

G1 X91.788 Y102.729 E0.01621

G1 X92.468 Y103.409 E0.02567

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.788 Y102.729 E-0.53326

G1 X91.180 Y102.726 E-0.33679

G1 X91.233 Y102.779 E-0.04195

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.403 Y109.668

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.586 Y109.670 E0.00476

G1 X92.581 Y110.769 E0.02862

G1 X92.523 Y110.886 E0.00341

G1 X90.232 Y110.865 E0.05969

G1 X81.955 Y110.889 E0.21565

G1 X81.893 Y110.689 E0.00545

G1 X81.890 Y109.658 E0.02687

G1 X92.343 Y109.668 E0.27237

M204 S1250

G1 X92.726 Y109.254 F9000.000

M204 S800

G1 F1500.000

G1 X92.840 Y109.268 E0.00300

G1 X92.889 Y109.307 E0.00164

G1 X93.004 Y109.549 E0.00698

G1 X92.998 Y110.824 E0.03321

G1 X92.957 Y110.979 E0.00417

G1 X92.776 Y111.268 E0.00890

G1 X92.694 Y111.306 E0.00236

G1 X90.230 Y111.282 E0.06419

G1 X81.802 Y111.307 E0.21960

G1 X81.722 Y111.260 E0.00244

G1 X81.619 Y111.159 E0.00376

G1 X81.532 Y110.967 E0.00548

G1 X81.476 Y110.768 E0.00539

G1 X81.470 Y109.617 E0.03000

G1 X81.521 Y109.407 E0.00562

G1 X81.663 Y109.261 E0.00532

G1 X81.764 Y109.240 E0.00268

G1 X91.238 Y109.239 E0.24686

G1 X92.666 Y109.253 E0.03721

M204 S1250

G1 X92.775 Y109.358 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.840 Y109.268 E-0.09694

G1 X92.889 Y109.307 E-0.03480

G1 X93.004 Y109.549 E-0.14841

G1 X92.999 Y110.690 E-0.63186

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.016 Y109.864

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.726 Y110.574 E0.02670

G1 X83.327 Y110.572 E0.01599

G1 X82.728 Y109.973 E0.02254

G1 X83.332 Y109.973 E0.01606

G1 X83.928 Y110.570 E0.02244

G1 X84.530 Y110.568 E0.01599

G1 X83.935 Y109.974 E0.02235

G1 X84.539 Y109.975 E0.01606

G1 X85.131 Y110.566 E0.02226

G1 X85.732 Y110.565 E0.01599

G1 X85.143 Y109.975 E0.02217

G1 X85.747 Y109.976 E0.01606

G1 X86.333 Y110.563 E0.02207

G1 X86.935 Y110.561 E0.01599

G1 X86.350 Y109.977 E0.02198

G1 X86.954 Y109.977 E0.01606

G1 X87.536 Y110.559 E0.02189

G1 X88.137 Y110.557 E0.01599

G1 X87.558 Y109.978 E0.02179

G1 X88.162 Y109.979 E0.01606

G1 X88.739 Y110.556 E0.02170

G1 X89.340 Y110.554 E0.01599

G1 X88.765 Y109.979 E0.02161

G1 X89.369 Y109.980 E0.01606

G1 X89.941 Y110.552 E0.02152

G1 X90.546 Y110.554 E0.01609

G1 X89.973 Y109.981 E0.02157

G1 X90.577 Y109.981 E0.01606

G1 X91.155 Y110.560 E0.02176

G1 X91.764 Y110.566 E0.01619

G1 X91.180 Y109.982 E0.02195

G1 X91.784 Y109.983 E0.01606

G1 X92.456 Y110.654 E0.02526

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.784 Y109.983 E-0.52634

G1 X91.180 Y109.982 E-0.33459

G1 X91.246 Y110.047 E-0.05108

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X92.539 Y115.414

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y115.557 E0.00395

G1 X92.594 Y116.602 E0.02725

G1 X89.864 Y116.625 E0.07114

G1 X81.885 Y116.620 E0.20788

G1 X81.897 Y115.548 E0.02794

G1 X81.957 Y115.367 E0.00495

G1 X92.479 Y115.414 E0.27417

M204 S1250

G1 X92.700 Y114.996 F9000.000

M204 S800

G1 F1500.000

G1 X92.796 Y115.032 E0.00265

G1 X92.842 Y115.089 E0.00191

G1 X92.967 Y115.333 E0.00714

G1 X93.010 Y115.505 E0.00463

G1 X93.012 Y116.681 E0.03064

G1 X92.964 Y116.868 E0.00503

G1 X92.934 Y116.916 E0.00145

G1 X92.805 Y117.018 E0.00430

G1 X89.865 Y117.043 E0.07661

G1 X81.771 Y117.038 E0.21090

G1 X81.629 Y116.999 E0.00383

G1 X81.551 Y116.927 E0.00277

G1 X81.485 Y116.764 E0.00458

G1 X81.468 Y116.657 E0.00283

G1 X81.481 Y115.478 E0.03073

G1 X81.590 Y115.146 E0.00911

G1 X81.698 Y115.028 E0.00416

G1 X81.811 Y114.949 E0.00360

G1 X92.640 Y114.996 E0.28217

M204 S1250

G1 X92.729 Y115.094 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.796 Y115.032 E-0.08822

G1 X92.842 Y115.089 E-0.04068

G1 X92.967 Y115.333 E-0.15194

G1 X93.010 Y115.505 E-0.09855

G1 X93.011 Y116.467 E-0.53260

G1 E-0.04800 F4200.00000

G1 Z4.900 F9000.000

G1 X82.022 Y115.639

G1 Z4.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.690 Y116.307 E0.02520

G1 X83.295 Y116.308 E0.01615

G1 X82.672 Y115.684 E0.02352

G1 X83.279 Y115.687 E0.01621

G1 X83.900 Y116.308 E0.02343

G1 X84.506 Y116.308 E0.01615

G1 X83.887 Y115.690 E0.02333

G1 X84.495 Y115.693 E0.01621

G1 X85.111 Y116.309 E0.02324

G1 X85.716 Y116.309 E0.01615

G1 X85.102 Y115.695 E0.02315

G1 X85.710 Y115.698 E0.01621

G1 X86.321 Y116.309 E0.02305

G1 X86.927 Y116.310 E0.01615

G1 X86.318 Y115.701 E0.02296

G1 X86.926 Y115.704 E0.01621

G1 X87.532 Y116.310 E0.02287

G1 X88.137 Y116.311 E0.01615

G1 X87.533 Y115.707 E0.02278

G1 X88.141 Y115.710 E0.01621

G1 X88.742 Y116.311 E0.02268

G1 X89.348 Y116.311 E0.01615

G1 X88.749 Y115.712 E0.02259

G1 X89.357 Y115.715 E0.01621

G1 X89.952 Y116.311 E0.02247

G1 X90.552 Y116.306 E0.01600

G1 X89.964 Y115.718 E0.02217

G1 X90.572 Y115.721 E0.01621

G1 X91.152 Y116.301 E0.02188

G1 X91.752 Y116.296 E0.01600

G1 X91.180 Y115.724 E0.02159

G1 X91.788 Y115.727 E0.01621

G1 X92.468 Y116.407 E0.02567

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;4.85

G1 Z4.850 F9000.000

;AFTER\_LAYER\_CHANGE

;4.85

G1 X92.592 Y116.722

M204 S800

G1 F1500.000

G1 X86.103 Y116.706 E0.16908

G1 X81.888 Y116.719 E0.10981

G1 X81.884 Y115.836 E0.02303

G1 X81.921 Y115.631 E0.00542

G1 X92.550 Y115.621 E0.27696

G1 X92.592 Y115.701 E0.00236

G1 X92.592 Y116.662 E0.02506

M204 S1250

G1 X92.932 Y117.022 F9000.000

M204 S800

G1 F1500.000

G1 X92.751 Y117.141 E0.00563

G1 X86.103 Y117.124 E0.17323

G1 X81.770 Y117.138 E0.11290

G1 X81.634 Y117.102 E0.00366

G1 X81.555 Y117.032 E0.00275

G1 X81.470 Y116.788 E0.00672

G1 X81.466 Y115.799 E0.02577

G1 X81.550 Y115.416 E0.01023

G1 X81.616 Y115.314 E0.00316

G1 X81.799 Y115.213 E0.00545

G1 X92.687 Y115.203 E0.28368

G1 X92.774 Y115.248 E0.00256

G1 X92.896 Y115.380 E0.00470

G1 X93.010 Y115.638 E0.00735

G1 X93.010 Y116.814 E0.03063

G1 X92.953 Y116.965 E0.00422

M204 S1250

G1 X92.718 Y116.988 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.751 Y117.141 E-0.14798

G1 X91.373 Y117.137 E-0.76402

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.866 Y115.755

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.219 Y116.403 E0.02418

G1 X82.820 Y116.401 E0.01586

G1 X83.278 Y115.943 E0.01711

G1 X83.877 Y115.943 E0.01584

G1 X83.420 Y116.400 E0.01707

G1 X84.021 Y116.398 E0.01586

G1 X84.477 Y115.942 E0.01703

G1 X85.076 Y115.942 E0.01584

G1 X84.621 Y116.397 E0.01699

G1 X85.222 Y116.395 E0.01586

G1 X85.676 Y115.941 E0.01696

G1 X86.275 Y115.941 E0.01584

G1 X85.823 Y116.394 E0.01692

G1 X86.422 Y116.394 E0.01582

G1 X86.875 Y115.940 E0.01694

G1 X87.474 Y115.940 E0.01584

G1 X87.019 Y116.395 E0.01701

G1 X87.617 Y116.397 E0.01579

G1 X88.074 Y115.939 E0.01708

G1 X88.673 Y115.939 E0.01584

G1 X88.214 Y116.398 E0.01716

G1 X88.812 Y116.400 E0.01579

G1 X89.273 Y115.938 E0.01723

G1 X89.872 Y115.938 E0.01584

G1 X89.409 Y116.401 E0.01730

G1 X90.007 Y116.403 E0.01579

G1 X90.472 Y115.938 E0.01737

G1 X91.071 Y115.937 E0.01584

G1 X90.604 Y116.404 E0.01745

G1 X91.202 Y116.406 E0.01579

G1 X91.671 Y115.937 E0.01752

G1 X92.271 Y115.936 E0.01584

G1 X91.612 Y116.595 E0.02460

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.271 Y115.936 E-0.51603

G1 X91.671 Y115.937 E-0.33223

G1 X91.590 Y116.018 E-0.06374

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.533 Y110.674

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.843 Y110.648 E0.07009

G1 X81.929 Y110.635 E0.20621

G1 X81.894 Y110.556 E0.00224

G1 X81.891 Y109.567 E0.02578

G1 X90.163 Y109.557 E0.21552

G1 X92.590 Y109.582 E0.06325

G1 X92.583 Y110.544 E0.02505

G1 X92.554 Y110.618 E0.00207

M204 S1250

G1 X92.785 Y111.032 F9000.000

M204 S800

G1 F1500.000

G1 X92.681 Y111.093 E0.00313

G1 X89.841 Y111.066 E0.07401

G1 X81.790 Y111.052 E0.20975

G1 X81.661 Y110.993 E0.00372

G1 X81.606 Y110.938 E0.00203

G1 X81.476 Y110.613 E0.00910

G1 X81.473 Y109.470 E0.02980

G1 X81.525 Y109.305 E0.00449

G1 X81.659 Y109.164 E0.00509

G1 X81.758 Y109.150 E0.00259

G1 X90.165 Y109.140 E0.21906

G1 X92.841 Y109.177 E0.06974

G1 X92.899 Y109.225 E0.00197

G1 X93.009 Y109.462 E0.00681

G1 X93.000 Y110.623 E0.03026

G1 X92.889 Y110.910 E0.00801

G1 X92.824 Y110.986 E0.00262

M204 S1250

G1 X92.671 Y110.993 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.681 Y111.093 E-0.09868

G1 X91.213 Y111.079 E-0.81332

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.874 Y109.691

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.244 Y110.322 E0.02356

G1 X82.842 Y110.323 E0.01579

G1 X83.286 Y109.879 E0.01659

G1 X83.886 Y109.878 E0.01584

G1 X83.440 Y110.324 E0.01666

G1 X84.037 Y110.325 E0.01579

G1 X84.485 Y109.877 E0.01672

G1 X85.085 Y109.877 E0.01584

G1 X84.635 Y110.326 E0.01679

G1 X85.233 Y110.327 E0.01579

G1 X85.684 Y109.876 E0.01685

G1 X86.284 Y109.875 E0.01584

G1 X85.831 Y110.328 E0.01692

G1 X86.429 Y110.329 E0.01579

G1 X86.884 Y109.875 E0.01698

G1 X87.483 Y109.874 E0.01584

G1 X87.027 Y110.330 E0.01705

G1 X87.625 Y110.331 E0.01579

G1 X88.083 Y109.873 E0.01711

G1 X88.683 Y109.872 E0.01584

G1 X88.223 Y110.332 E0.01718

G1 X88.821 Y110.333 E0.01579

G1 X89.282 Y109.872 E0.01724

G1 X89.882 Y109.871 E0.01584

G1 X89.419 Y110.334 E0.01731

G1 X90.015 Y110.337 E0.01576

G1 X90.478 Y109.874 E0.01728

G1 X91.071 Y109.880 E0.01566

G1 X90.609 Y110.342 E0.01726

G1 X91.202 Y110.348 E0.01567

G1 X91.664 Y109.886 E0.01724

G1 X92.256 Y109.892 E0.01566

G1 X91.609 Y110.540 E0.02418

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.256 Y109.892 E-0.50732

G1 X91.664 Y109.886 E-0.32853

G1 X91.567 Y109.983 E-0.07615

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.592 Y103.724

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.103 Y103.708 E0.16908

G1 X81.888 Y103.721 E0.10982

G1 X81.884 Y102.838 E0.02303

G1 X81.921 Y102.633 E0.00542

G1 X92.550 Y102.623 E0.27696

G1 X92.592 Y102.703 E0.00236

G1 X92.592 Y103.664 E0.02506

M204 S1250

G1 X92.932 Y104.024 F9000.000

M204 S800

G1 F1500.000

G1 X92.751 Y104.143 E0.00563

G1 X86.103 Y104.126 E0.17323

G1 X81.770 Y104.140 E0.11290

G1 X81.634 Y104.104 E0.00366

G1 X81.555 Y104.034 E0.00275

G1 X81.470 Y103.791 E0.00672

G1 X81.466 Y102.801 E0.02577

G1 X81.550 Y102.418 E0.01023

G1 X81.616 Y102.316 E0.00316

G1 X81.799 Y102.215 E0.00545

G1 X92.687 Y102.205 E0.28368

G1 X92.774 Y102.250 E0.00256

G1 X92.896 Y102.382 E0.00470

G1 X93.010 Y102.640 E0.00735

G1 X93.010 Y103.816 E0.03063

G1 X92.953 Y103.967 E0.00422

M204 S1250

G1 X92.718 Y103.990 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.751 Y104.143 E-0.14798

G1 X91.373 Y104.139 E-0.76402

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.866 Y102.757

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.219 Y103.405 E0.02418

G1 X82.820 Y103.403 E0.01586

G1 X83.278 Y102.945 E0.01711

G1 X83.877 Y102.945 E0.01584

G1 X83.420 Y103.402 E0.01707

G1 X84.021 Y103.400 E0.01586

G1 X84.477 Y102.944 E0.01703

G1 X85.076 Y102.944 E0.01584

G1 X84.621 Y103.399 E0.01700

G1 X85.222 Y103.397 E0.01586

G1 X85.676 Y102.943 E0.01696

G1 X86.275 Y102.943 E0.01584

G1 X85.823 Y103.396 E0.01692

G1 X86.422 Y103.396 E0.01582

G1 X86.875 Y102.942 E0.01694

G1 X87.474 Y102.942 E0.01584

G1 X87.019 Y103.397 E0.01701

G1 X87.617 Y103.399 E0.01579

G1 X88.074 Y102.941 E0.01708

G1 X88.673 Y102.941 E0.01584

G1 X88.214 Y103.400 E0.01716

G1 X88.812 Y103.402 E0.01579

G1 X89.273 Y102.940 E0.01723

G1 X89.872 Y102.940 E0.01584

G1 X89.409 Y103.403 E0.01730

G1 X90.007 Y103.405 E0.01579

G1 X90.472 Y102.940 E0.01737

G1 X91.071 Y102.939 E0.01584

G1 X90.604 Y103.406 E0.01745

G1 X91.202 Y103.408 E0.01579

G1 X91.671 Y102.939 E0.01752

G1 X92.271 Y102.938 E0.01584

G1 X91.612 Y103.597 E0.02460

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.271 Y102.938 E-0.51603

G1 X91.671 Y102.939 E-0.33223

G1 X91.590 Y103.020 E-0.06374

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.533 Y97.676

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.843 Y97.650 E0.07009

G1 X81.928 Y97.637 E0.20622

G1 X81.894 Y97.558 E0.00223

G1 X81.891 Y96.569 E0.02578

G1 X90.163 Y96.560 E0.21552

G1 X92.590 Y96.585 E0.06325

G1 X92.583 Y97.546 E0.02503

G1 X92.554 Y97.620 E0.00207

M204 S1250

G1 X92.785 Y98.035 F9000.000

M204 S800

G1 F1500.000

G1 X92.681 Y98.095 E0.00311

G1 X89.841 Y98.068 E0.07402

G1 X81.790 Y98.054 E0.20975

G1 X81.661 Y97.995 E0.00372

G1 X81.606 Y97.940 E0.00203

G1 X81.476 Y97.615 E0.00910

G1 X81.473 Y96.472 E0.02980

G1 X81.525 Y96.307 E0.00448

G1 X81.659 Y96.166 E0.00509

G1 X81.758 Y96.152 E0.00259

G1 X90.165 Y96.142 E0.21906

G1 X92.841 Y96.179 E0.06975

G1 X92.899 Y96.227 E0.00196

G1 X93.009 Y96.465 E0.00683

G1 X93.000 Y97.625 E0.03023

G1 X92.889 Y97.912 E0.00802

G1 X92.824 Y97.989 E0.00263

M204 S1250

G1 X92.672 Y97.996 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.681 Y98.095 E-0.09821

G1 X91.213 Y98.081 E-0.81379

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.874 Y96.693

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.244 Y97.324 E0.02356

G1 X82.842 Y97.325 E0.01579

G1 X83.286 Y96.881 E0.01659

G1 X83.885 Y96.880 E0.01584

G1 X83.440 Y97.326 E0.01665

G1 X84.038 Y97.327 E0.01579

G1 X84.485 Y96.880 E0.01672

G1 X85.085 Y96.879 E0.01584

G1 X84.635 Y97.328 E0.01678

G1 X85.233 Y97.329 E0.01579

G1 X85.684 Y96.878 E0.01685

G1 X86.284 Y96.877 E0.01584

G1 X85.831 Y97.330 E0.01691

G1 X86.429 Y97.331 E0.01579

G1 X86.884 Y96.877 E0.01697

G1 X87.483 Y96.876 E0.01584

G1 X87.027 Y97.332 E0.01704

G1 X87.625 Y97.333 E0.01579

G1 X88.083 Y96.875 E0.01710

G1 X88.683 Y96.875 E0.01584

G1 X88.223 Y97.334 E0.01717

G1 X88.821 Y97.335 E0.01579

G1 X89.282 Y96.874 E0.01723

G1 X89.882 Y96.873 E0.01584

G1 X89.419 Y97.336 E0.01729

G1 X90.015 Y97.339 E0.01576

G1 X90.478 Y96.876 E0.01727

G1 X91.070 Y96.883 E0.01566

G1 X90.609 Y97.344 E0.01725

G1 X91.202 Y97.350 E0.01567

G1 X91.663 Y96.889 E0.01722

G1 X92.256 Y96.895 E0.01566

G1 X91.609 Y97.542 E0.02416

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.256 Y96.895 E-0.50688

G1 X91.663 Y96.889 E-0.32849

G1 X91.565 Y96.987 E-0.07663

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.592 Y90.726

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.103 Y90.711 E0.16908

G1 X81.888 Y90.723 E0.10982

G1 X81.884 Y89.840 E0.02303

G1 X81.921 Y89.635 E0.00542

G1 X92.550 Y89.625 E0.27695

G1 X92.592 Y89.705 E0.00236

G1 X92.592 Y90.666 E0.02505

M204 S1250

G1 X92.932 Y91.026 F9000.000

M204 S800

G1 F1500.000

G1 X92.752 Y91.145 E0.00562

G1 X86.103 Y91.128 E0.17323

G1 X81.770 Y91.142 E0.11290

G1 X81.634 Y91.105 E0.00367

G1 X81.555 Y91.037 E0.00273

G1 X81.470 Y90.793 E0.00673

G1 X81.466 Y89.803 E0.02577

G1 X81.550 Y89.420 E0.01022

G1 X81.616 Y89.319 E0.00315

G1 X81.800 Y89.217 E0.00546

G1 X92.686 Y89.207 E0.28366

G1 X92.774 Y89.252 E0.00257

G1 X92.896 Y89.384 E0.00469

G1 X93.010 Y89.642 E0.00734

G1 X93.010 Y90.819 E0.03066

G1 X92.953 Y90.970 E0.00422

M204 S1250

G1 X92.719 Y90.993 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.752 Y91.145 E-0.14763

G1 X91.372 Y91.141 E-0.76437

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.866 Y89.759

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.219 Y90.407 E0.02419

G1 X82.819 Y90.405 E0.01586

G1 X83.278 Y89.947 E0.01712

G1 X83.877 Y89.947 E0.01584

G1 X83.420 Y90.404 E0.01708

G1 X84.021 Y90.402 E0.01586

G1 X84.477 Y89.946 E0.01704

G1 X85.076 Y89.946 E0.01584

G1 X84.621 Y90.401 E0.01700

G1 X85.222 Y90.400 E0.01586

G1 X85.676 Y89.945 E0.01696

G1 X86.275 Y89.945 E0.01584

G1 X85.822 Y90.398 E0.01692

G1 X86.421 Y90.398 E0.01582

G1 X86.875 Y89.945 E0.01694

G1 X87.474 Y89.944 E0.01584

G1 X87.019 Y90.400 E0.01701

G1 X87.616 Y90.401 E0.01579

G1 X88.074 Y89.944 E0.01708

G1 X88.673 Y89.943 E0.01584

G1 X88.214 Y90.402 E0.01715

G1 X88.812 Y90.404 E0.01579

G1 X89.273 Y89.943 E0.01722

G1 X89.872 Y89.942 E0.01584

G1 X89.409 Y90.405 E0.01729

G1 X90.007 Y90.407 E0.01579

G1 X90.472 Y89.942 E0.01736

G1 X91.071 Y89.942 E0.01584

G1 X90.604 Y90.408 E0.01743

G1 X91.202 Y90.410 E0.01579

G1 X91.670 Y89.941 E0.01750

G1 X92.270 Y89.941 E0.01584

G1 X91.612 Y90.599 E0.02458

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.270 Y89.941 E-0.51563

G1 X91.670 Y89.941 E-0.33221

G1 X91.589 Y90.023 E-0.06416

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.533 Y84.678

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.843 Y84.653 E0.07009

G1 X81.929 Y84.639 E0.20621

G1 X81.894 Y84.560 E0.00223

G1 X81.891 Y83.571 E0.02578

G1 X90.163 Y83.562 E0.21552

G1 X92.590 Y83.587 E0.06325

G1 X92.583 Y84.548 E0.02503

G1 X92.554 Y84.622 E0.00207

M204 S1250

G1 X92.785 Y85.037 F9000.000

M204 S800

G1 F1500.000

G1 X92.681 Y85.097 E0.00311

G1 X89.841 Y85.071 E0.07402

G1 X81.790 Y85.056 E0.20975

G1 X81.661 Y84.997 E0.00372

G1 X81.606 Y84.942 E0.00203

G1 X81.476 Y84.618 E0.00909

G1 X81.473 Y83.475 E0.02979

G1 X81.525 Y83.310 E0.00450

G1 X81.659 Y83.168 E0.00509

G1 X81.758 Y83.154 E0.00259

G1 X90.165 Y83.145 E0.21906

G1 X92.841 Y83.181 E0.06974

G1 X92.899 Y83.229 E0.00196

G1 X93.009 Y83.467 E0.00683

G1 X93.000 Y84.627 E0.03023

G1 X92.889 Y84.914 E0.00802

G1 X92.824 Y84.991 E0.00263

M204 S1250

G1 X92.672 Y84.998 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.681 Y85.097 E-0.09823

G1 X91.213 Y85.083 E-0.81377

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.874 Y83.695

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.244 Y84.326 E0.02355

G1 X82.842 Y84.327 E0.01579

G1 X83.286 Y83.883 E0.01659

G1 X83.885 Y83.882 E0.01584

G1 X83.439 Y84.328 E0.01665

G1 X84.037 Y84.329 E0.01579

G1 X84.485 Y83.882 E0.01672

G1 X85.084 Y83.881 E0.01584

G1 X84.635 Y84.330 E0.01678

G1 X85.233 Y84.331 E0.01579

G1 X85.684 Y83.880 E0.01684

G1 X86.284 Y83.880 E0.01584

G1 X85.831 Y84.333 E0.01691

G1 X86.429 Y84.334 E0.01579

G1 X86.883 Y83.879 E0.01697

G1 X87.483 Y83.879 E0.01584

G1 X87.027 Y84.335 E0.01704

G1 X87.625 Y84.336 E0.01579

G1 X88.082 Y83.878 E0.01710

G1 X88.682 Y83.877 E0.01584

G1 X88.222 Y84.337 E0.01717

G1 X88.820 Y84.338 E0.01579

G1 X89.282 Y83.877 E0.01723

G1 X89.881 Y83.876 E0.01584

G1 X89.418 Y84.339 E0.01729

G1 X90.015 Y84.341 E0.01576

G1 X90.477 Y83.879 E0.01727

G1 X91.070 Y83.885 E0.01566

G1 X90.608 Y84.347 E0.01725

G1 X91.202 Y84.352 E0.01568

G1 X91.663 Y83.891 E0.01723

G1 X92.256 Y83.897 E0.01566

G1 X91.609 Y84.544 E0.02416

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.256 Y83.897 E-0.50699

G1 X91.663 Y83.891 E-0.32858

G1 X91.565 Y83.989 E-0.07643

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.592 Y77.728

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.103 Y77.713 E0.16908

G1 X81.888 Y77.726 E0.10982

G1 X81.884 Y76.842 E0.02303

G1 X81.921 Y76.637 E0.00542

G1 X92.550 Y76.627 E0.27695

G1 X92.592 Y76.707 E0.00236

G1 X92.592 Y77.668 E0.02505

M204 S1250

G1 X92.932 Y78.028 F9000.000

M204 S800

G1 F1500.000

G1 X92.752 Y78.147 E0.00562

G1 X86.103 Y78.130 E0.17323

G1 X81.770 Y78.144 E0.11291

G1 X81.634 Y78.108 E0.00365

G1 X81.555 Y78.039 E0.00274

G1 X81.470 Y77.795 E0.00674

G1 X81.466 Y76.805 E0.02577

G1 X81.550 Y76.422 E0.01022

G1 X81.616 Y76.321 E0.00315

G1 X81.800 Y76.219 E0.00546

G1 X92.687 Y76.209 E0.28367

G1 X92.774 Y76.254 E0.00256

G1 X92.896 Y76.387 E0.00470

G1 X93.010 Y76.645 E0.00734

G1 X93.010 Y77.821 E0.03063

G1 X92.953 Y77.972 E0.00422

M204 S1250

G1 X92.719 Y77.995 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.752 Y78.147 E-0.14763

G1 X91.372 Y78.143 E-0.76437

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.866 Y76.761

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.219 Y77.409 E0.02419

G1 X82.819 Y77.407 E0.01586

G1 X83.278 Y76.949 E0.01712

G1 X83.877 Y76.949 E0.01584

G1 X83.420 Y77.406 E0.01708

G1 X84.021 Y77.404 E0.01586

G1 X84.477 Y76.948 E0.01704

G1 X85.076 Y76.948 E0.01584

G1 X84.621 Y77.403 E0.01700

G1 X85.222 Y77.402 E0.01586

G1 X85.675 Y76.948 E0.01696

G1 X86.275 Y76.947 E0.01584

G1 X85.822 Y77.400 E0.01692

G1 X86.421 Y77.400 E0.01582

G1 X86.874 Y76.947 E0.01693

G1 X87.474 Y76.946 E0.01584

G1 X87.019 Y77.402 E0.01700

G1 X87.616 Y77.403 E0.01579

G1 X88.073 Y76.946 E0.01707

G1 X88.673 Y76.946 E0.01584

G1 X88.214 Y77.404 E0.01714

G1 X88.812 Y77.406 E0.01579

G1 X89.272 Y76.945 E0.01721

G1 X89.872 Y76.945 E0.01584

G1 X89.409 Y77.407 E0.01728

G1 X90.007 Y77.409 E0.01579

G1 X90.471 Y76.945 E0.01735

G1 X91.070 Y76.944 E0.01584

G1 X90.604 Y77.410 E0.01741

G1 X91.202 Y77.412 E0.01579

G1 X91.670 Y76.944 E0.01748

G1 X92.269 Y76.943 E0.01584

G1 X91.612 Y77.601 E0.02456

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.269 Y76.943 E-0.51518

G1 X91.670 Y76.944 E-0.33219

G1 X91.587 Y77.026 E-0.06463

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.532 Y71.681

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.843 Y71.655 E0.07008

G1 X81.928 Y71.641 E0.20622

G1 X81.894 Y71.563 E0.00223

G1 X81.891 Y70.573 E0.02578

G1 X90.163 Y70.564 E0.21552

G1 X92.590 Y70.589 E0.06325

G1 X92.583 Y71.550 E0.02503

G1 X92.554 Y71.625 E0.00210

M204 S1250

G1 X92.784 Y72.039 F9000.000

M204 S800

G1 F1500.000

G1 X92.681 Y72.100 E0.00313

G1 X89.841 Y72.073 E0.07401

M73 P55 R31

G1 X81.790 Y72.058 E0.20976

G1 X81.661 Y72.000 E0.00371

G1 X81.606 Y71.945 E0.00202

G1 X81.476 Y71.620 E0.00911

G1 X81.473 Y70.477 E0.02979

G1 X81.525 Y70.312 E0.00450

G1 X81.659 Y70.170 E0.00509

G1 X81.758 Y70.156 E0.00259

G1 X90.165 Y70.147 E0.21906

G1 X92.841 Y70.183 E0.06974

G1 X92.899 Y70.231 E0.00196

G1 X93.009 Y70.469 E0.00683

G1 X93.000 Y71.630 E0.03024

G1 X92.889 Y71.916 E0.00801

G1 X92.823 Y71.994 E0.00264

M204 S1250

G1 X92.671 Y72.000 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.681 Y72.100 E-0.09850

G1 X91.213 Y72.086 E-0.81350

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.874 Y70.697

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.244 Y71.328 E0.02356

G1 X82.842 Y71.329 E0.01579

G1 X83.286 Y70.885 E0.01659

G1 X83.885 Y70.884 E0.01584

G1 X83.440 Y71.330 E0.01666

G1 X84.037 Y71.331 E0.01579

G1 X84.485 Y70.884 E0.01672

G1 X85.085 Y70.883 E0.01584

G1 X84.635 Y71.332 E0.01679

G1 X85.233 Y71.334 E0.01579

G1 X85.684 Y70.882 E0.01685

G1 X86.284 Y70.882 E0.01584

G1 X85.831 Y71.335 E0.01692

G1 X86.429 Y71.336 E0.01579

G1 X86.884 Y70.881 E0.01698

G1 X87.483 Y70.881 E0.01584

G1 X87.027 Y71.337 E0.01705

G1 X87.625 Y71.338 E0.01579

G1 X88.083 Y70.880 E0.01711

G1 X88.683 Y70.879 E0.01584

G1 X88.223 Y71.339 E0.01718

G1 X88.821 Y71.340 E0.01579

G1 X89.282 Y70.879 E0.01724

G1 X89.882 Y70.878 E0.01584

G1 X89.419 Y71.341 E0.01731

G1 X90.015 Y71.344 E0.01576

G1 X90.478 Y70.881 E0.01729

G1 X91.071 Y70.887 E0.01566

G1 X90.609 Y71.349 E0.01727

G1 X91.202 Y71.355 E0.01567

G1 X91.664 Y70.893 E0.01725

G1 X92.257 Y70.899 E0.01566

G1 X91.609 Y71.547 E0.02419

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.257 Y70.899 E-0.50756

G1 X91.664 Y70.893 E-0.32860

G1 X91.567 Y70.990 E-0.07584

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.592 Y64.730

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.103 Y64.715 E0.16908

G1 X81.888 Y64.728 E0.10982

G1 X81.884 Y63.844 E0.02301

G1 X81.921 Y63.639 E0.00544

G1 X92.550 Y63.629 E0.27695

G1 X92.592 Y63.709 E0.00236

G1 X92.592 Y64.670 E0.02505

M204 S1250

G1 X92.932 Y65.030 F9000.000

M204 S800

G1 F1500.000

G1 X92.752 Y65.149 E0.00562

G1 X86.103 Y65.133 E0.17323

G1 X81.770 Y65.146 E0.11291

G1 X81.634 Y65.110 E0.00365

G1 X81.555 Y65.041 E0.00274

G1 X81.470 Y64.797 E0.00674

G1 X81.466 Y63.808 E0.02575

G1 X81.550 Y63.424 E0.01024

G1 X81.616 Y63.323 E0.00316

G1 X81.800 Y63.221 E0.00546

G1 X92.687 Y63.211 E0.28367

G1 X92.774 Y63.256 E0.00256

G1 X92.896 Y63.389 E0.00470

G1 X93.010 Y63.647 E0.00734

G1 X93.010 Y64.823 E0.03064

G1 X92.953 Y64.974 E0.00422

M204 S1250

G1 X92.719 Y64.997 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.752 Y65.149 E-0.14765

G1 X91.372 Y65.145 E-0.76435

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.866 Y63.764

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.218 Y64.412 E0.02422

G1 X82.817 Y64.412 E0.01582

G1 X83.278 Y63.951 E0.01722

G1 X83.877 Y63.951 E0.01584

G1 X83.416 Y64.413 E0.01725

G1 X84.014 Y64.413 E0.01582

G1 X84.477 Y63.950 E0.01727

G1 X85.076 Y63.950 E0.01584

G1 X84.613 Y64.413 E0.01730

G1 X85.212 Y64.413 E0.01582

G1 X85.676 Y63.950 E0.01732

G1 X86.275 Y63.949 E0.01584

G1 X85.811 Y64.414 E0.01735

G1 X86.409 Y64.414 E0.01582

G1 X86.874 Y63.949 E0.01738

G1 X87.474 Y63.949 E0.01584

G1 X87.008 Y64.414 E0.01740

G1 X87.607 Y64.415 E0.01582

G1 X88.073 Y63.948 E0.01743

G1 X88.673 Y63.948 E0.01584

G1 X88.206 Y64.415 E0.01745

G1 X88.804 Y64.415 E0.01582

G1 X89.272 Y63.947 E0.01748

G1 X89.872 Y63.947 E0.01584

G1 X89.403 Y64.415 E0.01751

G1 X90.002 Y64.416 E0.01582

G1 X90.471 Y63.947 E0.01753

G1 X91.071 Y63.946 E0.01584

G1 X90.601 Y64.416 E0.01756

G1 X91.199 Y64.416 E0.01582

G1 X91.670 Y63.946 E0.01758

G1 X92.270 Y63.945 E0.01584

G1 X91.610 Y64.605 E0.02463

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.270 Y63.945 E-0.51667

G1 X91.670 Y63.946 E-0.33220

G1 X91.590 Y64.026 E-0.06313

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.532 Y58.683

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.843 Y58.657 E0.07008

G1 X81.929 Y58.644 E0.20622

G1 X81.894 Y58.565 E0.00223

G1 X81.891 Y57.575 E0.02580

G1 X90.163 Y57.566 E0.21552

G1 X92.590 Y57.591 E0.06325

G1 X92.583 Y58.552 E0.02503

G1 X92.554 Y58.627 E0.00210

M204 S1250

G1 X92.784 Y59.041 F9000.000

M204 S800

G1 F1500.000

G1 X92.681 Y59.102 E0.00313

G1 X89.841 Y59.075 E0.07401

G1 X81.790 Y59.061 E0.20975

G1 X81.661 Y59.002 E0.00371

G1 X81.606 Y58.947 E0.00203

G1 X81.476 Y58.622 E0.00910

G1 X81.473 Y57.479 E0.02980

G1 X81.525 Y57.314 E0.00450

G1 X81.659 Y57.172 E0.00509

G1 X81.758 Y57.158 E0.00260

G1 X90.165 Y57.149 E0.21905

G1 X92.841 Y57.186 E0.06974

G1 X92.899 Y57.233 E0.00196

G1 X93.009 Y57.471 E0.00682

G1 X93.000 Y58.632 E0.03024

G1 X92.889 Y58.918 E0.00801

G1 X92.823 Y58.996 E0.00264

M204 S1250

G1 X92.671 Y59.002 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.681 Y59.102 E-0.09848

G1 X91.213 Y59.088 E-0.81352

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.874 Y57.699

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.243 Y58.331 E0.02358

G1 X82.841 Y58.332 E0.01579

G1 X83.286 Y57.887 E0.01661

G1 X83.885 Y57.886 E0.01584

G1 X83.439 Y58.333 E0.01668

G1 X84.037 Y58.334 E0.01579

G1 X84.485 Y57.886 E0.01674

G1 X85.085 Y57.885 E0.01584

G1 X84.635 Y58.335 E0.01680

G1 X85.233 Y58.336 E0.01579

G1 X85.684 Y57.884 E0.01687

G1 X86.284 Y57.884 E0.01584

G1 X85.831 Y58.337 E0.01693

G1 X86.429 Y58.338 E0.01579

G1 X86.884 Y57.883 E0.01699

G1 X87.483 Y57.883 E0.01584

G1 X87.027 Y58.339 E0.01706

G1 X87.625 Y58.340 E0.01579

G1 X88.083 Y57.882 E0.01712

G1 X88.683 Y57.881 E0.01584

G1 X88.223 Y58.341 E0.01718

G1 X88.821 Y58.342 E0.01579

G1 X89.282 Y57.881 E0.01724

G1 X89.882 Y57.880 E0.01584

G1 X89.419 Y58.343 E0.01731

G1 X90.015 Y58.346 E0.01576

G1 X90.478 Y57.883 E0.01729

G1 X91.071 Y57.889 E0.01566

G1 X90.609 Y58.351 E0.01727

G1 X91.202 Y58.357 E0.01567

G1 X91.664 Y57.895 E0.01725

G1 X92.257 Y57.901 E0.01566

G1 X91.609 Y58.549 E0.02419

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.257 Y57.901 E-0.50756

G1 X91.664 Y57.895 E-0.32860

G1 X91.567 Y57.992 E-0.07584

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.592 Y51.733

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.103 Y51.717 E0.16908

G1 X81.889 Y51.730 E0.10981

G1 X81.884 Y50.846 E0.02303

G1 X81.921 Y50.641 E0.00544

G1 X92.550 Y50.631 E0.27694

G1 X92.592 Y50.712 E0.00237

G1 X92.592 Y51.673 E0.02504

M204 S1250

G1 X92.932 Y52.033 F9000.000

M204 S800

G1 F1500.000

G1 X92.752 Y52.151 E0.00561

G1 X86.103 Y52.135 E0.17325

G1 X81.770 Y52.149 E0.11290

G1 X81.634 Y52.113 E0.00366

G1 X81.555 Y52.043 E0.00275

G1 X81.470 Y51.799 E0.00674

G1 X81.466 Y50.810 E0.02575

G1 X81.550 Y50.426 E0.01024

G1 X81.616 Y50.325 E0.00316

G1 X81.800 Y50.223 E0.00546

G1 X92.687 Y50.213 E0.28367

G1 X92.774 Y50.258 E0.00256

G1 X92.896 Y50.391 E0.00470

G1 X93.010 Y50.649 E0.00735

G1 X93.010 Y51.825 E0.03063

G1 X92.953 Y51.976 E0.00422

M204 S1250

G1 X92.719 Y52.000 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.752 Y52.151 E-0.14745

G1 X91.372 Y52.148 E-0.76455

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.866 Y50.766

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.218 Y51.414 E0.02422

G1 X82.817 Y51.414 E0.01582

G1 X83.278 Y50.953 E0.01722

G1 X83.877 Y50.953 E0.01584

G1 X83.416 Y51.415 E0.01725

G1 X84.014 Y51.415 E0.01582

G1 X84.477 Y50.952 E0.01728

G1 X85.076 Y50.952 E0.01584

G1 X84.613 Y51.415 E0.01730

G1 X85.212 Y51.416 E0.01582

G1 X85.676 Y50.952 E0.01733

G1 X86.275 Y50.951 E0.01584

G1 X85.811 Y51.416 E0.01736

G1 X86.409 Y51.416 E0.01582

G1 X86.875 Y50.951 E0.01739

G1 X87.474 Y50.950 E0.01584

G1 X87.008 Y51.416 E0.01741

G1 X87.607 Y51.417 E0.01582

G1 X88.074 Y50.950 E0.01744

G1 X88.673 Y50.950 E0.01584

G1 X88.206 Y51.417 E0.01747

G1 X88.804 Y51.417 E0.01582

G1 X89.273 Y50.949 E0.01749

G1 X89.872 Y50.949 E0.01584

G1 X89.403 Y51.418 E0.01752

G1 X90.002 Y51.418 E0.01582

G1 X90.472 Y50.948 E0.01755

G1 X91.071 Y50.948 E0.01584

G1 X90.601 Y51.418 E0.01758

G1 X91.199 Y51.419 E0.01582

G1 X91.671 Y50.947 E0.01760

G1 X92.270 Y50.947 E0.01584

G1 X91.610 Y51.607 E0.02465

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.270 Y50.947 E-0.51711

G1 X91.671 Y50.947 E-0.33222

G1 X91.591 Y51.027 E-0.06267

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X92.532 Y45.685

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.843 Y45.659 E0.07008

G1 X81.929 Y45.646 E0.20622

G1 X81.894 Y45.567 E0.00223

G1 X81.891 Y44.578 E0.02577

G1 X90.163 Y44.568 E0.21552

G1 X92.590 Y44.593 E0.06325

G1 X92.583 Y45.554 E0.02504

G1 X92.554 Y45.629 E0.00208

M204 S1250

G1 X92.784 Y46.043 F9000.000

M204 S800

G1 F1500.000

G1 X92.681 Y46.104 E0.00313

G1 X89.841 Y46.077 E0.07401

G1 X81.790 Y46.063 E0.20975

G1 X81.661 Y46.004 E0.00371

G1 X81.606 Y45.949 E0.00203

G1 X81.476 Y45.624 E0.00910

G1 X81.473 Y44.481 E0.02980

G1 X81.525 Y44.316 E0.00450

G1 X81.659 Y44.175 E0.00507

G1 X81.758 Y44.161 E0.00259

G1 X90.165 Y44.150 E0.21906

G1 X92.841 Y44.188 E0.06974

G1 X92.899 Y44.236 E0.00197

G1 X93.009 Y44.473 E0.00681

G1 X93.000 Y45.634 E0.03025

G1 X92.889 Y45.920 E0.00800

G1 X92.823 Y45.998 E0.00264

M204 S1250

G1 X92.671 Y46.004 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.681 Y46.104 E-0.09852

G1 X91.213 Y46.090 E-0.81348

G1 E-0.04800 F4200.00000

G1 Z5.050 F9000.000

G1 X82.874 Y44.702

G1 Z4.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.244 Y45.333 E0.02355

G1 X82.842 Y45.334 E0.01579

G1 X83.286 Y44.890 E0.01658

G1 X83.886 Y44.889 E0.01584

G1 X83.440 Y45.335 E0.01665

G1 X84.038 Y45.336 E0.01579

G1 X84.485 Y44.888 E0.01671

G1 X85.085 Y44.888 E0.01584

G1 X84.636 Y45.337 E0.01678

G1 X85.233 Y45.338 E0.01579

G1 X85.684 Y44.887 E0.01685

G1 X86.284 Y44.886 E0.01584

G1 X85.831 Y45.339 E0.01691

G1 X86.429 Y45.340 E0.01579

G1 X86.884 Y44.886 E0.01698

G1 X87.483 Y44.885 E0.01584

G1 X87.027 Y45.341 E0.01704

G1 X87.625 Y45.342 E0.01579

G1 X88.083 Y44.884 E0.01711

G1 X88.683 Y44.883 E0.01584

G1 X88.223 Y45.343 E0.01717

G1 X88.821 Y45.344 E0.01579

G1 X89.282 Y44.883 E0.01724

G1 X89.882 Y44.882 E0.01584

G1 X89.419 Y45.345 E0.01730

G1 X90.015 Y45.348 E0.01576

G1 X90.478 Y44.885 E0.01728

G1 X91.071 Y44.891 E0.01566

G1 X90.609 Y45.353 E0.01726

G1 X91.202 Y45.359 E0.01567

G1 X91.664 Y44.897 E0.01724

G1 X92.256 Y44.903 E0.01566

G1 X91.609 Y45.551 E0.02418

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;5

G1 Z5.000 F9000.000

;AFTER\_LAYER\_CHANGE

;5

G1 E-3.20000 F4200.00000

G1 Z5.200 F9000.000

G1 X92.569 Y115.828

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y115.878 E0.00147

G1 X92.594 Y116.816 E0.02442

G1 X85.711 Y116.799 E0.17935

G1 X81.887 Y116.813 E0.09963

G1 X81.884 Y115.967 E0.02205

G1 X81.914 Y115.826 E0.00374

G1 X92.509 Y115.828 E0.27606

M204 S1250

G1 X92.877 Y115.505 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y115.783 E0.00804

G1 X93.012 Y116.888 E0.02879

G1 X92.930 Y117.118 E0.00636

G1 X92.826 Y117.202 E0.00349

G1 X92.711 Y117.234 E0.00311

G1 X85.711 Y117.217 E0.18238

G1 X81.775 Y117.231 E0.10257

G1 X81.620 Y117.183 E0.00424

G1 X81.575 Y117.144 E0.00155

G1 X81.523 Y117.072 E0.00230

G1 X81.470 Y116.901 E0.00467

G1 X81.466 Y115.924 E0.02547

G1 X81.521 Y115.663 E0.00695

G1 X81.597 Y115.527 E0.00407

G1 X81.785 Y115.408 E0.00579

G1 X92.701 Y115.410 E0.28443

G1 X92.832 Y115.466 E0.00370

M204 S1250

G1 X92.808 Y115.806 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.011 Y115.783 E-0.20200

G1 X93.012 Y116.888 E-0.61223

G1 X92.953 Y117.054 E-0.09778

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.125 Y115.952

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.670 Y116.497 E0.02016

G1 X83.261 Y116.495 E0.01547

G1 X82.908 Y116.141 E0.01309

G1 X83.502 Y116.142 E0.01555

G1 X83.852 Y116.492 E0.01298

G1 X84.444 Y116.490 E0.01547

G1 X84.096 Y116.143 E0.01287

G1 X84.690 Y116.143 E0.01555

G1 X85.035 Y116.488 E0.01276

G1 X85.626 Y116.486 E0.01547

G1 X85.284 Y116.144 E0.01265

G1 X85.878 Y116.145 E0.01555

G1 X86.220 Y116.487 E0.01265

G1 X86.815 Y116.488 E0.01556

G1 X86.473 Y116.146 E0.01267

G1 X87.067 Y116.147 E0.01555

G1 X87.410 Y116.490 E0.01269

G1 X88.004 Y116.491 E0.01556

G1 X87.661 Y116.148 E0.01271

G1 X88.255 Y116.149 E0.01555

G1 X88.599 Y116.493 E0.01273

G1 X89.194 Y116.494 E0.01556

G1 X88.849 Y116.149 E0.01277

G1 X89.441 Y116.148 E0.01549

G1 X89.789 Y116.495 E0.01286

G1 X90.383 Y116.497 E0.01556

G1 X90.033 Y116.146 E0.01296

G1 X90.625 Y116.145 E0.01549

G1 X90.978 Y116.498 E0.01306

G1 X91.573 Y116.499 E0.01556

G1 X91.217 Y116.144 E0.01315

G1 X91.809 Y116.143 E0.01549

G1 X92.356 Y116.689 E0.02022

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.809 Y116.143 E-0.42834

G1 X91.217 Y116.144 E-0.32812

G1 X91.416 Y116.342 E-0.15554

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.557 Y110.463

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.906 Y110.433 E0.27752

G1 X81.891 Y109.477 E0.02492

G1 X89.089 Y109.458 E0.18756

G1 X92.592 Y109.505 E0.09129

G1 X92.584 Y110.409 E0.02356

M204 S1250

G1 X92.823 Y110.831 F9000.000

M204 S800

G1 F1500.000

G1 X92.677 Y110.881 E0.00402

G1 X81.775 Y110.850 E0.28405

G1 X81.670 Y110.818 E0.00286

G1 X81.583 Y110.731 E0.00321

G1 X81.477 Y110.464 E0.00749

G1 X81.472 Y109.350 E0.02902

G1 X81.566 Y109.139 E0.00601

G1 X81.648 Y109.073 E0.00273

G1 X81.756 Y109.060 E0.00284

G1 X89.092 Y109.040 E0.19113

G1 X92.855 Y109.090 E0.09807

G1 X92.886 Y109.113 E0.00100

G1 X93.009 Y109.368 E0.00737

G1 X93.014 Y110.176 E0.02105

G1 X92.988 Y110.534 E0.00937

G1 X92.859 Y110.784 E0.00731

M204 S1250

G1 X92.681 Y110.771 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.677 Y110.881 E-0.11468

G1 X91.238 Y110.877 E-0.79732

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.915 Y110.310

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.393 Y109.789 E0.02026

G1 X83.014 Y109.787 E0.01706

G1 X83.350 Y110.124 E0.01307

G1 X83.975 Y110.125 E0.01715

G1 X83.635 Y109.785 E0.01320

G1 X84.256 Y109.784 E0.01706

G1 X84.599 Y110.127 E0.01333

G1 X85.224 Y110.129 E0.01715

G1 X84.877 Y109.782 E0.01346

G1 X85.499 Y109.781 E0.01706

G1 X85.848 Y110.131 E0.01359

G1 X86.473 Y110.132 E0.01715

G1 X86.120 Y109.779 E0.01372

G1 X86.741 Y109.778 E0.01706

G1 X87.097 Y110.134 E0.01384

G1 X87.722 Y110.136 E0.01715

G1 X87.362 Y109.776 E0.01397

G1 X87.983 Y109.774 E0.01706

G1 X88.346 Y110.138 E0.01410

G1 X88.971 Y110.139 E0.01715

G1 X88.604 Y109.773 E0.01423

G1 X89.228 Y109.773 E0.01712

G1 X89.595 Y110.141 E0.01427

G1 X90.220 Y110.143 E0.01715

G1 X89.859 Y109.782 E0.01402

G1 X90.490 Y109.790 E0.01733

G1 X90.844 Y110.145 E0.01376

G1 X91.469 Y110.146 E0.01715

G1 X91.121 Y109.799 E0.01350

G1 X91.752 Y109.807 E0.01733

G1 X92.282 Y110.337 E0.02057

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.752 Y109.807 E-0.41504

G1 X91.121 Y109.799 E-0.34978

G1 X91.309 Y109.986 E-0.14719

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.594 Y103.818

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.711 Y103.801 E0.17935

G1 X81.887 Y103.815 E0.09963

G1 X81.884 Y102.969 E0.02205

G1 X81.914 Y102.828 E0.00374

G1 X92.569 Y102.830 E0.27763

G1 X92.593 Y102.880 E0.00147

G1 X92.594 Y103.758 E0.02286

M204 S1250

G1 X92.826 Y104.204 F9000.000

M204 S800

G1 F1500.000

G1 X92.711 Y104.236 E0.00311

G1 X85.711 Y104.219 E0.18238

G1 X81.775 Y104.233 E0.10257

G1 X81.620 Y104.185 E0.00424

G1 X81.575 Y104.146 E0.00155

G1 X81.523 Y104.074 E0.00230

G1 X81.470 Y103.903 E0.00467

G1 X81.466 Y102.926 E0.02547

G1 X81.521 Y102.665 E0.00695

G1 X81.597 Y102.529 E0.00407

G1 X81.785 Y102.410 E0.00579

G1 X92.701 Y102.412 E0.28443

G1 X92.815 Y102.453 E0.00316

G1 X92.877 Y102.507 E0.00213

G1 X93.011 Y102.785 E0.00804

G1 X93.012 Y103.890 E0.02879

G1 X92.930 Y104.120 E0.00636

G1 X92.872 Y104.166 E0.00193

M204 S1250

G1 X92.722 Y104.144 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.711 Y104.236 E-0.09743

G1 X91.241 Y104.232 E-0.81457

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.125 Y102.954

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.670 Y103.499 E0.02016

G1 X83.261 Y103.497 E0.01547

G1 X82.908 Y103.143 E0.01309

G1 X83.502 Y103.144 E0.01555

G1 X83.852 Y103.494 E0.01298

G1 X84.444 Y103.492 E0.01547

G1 X84.096 Y103.145 E0.01287

G1 X84.690 Y103.145 E0.01555

G1 X85.035 Y103.490 E0.01276

G1 X85.626 Y103.488 E0.01547

G1 X85.284 Y103.146 E0.01265

G1 X85.878 Y103.147 E0.01555

G1 X86.220 Y103.489 E0.01265

G1 X86.815 Y103.490 E0.01556

G1 X86.473 Y103.148 E0.01267

G1 X87.067 Y103.149 E0.01555

G1 X87.410 Y103.492 E0.01269

G1 X88.004 Y103.493 E0.01556

G1 X87.661 Y103.150 E0.01271

G1 X88.255 Y103.151 E0.01555

G1 X88.599 Y103.495 E0.01273

G1 X89.194 Y103.496 E0.01556

G1 X88.849 Y103.151 E0.01277

G1 X89.441 Y103.150 E0.01549

G1 X89.789 Y103.497 E0.01286

G1 X90.383 Y103.499 E0.01556

G1 X90.033 Y103.148 E0.01296

G1 X90.625 Y103.147 E0.01549

G1 X90.978 Y103.500 E0.01306

G1 X91.573 Y103.501 E0.01556

G1 X91.217 Y103.146 E0.01315

G1 X91.809 Y103.145 E0.01549

G1 X92.356 Y103.691 E0.02022

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.809 Y103.145 E-0.42834

G1 X91.217 Y103.146 E-0.32812

G1 X91.416 Y103.344 E-0.15553

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.557 Y97.465

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.906 Y97.435 E0.27752

G1 X81.891 Y96.479 E0.02492

G1 X89.089 Y96.460 E0.18756

G1 X92.592 Y96.507 E0.09129

G1 X92.584 Y97.411 E0.02356

M204 S1250

G1 X92.822 Y97.834 F9000.000

M204 S800

G1 F1500.000

G1 X92.677 Y97.883 E0.00399

G1 X81.775 Y97.852 E0.28407

G1 X81.670 Y97.820 E0.00287

G1 X81.583 Y97.734 E0.00319

G1 X81.477 Y97.466 E0.00751

G1 X81.472 Y96.353 E0.02900

G1 X81.566 Y96.142 E0.00602

G1 X81.648 Y96.076 E0.00273

G1 X81.757 Y96.062 E0.00286

G1 X89.092 Y96.042 E0.19112

G1 X92.855 Y96.092 E0.09806

G1 X92.907 Y96.138 E0.00182

G1 X93.009 Y96.366 E0.00651

G1 X93.014 Y97.178 E0.02114

G1 X92.988 Y97.536 E0.00937

G1 X92.859 Y97.787 E0.00734

M204 S1250

G1 X92.681 Y97.774 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.677 Y97.883 E-0.11404

G1 X91.237 Y97.879 E-0.79796

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.915 Y97.312

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.393 Y96.791 E0.02026

G1 X83.014 Y96.789 E0.01706

G1 X83.350 Y97.126 E0.01307

G1 X83.975 Y97.127 E0.01715

G1 X83.635 Y96.787 E0.01320

G1 X84.256 Y96.786 E0.01706

G1 X84.599 Y97.129 E0.01333

G1 X85.224 Y97.131 E0.01715

G1 X84.878 Y96.784 E0.01346

G1 X85.499 Y96.783 E0.01706

G1 X85.848 Y97.133 E0.01358

G1 X86.473 Y97.134 E0.01715

G1 X86.120 Y96.781 E0.01371

G1 X86.741 Y96.780 E0.01706

G1 X87.097 Y97.136 E0.01384

G1 X87.722 Y97.138 E0.01715

G1 X87.362 Y96.778 E0.01397

G1 X87.983 Y96.776 E0.01706

G1 X88.346 Y97.140 E0.01410

G1 X88.971 Y97.141 E0.01715

G1 X88.605 Y96.775 E0.01423

G1 X89.228 Y96.776 E0.01712

G1 X89.595 Y97.143 E0.01427

G1 X90.220 Y97.145 E0.01715

G1 X89.859 Y96.784 E0.01402

G1 X90.490 Y96.792 E0.01733

G1 X90.844 Y97.147 E0.01376

G1 X91.469 Y97.148 E0.01715

G1 X91.121 Y96.801 E0.01350

G1 X91.752 Y96.809 E0.01733

G1 X92.282 Y97.339 E0.02057

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.752 Y96.809 E-0.41502

G1 X91.121 Y96.801 E-0.34977

G1 X91.309 Y96.988 E-0.14720

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.594 Y90.820

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.711 Y90.804 E0.17935

G1 X81.887 Y90.817 E0.09963

G1 X81.884 Y89.971 E0.02205

G1 X81.914 Y89.830 E0.00374

G1 X92.569 Y89.832 E0.27763

G1 X92.593 Y89.882 E0.00147

G1 X92.594 Y90.760 E0.02286

M204 S1250

G1 X92.826 Y91.206 F9000.000

M204 S800

G1 F1500.000

G1 X92.711 Y91.238 E0.00310

G1 X85.711 Y91.222 E0.18239

G1 X81.775 Y91.235 E0.10256

G1 X81.619 Y91.187 E0.00425

G1 X81.575 Y91.148 E0.00154

G1 X81.523 Y91.077 E0.00229

G1 X81.470 Y90.905 E0.00468

G1 X81.466 Y89.928 E0.02547

G1 X81.521 Y89.667 E0.00695

G1 X81.597 Y89.531 E0.00407

G1 X81.785 Y89.412 E0.00579

G1 X92.701 Y89.414 E0.28442

G1 X92.815 Y89.456 E0.00317

G1 X92.877 Y89.509 E0.00213

G1 X93.011 Y89.787 E0.00804

G1 X93.012 Y90.892 E0.02879

G1 X92.930 Y91.122 E0.00638

G1 X92.873 Y91.169 E0.00191

M204 S1250

G1 X92.723 Y91.147 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.711 Y91.238 E-0.09738

G1 X91.241 Y91.234 E-0.81462

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.125 Y89.956

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.670 Y90.501 E0.02017

G1 X83.261 Y90.499 E0.01547

G1 X82.907 Y90.145 E0.01310

G1 X83.502 Y90.146 E0.01555

G1 X83.853 Y90.497 E0.01299

G1 X84.444 Y90.495 E0.01547

G1 X84.096 Y90.147 E0.01289

G1 X84.690 Y90.147 E0.01555

G1 X85.035 Y90.493 E0.01278

G1 X85.627 Y90.491 E0.01547

G1 X85.284 Y90.148 E0.01267

G1 X85.878 Y90.149 E0.01555

G1 X86.221 Y90.492 E0.01267

G1 X86.816 Y90.493 E0.01556

G1 X86.472 Y90.150 E0.01269

G1 X87.067 Y90.151 E0.01555

G1 X87.410 Y90.494 E0.01271

G1 X88.005 Y90.496 E0.01556

G1 X87.661 Y90.152 E0.01273

G1 X88.255 Y90.153 E0.01555

G1 X88.600 Y90.497 E0.01275

G1 X89.194 Y90.498 E0.01556

G1 X88.849 Y90.153 E0.01279

G1 X89.441 Y90.152 E0.01549

G1 X89.789 Y90.500 E0.01288

G1 X90.384 Y90.501 E0.01556

G1 X90.033 Y90.150 E0.01298

G1 X90.625 Y90.149 E0.01549

G1 X90.978 Y90.503 E0.01308

G1 X91.573 Y90.504 E0.01556

G1 X91.217 Y90.148 E0.01317

G1 X91.809 Y90.147 E0.01549

G1 X92.356 Y90.694 E0.02024

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.809 Y90.147 E-0.42869

G1 X91.217 Y90.148 E-0.32813

G1 X91.415 Y90.346 E-0.15518

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.557 Y84.467

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.906 Y84.437 E0.27753

G1 X81.891 Y83.481 E0.02492

G1 X89.089 Y83.463 E0.18757

G1 X92.592 Y83.509 E0.09128

G1 X92.584 Y84.413 E0.02356

M204 S1250

G1 X92.822 Y84.836 F9000.000

M204 S800

G1 F1500.000

G1 X92.677 Y84.885 E0.00399

G1 X81.775 Y84.854 E0.28407

G1 X81.669 Y84.822 E0.00287

G1 X81.583 Y84.736 E0.00318

G1 X81.477 Y84.468 E0.00749

G1 X81.472 Y83.355 E0.02901

G1 X81.566 Y83.144 E0.00602

G1 X81.648 Y83.078 E0.00273

G1 X81.757 Y83.064 E0.00286

G1 X89.092 Y83.045 E0.19112

G1 X92.855 Y83.094 E0.09806

G1 X92.907 Y83.140 E0.00182

G1 X93.009 Y83.368 E0.00651

G1 X93.014 Y84.180 E0.02114

G1 X92.988 Y84.538 E0.00937

G1 X92.859 Y84.789 E0.00734

M204 S1250

G1 X92.681 Y84.776 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.677 Y84.885 E-0.11403

G1 X91.237 Y84.881 E-0.79797

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.915 Y84.314

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.393 Y83.793 E0.02026

G1 X83.014 Y83.791 E0.01706

G1 X83.350 Y84.128 E0.01306

G1 X83.975 Y84.129 E0.01715

G1 X83.635 Y83.790 E0.01319

G1 X84.257 Y83.788 E0.01706

G1 X84.599 Y84.131 E0.01331

G1 X85.224 Y84.133 E0.01715

G1 X84.878 Y83.787 E0.01344

G1 X85.499 Y83.785 E0.01706

G1 X85.848 Y84.135 E0.01357

G1 X86.473 Y84.136 E0.01715

G1 X86.120 Y83.784 E0.01369

G1 X86.742 Y83.782 E0.01706

G1 X87.097 Y84.138 E0.01382

G1 X87.722 Y84.140 E0.01715

G1 X87.363 Y83.781 E0.01394

G1 X87.984 Y83.779 E0.01706

G1 X88.346 Y84.142 E0.01407

G1 X88.971 Y84.143 E0.01715

G1 X88.605 Y83.778 E0.01420

G1 X89.229 Y83.778 E0.01712

G1 X89.595 Y84.145 E0.01424

G1 X90.220 Y84.147 E0.01715

G1 X89.860 Y83.787 E0.01399

G1 X90.491 Y83.795 E0.01733

G1 X90.844 Y84.149 E0.01373

G1 X91.469 Y84.150 E0.01715

G1 X91.122 Y83.803 E0.01348

G1 X91.753 Y83.811 E0.01733

G1 X92.282 Y84.341 E0.02055

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.753 Y83.811 E-0.41480

G1 X91.122 Y83.803 E-0.34968

G1 X91.310 Y83.991 E-0.14752

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.594 Y77.822

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.711 Y77.806 E0.17935

G1 X81.887 Y77.819 E0.09963

G1 X81.884 Y76.973 E0.02205

G1 X81.914 Y76.833 E0.00374

G1 X92.569 Y76.834 E0.27762

G1 X92.593 Y76.885 E0.00149

G1 X92.594 Y77.762 E0.02283

M204 S1250

G1 X92.826 Y78.208 F9000.000

M204 S800

G1 F1500.000

G1 X92.711 Y78.240 E0.00310

G1 X85.711 Y78.224 E0.18239

G1 X81.775 Y78.237 E0.10257

G1 X81.619 Y78.189 E0.00423

G1 X81.575 Y78.150 E0.00154

G1 X81.523 Y78.079 E0.00230

G1 X81.470 Y77.907 E0.00468

G1 X81.466 Y76.930 E0.02546

G1 X81.521 Y76.669 E0.00695

G1 X81.598 Y76.533 E0.00407

G1 X81.785 Y76.415 E0.00577

G1 X92.701 Y76.416 E0.28443

G1 X92.815 Y76.458 E0.00317

G1 X92.877 Y76.512 E0.00214

G1 X93.011 Y76.790 E0.00805

G1 X93.012 Y77.894 E0.02877

G1 X92.930 Y78.124 E0.00638

G1 X92.873 Y78.171 E0.00191

M204 S1250

G1 X92.723 Y78.149 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.711 Y78.240 E-0.09738

G1 X91.241 Y78.236 E-0.81462

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.125 Y76.958

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.670 Y77.503 E0.02016

G1 X83.261 Y77.501 E0.01547

G1 X82.908 Y77.147 E0.01309

G1 X83.502 Y77.148 E0.01555

G1 X83.853 Y77.499 E0.01298

G1 X84.444 Y77.497 E0.01547

G1 X84.096 Y77.149 E0.01288

G1 X84.690 Y77.150 E0.01555

G1 X85.035 Y77.495 E0.01277

G1 X85.627 Y77.493 E0.01547

G1 X85.284 Y77.150 E0.01267

G1 X85.878 Y77.151 E0.01555

G1 X86.221 Y77.494 E0.01267

G1 X86.815 Y77.495 E0.01556

G1 X86.472 Y77.152 E0.01269

G1 X87.067 Y77.153 E0.01555

G1 X87.410 Y77.496 E0.01271

G1 X88.005 Y77.498 E0.01556

G1 X87.661 Y77.154 E0.01273

G1 X88.255 Y77.155 E0.01555

G1 X88.599 Y77.499 E0.01275

G1 X89.194 Y77.500 E0.01556

G1 X88.849 Y77.155 E0.01279

G1 X89.441 Y77.154 E0.01549

G1 X89.789 Y77.502 E0.01288

G1 X90.384 Y77.503 E0.01556

G1 X90.033 Y77.152 E0.01298

G1 X90.625 Y77.151 E0.01549

G1 X90.978 Y77.504 E0.01307

G1 X91.573 Y77.506 E0.01556

G1 X91.217 Y77.150 E0.01317

G1 X91.809 Y77.149 E0.01549

G1 X92.356 Y77.696 E0.02024

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.809 Y77.149 E-0.42858

G1 X91.217 Y77.150 E-0.32814

G1 X91.415 Y77.348 E-0.15528

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.557 Y71.470

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.906 Y71.439 E0.27752

G1 X81.891 Y70.483 E0.02492

G1 X89.089 Y70.465 E0.18757

G1 X92.592 Y70.511 E0.09128

G1 X92.583 Y71.416 E0.02358

M204 S1250

G1 X92.822 Y71.839 F9000.000

M204 S800

G1 F1500.000

G1 X92.677 Y71.888 E0.00401

G1 X81.775 Y71.856 E0.28406

G1 X81.669 Y71.825 E0.00286

G1 X81.583 Y71.738 E0.00319

G1 X81.477 Y71.471 E0.00749

G1 X81.472 Y70.357 E0.02902

G1 X81.566 Y70.146 E0.00602

G1 X81.648 Y70.080 E0.00273

G1 X81.757 Y70.066 E0.00286

G1 X89.092 Y70.047 E0.19112

G1 X92.855 Y70.096 E0.09806

G1 X92.907 Y70.142 E0.00182

G1 X93.009 Y70.370 E0.00651

G1 X93.014 Y71.182 E0.02114

G1 X92.988 Y71.540 E0.00936

G1 X92.859 Y71.791 E0.00735

M204 S1250

G1 X92.681 Y71.778 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.677 Y71.888 E-0.11443

G1 X91.237 Y71.884 E-0.79757

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.915 Y71.316

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.393 Y70.795 E0.02026

G1 X83.014 Y70.793 E0.01706

G1 X83.351 Y71.130 E0.01307

G1 X83.975 Y71.132 E0.01715

G1 X83.635 Y70.792 E0.01320

G1 X84.257 Y70.790 E0.01706

G1 X84.600 Y71.133 E0.01332

G1 X85.224 Y71.135 E0.01715

G1 X84.878 Y70.789 E0.01345

G1 X85.499 Y70.787 E0.01706

G1 X85.849 Y71.137 E0.01358

G1 X86.473 Y71.139 E0.01715

G1 X86.120 Y70.786 E0.01371

G1 X86.742 Y70.784 E0.01706

G1 X87.098 Y71.141 E0.01384

G1 X87.722 Y71.142 E0.01715

G1 X87.363 Y70.783 E0.01396

G1 X87.984 Y70.781 E0.01706

G1 X88.347 Y71.144 E0.01409

G1 X88.972 Y71.146 E0.01715

G1 X88.605 Y70.780 E0.01422

G1 X89.229 Y70.780 E0.01712

G1 X89.596 Y71.148 E0.01426

G1 X90.221 Y71.150 E0.01715

G1 X89.860 Y70.789 E0.01402

G1 X90.491 Y70.797 E0.01733

G1 X90.845 Y71.151 E0.01377

G1 X91.470 Y71.153 E0.01715

G1 X91.122 Y70.805 E0.01352

G1 X91.753 Y70.813 E0.01733

G1 X92.283 Y71.344 E0.02059

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.753 Y70.813 E-0.41555

G1 X91.122 Y70.805 E-0.34968

G1 X91.309 Y70.992 E-0.14677

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.594 Y64.824

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.711 Y64.808 E0.17935

G1 X81.887 Y64.821 E0.09963

G1 X81.884 Y63.976 E0.02203

G1 X81.914 Y63.835 E0.00375

G1 X92.569 Y63.836 E0.27762

G1 X92.593 Y63.887 E0.00149

G1 X92.594 Y64.764 E0.02284

M204 S1250

G1 X92.826 Y65.210 F9000.000

M204 S800

G1 F1500.000

G1 X92.711 Y65.242 E0.00311

G1 X85.711 Y65.226 E0.18238

G1 X81.774 Y65.239 E0.10258

G1 X81.619 Y65.192 E0.00423

G1 X81.575 Y65.153 E0.00153

G1 X81.523 Y65.081 E0.00231

G1 X81.470 Y64.910 E0.00468

G1 X81.466 Y63.933 E0.02545

G1 X81.521 Y63.671 E0.00697

G1 X81.597 Y63.535 E0.00407

G1 X81.785 Y63.417 E0.00579

G1 X92.701 Y63.418 E0.28441

G1 X92.815 Y63.460 E0.00317

G1 X92.877 Y63.514 E0.00214

G1 X93.011 Y63.792 E0.00804

G1 X93.012 Y64.897 E0.02879

G1 X92.930 Y65.126 E0.00636

G1 X92.873 Y65.173 E0.00192

M204 S1250

G1 X92.723 Y65.151 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.711 Y65.242 E-0.09745

G1 X91.241 Y65.239 E-0.81456

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.125 Y63.960

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.670 Y64.505 E0.02016

G1 X83.261 Y64.503 E0.01547

G1 X82.908 Y64.149 E0.01309

G1 X83.502 Y64.150 E0.01555

G1 X83.853 Y64.501 E0.01299

G1 X84.444 Y64.499 E0.01547

G1 X84.096 Y64.151 E0.01289

G1 X84.690 Y64.152 E0.01555

G1 X85.036 Y64.497 E0.01278

G1 X85.627 Y64.495 E0.01547

G1 X85.284 Y64.152 E0.01268

G1 X85.878 Y64.153 E0.01555

G1 X86.221 Y64.496 E0.01268

G1 X86.816 Y64.497 E0.01556

G1 X86.472 Y64.154 E0.01270

G1 X87.067 Y64.155 E0.01555

G1 X87.410 Y64.499 E0.01272

G1 X88.005 Y64.500 E0.01556

G1 X87.661 Y64.156 E0.01274

G1 X88.255 Y64.157 E0.01555

G1 X88.600 Y64.501 E0.01276

G1 X89.195 Y64.503 E0.01556

G1 X88.849 Y64.157 E0.01280

G1 X89.441 Y64.156 E0.01549

G1 X89.789 Y64.504 E0.01290

G1 X90.384 Y64.506 E0.01556

G1 X90.033 Y64.154 E0.01299

G1 X90.625 Y64.153 E0.01549

G1 X90.979 Y64.507 E0.01309

G1 X91.573 Y64.508 E0.01556

G1 X91.217 Y64.152 E0.01318

G1 X91.809 Y64.151 E0.01549

G1 X92.357 Y64.698 E0.02025

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.809 Y64.151 E-0.42895

G1 X91.217 Y64.152 E-0.32814

G1 X91.415 Y64.350 E-0.15491

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.557 Y58.472

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.906 Y58.441 E0.27753

G1 X81.891 Y57.485 E0.02492

G1 X89.089 Y57.467 E0.18756

G1 X92.592 Y57.513 E0.09129

G1 X92.584 Y58.418 E0.02358

M204 S1250

G1 X92.823 Y58.840 F9000.000

M204 S800

G1 F1500.000

G1 X92.677 Y58.890 E0.00402

G1 X81.775 Y58.858 E0.28406

G1 X81.669 Y58.827 E0.00286

G1 X81.583 Y58.740 E0.00319

G1 X81.477 Y58.473 E0.00749

G1 X81.472 Y57.359 E0.02902

G1 X81.566 Y57.148 E0.00602

G1 X81.648 Y57.082 E0.00273

G1 X81.757 Y57.068 E0.00286

G1 X89.092 Y57.049 E0.19112

G1 X92.855 Y57.099 E0.09806

G1 X92.907 Y57.144 E0.00181

G1 X93.009 Y57.372 E0.00651

G1 X93.014 Y58.184 E0.02114

G1 X92.988 Y58.543 E0.00938

G1 X92.859 Y58.793 E0.00733

M204 S1250

G1 X92.681 Y58.780 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.677 Y58.890 E-0.11463

G1 X91.238 Y58.886 E-0.79737

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.915 Y58.319

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.393 Y57.797 E0.02027

G1 X83.014 Y57.795 E0.01706

G1 X83.351 Y58.132 E0.01307

G1 X83.975 Y58.134 E0.01715

G1 X83.635 Y57.794 E0.01320

G1 X84.256 Y57.792 E0.01706

G1 X84.600 Y58.135 E0.01333

G1 X85.224 Y58.137 E0.01715

G1 X84.878 Y57.791 E0.01345

G1 X85.499 Y57.789 E0.01706

G1 X85.849 Y58.139 E0.01358

G1 X86.473 Y58.141 E0.01715

G1 X86.120 Y57.788 E0.01371

G1 X86.741 Y57.786 E0.01706

G1 X87.098 Y58.143 E0.01384

G1 X87.722 Y58.144 E0.01715

G1 X87.363 Y57.785 E0.01397

G1 X87.984 Y57.783 E0.01706

G1 X88.347 Y58.146 E0.01409

G1 X88.971 Y58.148 E0.01715

G1 X88.605 Y57.782 E0.01422

G1 X89.229 Y57.782 E0.01712

G1 X89.596 Y58.150 E0.01426

G1 X90.220 Y58.152 E0.01715

G1 X89.860 Y57.791 E0.01401

G1 X90.491 Y57.799 E0.01733

G1 X90.845 Y58.153 E0.01376

G1 X91.469 Y58.155 E0.01715

G1 X91.122 Y57.807 E0.01351

G1 X91.753 Y57.815 E0.01733

G1 X92.283 Y58.346 E0.02059

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.753 Y57.815 E-0.41542

M73 P57 R30

G1 X91.122 Y57.807 E-0.34970

G1 X91.309 Y57.995 E-0.14688

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.594 Y51.826

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.711 Y51.810 E0.17936

G1 X81.887 Y51.824 E0.09963

G1 X81.884 Y50.978 E0.02205

G1 X81.914 Y50.837 E0.00375

G1 X92.569 Y50.838 E0.27762

G1 X92.593 Y50.889 E0.00149

G1 X92.594 Y51.766 E0.02284

M204 S1250

G1 X92.826 Y52.213 F9000.000

M204 S800

G1 F1500.000

G1 X92.711 Y52.244 E0.00310

G1 X85.711 Y52.228 E0.18239

G1 X81.775 Y52.242 E0.10257

G1 X81.620 Y52.194 E0.00424

G1 X81.575 Y52.155 E0.00155

G1 X81.523 Y52.083 E0.00230

G1 X81.470 Y51.912 E0.00469

G1 X81.466 Y50.935 E0.02545

G1 X81.521 Y50.673 E0.00697

G1 X81.597 Y50.537 E0.00407

G1 X81.785 Y50.419 E0.00579

G1 X92.701 Y50.420 E0.28441

G1 X92.815 Y50.462 E0.00317

G1 X92.877 Y50.516 E0.00214

G1 X93.011 Y50.794 E0.00804

G1 X93.012 Y51.899 E0.02879

G1 X92.930 Y52.129 E0.00636

G1 X92.873 Y52.175 E0.00192

M204 S1250

G1 X92.723 Y52.153 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.711 Y52.244 E-0.09731

G1 X91.241 Y52.241 E-0.81469

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.124 Y50.962

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.670 Y51.508 E0.02019

G1 X83.261 Y51.506 E0.01547

G1 X82.907 Y51.151 E0.01311

G1 X83.501 Y51.152 E0.01555

G1 X83.853 Y51.503 E0.01300

G1 X84.444 Y51.501 E0.01547

G1 X84.095 Y51.153 E0.01290

G1 X84.689 Y51.154 E0.01555

G1 X85.035 Y51.499 E0.01279

G1 X85.626 Y51.497 E0.01547

G1 X85.284 Y51.154 E0.01268

G1 X85.878 Y51.155 E0.01555

G1 X86.221 Y51.498 E0.01268

G1 X86.815 Y51.499 E0.01556

G1 X86.472 Y51.156 E0.01270

G1 X87.066 Y51.157 E0.01555

G1 X87.410 Y51.501 E0.01272

G1 X88.005 Y51.502 E0.01556

G1 X87.660 Y51.158 E0.01274

G1 X88.255 Y51.159 E0.01555

G1 X88.600 Y51.503 E0.01276

G1 X89.194 Y51.505 E0.01556

G1 X88.848 Y51.159 E0.01280

G1 X89.440 Y51.158 E0.01549

G1 X89.789 Y51.506 E0.01290

G1 X90.384 Y51.508 E0.01556

G1 X90.033 Y51.156 E0.01299

G1 X90.625 Y51.155 E0.01549

G1 X90.979 Y51.509 E0.01309

G1 X91.573 Y51.510 E0.01556

G1 X91.217 Y51.154 E0.01319

G1 X91.809 Y51.153 E0.01549

G1 X92.356 Y51.700 E0.02025

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.809 Y51.153 E-0.42895

G1 X91.217 Y51.154 E-0.32816

G1 X91.415 Y51.352 E-0.15489

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X92.557 Y45.474

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.906 Y45.443 E0.27753

G1 X81.891 Y44.488 E0.02490

G1 X89.089 Y44.469 E0.18756

G1 X92.592 Y44.516 E0.09129

G1 X92.584 Y45.420 E0.02356

M204 S1250

G1 X92.823 Y45.842 F9000.000

M204 S800

G1 F1500.000

G1 X92.677 Y45.892 E0.00402

G1 X81.775 Y45.860 E0.28406

G1 X81.669 Y45.829 E0.00286

G1 X81.583 Y45.742 E0.00319

G1 X81.477 Y45.475 E0.00749

G1 X81.472 Y44.361 E0.02902

G1 X81.566 Y44.150 E0.00602

G1 X81.647 Y44.084 E0.00271

G1 X81.756 Y44.071 E0.00286

G1 X89.092 Y44.051 E0.19113

G1 X92.855 Y44.101 E0.09807

G1 X92.886 Y44.124 E0.00100

G1 X93.009 Y44.379 E0.00737

G1 X93.014 Y45.187 E0.02105

G1 X92.988 Y45.545 E0.00937

G1 X92.859 Y45.795 E0.00732

M204 S1250

G1 X92.681 Y45.782 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.677 Y45.892 E-0.11467

G1 X91.238 Y45.888 E-0.79733

G1 E-0.04800 F4200.00000

G1 Z5.200 F9000.000

G1 X82.915 Y45.321

G1 Z5.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.394 Y44.800 E0.02023

G1 X83.015 Y44.798 E0.01706

G1 X83.350 Y45.134 E0.01304

G1 X83.975 Y45.136 E0.01715

G1 X83.636 Y44.796 E0.01317

G1 X84.257 Y44.795 E0.01706

G1 X84.599 Y45.137 E0.01330

G1 X85.224 Y45.139 E0.01715

G1 X84.878 Y44.793 E0.01343

G1 X85.499 Y44.792 E0.01706

G1 X85.848 Y45.141 E0.01356

G1 X86.473 Y45.143 E0.01715

G1 X86.120 Y44.790 E0.01369

G1 X86.741 Y44.789 E0.01706

G1 X87.097 Y45.145 E0.01383

G1 X87.722 Y45.146 E0.01715

G1 X87.363 Y44.787 E0.01396

G1 X87.984 Y44.785 E0.01706

G1 X88.346 Y45.148 E0.01409

G1 X88.971 Y45.150 E0.01715

G1 X88.605 Y44.784 E0.01422

G1 X89.228 Y44.784 E0.01712

G1 X89.595 Y45.152 E0.01426

G1 X90.220 Y45.154 E0.01715

G1 X89.859 Y44.793 E0.01401

G1 X90.490 Y44.801 E0.01733

G1 X90.844 Y45.155 E0.01375

G1 X91.469 Y45.157 E0.01715

G1 X91.121 Y44.810 E0.01350

G1 X91.752 Y44.818 E0.01733

G1 X92.282 Y45.348 E0.02056

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;5.15

G1 Z5.150 F9000.000

;AFTER\_LAYER\_CHANGE

;5.15

G1 X92.575 Y45.301

M204 S800

G1 F1500.000

G1 X81.904 Y45.284 E0.27806

G1 X81.889 Y44.405 E0.02289

G1 X90.053 Y44.391 E0.21271

G1 X92.593 Y44.418 E0.06618

G1 X92.586 Y45.242 E0.02149

M204 S1250

G1 X92.866 Y45.634 F9000.000

M204 S800

G1 F1500.000

G1 X92.811 Y45.690 E0.00205

G1 X92.710 Y45.719 E0.00275

G1 X81.779 Y45.701 E0.28480

G1 X81.694 Y45.671 E0.00236

G1 X81.554 Y45.537 E0.00505

G1 X81.479 Y45.344 E0.00540

G1 X81.470 Y44.295 E0.02734

G1 X81.527 Y44.126 E0.00463

G1 X81.573 Y44.056 E0.00218

G1 X81.646 Y44.006 E0.00231

G1 X81.713 Y43.988 E0.00181

G1 X90.054 Y43.973 E0.21734

G1 X92.852 Y44.011 E0.07290

G1 X92.929 Y44.087 E0.00282

G1 X93.009 Y44.275 E0.00531

G1 X93.016 Y45.220 E0.02464

G1 X92.973 Y45.451 E0.00610

G1 X92.896 Y45.582 E0.00396

M204 S1250

G1 X92.787 Y45.626 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.811 Y45.690 E-0.07628

G1 X92.710 Y45.719 E-0.05849

G1 X91.307 Y45.717 E-0.77723

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.277 Y45.159

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y44.717 E0.01712

G1 X83.341 Y44.716 E0.01706

G1 X83.085 Y44.972 E0.00992

G1 X83.706 Y44.973 E0.01700

G1 X83.964 Y44.715 E0.01001

G1 X84.586 Y44.714 E0.01706

G1 X84.326 Y44.974 E0.01009

G1 X84.947 Y44.975 E0.01700

G1 X85.209 Y44.713 E0.01017

G1 X85.831 Y44.712 E0.01706

G1 X85.567 Y44.976 E0.01025

G1 X86.187 Y44.977 E0.01700

G1 X86.454 Y44.711 E0.01033

G1 X87.076 Y44.710 E0.01706

G1 X86.808 Y44.978 E0.01041

G1 X87.428 Y44.980 E0.01700

G1 X87.699 Y44.709 E0.01050

G1 X88.322 Y44.708 E0.01706

G1 X88.049 Y44.981 E0.01058

G1 X88.669 Y44.982 E0.01700

G1 X88.944 Y44.707 E0.01066

G1 X89.567 Y44.705 E0.01706

G1 X89.289 Y44.983 E0.01074

G1 X89.910 Y44.984 E0.01700

G1 X90.187 Y44.706 E0.01076

G1 X90.802 Y44.712 E0.01686

G1 X90.530 Y44.985 E0.01055

G1 X91.151 Y44.986 E0.01700

G1 X91.418 Y44.719 E0.01035

G1 X92.033 Y44.725 E0.01686

G1 X91.583 Y45.174 E0.01741

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.033 Y44.725 E-0.35212

G1 X91.418 Y44.719 E-0.34087

G1 X91.151 Y44.986 E-0.20920

G1 X91.133 Y44.986 E-0.00981

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.591 Y51.024

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y51.911 E0.02311

G1 X81.887 Y51.907 E0.27900

G1 X81.884 Y51.093 E0.02122

G1 X81.900 Y51.012 E0.00213

G1 X92.531 Y51.024 E0.27702

M204 S1250

G1 X92.880 Y50.677 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y50.925 E0.00733

G1 X93.013 Y51.990 E0.02773

G1 X92.929 Y52.220 E0.00639

G1 X92.849 Y52.287 E0.00272

G1 X92.709 Y52.329 E0.00382

G1 X81.775 Y52.325 E0.28489

G1 X81.623 Y52.278 E0.00413

G1 X81.504 Y52.125 E0.00506

G1 X81.469 Y51.995 E0.00351

G1 X81.466 Y51.054 E0.02453

G1 X81.502 Y50.866 E0.00497

G1 X81.583 Y50.711 E0.00457

G1 X81.624 Y50.671 E0.00149

G1 X81.665 Y50.637 E0.00139

G1 X81.781 Y50.594 E0.00321

G1 X92.744 Y50.606 E0.28566

G1 X92.832 Y50.641 E0.00246

M204 S1250

G1 X92.824 Y50.952 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.012 Y50.925 E-0.18634

G1 X93.013 Y51.990 E-0.58975

G1 X92.929 Y52.220 E-0.13582

G1 X92.929 Y52.220 E-0.00009

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.256 Y51.782

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.711 Y51.327 E0.01764

G1 X83.332 Y51.328 E0.01702

G1 X83.066 Y51.594 E0.01033

G1 X83.687 Y51.594 E0.01704

G1 X83.953 Y51.329 E0.01031

G1 X84.574 Y51.329 E0.01702

G1 X84.309 Y51.595 E0.01028

G1 X84.930 Y51.595 E0.01704

G1 X85.195 Y51.330 E0.01026

G1 X85.815 Y51.331 E0.01702

G1 X85.552 Y51.595 E0.01023

G1 X86.173 Y51.595 E0.01704

G1 X86.436 Y51.332 E0.01021

G1 X87.057 Y51.333 E0.01702

G1 X86.794 Y51.595 E0.01018

G1 X87.416 Y51.596 E0.01704

G1 X87.678 Y51.333 E0.01016

G1 X88.299 Y51.334 E0.01703

G1 X88.037 Y51.596 E0.01015

G1 X88.659 Y51.596 E0.01704

G1 X88.921 Y51.334 E0.01014

G1 X89.542 Y51.335 E0.01703

G1 X89.280 Y51.596 E0.01013

G1 X89.902 Y51.596 E0.01704

G1 X90.163 Y51.335 E0.01012

G1 X90.784 Y51.336 E0.01703

G1 X90.523 Y51.597 E0.01011

G1 X91.145 Y51.597 E0.01704

G1 X91.405 Y51.336 E0.01010

G1 X92.027 Y51.337 E0.01703

G1 X91.578 Y51.785 E0.01738

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.027 Y51.337 E-0.35128

G1 X91.405 Y51.336 E-0.34426

G1 X91.145 Y51.597 E-0.20419

G1 X91.123 Y51.597 E-0.01228

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.593 Y57.415

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y58.180 E0.01995

G1 X92.575 Y58.299 E0.00315

G1 X81.903 Y58.281 E0.27807

G1 X81.896 Y58.262 E0.00053

G1 X81.889 Y57.403 E0.02240

G1 X90.053 Y57.389 E0.21271

G1 X92.533 Y57.414 E0.06462

M204 S1250

G1 X92.929 Y57.085 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y57.272 E0.00530

G1 X93.016 Y58.218 E0.02464

G1 X92.973 Y58.449 E0.00613

G1 X92.866 Y58.632 E0.00552

G1 X92.811 Y58.688 E0.00205

G1 X92.710 Y58.717 E0.00275

G1 X81.779 Y58.699 E0.28480

G1 X81.694 Y58.669 E0.00235

G1 X81.554 Y58.535 E0.00505

G1 X81.479 Y58.342 E0.00540

G1 X81.470 Y57.293 E0.02734

G1 X81.527 Y57.124 E0.00463

G1 X81.573 Y57.054 E0.00218

G1 X81.647 Y57.004 E0.00232

G1 X81.714 Y56.985 E0.00181

G1 X90.054 Y56.971 E0.21733

G1 X92.731 Y56.999 E0.06974

G1 X92.852 Y57.008 E0.00316

G1 X92.893 Y57.038 E0.00133

M204 S1250

G1 X92.852 Y57.273 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y57.272 E-0.14490

G1 X93.016 Y58.218 E-0.52404

G1 X92.973 Y58.449 E-0.13035

G1 X92.870 Y58.624 E-0.11271

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.277 Y58.157

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y57.715 E0.01713

G1 X83.341 Y57.714 E0.01706

G1 X83.085 Y57.970 E0.00993

G1 X83.706 Y57.971 E0.01700

G1 X83.964 Y57.713 E0.01001

G1 X84.586 Y57.711 E0.01706

G1 X84.326 Y57.972 E0.01010

G1 X84.946 Y57.973 E0.01700

G1 X85.209 Y57.710 E0.01018

G1 X85.831 Y57.709 E0.01706

G1 X85.567 Y57.974 E0.01026

G1 X86.187 Y57.975 E0.01700

G1 X86.454 Y57.708 E0.01034

G1 X87.077 Y57.707 E0.01706

G1 X86.808 Y57.976 E0.01042

G1 X87.428 Y57.977 E0.01700

G1 X87.699 Y57.706 E0.01050

G1 X88.322 Y57.705 E0.01706

G1 X88.048 Y57.978 E0.01058

G1 X88.669 Y57.979 E0.01700

G1 X88.944 Y57.704 E0.01066

G1 X89.567 Y57.703 E0.01706

G1 X89.289 Y57.980 E0.01075

G1 X89.910 Y57.981 E0.01700

G1 X90.187 Y57.704 E0.01076

G1 X90.803 Y57.710 E0.01686

G1 X90.530 Y57.983 E0.01056

G1 X91.151 Y57.984 E0.01700

G1 X91.418 Y57.716 E0.01036

G1 X92.033 Y57.723 E0.01686

G1 X91.583 Y58.172 E0.01743

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.033 Y57.723 E-0.35247

G1 X91.418 Y57.716 E-0.34094

G1 X91.151 Y57.984 E-0.20947

G1 X91.134 Y57.984 E-0.00912

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.591 Y64.022

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y64.909 E0.02311

G1 X81.887 Y64.905 E0.27900

G1 X81.884 Y64.091 E0.02121

G1 X81.900 Y64.010 E0.00213

G1 X92.531 Y64.022 E0.27702

M204 S1250

G1 X92.880 Y63.675 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y63.923 E0.00733

G1 X93.013 Y64.988 E0.02773

G1 X92.929 Y65.218 E0.00639

G1 X92.849 Y65.285 E0.00272

G1 X92.709 Y65.327 E0.00382

G1 X81.775 Y65.323 E0.28489

G1 X81.623 Y65.276 E0.00413

G1 X81.504 Y65.122 E0.00507

G1 X81.469 Y64.993 E0.00349

G1 X81.466 Y64.052 E0.02453

G1 X81.502 Y63.864 E0.00497

G1 X81.583 Y63.709 E0.00457

G1 X81.624 Y63.669 E0.00149

G1 X81.665 Y63.635 E0.00139

G1 X81.781 Y63.592 E0.00321

G1 X92.744 Y63.604 E0.28566

G1 X92.832 Y63.639 E0.00246

M204 S1250

G1 X92.824 Y63.950 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.012 Y63.923 E-0.18634

G1 X93.013 Y64.988 E-0.58975

G1 X92.929 Y65.218 E-0.13582

G1 X92.929 Y65.218 E-0.00009

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.257 Y64.780

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.711 Y64.325 E0.01763

G1 X83.332 Y64.326 E0.01702

G1 X83.066 Y64.592 E0.01032

G1 X83.687 Y64.592 E0.01704

G1 X83.953 Y64.327 E0.01029

G1 X84.574 Y64.327 E0.01702

G1 X84.309 Y64.592 E0.01027

G1 X84.930 Y64.593 E0.01704

G1 X85.195 Y64.328 E0.01025

G1 X85.815 Y64.329 E0.01702

G1 X85.552 Y64.593 E0.01022

G1 X86.173 Y64.593 E0.01704

G1 X86.436 Y64.330 E0.01020

G1 X87.057 Y64.331 E0.01702

G1 X86.795 Y64.593 E0.01017

G1 X87.416 Y64.593 E0.01704

G1 X87.678 Y64.331 E0.01016

G1 X88.299 Y64.332 E0.01703

G1 X88.038 Y64.594 E0.01015

G1 X88.659 Y64.594 E0.01704

G1 X88.921 Y64.332 E0.01014

G1 X89.542 Y64.333 E0.01703

G1 X89.281 Y64.594 E0.01013

G1 X89.902 Y64.594 E0.01704

G1 X90.163 Y64.333 E0.01012

G1 X90.784 Y64.334 E0.01703

G1 X90.524 Y64.595 E0.01011

G1 X91.145 Y64.595 E0.01704

G1 X91.405 Y64.334 E0.01010

G1 X92.027 Y64.335 E0.01703

G1 X91.578 Y64.783 E0.01738

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.027 Y64.335 E-0.35124

G1 X91.405 Y64.334 E-0.34426

G1 X91.145 Y64.595 E-0.20414

G1 X91.123 Y64.595 E-0.01237

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.593 Y70.413

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y71.178 E0.01994

G1 X92.575 Y71.297 E0.00316

G1 X81.903 Y71.279 E0.27806

G1 X81.896 Y71.260 E0.00053

G1 X81.889 Y70.401 E0.02240

G1 X90.053 Y70.387 E0.21271

G1 X92.533 Y70.412 E0.06462

M204 S1250

G1 X92.929 Y70.083 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y70.270 E0.00530

G1 X93.016 Y71.216 E0.02464

G1 X92.973 Y71.446 E0.00611

G1 X92.866 Y71.630 E0.00554

G1 X92.811 Y71.686 E0.00204

G1 X92.709 Y71.715 E0.00276

G1 X81.779 Y71.697 E0.28480

G1 X81.694 Y71.667 E0.00235

G1 X81.554 Y71.533 E0.00505

G1 X81.479 Y71.340 E0.00540

G1 X81.470 Y70.291 E0.02734

G1 X81.527 Y70.122 E0.00463

G1 X81.573 Y70.052 E0.00218

G1 X81.647 Y70.002 E0.00232

G1 X81.714 Y69.983 E0.00181

G1 X90.054 Y69.969 E0.21733

G1 X92.731 Y69.997 E0.06974

G1 X92.852 Y70.006 E0.00316

G1 X92.893 Y70.036 E0.00133

M204 S1250

G1 X92.852 Y70.271 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y70.270 E-0.14490

G1 X93.016 Y71.216 E-0.52400

G1 X92.973 Y71.446 E-0.12996

G1 X92.870 Y71.622 E-0.11314

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.277 Y71.155

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y70.713 E0.01713

G1 X83.341 Y70.712 E0.01706

G1 X83.085 Y70.968 E0.00993

G1 X83.706 Y70.969 E0.01700

G1 X83.964 Y70.711 E0.01001

G1 X84.586 Y70.710 E0.01706

G1 X84.326 Y70.970 E0.01010

G1 X84.946 Y70.971 E0.01700

G1 X85.209 Y70.708 E0.01018

G1 X85.831 Y70.707 E0.01706

G1 X85.567 Y70.972 E0.01026

G1 X86.187 Y70.973 E0.01700

G1 X86.454 Y70.706 E0.01034

G1 X87.077 Y70.705 E0.01706

G1 X86.808 Y70.974 E0.01042

G1 X87.428 Y70.975 E0.01700

G1 X87.699 Y70.704 E0.01050

G1 X88.322 Y70.703 E0.01706

G1 X88.048 Y70.976 E0.01058

G1 X88.669 Y70.977 E0.01700

G1 X88.944 Y70.702 E0.01066

G1 X89.567 Y70.701 E0.01706

G1 X89.289 Y70.978 E0.01075

G1 X89.910 Y70.979 E0.01700

G1 X90.187 Y70.702 E0.01076

G1 X90.803 Y70.708 E0.01686

G1 X90.530 Y70.981 E0.01056

G1 X91.151 Y70.982 E0.01700

G1 X91.418 Y70.714 E0.01036

G1 X92.033 Y70.721 E0.01686

G1 X91.583 Y71.170 E0.01743

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.033 Y70.721 E-0.35247

G1 X91.418 Y70.714 E-0.34094

G1 X91.151 Y70.982 E-0.20947

G1 X91.134 Y70.982 E-0.00913

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.591 Y77.020

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y77.906 E0.02309

G1 X81.887 Y77.903 E0.27900

G1 X81.884 Y77.088 E0.02122

G1 X81.899 Y77.008 E0.00212

G1 X92.531 Y77.020 E0.27702

M204 S1250

G1 X92.880 Y76.673 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y76.921 E0.00733

G1 X93.013 Y77.985 E0.02771

G1 X92.929 Y78.216 E0.00641

G1 X92.849 Y78.283 E0.00270

G1 X92.709 Y78.324 E0.00381

G1 X81.775 Y78.321 E0.28489

G1 X81.623 Y78.274 E0.00414

G1 X81.504 Y78.120 E0.00507

G1 X81.469 Y77.990 E0.00350

G1 X81.466 Y77.049 E0.02453

G1 X81.502 Y76.862 E0.00495

G1 X81.583 Y76.707 E0.00457

G1 X81.665 Y76.632 E0.00289

G1 X81.780 Y76.590 E0.00319

G1 X92.744 Y76.602 E0.28567

G1 X92.832 Y76.637 E0.00246

M204 S1250

G1 X92.824 Y76.948 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.012 Y76.921 E-0.18638

G1 X93.013 Y77.985 E-0.58931

G1 X92.929 Y78.216 E-0.13631

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.256 Y77.778

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.711 Y77.323 E0.01763

G1 X83.332 Y77.324 E0.01702

G1 X83.066 Y77.590 E0.01031

G1 X83.687 Y77.590 E0.01704

G1 X83.953 Y77.325 E0.01029

G1 X84.574 Y77.325 E0.01702

G1 X84.309 Y77.590 E0.01026

G1 X84.930 Y77.590 E0.01704

G1 X85.194 Y77.326 E0.01024

G1 X85.815 Y77.327 E0.01702

G1 X85.552 Y77.590 E0.01021

G1 X86.173 Y77.591 E0.01704

G1 X86.436 Y77.328 E0.01018

G1 X87.057 Y77.329 E0.01702

G1 X86.795 Y77.591 E0.01016

G1 X87.416 Y77.591 E0.01704

G1 X87.678 Y77.329 E0.01014

G1 X88.299 Y77.330 E0.01703

G1 X88.038 Y77.591 E0.01013

G1 X88.659 Y77.591 E0.01704

G1 X88.920 Y77.330 E0.01012

G1 X89.541 Y77.331 E0.01703

G1 X89.281 Y77.592 E0.01010

G1 X89.902 Y77.592 E0.01704

G1 X90.162 Y77.331 E0.01009

G1 X90.784 Y77.332 E0.01703

G1 X90.524 Y77.592 E0.01008

G1 X91.145 Y77.592 E0.01704

G1 X91.405 Y77.332 E0.01007

G1 X92.026 Y77.333 E0.01703

G1 X91.578 Y77.780 E0.01735

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.026 Y77.333 E-0.35067

G1 X91.405 Y77.332 E-0.34423

G1 X91.145 Y77.592 E-0.20359

G1 X91.121 Y77.592 E-0.01350

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.593 Y83.411

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y84.176 E0.01994

G1 X92.575 Y84.294 E0.00313

G1 X81.904 Y84.277 E0.27806

G1 X81.896 Y84.258 E0.00054

G1 X81.889 Y83.399 E0.02239

G1 X90.053 Y83.385 E0.21271

G1 X92.533 Y83.410 E0.06462

M204 S1250

G1 X92.929 Y83.081 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y83.268 E0.00530

G1 X93.016 Y84.214 E0.02464

G1 X92.973 Y84.444 E0.00611

G1 X92.866 Y84.627 E0.00553

G1 X92.811 Y84.684 E0.00204

G1 X92.710 Y84.712 E0.00275

G1 X81.779 Y84.695 E0.28481

G1 X81.694 Y84.665 E0.00235

G1 X81.554 Y84.531 E0.00505

G1 X81.479 Y84.337 E0.00542

G1 X81.470 Y83.289 E0.02733

G1 X81.527 Y83.120 E0.00463

G1 X81.573 Y83.050 E0.00218

G1 X81.647 Y83.000 E0.00232

G1 X81.714 Y82.981 E0.00181

G1 X90.054 Y82.967 E0.21733

G1 X92.731 Y82.995 E0.06974

G1 X92.852 Y83.004 E0.00316

G1 X92.893 Y83.034 E0.00133

M204 S1250

G1 X92.852 Y83.269 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y83.268 E-0.14490

G1 X93.016 Y84.214 E-0.52400

G1 X92.973 Y84.444 E-0.12988

G1 X92.870 Y84.620 E-0.11322

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.277 Y84.152

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y83.711 E0.01712

G1 X83.341 Y83.710 E0.01706

G1 X83.085 Y83.966 E0.00993

G1 X83.706 Y83.967 E0.01700

G1 X83.964 Y83.709 E0.01001

G1 X84.586 Y83.708 E0.01706

G1 X84.326 Y83.968 E0.01009

G1 X84.946 Y83.969 E0.01700

G1 X85.209 Y83.706 E0.01017

G1 X85.831 Y83.705 E0.01706

G1 X85.567 Y83.970 E0.01025

G1 X86.187 Y83.971 E0.01700

G1 X86.454 Y83.704 E0.01032

G1 X87.076 Y83.703 E0.01706

G1 X86.808 Y83.972 E0.01040

G1 X87.428 Y83.973 E0.01700

G1 X87.699 Y83.702 E0.01048

G1 X88.321 Y83.701 E0.01706

G1 X88.048 Y83.974 E0.01056

G1 X88.669 Y83.975 E0.01700

G1 X88.944 Y83.700 E0.01064

G1 X89.566 Y83.699 E0.01706

G1 X89.289 Y83.976 E0.01072

G1 X89.910 Y83.977 E0.01700

G1 X90.187 Y83.700 E0.01074

G1 X90.802 Y83.706 E0.01686

G1 X90.530 Y83.978 E0.01053

G1 X91.151 Y83.979 E0.01700

G1 X91.417 Y83.712 E0.01033

G1 X92.032 Y83.719 E0.01686

G1 X91.583 Y84.168 E0.01740

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.032 Y83.719 E-0.35185

G1 X91.417 Y83.712 E-0.34091

G1 X91.151 Y83.979 E-0.20888

G1 X91.132 Y83.979 E-0.01037

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.592 Y90.018

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y90.904 E0.02309

G1 X81.887 Y90.901 E0.27900

G1 X81.884 Y90.086 E0.02124

G1 X81.899 Y90.006 E0.00212

G1 X92.532 Y90.018 E0.27703

M204 S1250

G1 X92.880 Y89.670 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y89.918 E0.00733

G1 X93.013 Y90.983 E0.02773

G1 X92.929 Y91.214 E0.00641

G1 X92.849 Y91.281 E0.00270

G1 X92.709 Y91.322 E0.00381

G1 X81.775 Y91.319 E0.28489

G1 X81.623 Y91.272 E0.00414

G1 X81.504 Y91.118 E0.00506

G1 X81.469 Y90.988 E0.00350

G1 X81.466 Y90.047 E0.02454

G1 X81.502 Y89.860 E0.00496

G1 X81.583 Y89.705 E0.00455

G1 X81.625 Y89.664 E0.00151

G1 X81.665 Y89.630 E0.00139

G1 X81.781 Y89.588 E0.00320

G1 X92.745 Y89.600 E0.28568

G1 X92.832 Y89.635 E0.00244

M204 S1250

G1 X92.824 Y89.945 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.012 Y89.918 E-0.18629

G1 X93.013 Y90.983 E-0.58981

G1 X92.929 Y91.213 E-0.13590

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.256 Y90.776

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.711 Y90.320 E0.01765

G1 X83.332 Y90.321 E0.01702

G1 X83.065 Y90.588 E0.01034

G1 X83.687 Y90.588 E0.01704

G1 X83.953 Y90.322 E0.01031

G1 X84.574 Y90.323 E0.01702

G1 X84.308 Y90.588 E0.01029

G1 X84.930 Y90.588 E0.01704

G1 X85.194 Y90.324 E0.01026

G1 X85.815 Y90.325 E0.01702

G1 X85.551 Y90.588 E0.01023

G1 X86.173 Y90.589 E0.01704

G1 X86.436 Y90.325 E0.01020

G1 X87.057 Y90.326 E0.01702

G1 X86.794 Y90.589 E0.01018

G1 X87.416 Y90.589 E0.01704

G1 X87.678 Y90.327 E0.01016

G1 X88.299 Y90.328 E0.01703

G1 X88.037 Y90.589 E0.01014

G1 X88.659 Y90.589 E0.01704

G1 X88.920 Y90.328 E0.01013

G1 X89.541 Y90.329 E0.01703

G1 X89.280 Y90.590 E0.01012

G1 X89.902 Y90.590 E0.01704

G1 X90.163 Y90.329 E0.01010

G1 X90.784 Y90.330 E0.01703

G1 X90.523 Y90.590 E0.01009

G1 X91.145 Y90.590 E0.01704

G1 X91.405 Y90.330 E0.01008

G1 X92.026 Y90.331 E0.01703

G1 X91.578 Y90.778 E0.01735

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.026 Y90.331 E-0.35072

G1 X91.405 Y90.330 E-0.34423

G1 X91.145 Y90.590 E-0.20369

G1 X91.121 Y90.590 E-0.01336

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.593 Y96.409

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y97.174 E0.01994

G1 X92.575 Y97.292 E0.00313

G1 X81.904 Y97.275 E0.27806

G1 X81.896 Y97.255 E0.00056

G1 X81.889 Y96.397 E0.02237

G1 X90.053 Y96.382 E0.21271

G1 X92.533 Y96.408 E0.06462

M204 S1250

G1 X92.929 Y96.079 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y96.266 E0.00530

G1 X93.016 Y97.211 E0.02464

G1 X92.973 Y97.442 E0.00610

G1 X92.866 Y97.625 E0.00553

G1 X92.811 Y97.682 E0.00204

G1 X92.710 Y97.710 E0.00275

G1 X81.779 Y97.693 E0.28481

G1 X81.694 Y97.663 E0.00235

G1 X81.554 Y97.529 E0.00506

G1 X81.479 Y97.335 E0.00541

G1 X81.470 Y96.286 E0.02732

G1 X81.527 Y96.118 E0.00462

G1 X81.573 Y96.048 E0.00218

G1 X81.647 Y95.998 E0.00232

G1 X81.714 Y95.979 E0.00181

G1 X90.054 Y95.964 E0.21733

G1 X92.731 Y95.993 E0.06974

G1 X92.852 Y96.002 E0.00316

G1 X92.893 Y96.032 E0.00133

M204 S1250

G1 X92.852 Y96.267 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y96.266 E-0.14490

G1 X93.016 Y97.211 E-0.52400

G1 X92.973 Y97.442 E-0.12983

G1 X92.870 Y97.618 E-0.11327

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.277 Y97.150

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y96.709 E0.01713

G1 X83.341 Y96.707 E0.01706

G1 X83.085 Y96.964 E0.00993

G1 X83.705 Y96.965 E0.01700

G1 X83.964 Y96.706 E0.01002

G1 X84.586 Y96.705 E0.01706

G1 X84.326 Y96.966 E0.01010

G1 X84.946 Y96.967 E0.01700

G1 X85.209 Y96.704 E0.01018

G1 X85.831 Y96.703 E0.01706

G1 X85.567 Y96.968 E0.01026

G1 X86.187 Y96.969 E0.01700

G1 X86.454 Y96.702 E0.01034

G1 X87.077 Y96.701 E0.01706

G1 X86.808 Y96.970 E0.01042

G1 X87.428 Y96.971 E0.01700

G1 X87.699 Y96.700 E0.01050

G1 X88.322 Y96.699 E0.01706

G1 X88.048 Y96.972 E0.01058

G1 X88.669 Y96.973 E0.01700

G1 X88.944 Y96.698 E0.01067

G1 X89.567 Y96.696 E0.01706

G1 X89.289 Y96.974 E0.01075

G1 X89.910 Y96.975 E0.01700

G1 X90.187 Y96.697 E0.01076

G1 X90.802 Y96.703 E0.01685

G1 X90.530 Y96.976 E0.01055

G1 X91.151 Y96.977 E0.01700

G1 X91.417 Y96.710 E0.01034

G1 X92.032 Y96.716 E0.01685

G1 X91.583 Y97.166 E0.01741

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.032 Y96.716 E-0.35199

G1 X91.417 Y96.710 E-0.34082

G1 X91.151 Y96.977 E-0.20914

G1 X91.132 Y96.977 E-0.01005

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.592 Y103.016

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y103.902 E0.02309

G1 X81.887 Y103.898 E0.27900

G1 X81.884 Y103.084 E0.02122

G1 X81.899 Y103.004 E0.00212

G1 X92.532 Y103.016 E0.27703

M204 S1250

G1 X92.880 Y102.668 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y102.916 E0.00733

G1 X93.013 Y103.981 E0.02773

G1 X92.929 Y104.211 E0.00639

G1 X92.849 Y104.278 E0.00272

G1 X92.709 Y104.320 E0.00382

G1 X81.775 Y104.316 E0.28489

G1 X81.623 Y104.269 E0.00413

G1 X81.504 Y104.116 E0.00506

G1 X81.469 Y103.986 E0.00350

G1 X81.466 Y103.045 E0.02454

G1 X81.502 Y102.858 E0.00496

G1 X81.583 Y102.703 E0.00456

G1 X81.665 Y102.628 E0.00289

G1 X81.781 Y102.586 E0.00320

G1 X92.745 Y102.598 E0.28567

G1 X92.832 Y102.632 E0.00244

M204 S1250

G1 X92.824 Y102.943 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.012 Y102.916 E-0.18634

G1 X93.013 Y103.981 E-0.58975

G1 X92.929 Y104.211 E-0.13584

G1 X92.929 Y104.211 E-0.00007

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.256 Y103.773

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.711 Y103.318 E0.01763

G1 X83.332 Y103.319 E0.01702

G1 X83.066 Y103.585 E0.01032

G1 X83.687 Y103.585 E0.01704

G1 X83.953 Y103.320 E0.01030

G1 X84.574 Y103.321 E0.01702

G1 X84.309 Y103.586 E0.01027

G1 X84.930 Y103.586 E0.01704

G1 X85.194 Y103.322 E0.01024

G1 X85.815 Y103.323 E0.01702

G1 X85.552 Y103.586 E0.01022

G1 X86.173 Y103.586 E0.01704

G1 X86.436 Y103.323 E0.01019

G1 X87.057 Y103.324 E0.01702

G1 X86.795 Y103.587 E0.01017

G1 X87.416 Y103.587 E0.01704

G1 X87.678 Y103.325 E0.01015

G1 X88.299 Y103.326 E0.01703

G1 X88.038 Y103.587 E0.01014

G1 X88.659 Y103.587 E0.01704

G1 X88.920 Y103.326 E0.01012

G1 X89.541 Y103.327 E0.01703

G1 X89.281 Y103.587 E0.01011

G1 X89.902 Y103.588 E0.01704

G1 X90.163 Y103.327 E0.01010

G1 X90.784 Y103.328 E0.01703

G1 X90.524 Y103.588 E0.01009

G1 X91.145 Y103.588 E0.01704

G1 X91.405 Y103.328 E0.01008

G1 X92.026 Y103.329 E0.01703

G1 X91.579 Y103.776 E0.01736

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.026 Y103.329 E-0.35083

G1 X91.405 Y103.328 E-0.34424

G1 X91.145 Y103.588 E-0.20376

G1 X91.121 Y103.588 E-0.01317

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.593 Y109.407

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y110.172 E0.01995

G1 X92.575 Y110.290 E0.00313

G1 X81.904 Y110.273 E0.27806

G1 X81.896 Y110.253 E0.00056

G1 X81.889 Y109.394 E0.02238

G1 X90.053 Y109.380 E0.21271

G1 X92.533 Y109.406 E0.06462

M204 S1250

G1 X92.929 Y109.076 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y109.264 E0.00531

G1 X93.016 Y110.209 E0.02464

G1 X92.973 Y110.440 E0.00610

G1 X92.866 Y110.623 E0.00552

G1 X92.811 Y110.679 E0.00205

G1 X92.710 Y110.708 E0.00275

G1 X81.779 Y110.691 E0.28480

G1 X81.694 Y110.661 E0.00235

G1 X81.554 Y110.527 E0.00506

G1 X81.479 Y110.333 E0.00541

G1 X81.470 Y109.284 E0.02734

G1 X81.527 Y109.116 E0.00462

G1 X81.573 Y109.046 E0.00219

G1 X81.647 Y108.995 E0.00232

G1 X81.713 Y108.977 E0.00179

G1 X90.054 Y108.962 E0.21734

G1 X92.731 Y108.990 E0.06973

G1 X92.852 Y109.000 E0.00317

G1 X92.893 Y109.029 E0.00131

M204 S1250

G1 X92.851 Y109.265 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y109.264 E-0.14520

G1 X93.016 Y110.209 E-0.52410

G1 X92.973 Y110.440 E-0.12980

G1 X92.870 Y110.616 E-0.11290

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.277 Y110.148

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y109.706 E0.01714

G1 X83.341 Y109.705 E0.01706

G1 X83.085 Y109.962 E0.00994

G1 X83.705 Y109.963 E0.01700

G1 X83.964 Y109.704 E0.01002

G1 X84.586 Y109.703 E0.01706

G1 X84.326 Y109.964 E0.01010

G1 X84.946 Y109.965 E0.01700

G1 X85.209 Y109.702 E0.01018

G1 X85.831 Y109.701 E0.01706

G1 X85.567 Y109.966 E0.01027

G1 X86.187 Y109.967 E0.01700

G1 X86.454 Y109.700 E0.01035

G1 X87.076 Y109.699 E0.01706

G1 X86.807 Y109.968 E0.01043

G1 X87.428 Y109.969 E0.01700

G1 X87.699 Y109.698 E0.01051

G1 X88.322 Y109.697 E0.01706

G1 X88.048 Y109.970 E0.01059

G1 X88.669 Y109.971 E0.01700

G1 X88.944 Y109.696 E0.01067

G1 X89.567 Y109.694 E0.01706

G1 X89.289 Y109.972 E0.01075

G1 X89.910 Y109.973 E0.01700

G1 X90.187 Y109.695 E0.01076

G1 X90.802 Y109.701 E0.01686

G1 X90.530 Y109.974 E0.01056

G1 X91.151 Y109.975 E0.01700

G1 X91.418 Y109.708 E0.01035

G1 X92.033 Y109.714 E0.01686

G1 X91.583 Y110.164 E0.01741

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.033 Y109.714 E-0.35217

G1 X91.418 Y109.708 E-0.34087

G1 X91.151 Y109.975 E-0.20926

G1 X91.133 Y109.975 E-0.00970

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X92.592 Y116.014

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y116.900 E0.02309

G1 X81.887 Y116.896 E0.27900

G1 X81.884 Y116.082 E0.02122

G1 X81.899 Y116.002 E0.00212

G1 X92.532 Y116.014 E0.27703

M204 S1250

G1 X92.880 Y115.666 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y115.914 E0.00733

G1 X93.013 Y116.979 E0.02773

G1 X92.929 Y117.209 E0.00639

G1 X92.849 Y117.276 E0.00272

G1 X92.709 Y117.318 E0.00382

G1 X81.775 Y117.314 E0.28489

G1 X81.623 Y117.267 E0.00414

G1 X81.504 Y117.114 E0.00506

G1 X81.469 Y116.984 E0.00350

G1 X81.466 Y116.043 E0.02454

G1 X81.502 Y115.856 E0.00496

G1 X81.583 Y115.701 E0.00456

G1 X81.665 Y115.626 E0.00289

G1 X81.781 Y115.584 E0.00320

G1 X92.745 Y115.596 E0.28567

G1 X92.832 Y115.630 E0.00244

M204 S1250

G1 X92.824 Y115.941 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.012 Y115.914 E-0.18634

G1 X93.013 Y116.979 E-0.58975

G1 X92.929 Y117.209 E-0.13584

G1 X92.929 Y117.209 E-0.00007

G1 E-0.04800 F4200.00000

G1 Z5.350 F9000.000

G1 X82.256 Y116.771

G1 Z5.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.711 Y116.316 E0.01763

G1 X83.332 Y116.317 E0.01702

G1 X83.066 Y116.583 E0.01032

G1 X83.687 Y116.583 E0.01704

G1 X83.953 Y116.318 E0.01030

G1 X84.574 Y116.319 E0.01702

G1 X84.309 Y116.584 E0.01027

G1 X84.930 Y116.584 E0.01704

G1 X85.194 Y116.320 E0.01024

G1 X85.815 Y116.321 E0.01702

G1 X85.552 Y116.584 E0.01022

G1 X86.173 Y116.584 E0.01704

G1 X86.436 Y116.321 E0.01019

G1 X87.057 Y116.322 E0.01702

G1 X86.795 Y116.585 E0.01017

G1 X87.416 Y116.585 E0.01704

G1 X87.678 Y116.323 E0.01015

G1 X88.299 Y116.324 E0.01703

G1 X88.038 Y116.585 E0.01014

G1 X88.659 Y116.585 E0.01704

G1 X88.920 Y116.324 E0.01013

G1 X89.541 Y116.325 E0.01703

G1 X89.281 Y116.585 E0.01011

G1 X89.902 Y116.586 E0.01704

G1 X90.163 Y116.325 E0.01010

G1 X90.784 Y116.326 E0.01703

G1 X90.524 Y116.586 E0.01009

G1 X91.145 Y116.586 E0.01704

G1 X91.405 Y116.326 E0.01008

G1 X92.026 Y116.327 E0.01703

G1 X91.579 Y116.774 E0.01736

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;5.3

G1 Z5.300 F9000.000

;AFTER\_LAYER\_CHANGE

;5.3

G1 X92.594 Y116.974

M204 S800

G1 F1500.000

G1 X81.887 Y116.979 E0.27900

G1 X81.884 Y116.208 E0.02008

G1 X81.894 Y116.160 E0.00129

G1 X92.595 Y116.164 E0.27881

G1 X92.594 Y116.914 E0.01953

M204 S1250

G1 X92.945 Y117.253 F9000.000

M204 S800

G1 F1500.000

G1 X92.819 Y117.361 E0.00432

G1 X92.710 Y117.391 E0.00294

G1 X81.776 Y117.397 E0.28489

G1 X81.615 Y117.345 E0.00443

G1 X81.506 Y117.205 E0.00462

G1 X81.469 Y117.077 E0.00346

G1 X81.466 Y116.165 E0.02376

G1 X81.512 Y115.949 E0.00577

G1 X81.568 Y115.849 E0.00299

G1 X81.656 Y115.777 E0.00298

G1 X81.774 Y115.742 E0.00319

G1 X92.723 Y115.746 E0.28530

G1 X92.817 Y115.763 E0.00248

G1 X92.875 Y115.812 E0.00199

G1 X93.013 Y116.045 E0.00704

G1 X93.012 Y117.069 E0.02669

G1 X92.965 Y117.197 E0.00355

M204 S1250

G1 X92.779 Y117.242 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.819 Y117.361 E-0.12187

G1 X92.710 Y117.391 E-0.06244

G1 X91.397 Y117.392 E-0.72770

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X82.094 Y116.569

G1 Z5.300

G1 E3.20000 F2400.00000

G1 X92.386 Y116.569 E0.25155

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y116.569 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.461 Y110.156

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.751 Y110.124 E0.07060

G1 X81.897 Y110.120 E0.20466

G1 X81.887 Y109.315 E0.02099

G1 X92.592 Y109.319 E0.27892

G1 X92.594 Y110.094 E0.02019

G1 X92.575 Y110.158 E0.00172

G1 X92.521 Y110.157 E0.00142

M204 S1250

G1 X92.908 Y110.423 F9000.000

M204 S800

G1 F1500.000

G1 X92.802 Y110.527 E0.00386

G1 X92.693 Y110.577 E0.00312

G1 X89.749 Y110.542 E0.07672

G1 X81.771 Y110.538 E0.20788

G1 X81.707 Y110.521 E0.00171

G1 X81.541 Y110.382 E0.00564

G1 X81.480 Y110.218 E0.00456

G1 X81.469 Y109.218 E0.02605

G1 X81.524 Y109.035 E0.00500

G1 X81.561 Y108.984 E0.00162

G1 X81.648 Y108.924 E0.00275

G1 X81.744 Y108.897 E0.00261

G1 X92.720 Y108.902 E0.28600

G1 X92.851 Y108.926 E0.00346

G1 X92.899 Y108.954 E0.00145

G1 X92.951 Y109.020 E0.00219

M73 P58 R29

G1 X93.010 Y109.186 E0.00457

G1 X93.012 Y110.138 E0.02482

G1 X92.981 Y110.282 E0.00384

G1 X92.936 Y110.370 E0.00258

M204 S1250

G1 X92.761 Y110.405 F9000.000

G1 X92.384 Y109.737

G1 F2400.000

G1 X89.755 Y109.717 E0.06848

G1 X82.101 Y109.717 E0.18910

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y109.717 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X81.887 Y103.981

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.894 Y103.162 E0.02134

G1 X92.595 Y103.167 E0.27881

G1 X92.594 Y103.976 E0.02107

G1 X81.947 Y103.981 E0.27744

M204 S1250

G1 X81.506 Y104.207 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y104.079 E0.00346

G1 X81.466 Y103.167 E0.02376

G1 X81.512 Y102.951 E0.00577

G1 X81.568 Y102.851 E0.00299

G1 X81.656 Y102.779 E0.00298

G1 X81.774 Y102.744 E0.00319

G1 X92.724 Y102.749 E0.28532

G1 X92.817 Y102.765 E0.00246

G1 X92.875 Y102.814 E0.00199

G1 X93.013 Y103.047 E0.00704

G1 X93.012 Y104.071 E0.02669

G1 X92.945 Y104.255 E0.00511

G1 X92.819 Y104.363 E0.00432

G1 X92.710 Y104.393 E0.00294

G1 X81.776 Y104.399 E0.28489

G1 X81.615 Y104.347 E0.00442

G1 X81.543 Y104.254 E0.00305

M204 S1250

G1 X81.574 Y104.093 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.469 Y104.079 E-0.10522

G1 X81.466 Y103.167 E-0.50540

G1 X81.512 Y102.951 E-0.12265

G1 X81.568 Y102.851 E-0.06351

G1 X81.656 Y102.779 E-0.06332

G1 X81.746 Y102.752 E-0.05190

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.386 Y103.571

G1 Z5.300

G1 E3.20000 F2400.00000

G1 X82.094 Y103.571 E0.25097

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y103.571 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X81.897 Y97.122

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.317 E0.02098

G1 X92.592 Y96.322 E0.27892

G1 X92.594 Y97.096 E0.02019

G1 X92.575 Y97.160 E0.00172

G1 X89.751 Y97.126 E0.07359

G1 X81.957 Y97.122 E0.20310

M204 S1250

G1 X81.541 Y97.384 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y97.220 E0.00455

G1 X81.469 Y96.220 E0.02605

G1 X81.524 Y96.037 E0.00499

G1 X81.561 Y95.987 E0.00162

G1 X81.648 Y95.927 E0.00276

G1 X81.744 Y95.899 E0.00262

G1 X92.720 Y95.904 E0.28599

G1 X92.850 Y95.928 E0.00345

G1 X92.899 Y95.957 E0.00146

G1 X92.951 Y96.023 E0.00220

G1 X93.010 Y96.188 E0.00455

G1 X93.012 Y97.140 E0.02482

G1 X92.981 Y97.284 E0.00384

G1 X92.908 Y97.425 E0.00414

G1 X92.802 Y97.529 E0.00386

G1 X92.693 Y97.579 E0.00312

G1 X89.749 Y97.544 E0.07672

G1 X81.770 Y97.540 E0.20790

G1 X81.707 Y97.524 E0.00170

G1 X81.587 Y97.422 E0.00408

M204 S1250

G1 X81.623 Y97.229 F9000.000

G1 X82.101 Y96.720

G1 F2400.000

G1 X89.755 Y96.720 E0.18897

G1 X92.384 Y96.739 E0.06845

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.739 Y96.727 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.594 Y90.978

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y90.984 E0.27900

G1 X81.884 Y90.212 E0.02010

G1 X81.894 Y90.164 E0.00129

G1 X92.595 Y90.169 E0.27881

G1 X92.594 Y90.918 E0.01951

M204 S1250

G1 X92.945 Y91.258 F9000.000

M204 S800

G1 F1500.000

G1 X92.819 Y91.365 E0.00430

G1 X92.711 Y91.395 E0.00293

G1 X81.777 Y91.402 E0.28489

G1 X81.615 Y91.349 E0.00443

G1 X81.506 Y91.209 E0.00463

G1 X81.469 Y91.081 E0.00346

G1 X81.466 Y90.169 E0.02376

G1 X81.512 Y89.953 E0.00576

G1 X81.568 Y89.854 E0.00298

G1 X81.657 Y89.781 E0.00299

G1 X81.773 Y89.746 E0.00317

G1 X92.724 Y89.751 E0.28531

G1 X92.817 Y89.768 E0.00248

G1 X92.875 Y89.816 E0.00197

G1 X93.013 Y90.050 E0.00706

G1 X93.012 Y91.073 E0.02666

G1 X92.965 Y91.202 E0.00357

M204 S1250

G1 X92.780 Y91.246 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.819 Y91.365 E-0.12152

G1 X92.711 Y91.395 E-0.06237

G1 X91.397 Y91.396 E-0.72811

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X82.094 Y90.574

G1 Z5.300

G1 E3.20000 F2400.00000

G1 X92.386 Y90.573 E0.25103

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y90.573 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.459 Y84.160

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.751 Y84.129 E0.07056

G1 X81.897 Y84.124 E0.20466

G1 X81.887 Y83.319 E0.02098

G1 X92.592 Y83.324 E0.27892

G1 X92.594 Y84.099 E0.02020

G1 X92.576 Y84.162 E0.00171

G1 X92.519 Y84.161 E0.00147

M204 S1250

G1 X92.908 Y84.427 F9000.000

M204 S800

G1 F1500.000

G1 X92.802 Y84.531 E0.00387

G1 X92.693 Y84.581 E0.00312

G1 X89.749 Y84.547 E0.07672

G1 X81.770 Y84.542 E0.20790

G1 X81.707 Y84.525 E0.00170

G1 X81.541 Y84.386 E0.00563

G1 X81.480 Y84.222 E0.00456

G1 X81.469 Y83.223 E0.02603

G1 X81.525 Y83.039 E0.00501

G1 X81.561 Y82.989 E0.00162

G1 X81.648 Y82.929 E0.00276

G1 X81.744 Y82.901 E0.00262

G1 X92.720 Y82.906 E0.28599

G1 X92.850 Y82.930 E0.00345

G1 X92.899 Y82.959 E0.00146

G1 X92.951 Y83.025 E0.00220

G1 X93.010 Y83.190 E0.00455

G1 X93.012 Y84.142 E0.02482

G1 X92.981 Y84.287 E0.00385

G1 X92.936 Y84.374 E0.00256

M204 S1250

G1 X92.761 Y84.409 F9000.000

G1 X92.384 Y83.741

G1 F2400.000

G1 X89.755 Y83.722 E0.06848

G1 X82.101 Y83.722 E0.18931

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y83.722 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X81.887 Y77.986

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.894 Y77.167 E0.02134

G1 X92.595 Y77.171 E0.27881

G1 X92.594 Y77.980 E0.02107

G1 X81.947 Y77.986 E0.27744

M204 S1250

G1 X81.506 Y78.211 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y78.083 E0.00346

G1 X81.466 Y77.172 E0.02374

G1 X81.512 Y76.956 E0.00577

G1 X81.568 Y76.856 E0.00298

G1 X81.656 Y76.784 E0.00298

G1 X81.774 Y76.749 E0.00319

G1 X92.724 Y76.753 E0.28531

G1 X92.817 Y76.770 E0.00248

G1 X92.876 Y76.818 E0.00198

G1 X93.013 Y77.052 E0.00705

G1 X93.012 Y78.075 E0.02666

G1 X92.945 Y78.260 E0.00513

G1 X92.819 Y78.367 E0.00430

G1 X92.711 Y78.397 E0.00293

G1 X81.777 Y78.404 E0.28489

G1 X81.615 Y78.351 E0.00443

G1 X81.543 Y78.258 E0.00307

M204 S1250

G1 X81.574 Y78.097 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.469 Y78.083 E-0.10522

G1 X81.466 Y77.172 E-0.50502

G1 X81.512 Y76.956 E-0.12262

G1 X81.568 Y76.856 E-0.06339

G1 X81.656 Y76.784 E-0.06332

G1 X81.747 Y76.757 E-0.05244

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.386 Y77.575

G1 Z5.300

G1 E3.20000 F2400.00000

G1 X82.094 Y77.576 E0.25096

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y77.576 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X81.897 Y71.126

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y70.321 E0.02098

G1 X92.592 Y70.326 E0.27892

G1 X92.594 Y71.101 E0.02020

G1 X92.575 Y71.164 E0.00173

G1 X89.751 Y71.131 E0.07359

G1 X81.957 Y71.126 E0.20310

M204 S1250

G1 X81.541 Y71.389 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y71.225 E0.00456

G1 X81.469 Y70.225 E0.02605

G1 X81.525 Y70.041 E0.00501

G1 X81.561 Y69.991 E0.00162

G1 X81.648 Y69.931 E0.00276

G1 X81.744 Y69.903 E0.00262

G1 X92.720 Y69.908 E0.28599

G1 X92.850 Y69.932 E0.00345

G1 X92.899 Y69.961 E0.00146

G1 X92.951 Y70.027 E0.00220

G1 X93.010 Y70.192 E0.00455

G1 X93.012 Y71.144 E0.02482

G1 X92.981 Y71.289 E0.00386

G1 X92.908 Y71.430 E0.00413

G1 X92.802 Y71.533 E0.00385

G1 X92.693 Y71.583 E0.00314

G1 X89.749 Y71.549 E0.07671

G1 X81.770 Y71.544 E0.20790

G1 X81.706 Y71.527 E0.00171

G1 X81.587 Y71.427 E0.00405

M204 S1250

G1 X81.623 Y71.234 F9000.000

G1 X82.101 Y70.724

G1 F2400.000

G1 X89.755 Y70.724 E0.18945

G1 X92.384 Y70.743 E0.06857

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.739 Y70.731 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.594 Y64.982

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y64.988 E0.27900

G1 X81.884 Y64.217 E0.02008

G1 X81.894 Y64.169 E0.00129

G1 X92.595 Y64.173 E0.27881

G1 X92.594 Y64.922 E0.01953

M204 S1250

G1 X92.945 Y65.262 F9000.000

M204 S800

G1 F1500.000

G1 X92.819 Y65.370 E0.00432

G1 X92.710 Y65.400 E0.00294

G1 X81.776 Y65.406 E0.28489

G1 X81.615 Y65.354 E0.00442

G1 X81.506 Y65.214 E0.00463

G1 X81.469 Y65.086 E0.00345

G1 X81.466 Y64.174 E0.02376

G1 X81.512 Y63.958 E0.00577

G1 X81.568 Y63.858 E0.00298

G1 X81.656 Y63.786 E0.00298

G1 X81.774 Y63.751 E0.00319

G1 X92.724 Y63.755 E0.28531

G1 X92.817 Y63.772 E0.00246

G1 X92.875 Y63.821 E0.00200

G1 X93.013 Y64.054 E0.00704

G1 X93.012 Y65.078 E0.02669

G1 X92.965 Y65.206 E0.00354

M204 S1250

G1 X92.779 Y65.250 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.819 Y65.370 E-0.12188

G1 X92.710 Y65.400 E-0.06250

G1 X91.397 Y65.401 E-0.72762

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X82.094 Y64.578

G1 Z5.300

G1 E3.20000 F2400.00000

G1 X92.386 Y64.578 E0.25145

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y64.578 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.460 Y58.165

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.751 Y58.133 E0.07058

G1 X81.897 Y58.128 E0.20466

G1 X81.887 Y57.323 E0.02098

G1 X92.592 Y57.328 E0.27892

G1 X92.594 Y58.103 E0.02020

G1 X92.575 Y58.166 E0.00173

G1 X92.520 Y58.166 E0.00144

M204 S1250

G1 X92.908 Y58.432 F9000.000

M204 S800

G1 F1500.000

G1 X92.802 Y58.536 E0.00385

G1 X92.693 Y58.585 E0.00312

G1 X89.749 Y58.551 E0.07673

G1 X81.770 Y58.546 E0.20790

G1 X81.706 Y58.529 E0.00171

G1 X81.541 Y58.391 E0.00562

G1 X81.480 Y58.227 E0.00456

G1 X81.469 Y57.227 E0.02605

G1 X81.525 Y57.043 E0.00501

G1 X81.561 Y56.993 E0.00162

G1 X81.648 Y56.933 E0.00276

G1 X81.744 Y56.905 E0.00262

G1 X92.720 Y56.910 E0.28599

G1 X92.850 Y56.934 E0.00345

G1 X92.899 Y56.963 E0.00146

G1 X92.951 Y57.029 E0.00220

G1 X93.010 Y57.194 E0.00455

G1 X93.012 Y58.146 E0.02482

G1 X92.981 Y58.291 E0.00386

G1 X92.936 Y58.379 E0.00258

M204 S1250

G1 X92.762 Y58.414 F9000.000

G1 X92.384 Y57.745

G1 F2400.000

G1 X89.755 Y57.726 E0.06857

G1 X82.101 Y57.726 E0.18945

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y57.726 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X81.887 Y51.990

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.894 Y51.171 E0.02134

G1 X92.595 Y51.175 E0.27881

G1 X92.594 Y51.985 E0.02110

G1 X81.947 Y51.990 E0.27744

M204 S1250

G1 X81.506 Y52.216 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y52.088 E0.00346

G1 X81.466 Y51.176 E0.02376

G1 X81.512 Y50.960 E0.00577

G1 X81.568 Y50.860 E0.00298

G1 X81.656 Y50.788 E0.00298

G1 X81.774 Y50.753 E0.00319

G1 X92.724 Y50.757 E0.28531

G1 X92.817 Y50.774 E0.00246

G1 X92.875 Y50.823 E0.00200

G1 X93.013 Y51.056 E0.00704

G1 X93.012 Y52.080 E0.02669

G1 X92.945 Y52.264 E0.00511

G1 X92.819 Y52.372 E0.00432

G1 X92.710 Y52.402 E0.00294

G1 X81.776 Y52.408 E0.28488

G1 X81.615 Y52.356 E0.00443

G1 X81.543 Y52.263 E0.00305

M204 S1250

G1 X81.574 Y52.102 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.469 Y52.088 E-0.10516

G1 X81.466 Y51.176 E-0.50542

G1 X81.512 Y50.960 E-0.12277

G1 X81.568 Y50.860 E-0.06335

G1 X81.656 Y50.788 E-0.06338

G1 X81.746 Y50.761 E-0.05193

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X92.386 Y51.580

G1 Z5.300

G1 E3.20000 F2400.00000

G1 X82.094 Y51.580 E0.25155

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y51.580 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.500 F9000.000

G1 X81.897 Y45.131

G1 Z5.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.326 E0.02099

G1 X92.592 Y44.330 E0.27892

G1 X92.594 Y45.105 E0.02019

G1 X92.575 Y45.169 E0.00172

G1 X89.751 Y45.135 E0.07359

G1 X81.957 Y45.131 E0.20310

M204 S1250

G1 X81.541 Y45.393 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y45.229 E0.00456

G1 X81.469 Y44.229 E0.02605

G1 X81.525 Y44.045 E0.00501

G1 X81.561 Y43.995 E0.00162

G1 X81.647 Y43.935 E0.00274

G1 X81.744 Y43.908 E0.00261

G1 X92.720 Y43.913 E0.28600

G1 X92.851 Y43.937 E0.00346

G1 X92.899 Y43.965 E0.00145

G1 X92.951 Y44.031 E0.00219

G1 X93.010 Y44.197 E0.00457

G1 X93.012 Y45.149 E0.02482

G1 X92.981 Y45.293 E0.00384

G1 X92.908 Y45.434 E0.00414

G1 X92.802 Y45.538 E0.00386

G1 X92.693 Y45.588 E0.00312

G1 X89.749 Y45.553 E0.07672

G1 X81.771 Y45.549 E0.20788

G1 X81.707 Y45.532 E0.00171

G1 X81.587 Y45.431 E0.00407

M204 S1250

G1 X81.623 Y45.238 F9000.000

G1 X82.101 Y44.728

G1 F2400.000

G1 X89.755 Y44.728 E0.18910

G1 X92.384 Y44.748 E0.06848

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;5.45

G1 Z5.450 F9000.000

;AFTER\_LAYER\_CHANGE

;5.45

G1 X92.591 Y45.017

M204 S800

G1 F1500.000

G1 X92.571 Y45.037 E0.00074

G1 X89.140 Y44.997 E0.08942

G1 X81.890 Y45.004 E0.18890

G1 X81.886 Y44.258 E0.01944

G1 X92.594 Y44.246 E0.27899

G1 X92.591 Y44.957 E0.01852

M204 S1250

G1 X92.966 Y43.978 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y44.129 E0.00409

G1 X93.009 Y45.081 E0.02480

G1 X92.924 Y45.296 E0.00602

G1 X92.886 Y45.338 E0.00147

G1 X92.682 Y45.456 E0.00616

G1 X89.137 Y45.415 E0.09236

G1 X81.779 Y45.422 E0.19173

G1 X81.655 Y45.379 E0.00342

G1 X81.534 Y45.264 E0.00436

G1 X81.472 Y45.084 E0.00496

G1 X81.468 Y44.151 E0.02430

G1 X81.521 Y43.967 E0.00499

G1 X81.547 Y43.935 E0.00109

G1 X81.642 Y43.867 E0.00304

G1 X81.765 Y43.841 E0.00327

G1 X92.717 Y43.828 E0.28536

G1 X92.843 Y43.862 E0.00339

G1 X92.924 Y43.935 E0.00285

M204 S1250

G1 X92.889 Y44.115 F9000.000

G1 X92.384 Y44.641

G1 F2400.000

G1 X89.143 Y44.624 E0.07447

G1 X82.097 Y44.631 E0.14461

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y44.629 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X81.893 Y51.306

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y51.294 E0.27886

G1 X92.595 Y52.046 E0.01958

G1 X81.886 Y52.054 E0.27901

G1 X81.884 Y51.365 E0.01796

M204 S1250

G1 X81.569 Y50.967 F9000.000

M204 S800

G1 F1500.000

G1 X81.671 Y50.896 E0.00323

G1 X81.752 Y50.888 E0.00212

G1 X92.705 Y50.877 E0.28541

G1 X92.818 Y50.913 E0.00308

G1 X92.893 Y50.962 E0.00235

G1 X93.013 Y51.157 E0.00596

G1 X93.012 Y52.146 E0.02579

G1 X92.953 Y52.326 E0.00492

G1 X92.918 Y52.369 E0.00145

G1 X92.771 Y52.464 E0.00455

G1 X81.774 Y52.472 E0.28655

G1 X81.605 Y52.422 E0.00459

G1 X81.522 Y52.323 E0.00336

G1 X81.469 Y52.151 E0.00469

G1 X81.466 Y51.299 E0.02221

G1 X81.540 Y51.019 E0.00753

M204 S1250

G1 X81.692 Y50.985 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.671 Y50.896 E-0.09991

G1 X81.752 Y50.888 E-0.04514

G1 X83.136 Y50.887 E-0.76695

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.386 Y51.670

G1 Z5.450

G1 E3.20000 F2400.00000

G1 X82.094 Y51.680 E0.21418

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y51.678 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X81.886 Y57.256

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y57.243 E0.27899

G1 X92.591 Y58.015 E0.02010

G1 X92.582 Y58.035 E0.00057

G1 X89.140 Y57.995 E0.08971

G1 X81.890 Y58.002 E0.18890

G1 X81.887 Y57.316 E0.01788

M204 S1250

G1 X81.521 Y56.965 F9000.000

M204 S800

G1 F1500.000

G1 X81.643 Y56.865 E0.00411

G1 X81.766 Y56.838 E0.00328

G1 X92.717 Y56.825 E0.28534

G1 X92.870 Y56.877 E0.00422

G1 X92.966 Y56.976 E0.00360

G1 X93.011 Y57.126 E0.00407

G1 X93.009 Y58.078 E0.02480

G1 X92.924 Y58.293 E0.00603

G1 X92.841 Y58.375 E0.00302

G1 X92.688 Y58.454 E0.00450

G1 X89.137 Y58.413 E0.09251

G1 X81.779 Y58.420 E0.19173

G1 X81.655 Y58.377 E0.00341

G1 X81.534 Y58.262 E0.00435

G1 X81.472 Y58.082 E0.00496

G1 X81.468 Y57.149 E0.02430

G1 X81.504 Y57.023 E0.00343

M204 S1250

G1 X81.678 Y56.978 F9000.000

G1 X82.097 Y57.628

G1 F2400.000

G1 X89.143 Y57.621 E0.14493

G1 X92.384 Y57.638 E0.07457

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y57.629 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.595 Y64.292

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y65.044 E0.01958

G1 X81.886 Y65.052 E0.27901

G1 X81.893 Y64.304 E0.01950

G1 X92.535 Y64.292 E0.27730

M204 S1250

G1 X92.818 Y63.911 F9000.000

M204 S800

G1 F1500.000

G1 X92.893 Y63.960 E0.00235

G1 X93.013 Y64.155 E0.00596

G1 X93.012 Y65.144 E0.02579

G1 X92.953 Y65.323 E0.00491

G1 X92.918 Y65.367 E0.00145

G1 X92.771 Y65.462 E0.00455

G1 X81.774 Y65.470 E0.28655

G1 X81.605 Y65.420 E0.00459

G1 X81.522 Y65.321 E0.00336

G1 X81.469 Y65.149 E0.00469

G1 X81.466 Y64.297 E0.02221

G1 X81.522 Y64.048 E0.00665

G1 X81.569 Y63.965 E0.00248

G1 X81.671 Y63.894 E0.00323

G1 X92.705 Y63.875 E0.28752

G1 X92.761 Y63.893 E0.00152

M204 S1250

G1 X92.830 Y64.000 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.893 Y63.960 E-0.08247

G1 X93.013 Y64.155 E-0.12670

G1 X93.012 Y65.144 E-0.54841

G1 X92.953 Y65.323 E-0.10446

G1 X92.918 Y65.367 E-0.03094

G1 X92.889 Y65.385 E-0.01902

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X82.094 Y64.678

G1 Z5.450

G1 E3.20000 F2400.00000

G1 X92.386 Y64.668 E0.21418

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y64.670 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.594 Y70.241

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y71.012 E0.02010

G1 X92.571 Y71.033 E0.00074

G1 X89.140 Y70.993 E0.08942

G1 X81.890 Y71.000 E0.18890

G1 X81.886 Y70.254 E0.01944

G1 X92.534 Y70.241 E0.27743

M204 S1250

G1 X92.966 Y69.974 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y70.124 E0.00407

G1 X93.009 Y71.076 E0.02480

G1 X92.924 Y71.291 E0.00602

G1 X92.886 Y71.333 E0.00148

G1 X92.682 Y71.452 E0.00616

G1 X89.137 Y71.411 E0.09236

G1 X81.779 Y71.418 E0.19173

G1 X81.655 Y71.375 E0.00341

G1 X81.534 Y71.260 E0.00435

G1 X81.472 Y71.080 E0.00496

G1 X81.468 Y70.147 E0.02430

G1 X81.521 Y69.963 E0.00499

G1 X81.547 Y69.931 E0.00109

G1 X81.643 Y69.863 E0.00305

G1 X81.766 Y69.836 E0.00328

G1 X92.717 Y69.823 E0.28534

G1 X92.842 Y69.857 E0.00338

G1 X92.925 Y69.931 E0.00289

M204 S1250

G1 X92.890 Y70.110 F9000.000

G1 X92.384 Y70.636

G1 F2400.000

G1 X89.143 Y70.619 E0.07457

G1 X82.097 Y70.626 E0.14493

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y70.625 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X81.893 Y77.302

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y77.290 E0.27886

G1 X92.595 Y78.042 E0.01958

G1 X81.886 Y78.050 E0.27901

G1 X81.884 Y77.361 E0.01796

M204 S1250

G1 X81.569 Y76.963 F9000.000

M204 S800

G1 F1500.000

G1 X81.671 Y76.892 E0.00323

G1 X81.752 Y76.884 E0.00213

G1 X92.705 Y76.872 E0.28540

G1 X92.818 Y76.909 E0.00310

G1 X92.894 Y76.957 E0.00233

G1 X93.013 Y77.153 E0.00597

G1 X93.012 Y78.142 E0.02577

G1 X92.952 Y78.321 E0.00493

G1 X92.918 Y78.365 E0.00145

G1 X92.772 Y78.459 E0.00453

G1 X81.774 Y78.468 E0.28656

G1 X81.605 Y78.418 E0.00458

G1 X81.522 Y78.319 E0.00338

G1 X81.469 Y78.146 E0.00470

G1 X81.466 Y77.295 E0.02219

G1 X81.540 Y77.015 E0.00753

M204 S1250

G1 X81.692 Y76.980 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.671 Y76.892 E-0.09972

G1 X81.752 Y76.884 E-0.04522

G1 X83.136 Y76.882 E-0.76706

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.386 Y77.666

G1 Z5.450

G1 E3.20000 F2400.00000

G1 X82.094 Y77.676 E0.21413

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y77.674 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X81.886 Y83.252

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y83.239 E0.27899

G1 X92.591 Y84.010 E0.02009

G1 X92.571 Y84.030 E0.00073

G1 X89.139 Y83.991 E0.08942

G1 X81.890 Y83.998 E0.18890

G1 X81.887 Y83.312 E0.01788

M204 S1250

G1 X81.521 Y82.961 F9000.000

M204 S800

G1 F1500.000

G1 X81.643 Y82.861 E0.00411

G1 X81.766 Y82.834 E0.00328

G1 X92.717 Y82.821 E0.28534

G1 X92.870 Y82.873 E0.00422

G1 X92.966 Y82.972 E0.00360

G1 X93.011 Y83.122 E0.00407

G1 X93.009 Y84.074 E0.02480

G1 X92.924 Y84.289 E0.00601

G1 X92.886 Y84.331 E0.00148

G1 X92.682 Y84.449 E0.00616

G1 X89.137 Y84.409 E0.09236

G1 X81.779 Y84.416 E0.19173

G1 X81.655 Y84.373 E0.00340

G1 X81.534 Y84.257 E0.00438

G1 X81.472 Y84.078 E0.00494

G1 X81.468 Y83.145 E0.02430

G1 X81.504 Y83.019 E0.00342

M204 S1250

G1 X81.678 Y82.974 F9000.000

G1 X82.097 Y83.624

G1 F2400.000

G1 X89.142 Y83.617 E0.14493

G1 X92.384 Y83.634 E0.07449

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y83.625 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.595 Y90.288

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y91.040 E0.01958

G1 X81.886 Y91.048 E0.27901

G1 X81.893 Y90.300 E0.01950

G1 X92.535 Y90.288 E0.27730

M204 S1250

G1 X92.818 Y89.907 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y89.956 E0.00234

G1 X93.013 Y90.150 E0.00594

G1 X93.012 Y91.140 E0.02579

G1 X92.952 Y91.319 E0.00493

G1 X92.918 Y91.363 E0.00145

G1 X92.772 Y91.457 E0.00453

G1 X81.774 Y91.466 E0.28656

G1 X81.605 Y91.416 E0.00458

G1 X81.522 Y91.317 E0.00338

G1 X81.469 Y91.144 E0.00470

G1 X81.466 Y90.292 E0.02221

G1 X81.522 Y90.043 E0.00663

G1 X81.569 Y89.961 E0.00248

G1 X81.670 Y89.889 E0.00323

G1 X92.705 Y89.870 E0.28752

G1 X92.761 Y89.889 E0.00154

M204 S1250

G1 X92.831 Y89.996 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y89.956 E-0.08231

G1 X93.013 Y90.150 E-0.12639

G1 X93.012 Y91.140 E-0.54860

G1 X92.952 Y91.319 E-0.10486

G1 X92.918 Y91.363 E-0.03089

G1 X92.889 Y91.381 E-0.01895

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X82.094 Y90.674

G1 Z5.450

G1 E3.20000 F2400.00000

G1 X92.386 Y90.664 E0.21413

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y90.666 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.594 Y96.237

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y97.008 E0.02009

G1 X92.571 Y97.028 E0.00074

G1 X89.140 Y96.988 E0.08942

G1 X81.890 Y96.996 E0.18890

G1 X81.886 Y96.249 E0.01945

G1 X92.534 Y96.237 E0.27743

M204 S1250

G1 X92.966 Y95.970 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y96.120 E0.00407

G1 X93.009 Y97.072 E0.02480

G1 X92.924 Y97.287 E0.00602

G1 X92.886 Y97.329 E0.00147

G1 X92.682 Y97.447 E0.00616

G1 X89.137 Y97.406 E0.09236

G1 X81.779 Y97.414 E0.19173

G1 X81.655 Y97.371 E0.00340

G1 X81.534 Y97.255 E0.00438

G1 X81.472 Y97.076 E0.00494

G1 X81.468 Y96.142 E0.02432

G1 X81.521 Y95.959 E0.00496

G1 X81.547 Y95.927 E0.00110

G1 X81.643 Y95.859 E0.00305

G1 X81.766 Y95.832 E0.00328

G1 X92.717 Y95.819 E0.28534

G1 X92.842 Y95.853 E0.00338

G1 X92.925 Y95.927 E0.00288

M204 S1250

G1 X92.890 Y96.106 F9000.000

G1 X92.384 Y96.632

G1 F2400.000

G1 X89.143 Y96.615 E0.07447

G1 X82.097 Y96.622 E0.14460

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y96.620 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X81.893 Y103.297

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y103.286 E0.27886

G1 X92.595 Y104.038 E0.01958

G1 X81.886 Y104.045 E0.27901

G1 X81.884 Y103.356 E0.01797

M204 S1250

G1 X81.569 Y102.958 F9000.000

M204 S800

G1 F1500.000

G1 X81.671 Y102.887 E0.00323

G1 X81.752 Y102.879 E0.00212

G1 X92.706 Y102.868 E0.28542

G1 X92.818 Y102.904 E0.00308

G1 X92.893 Y102.953 E0.00234

G1 X93.013 Y103.148 E0.00596

G1 X93.012 Y104.138 E0.02579

G1 X92.953 Y104.317 E0.00492

G1 X92.918 Y104.360 E0.00146

G1 X92.771 Y104.455 E0.00455

G1 X81.773 Y104.463 E0.28656

G1 X81.605 Y104.414 E0.00458

G1 X81.522 Y104.315 E0.00337

G1 X81.469 Y104.142 E0.00470

G1 X81.466 Y103.290 E0.02221

G1 X81.540 Y103.010 E0.00753

M204 S1250

G1 X81.692 Y102.976 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.671 Y102.887 E-0.09979

G1 X81.752 Y102.879 E-0.04514

G1 X83.136 Y102.878 E-0.76708

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.386 Y103.662

G1 Z5.450

G1 E3.20000 F2400.00000

M73 P59 R28

G1 X82.094 Y103.671 E0.21414

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y103.669 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X81.886 Y109.258

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y109.235 E0.27899

G1 X92.591 Y110.006 E0.02008

G1 X92.571 Y110.026 E0.00074

G1 X89.140 Y109.986 E0.08942

G1 X81.890 Y109.994 E0.18890

G1 X81.887 Y109.318 E0.01762

M204 S1250

G1 X81.530 Y108.943 F9000.000

M204 S800

G1 F1500.000

G1 X81.648 Y108.852 E0.00387

G1 X81.692 Y108.840 E0.00118

G1 X92.717 Y108.817 E0.28728

G1 X92.871 Y108.868 E0.00421

G1 X92.966 Y108.967 E0.00359

G1 X93.011 Y109.118 E0.00409

G1 X93.009 Y110.070 E0.02480

G1 X92.924 Y110.285 E0.00602

G1 X92.886 Y110.327 E0.00147

G1 X92.682 Y110.445 E0.00616

G1 X89.137 Y110.404 E0.09236

G1 X81.779 Y110.412 E0.19172

G1 X81.655 Y110.368 E0.00342

G1 X81.534 Y110.253 E0.00437

G1 X81.472 Y110.074 E0.00494

G1 X81.468 Y109.143 E0.02426

G1 X81.512 Y109.000 E0.00389

M204 S1250

G1 X81.678 Y108.958 F9000.000

G1 X82.097 Y109.625

G1 F2400.000

G1 X89.143 Y109.614 E0.14312

G1 X92.384 Y109.630 E0.07437

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y109.622 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X92.595 Y116.283

G1 Z5.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y117.036 E0.01960

G1 X81.886 Y117.043 E0.27901

G1 X81.893 Y116.295 E0.01950

G1 X92.535 Y116.283 E0.27730

M204 S1250

G1 X92.818 Y115.902 F9000.000

M204 S800

G1 F1500.000

G1 X92.893 Y115.951 E0.00235

G1 X93.013 Y116.146 E0.00596

G1 X93.012 Y117.136 E0.02579

G1 X92.953 Y117.315 E0.00492

G1 X92.918 Y117.358 E0.00146

G1 X92.771 Y117.453 E0.00455

G1 X81.774 Y117.461 E0.28655

G1 X81.605 Y117.411 E0.00459

G1 X81.522 Y117.312 E0.00336

G1 X81.469 Y117.140 E0.00469

G1 X81.466 Y116.288 E0.02221

G1 X81.522 Y116.039 E0.00664

G1 X81.569 Y115.956 E0.00249

G1 X81.671 Y115.885 E0.00323

G1 X92.705 Y115.866 E0.28752

G1 X92.761 Y115.884 E0.00152

M204 S1250

G1 X92.830 Y115.991 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.893 Y115.951 E-0.08247

G1 X93.013 Y116.146 E-0.12670

G1 X93.012 Y117.136 E-0.54844

G1 X92.953 Y117.315 E-0.10466

G1 X92.918 Y117.358 E-0.03096

G1 X92.889 Y117.377 E-0.01876

G1 E-0.04800 F4200.00000

G1 Z5.650 F9000.000

G1 X82.094 Y116.669

G1 Z5.450

G1 E3.20000 F2400.00000

G1 X92.386 Y116.660 E0.21452

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;5.6

G1 Z5.600 F9000.000

;AFTER\_LAYER\_CHANGE

;5.6

G1 E-3.20000 F4200.00000

G1 Z5.800 F9000.000

G1 X92.581 Y44.906

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.865 Y44.886 E0.04472

G1 X88.489 Y44.907 E0.06189

G1 X81.890 Y44.885 E0.17194

G1 X81.888 Y44.195 E0.01799

G1 X92.592 Y44.200 E0.27891

G1 X92.588 Y44.848 E0.01688

M204 S1250

G1 X92.869 Y45.244 F9000.000

M204 S800

G1 F1500.000

G1 X92.693 Y45.325 E0.00507

G1 X90.864 Y45.304 E0.04765

G1 X88.490 Y45.325 E0.06185

G1 X81.764 Y45.303 E0.17527

G1 X81.604 Y45.228 E0.00460

G1 X81.507 Y45.116 E0.00385

G1 X81.473 Y45.005 E0.00303

G1 X81.470 Y44.058 E0.02468

G1 X81.503 Y43.942 E0.00312

G1 X81.551 Y43.862 E0.00245

G1 X81.640 Y43.798 E0.00283

G1 X81.761 Y43.777 E0.00321

G1 X92.794 Y43.782 E0.28747

G1 X92.854 Y43.805 E0.00168

G1 X92.964 Y43.908 E0.00393

G1 X93.011 Y44.065 E0.00428

G1 X93.005 Y44.986 E0.02399

G1 X92.905 Y45.197 E0.00608

M204 S1250

G1 X92.682 Y45.191 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.693 Y45.325 E-0.13763

G1 X91.296 Y45.309 E-0.77437

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y44.541

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.381 Y44.552 E0.18240

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y44.550 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.596 Y51.412

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y52.111 E0.01821

G1 X81.888 Y52.115 E0.27899

G1 X81.891 Y51.414 E0.01829

G1 X92.536 Y51.412 E0.27736

M204 S1250

G1 X92.821 Y51.019 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y51.074 E0.00238

G1 X93.014 Y51.284 E0.00629

G1 X93.013 Y52.204 E0.02398

G1 X92.954 Y52.383 E0.00491

G1 X92.897 Y52.454 E0.00237

G1 X92.780 Y52.527 E0.00361

G1 X81.775 Y52.533 E0.28675

G1 X81.567 Y52.458 E0.00577

G1 X81.469 Y52.213 E0.00687

G1 X81.474 Y51.347 E0.02256

G1 X81.530 Y51.144 E0.00550

G1 X81.578 Y51.062 E0.00246

G1 X81.666 Y50.996 E0.00286

G1 X92.705 Y50.994 E0.28765

G1 X92.761 Y51.012 E0.00154

M204 S1250

G1 X92.829 Y51.110 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y51.074 E-0.08105

G1 X93.014 Y51.284 E-0.13377

G1 X93.013 Y52.204 E-0.50998

G1 X92.954 Y52.383 E-0.10447

G1 X92.897 Y52.454 E-0.05033

G1 X92.848 Y52.485 E-0.03240

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y51.764

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.387 Y51.762 E0.18795

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y51.762 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.592 Y57.198

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.581 Y57.903 E0.01839

G1 X90.865 Y57.883 E0.04472

G1 X88.489 Y57.905 E0.06189

G1 X81.890 Y57.883 E0.17194

G1 X81.888 Y57.192 E0.01800

G1 X92.532 Y57.197 E0.27734

M204 S1250

G1 X92.953 Y56.893 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y57.062 E0.00466

G1 X93.005 Y57.983 E0.02399

G1 X92.896 Y58.215 E0.00667

G1 X92.693 Y58.323 E0.00599

G1 X90.864 Y58.301 E0.04765

G1 X88.490 Y58.323 E0.06185

G1 X81.764 Y58.301 E0.17527

G1 X81.604 Y58.226 E0.00460

G1 X81.507 Y58.113 E0.00386

G1 X81.473 Y58.002 E0.00302

G1 X81.470 Y57.056 E0.02467

G1 X81.503 Y56.940 E0.00312

G1 X81.551 Y56.860 E0.00245

G1 X81.640 Y56.796 E0.00284

G1 X81.761 Y56.775 E0.00321

G1 X92.793 Y56.780 E0.28746

G1 X92.854 Y56.802 E0.00169

G1 X92.909 Y56.853 E0.00194

M204 S1250

G1 X92.866 Y57.049 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.011 Y57.062 E-0.12936

G1 X93.005 Y57.983 E-0.51017

G1 X92.896 Y58.215 E-0.14194

G1 X92.693 Y58.323 E-0.12738

G1 X92.687 Y58.322 E-0.00315

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y57.538

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.381 Y57.549 E0.18228

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y57.547 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.596 Y64.410

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y65.107 E0.01817

G1 X81.888 Y65.114 E0.27899

G1 X81.891 Y64.412 E0.01829

G1 X92.536 Y64.410 E0.27736

M204 S1250

G1 X92.821 Y64.017 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y64.072 E0.00238

G1 X93.014 Y64.282 E0.00629

G1 X93.013 Y65.202 E0.02398

G1 X92.954 Y65.380 E0.00489

G1 X92.897 Y65.452 E0.00238

G1 X92.781 Y65.525 E0.00360

G1 X81.775 Y65.531 E0.28676

G1 X81.567 Y65.456 E0.00577

G1 X81.469 Y65.211 E0.00687

G1 X81.474 Y64.345 E0.02256

G1 X81.530 Y64.142 E0.00551

G1 X81.578 Y64.060 E0.00247

G1 X81.666 Y63.994 E0.00286

G1 X92.705 Y63.992 E0.28765

G1 X92.761 Y64.011 E0.00154

M204 S1250

G1 X92.829 Y64.108 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y64.072 E-0.08089

G1 X93.014 Y64.282 E-0.13386

G1 X93.013 Y65.202 E-0.50999

G1 X92.954 Y65.380 E-0.10409

G1 X92.897 Y65.452 E-0.05053

G1 X92.847 Y65.483 E-0.03264

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y64.763

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.387 Y64.759 E0.18218

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y64.759 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.592 Y70.196

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.581 Y70.901 E0.01839

G1 X90.865 Y70.881 E0.04472

G1 X88.489 Y70.903 E0.06189

G1 X81.890 Y70.881 E0.17194

G1 X81.888 Y70.190 E0.01800

G1 X92.532 Y70.195 E0.27734

M204 S1250

G1 X92.953 Y69.891 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y70.060 E0.00466

G1 X93.005 Y70.981 E0.02398

G1 X92.896 Y71.212 E0.00667

G1 X92.693 Y71.321 E0.00599

G1 X90.864 Y71.299 E0.04765

G1 X88.490 Y71.321 E0.06185

G1 X81.764 Y71.299 E0.17527

G1 X81.604 Y71.224 E0.00460

G1 X81.507 Y71.111 E0.00386

G1 X81.473 Y71.000 E0.00302

G1 X81.470 Y70.053 E0.02468

G1 X81.503 Y69.938 E0.00312

G1 X81.551 Y69.858 E0.00244

G1 X81.640 Y69.794 E0.00284

G1 X81.761 Y69.773 E0.00321

G1 X92.793 Y69.778 E0.28746

G1 X92.854 Y69.800 E0.00169

G1 X92.909 Y69.851 E0.00194

M204 S1250

G1 X92.866 Y70.047 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.011 Y70.060 E-0.12936

G1 X93.005 Y70.981 E-0.51009

G1 X92.896 Y71.212 E-0.14176

G1 X92.693 Y71.321 E-0.12749

G1 X92.687 Y71.320 E-0.00330

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y70.536

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.381 Y70.547 E0.18228

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y70.545 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.596 Y77.407

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y78.105 E0.01819

G1 X81.888 Y78.112 E0.27899

G1 X81.891 Y77.410 E0.01829

G1 X92.536 Y77.407 E0.27736

M204 S1250

G1 X92.821 Y77.014 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y77.069 E0.00238

G1 X93.014 Y77.280 E0.00631

G1 X93.013 Y78.199 E0.02397

G1 X92.954 Y78.378 E0.00490

G1 X92.897 Y78.450 E0.00237

G1 X92.781 Y78.523 E0.00359

G1 X81.775 Y78.529 E0.28675

G1 X81.567 Y78.454 E0.00577

G1 X81.469 Y78.208 E0.00690

G1 X81.474 Y77.343 E0.02254

G1 X81.530 Y77.140 E0.00551

G1 X81.578 Y77.058 E0.00247

G1 X81.666 Y76.992 E0.00286

G1 X92.705 Y76.989 E0.28765

G1 X92.761 Y77.008 E0.00154

M204 S1250

G1 X92.829 Y77.105 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y77.069 E-0.08097

G1 X93.014 Y77.280 E-0.13419

G1 X93.013 Y78.199 E-0.50975

G1 X92.954 Y78.378 E-0.10431

G1 X92.897 Y78.450 E-0.05051

G1 X92.848 Y78.481 E-0.03226

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y77.761

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.387 Y77.756 E0.18220

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y77.757 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.592 Y83.194

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.581 Y83.899 E0.01839

G1 X90.865 Y83.879 E0.04472

G1 X88.489 Y83.901 E0.06189

G1 X81.890 Y83.879 E0.17194

G1 X81.888 Y83.188 E0.01800

G1 X92.532 Y83.193 E0.27734

M204 S1250

G1 X92.953 Y82.889 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y83.058 E0.00466

G1 X93.005 Y83.979 E0.02398

G1 X92.896 Y84.210 E0.00667

G1 X92.693 Y84.318 E0.00599

G1 X90.864 Y84.297 E0.04766

G1 X88.490 Y84.319 E0.06185

G1 X81.765 Y84.297 E0.17525

G1 X81.604 Y84.221 E0.00463

G1 X81.507 Y84.109 E0.00385

G1 X81.473 Y83.998 E0.00302

G1 X81.470 Y83.051 E0.02468

G1 X81.503 Y82.936 E0.00312

G1 X81.551 Y82.856 E0.00244

G1 X81.640 Y82.792 E0.00284

G1 X81.761 Y82.771 E0.00321

G1 X92.793 Y82.776 E0.28746

G1 X92.854 Y82.798 E0.00169

G1 X92.909 Y82.849 E0.00194

M204 S1250

G1 X92.866 Y83.045 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.011 Y83.058 E-0.12937

G1 X93.005 Y83.979 E-0.51009

G1 X92.896 Y84.210 E-0.14176

G1 X92.693 Y84.318 E-0.12740

G1 X92.687 Y84.318 E-0.00339

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y83.534

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.381 Y83.545 E0.18217

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y83.543 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.596 Y90.405

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y91.103 E0.01819

G1 X81.888 Y91.110 E0.27899

G1 X81.891 Y90.407 E0.01830

G1 X92.536 Y90.405 E0.27736

M204 S1250

G1 X92.821 Y90.012 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y90.068 E0.00238

G1 X93.014 Y90.277 E0.00628

G1 X93.013 Y91.197 E0.02399

G1 X92.954 Y91.376 E0.00490

G1 X92.897 Y91.448 E0.00237

G1 X92.781 Y91.521 E0.00359

G1 X81.775 Y91.527 E0.28675

G1 X81.567 Y91.452 E0.00577

G1 X81.469 Y91.206 E0.00690

G1 X81.474 Y90.340 E0.02256

G1 X81.530 Y90.138 E0.00549

G1 X81.578 Y90.055 E0.00248

G1 X81.665 Y89.989 E0.00284

G1 X92.705 Y89.987 E0.28766

G1 X92.761 Y90.006 E0.00154

M204 S1250

G1 X92.829 Y90.104 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y90.068 E-0.08110

G1 X93.014 Y90.277 E-0.13359

G1 X93.013 Y91.197 E-0.51031

G1 X92.954 Y91.376 E-0.10431

G1 X92.897 Y91.448 E-0.05051

G1 X92.848 Y91.478 E-0.03218

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y90.758

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.387 Y90.754 E0.18256

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y90.755 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.592 Y96.192

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.581 Y96.897 E0.01839

G1 X90.865 Y96.877 E0.04472

G1 X88.489 Y96.898 E0.06189

G1 X81.890 Y96.877 E0.17194

G1 X81.888 Y96.186 E0.01801

G1 X92.532 Y96.191 E0.27734

M204 S1250

G1 X92.953 Y95.887 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y96.056 E0.00467

G1 X93.005 Y96.977 E0.02398

G1 X92.896 Y97.208 E0.00667

G1 X92.693 Y97.316 E0.00599

G1 X90.864 Y97.295 E0.04765

G1 X88.490 Y97.316 E0.06185

G1 X81.764 Y97.295 E0.17525

G1 X81.604 Y97.219 E0.00463

G1 X81.507 Y97.107 E0.00385

G1 X81.473 Y96.996 E0.00302

G1 X81.470 Y96.049 E0.02470

G1 X81.503 Y95.934 E0.00310

G1 X81.551 Y95.853 E0.00247

G1 X81.668 Y95.780 E0.00358

G1 X81.756 Y95.768 E0.00233

G1 X92.793 Y95.774 E0.28758

G1 X92.854 Y95.797 E0.00169

G1 X92.909 Y95.846 E0.00192

M204 S1250

G1 X92.866 Y96.043 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.011 Y96.056 E-0.12952

G1 X93.005 Y96.977 E-0.51011

G1 X92.896 Y97.208 E-0.14176

G1 X92.693 Y97.316 E-0.12738

G1 X92.687 Y97.316 E-0.00323

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y96.532

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.381 Y96.543 E0.18211

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y96.541 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.596 Y103.403

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y104.101 E0.01819

G1 X81.888 Y104.107 E0.27899

G1 X81.891 Y103.405 E0.01830

G1 X92.536 Y103.403 E0.27736

M204 S1250

G1 X92.821 Y103.010 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y103.065 E0.00238

G1 X93.014 Y103.275 E0.00629

G1 X93.013 Y104.195 E0.02398

G1 X92.954 Y104.374 E0.00491

G1 X92.897 Y104.445 E0.00238

G1 X92.780 Y104.519 E0.00360

G1 X81.775 Y104.525 E0.28676

G1 X81.567 Y104.450 E0.00575

G1 X81.469 Y104.204 E0.00690

G1 X81.474 Y103.338 E0.02256

G1 X81.530 Y103.135 E0.00549

G1 X81.578 Y103.053 E0.00248

G1 X81.666 Y102.987 E0.00286

G1 X92.706 Y102.985 E0.28766

G1 X92.761 Y103.003 E0.00152

M204 S1250

G1 X92.829 Y103.101 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y103.065 E-0.08106

G1 X93.014 Y103.275 E-0.13377

G1 X93.013 Y104.195 E-0.50999

G1 X92.954 Y104.374 E-0.10447

G1 X92.897 Y104.445 E-0.05053

G1 X92.848 Y104.476 E-0.03218

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y103.756

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.387 Y103.752 E0.18250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y103.753 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.592 Y109.189

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.581 Y109.895 E0.01840

G1 X90.865 Y109.875 E0.04472

G1 X88.489 Y109.896 E0.06189

G1 X81.890 Y109.875 E0.17194

G1 X81.888 Y109.184 E0.01801

G1 X92.532 Y109.189 E0.27734

M204 S1250

G1 X92.953 Y108.884 F9000.000

M204 S800

G1 F1500.000

G1 X93.011 Y109.054 E0.00469

G1 X93.005 Y109.975 E0.02399

G1 X92.896 Y110.206 E0.00667

G1 X92.693 Y110.314 E0.00599

G1 X90.864 Y110.293 E0.04765

G1 X88.490 Y110.314 E0.06185

G1 X81.764 Y110.293 E0.17525

G1 X81.604 Y110.217 E0.00463

G1 X81.507 Y110.105 E0.00386

G1 X81.473 Y109.994 E0.00301

G1 X81.470 Y109.047 E0.02470

G1 X81.503 Y108.931 E0.00312

G1 X81.551 Y108.851 E0.00245

G1 X81.640 Y108.787 E0.00284

G1 X81.761 Y108.766 E0.00320

G1 X92.794 Y108.771 E0.28747

G1 X92.854 Y108.794 E0.00168

G1 X92.909 Y108.844 E0.00193

M204 S1250

G1 X92.865 Y109.041 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.011 Y109.054 E-0.12980

G1 X93.005 Y109.975 E-0.51016

G1 X92.896 Y110.206 E-0.14176

G1 X92.693 Y110.314 E-0.12738

G1 X92.688 Y110.314 E-0.00290

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y109.530

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.381 Y109.541 E0.18240

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y109.539 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X92.596 Y116.401

G1 Z5.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y117.099 E0.01820

G1 X81.888 Y117.105 E0.27899

G1 X81.891 Y116.403 E0.01829

G1 X92.536 Y116.401 E0.27736

M204 S1250

G1 X92.821 Y116.008 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y116.063 E0.00239

G1 X93.014 Y116.273 E0.00629

G1 X93.013 Y117.193 E0.02398

G1 X92.954 Y117.372 E0.00491

G1 X92.897 Y117.443 E0.00238

G1 X92.780 Y117.517 E0.00360

G1 X81.775 Y117.522 E0.28675

G1 X81.567 Y117.447 E0.00577

G1 X81.469 Y117.202 E0.00687

G1 X81.474 Y116.336 E0.02256

G1 X81.530 Y116.133 E0.00549

G1 X81.578 Y116.051 E0.00248

G1 X81.666 Y115.985 E0.00286

G1 X92.705 Y115.983 E0.28765

G1 X92.761 Y116.001 E0.00153

M204 S1250

G1 X92.829 Y116.099 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y116.063 E-0.08106

G1 X93.014 Y116.273 E-0.13377

G1 X93.013 Y117.193 E-0.50999

G1 X92.954 Y117.372 E-0.10447

G1 X92.897 Y117.443 E-0.05053

G1 X92.848 Y117.474 E-0.03219

G1 E-0.04800 F4200.00000

G1 Z5.800 F9000.000

G1 X82.098 Y116.754

G1 Z5.600

G1 E3.20000 F2400.00000

G1 X92.387 Y116.750 E0.18220

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;5.75

G1 Z5.750 F9000.000

;AFTER\_LAYER\_CHANGE

;5.75

G1 E-3.20000 F4200.00000

G1 Z5.950 F9000.000

G1 X92.587 Y44.778

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.491 Y44.811 E0.10673

G1 X84.749 Y44.779 E0.09752

G1 X81.891 Y44.779 E0.07446

G1 X81.890 Y44.131 E0.01688

G1 X92.593 Y44.132 E0.27887

G1 X92.588 Y44.718 E0.01526

M204 S1250

G1 X92.853 Y45.145 F9000.000

M204 S800

G1 F1500.000

G1 X92.704 Y45.195 E0.00409

G1 X88.491 Y45.229 E0.10976

G1 X84.747 Y45.197 E0.09756

G1 X81.758 Y45.197 E0.07788

G1 X81.588 Y45.121 E0.00486

G1 X81.511 Y45.026 E0.00319

G1 X81.474 Y44.925 E0.00282

G1 X81.472 Y43.982 E0.02456

G1 X81.561 Y43.788 E0.00558

G1 X81.642 Y43.728 E0.00262

G1 X81.756 Y43.713 E0.00297

G1 X92.727 Y43.714 E0.28586

G1 X92.830 Y43.728 E0.00271

G1 X92.968 Y43.858 E0.00495

G1 X93.012 Y44.003 E0.00395

G1 X93.004 Y44.900 E0.02338

G1 X92.884 Y45.094 E0.00594

M204 S1250

G1 X92.705 Y45.091 F9000.000

G1 X92.381 Y44.456

G1 F2400.000

G1 X88.491 Y44.476 E0.06113

G1 X84.751 Y44.458 E0.05879

G1 X82.099 Y44.456 E0.03726

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.745 Y44.457 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X81.885 Y51.519

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y51.521 E0.27911

G1 X92.595 Y52.183 E0.01726

G1 X89.698 Y52.149 E0.07550

G1 X86.222 Y52.178 E0.09056

G1 X81.887 Y52.177 E0.11297

G1 X81.885 Y51.579 E0.01558

M204 S1250

G1 X81.585 Y51.162 F9000.000

M204 S800

G1 F1500.000

G1 X81.687 Y51.095 E0.00317

G1 X92.729 Y51.103 E0.28771

G1 X92.796 Y51.110 E0.00177

G1 X92.924 Y51.212 E0.00426

G1 X93.015 Y51.410 E0.00568

G1 X93.013 Y52.267 E0.02232

G1 X92.975 Y52.394 E0.00346

G1 X92.866 Y52.550 E0.00494

G1 X92.715 Y52.602 E0.00416

G1 X89.697 Y52.567 E0.07863

G1 X86.224 Y52.595 E0.09050

G1 X81.777 Y52.595 E0.11587

G1 X81.558 Y52.508 E0.00614

G1 X81.469 Y52.281 E0.00636

G1 X81.467 Y51.463 E0.02130

G1 X81.504 Y51.305 E0.00423

G1 X81.555 Y51.214 E0.00273

M204 S1250

G1 X81.702 Y51.193 F9000.000

G1 X82.094 Y51.848

G1 F2400.000

G1 X89.700 Y51.834 E0.09998

G1 X92.387 Y51.850 E0.04033

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y51.841 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X92.593 Y57.129

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.587 Y57.775 E0.01684

G1 X88.491 Y57.809 E0.10673

G1 X84.749 Y57.777 E0.09751

G1 X81.893 Y57.777 E0.07440

G1 X81.899 Y57.129 E0.01690

G1 X92.533 Y57.129 E0.27707

M204 S1250

G1 X92.969 Y56.858 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y57.000 E0.00388

G1 X93.004 Y57.898 E0.02338

G1 X92.853 Y58.143 E0.00750

G1 X92.704 Y58.192 E0.00408

G1 X88.491 Y58.227 E0.10977

G1 X84.747 Y58.195 E0.09756

G1 X81.758 Y58.195 E0.07788

G1 X81.588 Y58.119 E0.00485

G1 X81.511 Y58.023 E0.00321

G1 X81.474 Y57.924 E0.00277

G1 X81.483 Y56.943 E0.02555

G1 X81.560 Y56.786 E0.00456

G1 X81.638 Y56.727 E0.00255

G1 X81.756 Y56.711 E0.00311

G1 X92.727 Y56.711 E0.28584

G1 X92.822 Y56.723 E0.00250

G1 X92.924 Y56.817 E0.00362

M204 S1250

G1 X92.896 Y56.988 F9000.000

G1 X92.381 Y57.453

G1 F2400.000

G1 X88.491 Y57.469 E0.06362

G1 X84.751 Y57.453 E0.06118

G1 X82.105 Y57.453 E0.03806

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.751 Y57.453 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X81.899 Y70.127

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y70.127 E0.27863

G1 X92.587 Y70.773 E0.01684

G1 X88.491 Y70.807 E0.10673

G1 X84.749 Y70.775 E0.09751

G1 X81.893 Y70.775 E0.07440

G1 X81.898 Y70.187 E0.01534

M204 S1250

G1 X81.560 Y69.784 F9000.000

M204 S800

G1 F1500.000

G1 X81.638 Y69.725 E0.00256

G1 X81.756 Y69.709 E0.00311

G1 X92.727 Y69.709 E0.28584

G1 X92.822 Y69.721 E0.00250

G1 X92.969 Y69.856 E0.00519

G1 X93.012 Y69.998 E0.00388

G1 X93.004 Y70.896 E0.02338

G1 X92.853 Y71.140 E0.00749

G1 X92.704 Y71.190 E0.00409

G1 X88.491 Y71.225 E0.10976

G1 X84.747 Y71.193 E0.09756

G1 X81.758 Y71.193 E0.07788

G1 X81.588 Y71.117 E0.00486

G1 X81.511 Y71.021 E0.00320

G1 X81.474 Y70.922 E0.00277

G1 X81.483 Y69.940 E0.02557

G1 X81.533 Y69.838 E0.00297

M204 S1250

G1 X81.657 Y69.796 F9000.000

G1 X82.105 Y70.451

G1 F2400.000

G1 X84.751 Y70.451 E0.03806

G1 X88.491 Y70.467 E0.06117

G1 X92.381 Y70.451 E0.06362

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y70.458 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X92.443 Y65.178

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.698 Y65.146 E0.07152

G1 X86.222 Y65.175 E0.09056

G1 X81.887 Y65.175 E0.11297

G1 X81.885 Y64.517 E0.01715

G1 X92.597 Y64.519 E0.27911

G1 X92.595 Y65.180 E0.01723

G1 X92.503 Y65.179 E0.00241

M204 S1250

G1 X92.866 Y65.547 F9000.000

M204 S800

G1 F1500.000

G1 X92.715 Y65.599 E0.00415

G1 X89.697 Y65.564 E0.07864

G1 X86.224 Y65.593 E0.09050

G1 X81.777 Y65.593 E0.11587

G1 X81.558 Y65.506 E0.00614

G1 X81.469 Y65.279 E0.00636

G1 X81.467 Y64.461 E0.02130

G1 X81.504 Y64.303 E0.00424

G1 X81.585 Y64.159 E0.00430

G1 X81.687 Y64.093 E0.00317

G1 X92.729 Y64.101 E0.28772

G1 X92.796 Y64.108 E0.00176

G1 X92.924 Y64.210 E0.00426

G1 X93.015 Y64.408 E0.00568

G1 X93.013 Y65.265 E0.02232

G1 X92.975 Y65.392 E0.00347

G1 X92.900 Y65.498 E0.00336

M204 S1250

G1 X92.723 Y65.476 F9000.000

G1 X92.387 Y64.848

G1 F2400.000

G1 X89.699 Y64.832 E0.04018

G1 X82.094 Y64.846 E0.09961

M73 P61 R27

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y64.843 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X81.885 Y77.514

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y77.516 E0.27911

G1 X92.595 Y78.178 E0.01725

G1 X89.698 Y78.144 E0.07550

G1 X86.222 Y78.173 E0.09056

G1 X81.887 Y78.173 E0.11297

G1 X81.885 Y77.574 E0.01560

M204 S1250

G1 X81.585 Y77.157 F9000.000

M204 S800

G1 F1500.000

G1 X81.688 Y77.091 E0.00320

G1 X92.729 Y77.098 E0.28767

G1 X92.796 Y77.106 E0.00177

G1 X92.924 Y77.208 E0.00427

G1 X93.015 Y77.406 E0.00569

G1 X93.013 Y78.263 E0.02231

G1 X92.975 Y78.390 E0.00347

G1 X92.866 Y78.545 E0.00493

G1 X92.715 Y78.597 E0.00415

G1 X89.697 Y78.562 E0.07864

G1 X86.224 Y78.591 E0.09050

G1 X81.777 Y78.591 E0.11586

G1 X81.558 Y78.504 E0.00614

G1 X81.469 Y78.276 E0.00638

G1 X81.467 Y77.459 E0.02127

G1 X81.504 Y77.301 E0.00424

G1 X81.555 Y77.209 E0.00273

M204 S1250

G1 X81.703 Y77.190 F9000.000

G1 X82.094 Y77.844

G1 F2400.000

G1 X89.699 Y77.830 E0.09989

G1 X92.387 Y77.846 E0.04030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y77.836 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X92.593 Y83.125

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.587 Y83.771 E0.01684

G1 X88.491 Y83.805 E0.10673

G1 X84.749 Y83.773 E0.09751

G1 X81.893 Y83.773 E0.07440

G1 X81.899 Y83.125 E0.01689

G1 X92.533 Y83.125 E0.27707

M204 S1250

G1 X92.969 Y82.854 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y82.996 E0.00388

G1 X93.004 Y83.893 E0.02337

G1 X92.853 Y84.138 E0.00750

G1 X92.704 Y84.188 E0.00409

G1 X88.491 Y84.223 E0.10976

G1 X84.747 Y84.191 E0.09756

G1 X81.759 Y84.191 E0.07786

G1 X81.588 Y84.115 E0.00489

G1 X81.511 Y84.019 E0.00319

G1 X81.474 Y83.920 E0.00277

G1 X81.483 Y82.938 E0.02557

G1 X81.560 Y82.782 E0.00454

G1 X81.638 Y82.723 E0.00256

G1 X81.756 Y82.707 E0.00311

G1 X92.727 Y82.707 E0.28584

G1 X92.822 Y82.719 E0.00250

G1 X92.924 Y82.813 E0.00362

M204 S1250

G1 X92.896 Y82.984 F9000.000

G1 X92.381 Y83.449

G1 F2400.000

G1 X88.491 Y83.465 E0.06362

G1 X84.751 Y83.449 E0.06117

G1 X82.105 Y83.449 E0.03806

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.751 Y83.449 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X81.885 Y90.512

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y90.514 E0.27911

G1 X92.595 Y91.176 E0.01725

G1 X89.698 Y91.142 E0.07550

G1 X86.222 Y91.171 E0.09056

G1 X81.887 Y91.171 E0.11297

G1 X81.885 Y90.572 E0.01560

M204 S1250

G1 X81.585 Y90.155 F9000.000

M204 S800

G1 F1500.000

G1 X81.687 Y90.089 E0.00317

G1 X92.729 Y90.096 E0.28770

G1 X92.796 Y90.104 E0.00177

G1 X92.924 Y90.206 E0.00428

G1 X93.015 Y90.403 E0.00566

G1 X93.013 Y91.261 E0.02234

G1 X92.975 Y91.388 E0.00347

G1 X92.866 Y91.543 E0.00493

G1 X92.715 Y91.595 E0.00415

G1 X89.697 Y91.560 E0.07864

G1 X86.224 Y91.589 E0.09050

G1 X81.777 Y91.589 E0.11586

G1 X81.558 Y91.502 E0.00614

G1 X81.469 Y91.274 E0.00638

G1 X81.467 Y90.457 E0.02129

G1 X81.504 Y90.299 E0.00424

G1 X81.555 Y90.207 E0.00273

M204 S1250

G1 X81.702 Y90.187 F9000.000

G1 X82.094 Y90.842

G1 F2400.000

G1 X89.699 Y90.828 E0.09989

G1 X92.387 Y90.844 E0.04030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y90.834 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X92.399 Y96.124

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y96.123 E0.00506

G1 X92.587 Y96.769 E0.01683

G1 X88.491 Y96.802 E0.10673

G1 X84.749 Y96.771 E0.09752

G1 X81.891 Y96.771 E0.07445

G1 X81.890 Y96.122 E0.01691

G1 X92.339 Y96.124 E0.27225

M204 S1250

G1 X92.968 Y95.850 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y95.994 E0.00394

G1 X93.004 Y96.891 E0.02337

G1 X92.853 Y97.136 E0.00750

G1 X92.704 Y97.186 E0.00409

G1 X88.491 Y97.220 E0.10976

G1 X84.747 Y97.189 E0.09756

G1 X81.759 Y97.189 E0.07785

G1 X81.588 Y97.113 E0.00489

G1 X81.511 Y97.017 E0.00319

G1 X81.474 Y96.916 E0.00280

G1 X81.472 Y95.973 E0.02458

G1 X81.561 Y95.780 E0.00556

G1 X81.643 Y95.720 E0.00263

G1 X81.756 Y95.704 E0.00298

G1 X92.726 Y95.705 E0.28583

G1 X92.829 Y95.719 E0.00272

G1 X92.924 Y95.808 E0.00339

M204 S1250

G1 X92.895 Y95.982 F9000.000

G1 X92.381 Y96.447

G1 F2400.000

G1 X88.491 Y96.467 E0.06114

G1 X84.750 Y96.449 E0.05879

G1 X82.099 Y96.447 E0.03741

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.745 Y96.448 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X81.885 Y103.510

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y103.512 E0.27911

G1 X92.595 Y104.174 E0.01725

G1 X89.698 Y104.140 E0.07550

G1 X86.222 Y104.169 E0.09056

G1 X81.887 Y104.169 E0.11297

G1 X81.885 Y103.570 E0.01560

M204 S1250

G1 X81.585 Y103.153 F9000.000

M204 S800

G1 F1500.000

G1 X81.687 Y103.086 E0.00317

G1 X92.729 Y103.094 E0.28771

G1 X92.796 Y103.101 E0.00177

G1 X92.924 Y103.204 E0.00427

G1 X93.015 Y103.401 E0.00566

G1 X93.013 Y104.258 E0.02232

G1 X92.975 Y104.386 E0.00348

G1 X92.865 Y104.541 E0.00494

G1 X92.715 Y104.593 E0.00414

G1 X89.697 Y104.558 E0.07864

G1 X86.224 Y104.587 E0.09050

G1 X81.777 Y104.587 E0.11586

G1 X81.559 Y104.499 E0.00614

G1 X81.469 Y104.272 E0.00637

G1 X81.467 Y103.455 E0.02129

G1 X81.504 Y103.297 E0.00424

G1 X81.555 Y103.205 E0.00274

M204 S1250

G1 X81.702 Y103.184 F9000.000

G1 X82.094 Y103.840

G1 F2400.000

G1 X89.699 Y103.826 E0.09991

G1 X92.387 Y103.842 E0.04030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y103.832 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X92.399 Y109.122

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y109.121 E0.00506

G1 X92.587 Y109.767 E0.01683

G1 X88.491 Y109.800 E0.10673

G1 X84.749 Y109.768 E0.09752

G1 X81.891 Y109.769 E0.07445

G1 X81.890 Y109.120 E0.01690

G1 X92.339 Y109.122 E0.27225

M204 S1250

G1 X92.968 Y108.847 F9000.000

M204 S800

G1 F1500.000

G1 X93.012 Y108.992 E0.00395

G1 X93.004 Y109.889 E0.02338

G1 X92.853 Y110.134 E0.00750

G1 X92.704 Y110.184 E0.00409

G1 X88.491 Y110.218 E0.10976

G1 X84.747 Y110.186 E0.09756

G1 X81.759 Y110.187 E0.07786

G1 X81.588 Y110.110 E0.00489

G1 X81.511 Y110.015 E0.00319

G1 X81.474 Y109.914 E0.00279

G1 X81.472 Y108.971 E0.02458

G1 X81.561 Y108.777 E0.00558

G1 X81.642 Y108.717 E0.00262

G1 X81.756 Y108.702 E0.00297

G1 X92.727 Y108.703 E0.28586

G1 X92.830 Y108.717 E0.00271

G1 X92.924 Y108.806 E0.00339

M204 S1250

G1 X92.894 Y108.980 F9000.000

G1 X92.381 Y109.445

G1 F2400.000

G1 X88.491 Y109.465 E0.06114

G1 X84.750 Y109.447 E0.05880

G1 X82.099 Y109.445 E0.03726

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.745 Y109.446 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z5.950 F9000.000

G1 X81.885 Y116.508

G1 Z5.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y116.510 E0.27911

G1 X92.595 Y117.172 E0.01726

G1 X89.698 Y117.138 E0.07550

G1 X86.222 Y117.167 E0.09056

G1 X81.887 Y117.166 E0.11297

G1 X81.885 Y116.568 E0.01558

M204 S1250

G1 X81.585 Y116.151 F9000.000

M204 S800

G1 F1500.000

G1 X81.687 Y116.084 E0.00317

G1 X92.729 Y116.092 E0.28770

G1 X92.796 Y116.099 E0.00177

G1 X92.924 Y116.201 E0.00426

G1 X93.015 Y116.399 E0.00568

G1 X93.013 Y117.256 E0.02232

G1 X92.975 Y117.384 E0.00348

G1 X92.865 Y117.539 E0.00494

G1 X92.715 Y117.591 E0.00414

G1 X89.697 Y117.556 E0.07864

G1 X86.224 Y117.585 E0.09050

G1 X81.777 Y117.584 E0.11586

G1 X81.558 Y117.497 E0.00614

G1 X81.469 Y117.270 E0.00636

G1 X81.467 Y116.453 E0.02129

G1 X81.504 Y116.295 E0.00424

G1 X81.555 Y116.203 E0.00274

M204 S1250

G1 X81.702 Y116.182 F9000.000

G1 X82.094 Y116.837

G1 F2400.000

G1 X89.699 Y116.823 E0.09998

G1 X92.387 Y116.839 E0.04033

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;5.9

G1 Z5.900 F9000.000

;AFTER\_LAYER\_CHANGE

;5.9

G1 E-3.20000 F4200.00000

G1 Z6.100 F9000.000

G1 X92.586 Y44.684

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.491 Y44.715 E0.10669

G1 X85.475 Y44.690 E0.07859

G1 X81.893 Y44.690 E0.09335

G1 X81.894 Y44.075 E0.01604

G1 X92.593 Y44.076 E0.27877

G1 X92.587 Y44.624 E0.01430

M204 S1250

G1 X92.848 Y45.057 F9000.000

M204 S800

G1 F1500.000

G1 X92.706 Y45.101 E0.00389

G1 X88.491 Y45.133 E0.10982

G1 X85.474 Y45.107 E0.07863

G1 X81.773 Y45.108 E0.09643

G1 X81.639 Y45.070 E0.00362

G1 X81.575 Y45.024 E0.00206

G1 X81.517 Y44.950 E0.00245

G1 X81.475 Y44.847 E0.00290

G1 X81.477 Y43.900 E0.02466

G1 X81.570 Y43.725 E0.00518

G1 X81.644 Y43.674 E0.00232

G1 X81.714 Y43.657 E0.00188

G1 X92.723 Y43.657 E0.28685

G1 X92.830 Y43.675 E0.00284

G1 X92.969 Y43.799 E0.00484

G1 X93.012 Y43.941 E0.00388

G1 X93.002 Y44.849 E0.02367

G1 X92.880 Y45.006 E0.00517

M204 S1250

G1 X92.709 Y45.003 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.706 Y45.101 E-0.10983

G1 X91.259 Y45.112 E-0.80217

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X82.102 Y44.383

G1 Z5.900

G1 E3.20000 F2400.00000

G1 X88.492 Y44.398 E0.08164

G1 X92.381 Y44.381 E0.04970

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y44.388 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.598 Y51.612

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y52.224 E0.01593

G1 X90.119 Y52.191 E0.06455

G1 X85.071 Y52.233 E0.13152

G1 X81.887 Y52.237 E0.08298

G1 X81.885 Y51.607 E0.01641

G1 X92.538 Y51.612 E0.27756

M204 S1250

G1 X92.782 Y51.202 F9000.000

M204 S800

G1 F1500.000

G1 X92.906 Y51.286 E0.00389

G1 X92.991 Y51.413 E0.00398

G1 X93.016 Y51.528 E0.00306

G1 X93.013 Y52.349 E0.02141

G1 X93.000 Y52.414 E0.00173

G1 X92.865 Y52.605 E0.00608

G1 X92.715 Y52.643 E0.00405

G1 X90.117 Y52.609 E0.06767

G1 X85.073 Y52.651 E0.13144

G1 X81.778 Y52.655 E0.08585

G1 X81.579 Y52.581 E0.00554

G1 X81.523 Y52.509 E0.00238

G1 X81.469 Y52.340 E0.00461

G1 X81.467 Y51.534 E0.02100

G1 X81.494 Y51.409 E0.00332

G1 X81.585 Y51.266 E0.00442

G1 X81.656 Y51.213 E0.00233

G1 X81.726 Y51.189 E0.00192

G1 X92.723 Y51.195 E0.28653

M204 S1250

G1 X92.801 Y51.350 F9000.000

G1 X92.388 Y51.917

G1 F2400.000

G1 X90.120 Y51.901 E0.02684

G1 X82.095 Y51.922 E0.08137

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y51.917 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X82.091 Y57.073

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y57.073 E0.27363

G1 X92.586 Y57.682 E0.01587

G1 X88.491 Y57.713 E0.10670

G1 X85.475 Y57.688 E0.07859

G1 X81.893 Y57.688 E0.09335

G1 X81.894 Y57.073 E0.01604

G1 X82.031 Y57.073 E0.00357

M204 S1250

G1 X81.570 Y56.722 F9000.000

M204 S800

G1 F1500.000

G1 X81.643 Y56.672 E0.00231

G1 X81.714 Y56.655 E0.00189

G1 X92.722 Y56.654 E0.28684

G1 X92.830 Y56.673 E0.00284

G1 X92.969 Y56.797 E0.00486

G1 X93.012 Y56.938 E0.00386

G1 X93.002 Y57.847 E0.02368

G1 X92.929 Y57.921 E0.00271

G1 X92.848 Y58.055 E0.00407

G1 X92.706 Y58.099 E0.00388

G1 X88.491 Y58.131 E0.10983

G1 X85.474 Y58.105 E0.07863

G1 X81.773 Y58.106 E0.09643

G1 X81.639 Y58.068 E0.00362

G1 X81.575 Y58.022 E0.00205

G1 X81.517 Y57.947 E0.00247

G1 X81.475 Y57.844 E0.00289

G1 X81.477 Y56.898 E0.02466

G1 X81.542 Y56.775 E0.00363

M204 S1250

G1 X81.658 Y56.735 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.643 Y56.672 E-0.08000

G1 X81.714 Y56.655 E-0.04011

G1 X83.143 Y56.655 E-0.79189

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.381 Y57.378

G1 Z5.900

G1 E3.20000 F2400.00000

G1 X88.492 Y57.395 E0.04988

G1 X82.102 Y57.381 E0.08195

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.748 Y57.384 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X81.885 Y64.605

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y64.610 E0.27912

G1 X92.596 Y65.221 E0.01591

G1 X90.118 Y65.189 E0.06455

G1 X85.071 Y65.231 E0.13152

G1 X81.887 Y65.235 E0.08297

G1 X81.885 Y64.665 E0.01485

M204 S1250

G1 X81.585 Y64.264 F9000.000

M204 S800

G1 F1500.000

G1 X81.656 Y64.211 E0.00231

G1 X81.726 Y64.187 E0.00193

G1 X92.727 Y64.193 E0.28664

G1 X92.783 Y64.199 E0.00146

G1 X92.906 Y64.283 E0.00388

G1 X92.991 Y64.411 E0.00399

G1 X93.016 Y64.526 E0.00306

G1 X93.013 Y65.347 E0.02141

G1 X92.999 Y65.413 E0.00174

G1 X92.865 Y65.602 E0.00605

G1 X92.715 Y65.640 E0.00406

G1 X90.117 Y65.607 E0.06767

G1 X85.073 Y65.649 E0.13144

G1 X81.778 Y65.653 E0.08584

G1 X81.579 Y65.579 E0.00554

G1 X81.523 Y65.507 E0.00238

G1 X81.469 Y65.338 E0.00461

G1 X81.467 Y64.532 E0.02100

G1 X81.494 Y64.407 E0.00333

G1 X81.553 Y64.314 E0.00286

M204 S1250

G1 X81.671 Y64.284 F9000.000

G1 X82.095 Y64.920

G1 F2400.000

G1 X90.120 Y64.899 E0.08103

G1 X92.388 Y64.914 E0.02672

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y64.903 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.399 Y70.071

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y70.071 E0.00506

G1 X92.586 Y70.680 E0.01589

G1 X88.491 Y70.711 E0.10669

G1 X85.475 Y70.686 E0.07859

G1 X81.893 Y70.686 E0.09335

G1 X81.894 Y70.071 E0.01604

G1 X92.339 Y70.071 E0.27215

M204 S1250

G1 X92.830 Y69.671 F9000.000

M204 S800

G1 F1500.000

G1 X92.969 Y69.795 E0.00486

G1 X93.012 Y69.936 E0.00386

G1 X93.002 Y70.845 E0.02368

G1 X92.930 Y70.919 E0.00271

G1 X92.848 Y71.052 E0.00406

G1 X92.706 Y71.097 E0.00390

G1 X88.491 Y71.129 E0.10982

G1 X85.474 Y71.103 E0.07863

G1 X81.773 Y71.104 E0.09643

G1 X81.640 Y71.066 E0.00361

G1 X81.575 Y71.019 E0.00208

G1 X81.517 Y70.945 E0.00247

G1 X81.475 Y70.842 E0.00288

G1 X81.477 Y69.896 E0.02467

G1 X81.570 Y69.720 E0.00518

G1 X81.643 Y69.670 E0.00231

G1 X81.714 Y69.653 E0.00189

G1 X92.771 Y69.661 E0.28810

M204 S1250

G1 X92.837 Y69.857 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.969 Y69.795 E-0.13272

G1 X93.012 Y69.936 E-0.08206

G1 X93.002 Y70.845 E-0.50355

G1 X92.930 Y70.919 E-0.05755

G1 X92.848 Y71.052 E-0.08641

G1 X92.763 Y71.079 E-0.04970

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X82.102 Y70.379

G1 Z5.900

G1 E3.20000 F2400.00000

G1 X88.492 Y70.393 E0.08198

G1 X92.381 Y70.376 E0.04990

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y70.383 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.598 Y77.608

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y78.219 E0.01591

G1 X90.118 Y78.186 E0.06455

G1 X85.071 Y78.229 E0.13152

G1 X81.887 Y78.233 E0.08297

G1 X81.885 Y77.602 E0.01642

G1 X92.538 Y77.608 E0.27756

M204 S1250

G1 X92.783 Y77.197 F9000.000

M204 S800

G1 F1500.000

G1 X92.906 Y77.281 E0.00388

G1 X92.991 Y77.408 E0.00398

G1 X93.016 Y77.524 E0.00307

G1 X93.013 Y78.345 E0.02141

G1 X92.999 Y78.411 E0.00175

G1 X92.865 Y78.600 E0.00604

G1 X92.715 Y78.638 E0.00405

G1 X90.117 Y78.604 E0.06767

G1 X85.073 Y78.647 E0.13144

G1 X81.779 Y78.651 E0.08584

G1 X81.579 Y78.576 E0.00556

G1 X81.523 Y78.504 E0.00236

G1 X81.469 Y78.335 E0.00463

G1 X81.467 Y77.530 E0.02098

G1 X81.494 Y77.405 E0.00333

G1 X81.585 Y77.262 E0.00443

G1 X81.656 Y77.209 E0.00231

G1 X81.727 Y77.185 E0.00196

G1 X92.723 Y77.190 E0.28651

M204 S1250

G1 X92.801 Y77.345 F9000.000

G1 X92.388 Y77.912

G1 F2400.000

G1 X90.120 Y77.897 E0.02673

G1 X82.095 Y77.917 E0.08099

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y77.913 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X82.091 Y83.069

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y83.069 E0.27363

G1 X92.586 Y83.677 E0.01586

G1 X88.491 Y83.709 E0.10670

G1 X85.475 Y83.684 E0.07859

G1 X81.893 Y83.684 E0.09335

G1 X81.894 Y83.069 E0.01602

G1 X82.031 Y83.069 E0.00357

M204 S1250

G1 X81.570 Y82.718 F9000.000

M204 S800

G1 F1500.000

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G1 X81.714 Y82.651 E0.00189

G1 X92.722 Y82.650 E0.28684

G1 X92.830 Y82.669 E0.00284

G1 X92.969 Y82.793 E0.00486

G1 X93.012 Y82.934 E0.00386

G1 X93.002 Y83.843 E0.02367

G1 X92.930 Y83.917 E0.00270

G1 X92.848 Y84.050 E0.00408

G1 X92.706 Y84.095 E0.00389

G1 X88.491 Y84.127 E0.10982

G1 X85.474 Y84.101 E0.07863

G1 X81.772 Y84.102 E0.09644

G1 X81.639 Y84.064 E0.00360

G1 X81.575 Y84.017 E0.00207

G1 X81.517 Y83.943 E0.00247

G1 X81.475 Y83.840 E0.00288

G1 X81.477 Y82.894 E0.02467

G1 X81.542 Y82.771 E0.00362

M204 S1250

G1 X81.658 Y82.731 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.643 Y82.668 E-0.08005

G1 X81.714 Y82.651 E-0.04011

G1 X83.143 Y82.651 E-0.79184

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.381 Y83.374

G1 Z5.900

G1 E3.20000 F2400.00000

G1 X88.491 Y83.391 E0.04985

G1 X82.102 Y83.376 E0.08190

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.748 Y83.380 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X81.885 Y90.600

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y90.606 E0.27912

G1 X92.596 Y91.217 E0.01591

G1 X90.118 Y91.184 E0.06455

G1 X85.071 Y91.227 E0.13152

G1 X81.887 Y91.231 E0.08297

G1 X81.885 Y90.660 E0.01486

M204 S1250

G1 X81.585 Y90.259 F9000.000

M204 S800

G1 F1500.000

G1 X81.656 Y90.206 E0.00231

G1 X81.726 Y90.183 E0.00192

G1 X92.727 Y90.188 E0.28664

G1 X92.783 Y90.195 E0.00146

G1 X92.906 Y90.279 E0.00389

G1 X92.991 Y90.406 E0.00396

G1 X93.016 Y90.521 E0.00306

G1 X93.013 Y91.343 E0.02143

G1 X92.999 Y91.409 E0.00175

G1 X92.865 Y91.598 E0.00604

G1 X92.715 Y91.636 E0.00405

G1 X90.117 Y91.602 E0.06767

G1 X85.073 Y91.645 E0.13144

G1 X81.779 Y91.649 E0.08584

G1 X81.579 Y91.574 E0.00556

G1 X81.523 Y91.502 E0.00236

G1 X81.469 Y91.333 E0.00463

G1 X81.467 Y90.528 E0.02099

G1 X81.494 Y90.402 E0.00334

G1 X81.553 Y90.310 E0.00286

M204 S1250

G1 X81.671 Y90.280 F9000.000

G1 X82.095 Y90.915

G1 F2400.000

G1 X90.120 Y90.895 E0.08099

G1 X92.388 Y90.910 E0.02673

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y90.899 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.399 Y96.067

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y96.067 E0.00506

G1 X92.586 Y96.676 E0.01589

G1 X88.491 Y96.706 E0.10668

G1 X85.475 Y96.681 E0.07859

G1 X81.893 Y96.682 E0.09334

G1 X81.894 Y96.066 E0.01604

G1 X92.339 Y96.067 E0.27215

M204 S1250

G1 X92.830 Y95.667 F9000.000

M204 S800

G1 F1500.000

G1 X92.969 Y95.790 E0.00484

G1 X93.012 Y95.932 E0.00388

G1 X93.002 Y96.841 E0.02367

G1 X92.930 Y96.915 E0.00270

G1 X92.848 Y97.048 E0.00408

G1 X92.706 Y97.093 E0.00389

G1 X88.491 Y97.124 E0.10982

G1 X85.474 Y97.099 E0.07863

G1 X81.772 Y97.100 E0.09644

G1 X81.639 Y97.062 E0.00360

G1 X81.575 Y97.015 E0.00207

G1 X81.517 Y96.941 E0.00247

G1 X81.475 Y96.838 E0.00288

G1 X81.477 Y95.892 E0.02467

G1 X81.570 Y95.716 E0.00518

G1 X81.644 Y95.666 E0.00232

G1 X81.714 Y95.648 E0.00189

G1 X92.771 Y95.657 E0.28809

M204 S1250

G1 X92.838 Y95.852 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.969 Y95.790 E-0.13232

G1 X93.012 Y95.932 E-0.08244

G1 X93.002 Y96.841 E-0.50352

G1 X92.930 Y96.915 E-0.05735

G1 X92.848 Y97.048 E-0.08674

G1 X92.763 Y97.075 E-0.04963

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X82.102 Y96.374

G1 Z5.900

G1 E3.20000 F2400.00000

G1 X88.491 Y96.389 E0.08164

G1 X92.381 Y96.372 E0.04970

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y96.379 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.598 Y103.604

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y104.215 E0.01591

G1 X90.118 Y104.182 E0.06455

G1 X85.071 Y104.225 E0.13152

G1 X81.887 Y104.229 E0.08297

G1 X81.885 Y103.598 E0.01643

G1 X92.538 Y103.604 E0.27756

M204 S1250

G1 X92.783 Y103.193 F9000.000

M204 S800

G1 F1500.000

G1 X92.906 Y103.277 E0.00389

G1 X92.991 Y103.404 E0.00396

G1 X93.016 Y103.519 E0.00306

G1 X93.013 Y104.340 E0.02141

G1 X92.999 Y104.406 E0.00175

G1 X92.865 Y104.596 E0.00606

G1 X92.715 Y104.634 E0.00405

G1 X90.117 Y104.600 E0.06767

G1 X85.073 Y104.643 E0.13144

G1 X81.779 Y104.647 E0.08584

G1 X81.579 Y104.572 E0.00556

G1 X81.523 Y104.500 E0.00237

G1 X81.469 Y104.331 E0.00463

G1 X81.467 Y103.526 E0.02099

G1 X81.494 Y103.400 E0.00334

G1 X81.585 Y103.257 E0.00442

G1 X81.656 Y103.204 E0.00233

G1 X81.726 Y103.180 E0.00192

G1 X92.723 Y103.186 E0.28654

M204 S1250

G1 X92.801 Y103.341 F9000.000

G1 X92.388 Y103.908

G1 F2400.000

G1 X90.120 Y103.893 E0.02673

G1 X82.095 Y103.913 E0.08106

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y103.909 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X82.091 Y109.064

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.593 Y109.065 E0.27365

G1 X92.586 Y109.673 E0.01586

G1 X88.491 Y109.704 E0.10670

G1 X85.475 Y109.679 E0.07859

G1 X81.893 Y109.680 E0.09334

G1 X81.894 Y109.064 E0.01604

G1 X82.031 Y109.064 E0.00356

M204 S1250

G1 X81.570 Y108.714 F9000.000

M204 S800

G1 F1500.000

G1 X81.644 Y108.663 E0.00232

G1 X81.714 Y108.646 E0.00188

G1 X92.723 Y108.646 E0.28685

G1 X92.830 Y108.664 E0.00284

G1 X92.969 Y108.788 E0.00484

G1 X93.012 Y108.930 E0.00388

G1 X93.002 Y109.838 E0.02367

G1 X92.930 Y109.913 E0.00271

G1 X92.848 Y110.046 E0.00406

G1 X92.706 Y110.090 E0.00389

G1 X88.491 Y110.122 E0.10982

G1 X85.474 Y110.096 E0.07863

G1 X81.773 Y110.098 E0.09642

G1 X81.639 Y110.059 E0.00363

G1 X81.575 Y110.013 E0.00207

G1 X81.517 Y109.939 E0.00246

G1 X81.475 Y109.836 E0.00288

G1 X81.477 Y108.889 E0.02468

G1 X81.542 Y108.766 E0.00362

M204 S1250

G1 X81.658 Y108.727 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.644 Y108.663 E-0.08031

G1 X81.714 Y108.646 E-0.04002

G1 X83.142 Y108.646 E-0.79167

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X92.381 Y109.370

G1 Z5.900

G1 E3.20000 F2400.00000

G1 X88.492 Y109.387 E0.04970

G1 X82.102 Y109.372 E0.08165

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.748 Y109.376 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.100 F9000.000

G1 X81.885 Y116.596

G1 Z5.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y116.601 E0.27912

G1 X92.596 Y117.213 E0.01593

G1 X90.118 Y117.180 E0.06455

G1 X85.071 Y117.223 E0.13152

G1 X81.887 Y117.226 E0.08298

G1 X81.885 Y116.656 E0.01485

M204 S1250

G1 X81.585 Y116.255 F9000.000

M204 S800

G1 F1500.000

G1 X81.656 Y116.202 E0.00233

G1 X81.726 Y116.178 E0.00192

G1 X92.726 Y116.184 E0.28662

G1 X92.782 Y116.191 E0.00147

G1 X92.906 Y116.275 E0.00389

G1 X92.991 Y116.402 E0.00398

G1 X93.016 Y116.517 E0.00306

G1 X93.013 Y117.338 E0.02141

G1 X92.999 Y117.404 E0.00175

G1 X92.865 Y117.594 E0.00606

G1 X92.715 Y117.632 E0.00405

G1 X90.117 Y117.598 E0.06767

G1 X85.073 Y117.641 E0.13144

G1 X81.778 Y117.644 E0.08584

G1 X81.579 Y117.570 E0.00554

G1 X81.523 Y117.498 E0.00238

G1 X81.469 Y117.329 E0.00461

G1 X81.467 Y116.524 E0.02099

G1 X81.494 Y116.398 E0.00334

G1 X81.553 Y116.306 E0.00285

M204 S1250

G1 X81.672 Y116.276 F9000.000

G1 X82.095 Y116.911

G1 F2400.000

G1 X90.120 Y116.890 E0.08137

G1 X92.388 Y116.906 E0.02684

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;6.05

G1 Z6.050 F9000.000

;AFTER\_LAYER\_CHANGE

;6.05

G1 E-3.20000 F4200.00000

G1 Z6.250 F9000.000

G1 X92.405 Y44.609

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.894 Y44.606 E0.27386

G1 X81.896 Y44.020 E0.01527

G1 X92.594 Y44.023 E0.27874

G1 X92.586 Y44.609 E0.01526

G1 X92.465 Y44.609 E0.00315

M204 S1250

G1 X92.879 Y44.920 F9000.000

M204 S800

G1 F1500.000

G1 X92.837 Y44.989 E0.00211

G1 X92.709 Y45.026 E0.00347

G1 X81.780 Y45.024 E0.28477

G1 X81.617 Y44.967 E0.00449

G1 X81.518 Y44.874 E0.00354

G1 X81.475 Y44.772 E0.00288

G1 X81.479 Y43.833 E0.02447

G1 X81.572 Y43.669 E0.00491

G1 X81.635 Y43.631 E0.00191

G1 X81.766 Y43.602 E0.00348

G1 X92.755 Y43.606 E0.28635

G1 X92.825 Y43.622 E0.00186

G1 X92.969 Y43.748 E0.00500

G1 X93.013 Y43.894 E0.00395

G1 X93.001 Y44.783 E0.02318

G1 X92.967 Y44.855 E0.00208

G1 X92.927 Y44.884 E0.00129

M204 S1250

G1 X92.798 Y44.913 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.837 Y44.989 E-0.07674

G1 X92.709 Y45.026 E-0.07381

G1 X91.335 Y45.026 E-0.76146

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X82.104 Y44.313

G1 Z6.050

G1 E3.20000 F2400.00000

G1 X92.381 Y44.316 E0.10899

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y44.315 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.598 Y51.689

G1 Z6.050

G1 E3.20000 F2400.00000

M73 P62 R26

M204 S800

G1 F1500.000

G1 X92.596 Y52.261 E0.01489

G1 X90.539 Y52.234 E0.05360

G1 X85.071 Y52.277 E0.14246

G1 X81.887 Y52.280 E0.08298

G1 X81.885 Y51.693 E0.01530

G1 X92.538 Y51.689 E0.27755

M204 S1250

G1 X92.889 Y51.342 F9000.000

M204 S800

G1 F1500.000

G1 X92.986 Y51.464 E0.00407

G1 X93.016 Y51.609 E0.00386

G1 X93.013 Y52.407 E0.02078

G1 X92.993 Y52.496 E0.00239

G1 X92.874 Y52.642 E0.00490

G1 X92.716 Y52.680 E0.00426

G1 X90.538 Y52.652 E0.05675

G1 X85.073 Y52.695 E0.14239

G1 X81.777 Y52.698 E0.08588

G1 X81.596 Y52.638 E0.00498

G1 X81.485 Y52.492 E0.00476

G1 X81.469 Y52.420 E0.00193

G1 X81.467 Y51.602 E0.02132

G1 X81.515 Y51.435 E0.00452

G1 X81.567 Y51.352 E0.00255

G1 X81.637 Y51.301 E0.00226

G1 X81.764 Y51.275 E0.00337

G1 X92.725 Y51.272 E0.28561

G1 X92.835 Y51.316 E0.00308

M204 S1250

G1 X92.877 Y51.498 F9000.000

G1 X92.388 Y51.974

G1 F2400.000

G1 X90.540 Y51.962 E0.01728

G1 X82.095 Y51.986 E0.06654

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y51.981 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X82.095 Y57.018

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y57.020 E0.27354

G1 X92.586 Y57.606 E0.01527

G1 X81.894 Y57.604 E0.27858

G1 X81.896 Y57.018 E0.01527

G1 X82.035 Y57.018 E0.00363

M204 S1250

G1 X81.573 Y56.666 F9000.000

M204 S800

G1 F1500.000

G1 X81.635 Y56.629 E0.00188

G1 X81.765 Y56.600 E0.00349

G1 X92.755 Y56.603 E0.28634

G1 X92.825 Y56.620 E0.00187

G1 X92.969 Y56.746 E0.00501

G1 X93.013 Y56.891 E0.00393

G1 X93.001 Y57.781 E0.02319

G1 X92.967 Y57.853 E0.00207

G1 X92.879 Y57.918 E0.00285

G1 X92.837 Y57.987 E0.00212

G1 X92.709 Y58.024 E0.00346

G1 X81.780 Y58.022 E0.28477

G1 X81.618 Y57.965 E0.00447

G1 X81.517 Y57.872 E0.00357

G1 X81.475 Y57.770 E0.00287

G1 X81.479 Y56.831 E0.02447

G1 X81.536 Y56.714 E0.00340

M204 S1250

G1 X81.644 Y56.680 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.635 Y56.629 E-0.07201

G1 X81.765 Y56.600 E-0.07421

G1 X83.147 Y56.601 E-0.76578

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.381 Y57.313

G1 Z6.050

G1 E3.20000 F2400.00000

G1 X82.104 Y57.311 E0.10941

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.749 Y57.311 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X81.885 Y64.691

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y64.687 E0.27911

G1 X92.596 Y65.258 E0.01487

G1 X90.539 Y65.232 E0.05361

G1 X85.071 Y65.275 E0.14246

G1 X81.887 Y65.278 E0.08298

G1 X81.886 Y64.751 E0.01374

M204 S1250

G1 X81.515 Y64.432 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y64.350 E0.00255

G1 X81.637 Y64.299 E0.00224

G1 X81.764 Y64.273 E0.00338

G1 X92.726 Y64.270 E0.28563

G1 X92.888 Y64.340 E0.00461

G1 X92.986 Y64.462 E0.00408

G1 X93.016 Y64.607 E0.00386

G1 X93.013 Y65.404 E0.02078

G1 X92.993 Y65.493 E0.00237

G1 X92.874 Y65.639 E0.00490

G1 X92.716 Y65.678 E0.00426

G1 X90.538 Y65.649 E0.05675

G1 X85.073 Y65.693 E0.14239

G1 X81.777 Y65.696 E0.08588

G1 X81.596 Y65.636 E0.00498

G1 X81.485 Y65.490 E0.00476

G1 X81.469 Y65.418 E0.00193

G1 X81.467 Y64.600 E0.02132

G1 X81.499 Y64.490 E0.00296

M204 S1250

G1 X81.612 Y64.420 F9000.000

G1 X82.095 Y64.984

G1 F2400.000

G1 X90.540 Y64.960 E0.06624

G1 X92.388 Y64.972 E0.01720

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y64.961 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.594 Y70.018

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.586 Y70.604 E0.01527

G1 X81.894 Y70.602 E0.27858

G1 X81.896 Y70.016 E0.01527

G1 X92.534 Y70.018 E0.27717

M204 S1250

G1 X92.825 Y69.618 F9000.000

M204 S800

G1 F1500.000

G1 X92.969 Y69.744 E0.00501

G1 X93.013 Y69.889 E0.00393

G1 X93.001 Y70.779 E0.02319

G1 X92.967 Y70.851 E0.00207

G1 X92.879 Y70.915 E0.00285

G1 X92.837 Y70.985 E0.00211

G1 X92.709 Y71.022 E0.00347

G1 X81.780 Y71.020 E0.28477

G1 X81.618 Y70.963 E0.00448

G1 X81.517 Y70.870 E0.00356

G1 X81.475 Y70.768 E0.00287

G1 X81.479 Y69.829 E0.02447

G1 X81.573 Y69.664 E0.00494

G1 X81.635 Y69.627 E0.00188

G1 X81.765 Y69.598 E0.00349

G1 X92.766 Y69.604 E0.28664

M204 S1250

G1 X92.833 Y69.810 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.969 Y69.744 E-0.13698

G1 X93.013 Y69.889 E-0.08364

G1 X93.001 Y70.779 E-0.49326

G1 X92.967 Y70.851 E-0.04405

G1 X92.879 Y70.915 E-0.06054

G1 X92.837 Y70.985 E-0.04491

G1 X92.753 Y71.009 E-0.04862

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X82.104 Y70.309

G1 Z6.050

G1 E3.20000 F2400.00000

G1 X92.381 Y70.311 E0.10941

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y70.311 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.598 Y77.685

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y78.256 E0.01487

G1 X90.539 Y78.229 E0.05360

G1 X85.071 Y78.272 E0.14246

G1 X81.887 Y78.276 E0.08298

G1 X81.885 Y77.689 E0.01530

G1 X92.538 Y77.685 E0.27755

M204 S1250

G1 X92.888 Y77.337 F9000.000

M204 S800

G1 F1500.000

G1 X92.986 Y77.460 E0.00408

G1 X93.016 Y77.605 E0.00387

G1 X93.013 Y78.402 E0.02078

G1 X92.993 Y78.491 E0.00237

G1 X92.875 Y78.637 E0.00490

G1 X92.716 Y78.675 E0.00426

G1 X90.538 Y78.647 E0.05676

G1 X85.073 Y78.690 E0.14239

G1 X81.778 Y78.694 E0.08587

G1 X81.596 Y78.633 E0.00499

G1 X81.485 Y78.488 E0.00475

G1 X81.469 Y78.415 E0.00195

G1 X81.467 Y77.597 E0.02130

G1 X81.515 Y77.430 E0.00452

G1 X81.567 Y77.348 E0.00255

G1 X81.637 Y77.297 E0.00224

G1 X81.764 Y77.271 E0.00338

G1 X92.726 Y77.268 E0.28563

G1 X92.835 Y77.311 E0.00305

M204 S1250

G1 X92.877 Y77.494 F9000.000

G1 X92.388 Y77.969

G1 F2400.000

G1 X90.540 Y77.958 E0.01717

G1 X82.095 Y77.982 E0.06601

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y77.977 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X82.095 Y83.014

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y83.016 E0.27354

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G1 X81.894 Y83.599 E0.27858

G1 X81.896 Y83.014 E0.01525

G1 X82.035 Y83.014 E0.00363

M204 S1250

G1 X81.573 Y82.662 F9000.000

M204 S800

G1 F1500.000

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G1 X81.765 Y82.596 E0.00349

G1 X92.755 Y82.599 E0.28634

G1 X92.825 Y82.616 E0.00187

G1 X92.969 Y82.742 E0.00501

G1 X93.013 Y82.887 E0.00393

G1 X93.001 Y83.776 E0.02317

G1 X92.967 Y83.848 E0.00207

G1 X92.879 Y83.912 E0.00284

G1 X92.837 Y83.982 E0.00214

G1 X92.709 Y84.020 E0.00348

G1 X81.779 Y84.017 E0.28477

G1 X81.618 Y83.960 E0.00446

G1 X81.517 Y83.867 E0.00357

G1 X81.475 Y83.766 E0.00286

G1 X81.479 Y82.827 E0.02447

G1 X81.536 Y82.710 E0.00340

M204 S1250

G1 X81.644 Y82.676 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.635 Y82.625 E-0.07201

G1 X81.765 Y82.596 E-0.07421

G1 X83.147 Y82.597 E-0.76578

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.381 Y83.309

G1 Z6.050

G1 E3.20000 F2400.00000

G1 X82.104 Y83.307 E0.10936

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.749 Y83.307 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X81.885 Y90.687

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y90.683 E0.27911

G1 X92.596 Y91.254 E0.01487

G1 X90.539 Y91.227 E0.05360

G1 X85.071 Y91.270 E0.14246

G1 X81.887 Y91.274 E0.08298

G1 X81.886 Y90.747 E0.01374

M204 S1250

G1 X81.515 Y90.428 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y90.345 E0.00255

G1 X81.637 Y90.294 E0.00225

G1 X81.763 Y90.269 E0.00336

G1 X92.726 Y90.266 E0.28564

G1 X92.889 Y90.336 E0.00461

G1 X92.986 Y90.457 E0.00407

G1 X93.016 Y90.602 E0.00386

G1 X93.013 Y91.400 E0.02080

G1 X92.993 Y91.489 E0.00237

G1 X92.874 Y91.635 E0.00490

G1 X92.716 Y91.673 E0.00426

G1 X90.538 Y91.645 E0.05676

G1 X85.073 Y91.688 E0.14239

G1 X81.778 Y91.692 E0.08587

G1 X81.596 Y91.631 E0.00499

G1 X81.485 Y91.486 E0.00475

G1 X81.469 Y91.413 E0.00195

G1 X81.467 Y90.595 E0.02130

G1 X81.499 Y90.486 E0.00297

M204 S1250

G1 X81.612 Y90.415 F9000.000

G1 X82.095 Y90.980

G1 F2400.000

G1 X90.540 Y90.956 E0.06601

G1 X92.388 Y90.967 E0.01717

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y90.957 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.594 Y96.014

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.586 Y96.600 E0.01527

G1 X81.894 Y96.597 E0.27858

G1 X81.896 Y96.011 E0.01527

G1 X92.534 Y96.014 E0.27717

M204 S1250

G1 X92.825 Y95.614 F9000.000

M204 S800

G1 F1500.000

G1 X92.969 Y95.740 E0.00500

G1 X93.013 Y95.885 E0.00395

G1 X93.001 Y96.774 E0.02318

G1 X92.967 Y96.846 E0.00207

G1 X92.879 Y96.910 E0.00284

G1 X92.837 Y96.980 E0.00214

G1 X92.709 Y97.018 E0.00348

G1 X81.779 Y97.015 E0.28477

G1 X81.618 Y96.958 E0.00446

G1 X81.517 Y96.865 E0.00357

G1 X81.475 Y96.764 E0.00286

G1 X81.479 Y95.825 E0.02447

G1 X81.572 Y95.660 E0.00493

G1 X81.635 Y95.622 E0.00190

G1 X81.766 Y95.593 E0.00349

G1 X92.767 Y95.600 E0.28663

M204 S1250

G1 X92.834 Y95.805 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.969 Y95.740 E-0.13660

G1 X93.013 Y95.885 E-0.08399

G1 X93.001 Y96.774 E-0.49294

G1 X92.967 Y96.846 E-0.04404

G1 X92.879 Y96.910 E-0.06037

G1 X92.837 Y96.980 E-0.04548

G1 X92.752 Y97.005 E-0.04857

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X82.104 Y96.304

G1 Z6.050

G1 E3.20000 F2400.00000

G1 X92.381 Y96.307 E0.10935

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y96.306 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.598 Y103.681

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y104.252 E0.01487

G1 X90.539 Y104.225 E0.05360

G1 X85.071 Y104.268 E0.14246

G1 X81.887 Y104.272 E0.08298

G1 X81.885 Y103.684 E0.01533

G1 X92.538 Y103.681 E0.27755

M204 S1250

G1 X92.889 Y103.334 F9000.000

M204 S800

G1 F1500.000

G1 X92.986 Y103.455 E0.00407

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G1 X93.013 Y104.398 E0.02078

G1 X92.993 Y104.487 E0.00239

G1 X92.874 Y104.633 E0.00489

G1 X92.716 Y104.671 E0.00426

G1 X90.538 Y104.643 E0.05675

G1 X85.073 Y104.686 E0.14239

G1 X81.778 Y104.690 E0.08587

G1 X81.596 Y104.629 E0.00500

G1 X81.485 Y104.484 E0.00475

G1 X81.469 Y104.411 E0.00195

G1 X81.467 Y103.593 E0.02131

G1 X81.515 Y103.426 E0.00454

G1 X81.567 Y103.343 E0.00254

G1 X81.637 Y103.292 E0.00226

G1 X81.764 Y103.266 E0.00337

G1 X92.726 Y103.264 E0.28563

G1 X92.835 Y103.307 E0.00305

M204 S1250

G1 X92.877 Y103.489 F9000.000

G1 X92.388 Y103.965

G1 F2400.000

G1 X90.540 Y103.954 E0.01717

G1 X82.095 Y103.978 E0.06611

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y103.973 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X82.095 Y109.009

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y109.012 E0.27356

G1 X92.586 Y109.598 E0.01526

G1 X81.894 Y109.595 E0.27858

G1 X81.896 Y109.009 E0.01527

G1 X82.035 Y109.009 E0.00362

M204 S1250

G1 X81.572 Y108.658 F9000.000

M204 S800

G1 F1500.000

G1 X81.635 Y108.620 E0.00191

G1 X81.766 Y108.591 E0.00348

G1 X92.755 Y108.595 E0.28635

G1 X92.825 Y108.611 E0.00186

G1 X92.969 Y108.737 E0.00500

G1 X93.013 Y108.883 E0.00395

G1 X93.001 Y109.772 E0.02317

G1 X92.967 Y109.845 E0.00209

G1 X92.879 Y109.908 E0.00283

G1 X92.837 Y109.978 E0.00213

G1 X92.709 Y110.015 E0.00347

G1 X81.780 Y110.013 E0.28477

G1 X81.617 Y109.956 E0.00449

G1 X81.517 Y109.863 E0.00355

G1 X81.475 Y109.762 E0.00286

G1 X81.479 Y108.822 E0.02449

G1 X81.536 Y108.706 E0.00338

M204 S1250

G1 X81.644 Y108.672 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.635 Y108.620 E-0.07262

G1 X81.766 Y108.591 E-0.07406

G1 X83.147 Y108.592 E-0.76532

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X92.381 Y109.305

G1 Z6.050

G1 E3.20000 F2400.00000

G1 X82.104 Y109.302 E0.10899

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.749 Y109.303 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.250 F9000.000

G1 X81.885 Y116.682

G1 Z6.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y116.678 E0.27911

G1 X92.596 Y117.250 E0.01489

G1 X90.539 Y117.223 E0.05360

G1 X85.071 Y117.266 E0.14246

G1 X81.887 Y117.269 E0.08298

G1 X81.886 Y116.742 E0.01375

M204 S1250

G1 X81.515 Y116.424 F9000.000

M204 S800

G1 F1500.000

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G1 X81.764 Y116.264 E0.00337

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G1 X92.889 Y116.331 E0.00464

G1 X92.986 Y116.453 E0.00407

G1 X93.016 Y116.598 E0.00386

G1 X93.013 Y117.396 E0.02078

G1 X92.993 Y117.485 E0.00239

G1 X92.874 Y117.631 E0.00489

G1 X92.716 Y117.669 E0.00426

G1 X90.538 Y117.641 E0.05675

G1 X85.073 Y117.684 E0.14239

G1 X81.777 Y117.687 E0.08587

G1 X81.596 Y117.627 E0.00499

G1 X81.485 Y117.481 E0.00477

G1 X81.469 Y117.409 E0.00193

G1 X81.467 Y116.591 E0.02130

G1 X81.499 Y116.481 E0.00298

M204 S1250

G1 X81.612 Y116.411 F9000.000

G1 X82.095 Y116.975

G1 F2400.000

G1 X90.540 Y116.951 E0.06654

G1 X92.388 Y116.963 E0.01728

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;6.2

G1 Z6.200 F9000.000

;AFTER\_LAYER\_CHANGE

;6.2

G1 E-3.20000 F4200.00000

G1 Z6.400 F9000.000

G1 X92.590 Y44.539

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y44.542 E0.27872

G1 X81.892 Y43.981 E0.01462

G1 X92.596 Y43.976 E0.27890

G1 X92.591 Y44.479 E0.01311

M204 S1250

G1 X92.977 Y44.787 F9000.000

M204 S800

G1 F1500.000

G1 X92.861 Y44.912 E0.00444

G1 X92.709 Y44.956 E0.00413

G1 X81.775 Y44.960 E0.28490

G1 X81.637 Y44.918 E0.00376

G1 X81.530 Y44.827 E0.00366

G1 X81.476 Y44.697 E0.00367

G1 X81.473 Y43.805 E0.02324

G1 X81.522 Y43.691 E0.00322

G1 X81.624 Y43.592 E0.00371

G1 X81.762 Y43.563 E0.00366

G1 X92.723 Y43.558 E0.28560

G1 X92.837 Y43.577 E0.00301

G1 X92.928 Y43.642 E0.00292

G1 X92.963 Y43.684 E0.00141

G1 X93.014 Y43.861 E0.00482

G1 X92.995 Y44.730 E0.02264

M204 S1250

G1 X92.807 Y44.792 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.861 Y44.912 E-0.12516

G1 X92.709 Y44.956 E-0.08784

G1 X91.448 Y44.957 E-0.69901

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.101 Y44.262

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.384 Y44.257 E0.09410

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y44.258 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.597 Y51.759

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y52.298 E0.01405

G1 X90.959 Y52.277 E0.04265

G1 X85.071 Y52.321 E0.15341

G1 X81.890 Y52.323 E0.08289

G1 X81.887 Y51.755 E0.01480

G1 X92.537 Y51.759 E0.27750

M204 S1250

G1 X92.866 Y51.394 F9000.000

M204 S800

G1 F1500.000

G1 X92.985 Y51.517 E0.00444

G1 X93.015 Y51.646 E0.00347

G1 X93.013 Y52.439 E0.02065

G1 X92.992 Y52.542 E0.00275

G1 X92.877 Y52.680 E0.00468

G1 X92.717 Y52.718 E0.00428

G1 X90.958 Y52.695 E0.04583

G1 X85.073 Y52.738 E0.15333

G1 X81.771 Y52.741 E0.08603

G1 X81.615 Y52.698 E0.00423

G1 X81.473 Y52.494 E0.00648

G1 X81.468 Y51.640 E0.02224

G1 X81.564 Y51.424 E0.00616

G1 X81.635 Y51.367 E0.00238

G1 X81.766 Y51.337 E0.00351

G1 X92.705 Y51.341 E0.28502

G1 X92.809 Y51.376 E0.00286

M204 S1250

G1 X92.864 Y51.565 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.985 Y51.517 E-0.12497

G1 X93.015 Y51.646 E-0.07378

G1 X93.013 Y52.439 E-0.43916

G1 X92.992 Y52.542 E-0.05856

G1 X92.877 Y52.680 E-0.09963

G1 X92.717 Y52.718 E-0.09109

G1 X92.672 Y52.717 E-0.02480

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.097 Y52.039

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.387 Y52.027 E0.07584

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y52.029 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.596 Y56.973

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y57.536 E0.01467

G1 X81.893 Y57.540 E0.27872

G1 X81.892 Y56.979 E0.01462

G1 X92.536 Y56.972 E0.27734

M204 S1250

G1 X92.824 Y56.572 F9000.000

M204 S800

G1 F1500.000

G1 X92.963 Y56.682 E0.00462

G1 X93.014 Y56.859 E0.00480

G1 X93.007 Y57.689 E0.02162

G1 X92.977 Y57.785 E0.00263

G1 X92.929 Y57.852 E0.00214

G1 X92.862 Y57.910 E0.00232

G1 X92.709 Y57.953 E0.00412

G1 X81.775 Y57.958 E0.28491

G1 X81.637 Y57.916 E0.00376

G1 X81.530 Y57.825 E0.00367

G1 X81.476 Y57.695 E0.00367

G1 X81.473 Y56.803 E0.02324

G1 X81.522 Y56.689 E0.00323

G1 X81.624 Y56.589 E0.00372

G1 X81.761 Y56.561 E0.00364

G1 X92.765 Y56.562 E0.28671

M204 S1250

G1 X92.838 Y56.749 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.963 Y56.682 E-0.12838

G1 X93.014 Y56.859 E-0.10219

G1 X93.007 Y57.689 E-0.45985

G1 X92.977 Y57.785 E-0.05593

G1 X92.929 Y57.852 E-0.04555

G1 X92.862 Y57.910 E-0.04930

G1 X92.739 Y57.945 E-0.07080

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.101 Y57.260

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.384 Y57.254 E0.09417

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y57.255 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.597 Y64.757

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y65.296 E0.01404

G1 X90.959 Y65.274 E0.04265

G1 X85.071 Y65.319 E0.15341

G1 X81.890 Y65.321 E0.08289

G1 X81.887 Y64.753 E0.01480

G1 X92.537 Y64.757 E0.27750

M204 S1250

G1 X92.866 Y64.392 F9000.000

M204 S800

G1 F1500.000

G1 X92.985 Y64.515 E0.00444

G1 X93.015 Y64.644 E0.00347

G1 X93.013 Y65.437 E0.02064

G1 X92.992 Y65.540 E0.00275

G1 X92.877 Y65.678 E0.00468

G1 X92.717 Y65.715 E0.00428

G1 X90.958 Y65.692 E0.04583

G1 X85.073 Y65.736 E0.15333

G1 X81.771 Y65.739 E0.08603

G1 X81.615 Y65.696 E0.00423

G1 X81.473 Y65.492 E0.00648

G1 X81.468 Y64.638 E0.02224

G1 X81.564 Y64.422 E0.00616

G1 X81.634 Y64.365 E0.00237

G1 X81.766 Y64.335 E0.00351

G1 X92.705 Y64.339 E0.28502

G1 X92.809 Y64.374 E0.00286

M204 S1250

G1 X92.864 Y64.563 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.985 Y64.515 E-0.12497

G1 X93.015 Y64.644 E-0.07378

G1 X93.013 Y65.437 E-0.43907

G1 X92.992 Y65.540 E-0.05840

G1 X92.877 Y65.678 E-0.09957

G1 X92.717 Y65.715 E-0.09111

G1 X92.671 Y65.715 E-0.02509

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.097 Y65.037

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.387 Y65.025 E0.07548

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y65.027 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.596 Y69.971

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y70.534 E0.01467

G1 X81.893 Y70.538 E0.27872

G1 X81.892 Y69.977 E0.01462

G1 X92.536 Y69.970 E0.27734

M204 S1250

G1 X92.824 Y69.570 F9000.000

M204 S800

G1 F1500.000

G1 X92.963 Y69.679 E0.00461

G1 X93.014 Y69.857 E0.00482

G1 X93.007 Y70.687 E0.02162

G1 X92.977 Y70.783 E0.00263

G1 X92.929 Y70.850 E0.00214

G1 X92.862 Y70.908 E0.00232

G1 X92.709 Y70.951 E0.00413

G1 X81.775 Y70.956 E0.28491

G1 X81.637 Y70.914 E0.00376

G1 X81.530 Y70.823 E0.00367

G1 X81.476 Y70.693 E0.00367

G1 X81.473 Y69.801 E0.02324

G1 X81.522 Y69.687 E0.00323

G1 X81.624 Y69.587 E0.00372

G1 X81.761 Y69.559 E0.00364

G1 X92.765 Y69.560 E0.28671

M204 S1250

G1 X92.838 Y69.746 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.963 Y69.679 E-0.12819

G1 X93.014 Y69.857 E-0.10245

G1 X93.007 Y70.687 E-0.45985

G1 X92.977 Y70.783 E-0.05593

G1 X92.929 Y70.850 E-0.04551

G1 X92.862 Y70.908 E-0.04929

G1 X92.739 Y70.943 E-0.07079

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.101 Y70.258

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.384 Y70.252 E0.09417

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y70.253 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.597 Y77.755

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y78.293 E0.01403

G1 X90.959 Y78.272 E0.04265

G1 X85.071 Y78.316 E0.15341

G1 X81.890 Y78.319 E0.08289

G1 X81.887 Y77.751 E0.01480

G1 X92.537 Y77.755 E0.27750

M204 S1250

G1 X92.866 Y77.390 F9000.000

M204 S800

G1 F1500.000

G1 X92.985 Y77.512 E0.00443

G1 X93.015 Y77.642 E0.00349

G1 X93.013 Y78.435 E0.02065

G1 X92.992 Y78.538 E0.00275

G1 X92.877 Y78.676 E0.00468

G1 X92.717 Y78.713 E0.00428

G1 X90.958 Y78.690 E0.04584

G1 X85.073 Y78.734 E0.15333

G1 X81.772 Y78.737 E0.08603

G1 X81.615 Y78.694 E0.00424

G1 X81.473 Y78.489 E0.00648

G1 X81.468 Y77.636 E0.02224

G1 X81.564 Y77.420 E0.00615

G1 X81.634 Y77.363 E0.00237

G1 X81.766 Y77.333 E0.00351

G1 X92.705 Y77.337 E0.28503

G1 X92.809 Y77.371 E0.00286

M204 S1250

G1 X92.864 Y77.560 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.985 Y77.512 E-0.12465

G1 X93.015 Y77.642 E-0.07418

G1 X93.013 Y78.435 E-0.43911

G1 X92.992 Y78.538 E-0.05840

G1 X92.877 Y78.676 E-0.09947

G1 X92.717 Y78.713 E-0.09105

G1 X92.671 Y78.712 E-0.02514

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.097 Y78.035

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.387 Y78.023 E0.07520

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y78.025 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.596 Y82.969

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y83.532 E0.01467

G1 X81.893 Y83.536 E0.27872

G1 X81.892 Y82.975 E0.01461

G1 X92.536 Y82.968 E0.27734

M204 S1250

G1 X92.824 Y82.568 F9000.000

M204 S800

G1 F1500.000

G1 X92.963 Y82.677 E0.00461

G1 X93.014 Y82.855 E0.00482

G1 X93.007 Y83.684 E0.02161

G1 X92.977 Y83.781 E0.00264

G1 X92.929 Y83.848 E0.00213

G1 X92.862 Y83.905 E0.00231

G1 X92.709 Y83.949 E0.00414

G1 X81.775 Y83.953 E0.28490

G1 X81.637 Y83.911 E0.00376

G1 X81.530 Y83.820 E0.00366

G1 X81.476 Y83.691 E0.00366

G1 X81.473 Y82.799 E0.02324

G1 X81.522 Y82.685 E0.00323

G1 X81.624 Y82.585 E0.00372

G1 X81.761 Y82.557 E0.00364

G1 X92.765 Y82.558 E0.28671

M204 S1250

G1 X92.838 Y82.744 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.963 Y82.677 E-0.12819

G1 X93.014 Y82.855 E-0.10245

G1 X93.007 Y83.684 E-0.45962

G1 X92.977 Y83.781 E-0.05621

G1 X92.929 Y83.848 E-0.04520

G1 X92.862 Y83.905 E-0.04921

G1 X92.738 Y83.941 E-0.07113

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.101 Y83.255

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.384 Y83.250 E0.09420

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y83.251 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.597 Y90.753

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y91.291 E0.01403

G1 X90.959 Y91.270 E0.04265

G1 X85.071 Y91.314 E0.15341

G1 X81.890 Y91.317 E0.08289

G1 X81.887 Y90.749 E0.01480

G1 X92.537 Y90.753 E0.27750

M204 S1250

G1 X92.866 Y90.388 F9000.000

M204 S800

G1 F1500.000

G1 X92.985 Y90.510 E0.00443

G1 X93.015 Y90.639 E0.00347

G1 X93.013 Y91.433 E0.02067

G1 X92.992 Y91.536 E0.00275

G1 X92.877 Y91.674 E0.00468

G1 X92.717 Y91.711 E0.00428

G1 X90.958 Y91.688 E0.04584

G1 X85.073 Y91.732 E0.15333

G1 X81.772 Y91.735 E0.08603

G1 X81.615 Y91.692 E0.00424

G1 X81.473 Y91.487 E0.00648

G1 X81.468 Y90.634 E0.02224

G1 X81.564 Y90.418 E0.00616

G1 X81.635 Y90.360 E0.00237

G1 X81.766 Y90.331 E0.00350

G1 X92.705 Y90.335 E0.28504

G1 X92.809 Y90.369 E0.00286

M204 S1250

G1 X92.865 Y90.558 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.985 Y90.510 E-0.12461

G1 X93.015 Y90.639 E-0.07378

G1 X93.013 Y91.433 E-0.43963

G1 X92.992 Y91.536 E-0.05840

G1 X92.877 Y91.674 E-0.09947

G1 X92.717 Y91.711 E-0.09105

G1 X92.672 Y91.710 E-0.02506

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.097 Y91.033

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.387 Y91.021 E0.07520

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y91.023 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.596 Y95.967

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y96.530 E0.01467

G1 X81.893 Y96.533 E0.27872

G1 X81.892 Y95.972 E0.01461

G1 X92.536 Y95.966 E0.27734

M204 S1250

G1 X92.825 Y95.565 F9000.000

M204 S800

G1 F1500.000

G1 X92.963 Y95.675 E0.00459

G1 X93.014 Y95.853 E0.00482

G1 X93.007 Y96.682 E0.02161

G1 X92.977 Y96.779 E0.00264

G1 X92.929 Y96.846 E0.00213

G1 X92.862 Y96.903 E0.00231

G1 X92.709 Y96.947 E0.00414

G1 X81.775 Y96.951 E0.28491

M73 P64 R25

G1 X81.637 Y96.909 E0.00375

G1 X81.530 Y96.818 E0.00367

G1 X81.476 Y96.688 E0.00365

G1 X81.473 Y95.797 E0.02324

G1 X81.522 Y95.682 E0.00324

G1 X81.624 Y95.583 E0.00370

G1 X81.762 Y95.555 E0.00366

G1 X92.766 Y95.556 E0.28672

M204 S1250

G1 X92.838 Y95.741 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.963 Y95.675 E-0.12772

G1 X93.014 Y95.853 E-0.10256

G1 X93.007 Y96.682 E-0.45964

G1 X92.977 Y96.779 E-0.05620

G1 X92.929 Y96.846 E-0.04522

G1 X92.862 Y96.903 E-0.04920

G1 X92.738 Y96.939 E-0.07147

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.101 Y96.253

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.384 Y96.248 E0.09419

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y96.249 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.597 Y103.751

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y104.289 E0.01403

G1 X90.959 Y104.268 E0.04265

G1 X85.071 Y104.312 E0.15341

G1 X81.890 Y104.315 E0.08289

G1 X81.887 Y103.747 E0.01482

G1 X92.537 Y103.751 E0.27750

M204 S1250

G1 X92.866 Y103.386 F9000.000

M204 S800

G1 F1500.000

G1 X92.985 Y103.508 E0.00443

G1 X93.015 Y103.637 E0.00347

G1 X93.013 Y104.430 E0.02065

G1 X92.992 Y104.534 E0.00277

G1 X92.877 Y104.671 E0.00467

G1 X92.717 Y104.709 E0.00429

G1 X90.958 Y104.686 E0.04583

G1 X85.073 Y104.730 E0.15333

G1 X81.772 Y104.733 E0.08603

G1 X81.615 Y104.690 E0.00423

G1 X81.473 Y104.485 E0.00649

G1 X81.468 Y103.632 E0.02222

G1 X81.564 Y103.415 E0.00617

G1 X81.634 Y103.358 E0.00237

G1 X81.766 Y103.329 E0.00351

G1 X92.705 Y103.333 E0.28503

G1 X92.809 Y103.367 E0.00286

M204 S1250

G1 X92.865 Y103.556 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.985 Y103.508 E-0.12461

G1 X93.015 Y103.637 E-0.07378

G1 X93.013 Y104.430 E-0.43920

G1 X92.992 Y104.534 E-0.05881

G1 X92.877 Y104.671 E-0.09933

G1 X92.717 Y104.709 E-0.09118

G1 X92.671 Y104.708 E-0.02508

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.097 Y104.031

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.387 Y104.019 E0.07522

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y104.021 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.596 Y108.965

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y109.528 E0.01467

G1 X81.893 Y109.531 E0.27872

G1 X81.892 Y108.970 E0.01461

G1 X92.536 Y108.964 E0.27734

M204 S1250

G1 X92.825 Y108.563 F9000.000

M204 S800

G1 F1500.000

G1 X92.963 Y108.673 E0.00459

G1 X93.014 Y108.850 E0.00482

G1 X93.007 Y109.680 E0.02161

G1 X92.977 Y109.777 E0.00264

G1 X92.929 Y109.844 E0.00215

G1 X92.862 Y109.901 E0.00230

G1 X92.709 Y109.945 E0.00414

G1 X81.775 Y109.949 E0.28490

G1 X81.637 Y109.907 E0.00376

G1 X81.530 Y109.816 E0.00367

G1 X81.476 Y109.686 E0.00364

G1 X81.473 Y108.794 E0.02324

G1 X81.522 Y108.680 E0.00324

G1 X81.624 Y108.581 E0.00370

G1 X81.761 Y108.553 E0.00365

G1 X92.766 Y108.554 E0.28673

M204 S1250

G1 X92.839 Y108.739 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.963 Y108.673 E-0.12760

G1 X93.014 Y108.850 E-0.10244

G1 X93.007 Y109.680 E-0.45962

G1 X92.977 Y109.777 E-0.05619

G1 X92.929 Y109.844 E-0.04571

G1 X92.862 Y109.901 E-0.04892

G1 X92.738 Y109.937 E-0.07153

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.101 Y109.251

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.384 Y109.246 E0.09410

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y109.247 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X92.597 Y116.748

G1 Z6.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y117.287 E0.01405

G1 X90.959 Y117.266 E0.04265

G1 X85.071 Y117.310 E0.15341

G1 X81.890 Y117.313 E0.08289

G1 X81.887 Y116.744 E0.01481

G1 X92.537 Y116.748 E0.27750

M204 S1250

G1 X92.866 Y116.383 F9000.000

M204 S800

G1 F1500.000

G1 X92.985 Y116.506 E0.00444

G1 X93.015 Y116.635 E0.00347

G1 X93.013 Y117.428 E0.02065

G1 X92.992 Y117.532 E0.00277

G1 X92.877 Y117.669 E0.00467

G1 X92.717 Y117.707 E0.00429

G1 X90.958 Y117.684 E0.04583

G1 X85.073 Y117.728 E0.15333

G1 X81.772 Y117.731 E0.08603

G1 X81.615 Y117.688 E0.00423

G1 X81.473 Y117.483 E0.00649

G1 X81.468 Y116.630 E0.02222

G1 X81.564 Y116.413 E0.00617

G1 X81.634 Y116.356 E0.00237

G1 X81.766 Y116.327 E0.00351

G1 X92.705 Y116.330 E0.28502

G1 X92.809 Y116.365 E0.00286

M204 S1250

G1 X92.864 Y116.554 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.985 Y116.506 E-0.12497

G1 X93.015 Y116.635 E-0.07378

G1 X93.013 Y117.428 E-0.43920

G1 X92.992 Y117.532 E-0.05881

G1 X92.877 Y117.669 E-0.09933

G1 X92.717 Y117.707 E-0.09118

G1 X92.672 Y117.706 E-0.02472

G1 E-0.04800 F4200.00000

G1 Z6.400 F9000.000

G1 X82.097 Y117.029

G1 Z6.200

G1 E3.20000 F2400.00000

G1 X92.387 Y117.016 E0.07583

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;6.35

G1 Z6.350 F9000.000

;AFTER\_LAYER\_CHANGE

;6.35

G1 E-3.20000 F4200.00000

G1 Z6.550 F9000.000

G1 X92.595 Y44.482

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.243 Y44.495 E0.21762

G1 X81.891 Y44.479 E0.06128

G1 X81.889 Y43.942 E0.01400

G1 X92.597 Y43.948 E0.27902

G1 X92.595 Y44.422 E0.01236

M204 S1250

G1 X92.980 Y44.734 F9000.000

M204 S800

G1 F1500.000

G1 X92.895 Y44.828 E0.00331

G1 X92.701 Y44.900 E0.00541

G1 X84.242 Y44.913 E0.22040

G1 X81.771 Y44.896 E0.06437

G1 X81.641 Y44.862 E0.00352

G1 X81.537 Y44.779 E0.00346

G1 X81.474 Y44.632 E0.00416

G1 X81.470 Y43.787 E0.02204

G1 X81.514 Y43.660 E0.00349

G1 X81.650 Y43.540 E0.00473

G1 X81.757 Y43.525 E0.00282

G1 X92.726 Y43.530 E0.28580

G1 X92.852 Y43.547 E0.00330

G1 X92.913 Y43.586 E0.00189

G1 X92.965 Y43.650 E0.00214

G1 X93.016 Y43.829 E0.00486

G1 X93.012 Y44.604 E0.02018

G1 X92.995 Y44.675 E0.00192

M204 S1250

G1 X92.853 Y44.736 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.895 Y44.828 E-0.10088

G1 X92.701 Y44.900 E-0.11511

G1 X91.445 Y44.902 E-0.69601

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.099 Y44.212

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y44.215 E0.08004

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y44.215 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.413 Y51.818

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y51.817 E0.00479

G1 X92.595 Y52.336 E0.01351

G1 X91.379 Y52.320 E0.03169

G1 X85.072 Y52.364 E0.16435

G1 X81.894 Y52.367 E0.08280

G1 X81.888 Y51.818 E0.01431

G1 X92.353 Y51.818 E0.27265

M204 S1250

G1 X92.986 Y51.580 F9000.000

M204 S800

G1 F1500.000

G1 X93.015 Y51.684 E0.00282

G1 X93.013 Y52.471 E0.02049

G1 X92.991 Y52.588 E0.00312

G1 X92.885 Y52.712 E0.00424

G1 X92.715 Y52.755 E0.00458

G1 X91.378 Y52.738 E0.03483

G1 X85.073 Y52.782 E0.16428

G1 X81.773 Y52.785 E0.08600

G1 X81.613 Y52.738 E0.00434

G1 X81.478 Y52.537 E0.00631

G1 X81.469 Y51.682 E0.02228

G1 X81.543 Y51.510 E0.00487

G1 X81.631 Y51.433 E0.00307

G1 X81.768 Y51.400 E0.00367

G1 X92.709 Y51.399 E0.28508

G1 X92.825 Y51.433 E0.00314

G1 X92.902 Y51.478 E0.00233

G1 X92.948 Y51.533 E0.00189

M204 S1250

G1 X92.926 Y51.669 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.015 Y51.684 E-0.09126

G1 X93.013 Y52.471 E-0.43582

G1 X92.991 Y52.588 E-0.06635

G1 X92.885 Y52.712 E-0.09014

G1 X92.715 Y52.755 E-0.09748

G1 X92.478 Y52.752 E-0.13095

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.100 Y52.092

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y52.075 E0.06180

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y52.078 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.597 Y56.945

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y57.480 E0.01393

G1 X84.243 Y57.493 E0.21763

G1 X81.891 Y57.477 E0.06127

G1 X81.889 Y56.940 E0.01400

G1 X92.537 Y56.945 E0.27745

M204 S1250

G1 X92.851 Y56.545 F9000.000

M204 S800

G1 F1500.000

G1 X92.965 Y56.648 E0.00400

G1 X93.016 Y56.827 E0.00486

G1 X93.012 Y57.602 E0.02018

G1 X92.980 Y57.732 E0.00348

G1 X92.930 Y57.799 E0.00219

G1 X92.701 Y57.897 E0.00650

G1 X84.242 Y57.911 E0.22041

G1 X81.771 Y57.894 E0.06437

G1 X81.641 Y57.860 E0.00352

G1 X81.537 Y57.777 E0.00345

G1 X81.474 Y57.630 E0.00417

G1 X81.470 Y56.785 E0.02203

G1 X81.514 Y56.658 E0.00350

G1 X81.650 Y56.537 E0.00473

G1 X81.757 Y56.523 E0.00281

G1 X92.792 Y56.537 E0.28753

M204 S1250

G1 X92.856 Y56.698 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.965 Y56.648 E-0.11410

G1 X93.016 Y56.827 E-0.10341

G1 X93.012 Y57.602 E-0.42920

G1 X92.980 Y57.732 E-0.07403

G1 X92.930 Y57.799 E-0.04656

G1 X92.701 Y57.897 E-0.13826

G1 X92.689 Y57.897 E-0.00644

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.099 Y57.210

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y57.212 E0.08005

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y57.212 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.411 Y64.816

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y64.815 E0.00484

G1 X92.595 Y65.333 E0.01350

G1 X91.379 Y65.317 E0.03169

G1 X85.072 Y65.362 E0.16435

G1 X81.894 Y65.365 E0.08280

G1 X81.888 Y64.816 E0.01431

G1 X92.351 Y64.816 E0.27261

M204 S1250

G1 X92.986 Y64.578 F9000.000

M204 S800

G1 F1500.000

G1 X93.015 Y64.682 E0.00282

G1 X93.013 Y65.468 E0.02049

G1 X92.991 Y65.586 E0.00312

G1 X92.885 Y65.709 E0.00422

G1 X92.714 Y65.752 E0.00459

G1 X91.378 Y65.735 E0.03483

G1 X85.073 Y65.780 E0.16428

G1 X81.773 Y65.783 E0.08600

G1 X81.613 Y65.736 E0.00434

G1 X81.478 Y65.535 E0.00632

G1 X81.469 Y64.680 E0.02228

G1 X81.489 Y64.603 E0.00207

G1 X81.542 Y64.509 E0.00283

G1 X81.631 Y64.431 E0.00307

G1 X81.768 Y64.398 E0.00367

G1 X92.709 Y64.397 E0.28508

G1 X92.825 Y64.431 E0.00314

G1 X92.902 Y64.476 E0.00233

G1 X92.948 Y64.531 E0.00189

M204 S1250

G1 X92.926 Y64.667 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.015 Y64.682 E-0.09126

G1 X93.013 Y65.468 E-0.43569

G1 X92.991 Y65.586 E-0.06638

G1 X92.885 Y65.709 E-0.08985

G1 X92.714 Y65.752 E-0.09768

G1 X92.478 Y65.749 E-0.13113

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.100 Y65.090

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y65.073 E0.06159

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y65.076 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.597 Y69.943

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y70.478 E0.01393

G1 X84.243 Y70.491 E0.21763

G1 X81.891 Y70.475 E0.06127

G1 X81.889 Y69.938 E0.01400

G1 X92.537 Y69.943 E0.27745

M204 S1250

G1 X92.852 Y69.543 F9000.000

M204 S800

G1 F1500.000

G1 X92.965 Y69.645 E0.00398

G1 X93.016 Y69.825 E0.00487

G1 X93.012 Y70.600 E0.02018

G1 X92.980 Y70.730 E0.00348

G1 X92.930 Y70.797 E0.00219

G1 X92.701 Y70.895 E0.00650

G1 X84.242 Y70.909 E0.22041

G1 X81.771 Y70.892 E0.06436

G1 X81.641 Y70.857 E0.00353

G1 X81.537 Y70.775 E0.00345

G1 X81.474 Y70.628 E0.00417

G1 X81.470 Y69.783 E0.02203

G1 X81.514 Y69.656 E0.00350

G1 X81.650 Y69.535 E0.00473

G1 X81.757 Y69.521 E0.00281

G1 X92.792 Y69.535 E0.28754

M204 S1250

G1 X92.857 Y69.696 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.965 Y69.645 E-0.11368

G1 X93.016 Y69.825 E-0.10364

G1 X93.012 Y70.600 E-0.42920

G1 X92.980 Y70.730 E-0.07403

G1 X92.930 Y70.797 E-0.04656

G1 X92.701 Y70.895 E-0.13826

G1 X92.689 Y70.895 E-0.00663

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.099 Y70.208

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y70.210 E0.08005

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y70.210 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.411 Y77.814

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y77.813 E0.00484

G1 X92.595 Y78.331 E0.01348

G1 X91.379 Y78.315 E0.03169

G1 X85.072 Y78.359 E0.16435

G1 X81.894 Y78.363 E0.08279

G1 X81.888 Y77.814 E0.01431

G1 X92.351 Y77.814 E0.27261

M204 S1250

G1 X92.986 Y77.575 F9000.000

M204 S800

G1 F1500.000

G1 X93.015 Y77.680 E0.00284

G1 X93.013 Y78.466 E0.02049

G1 X92.991 Y78.584 E0.00312

G1 X92.886 Y78.707 E0.00420

G1 X92.715 Y78.750 E0.00460

G1 X91.378 Y78.733 E0.03483

G1 X85.073 Y78.777 E0.16428

G1 X81.773 Y78.781 E0.08600

G1 X81.613 Y78.734 E0.00434

G1 X81.478 Y78.533 E0.00632

G1 X81.469 Y77.677 E0.02229

G1 X81.489 Y77.601 E0.00205

G1 X81.542 Y77.507 E0.00283

G1 X81.631 Y77.429 E0.00307

G1 X81.768 Y77.396 E0.00367

G1 X92.710 Y77.395 E0.28509

G1 X92.825 Y77.428 E0.00314

G1 X92.902 Y77.473 E0.00231

G1 X92.948 Y77.529 E0.00188

M204 S1250

G1 X92.925 Y77.665 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.015 Y77.680 E-0.09169

G1 X93.013 Y78.466 E-0.43576

G1 X92.991 Y78.584 E-0.06638

G1 X92.886 Y78.707 E-0.08942

G1 X92.715 Y78.750 E-0.09792

G1 X92.478 Y78.747 E-0.13082

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.100 Y78.088

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y78.071 E0.06122

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y78.074 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.597 Y82.941

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y83.476 E0.01393

G1 X84.243 Y83.488 E0.21763

G1 X81.891 Y83.473 E0.06127

G1 X81.889 Y82.936 E0.01399

G1 X92.537 Y82.941 E0.27745

M204 S1250

G1 X92.852 Y82.541 F9000.000

M204 S800

G1 F1500.000

G1 X92.965 Y82.643 E0.00398

G1 X93.016 Y82.823 E0.00487

G1 X93.012 Y83.598 E0.02018

G1 X92.980 Y83.728 E0.00348

G1 X92.931 Y83.795 E0.00217

G1 X92.701 Y83.893 E0.00652

G1 X84.242 Y83.906 E0.22040

G1 X81.772 Y83.890 E0.06436

G1 X81.641 Y83.855 E0.00354

G1 X81.537 Y83.773 E0.00345

G1 X81.474 Y83.626 E0.00416

G1 X81.470 Y82.781 E0.02203

G1 X81.514 Y82.654 E0.00350

G1 X81.650 Y82.533 E0.00473

G1 X81.757 Y82.519 E0.00281

G1 X92.792 Y82.533 E0.28754

M204 S1250

G1 X92.857 Y82.694 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.965 Y82.643 E-0.11368

G1 X93.016 Y82.823 E-0.10364

G1 X93.012 Y83.598 E-0.42917

G1 X92.980 Y83.728 E-0.07407

G1 X92.931 Y83.795 E-0.04623

G1 X92.701 Y83.893 E-0.13866

G1 X92.689 Y83.893 E-0.00654

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.099 Y83.205

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y83.208 E0.08013

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y83.208 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.411 Y90.812

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y90.811 E0.00484

G1 X92.595 Y91.329 E0.01348

G1 X91.379 Y91.313 E0.03169

G1 X85.072 Y91.357 E0.16435

G1 X81.894 Y91.361 E0.08279

G1 X81.888 Y90.812 E0.01431

G1 X92.351 Y90.812 E0.27261

M204 S1250

G1 X92.986 Y90.573 F9000.000

M204 S800

G1 F1500.000

G1 X93.015 Y90.677 E0.00282

G1 X93.013 Y91.464 E0.02051

G1 X92.991 Y91.582 E0.00312

G1 X92.886 Y91.705 E0.00420

G1 X92.715 Y91.748 E0.00460

G1 X91.378 Y91.731 E0.03483

G1 X85.073 Y91.775 E0.16428

G1 X81.773 Y91.779 E0.08600

G1 X81.613 Y91.732 E0.00434

G1 X81.478 Y91.531 E0.00632

G1 X81.469 Y90.675 E0.02229

G1 X81.489 Y90.599 E0.00205

G1 X81.542 Y90.504 E0.00284

G1 X81.631 Y90.427 E0.00307

G1 X81.768 Y90.394 E0.00366

G1 X92.710 Y90.393 E0.28509

G1 X92.825 Y90.426 E0.00314

G1 X92.902 Y90.471 E0.00231

G1 X92.948 Y90.526 E0.00188

M204 S1250

G1 X92.926 Y90.662 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.015 Y90.677 E-0.09126

G1 X93.013 Y91.464 E-0.43625

G1 X92.991 Y91.582 E-0.06638

G1 X92.886 Y91.705 E-0.08942

G1 X92.715 Y91.748 E-0.09793

G1 X92.479 Y91.745 E-0.13076

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.100 Y91.086

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y91.069 E0.06122

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y91.072 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.597 Y95.939

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y96.474 E0.01393

G1 X84.243 Y96.486 E0.21762

G1 X81.891 Y96.470 E0.06128

G1 X81.889 Y95.934 E0.01398

G1 X92.537 Y95.939 E0.27745

M204 S1250

G1 X92.852 Y95.538 F9000.000

M204 S800

G1 F1500.000

G1 X92.965 Y95.641 E0.00399

G1 X93.016 Y95.821 E0.00488

G1 X93.012 Y96.596 E0.02018

G1 X92.980 Y96.725 E0.00348

G1 X92.930 Y96.793 E0.00218

G1 X92.701 Y96.891 E0.00652

G1 X84.242 Y96.904 E0.22040

G1 X81.771 Y96.887 E0.06437

G1 X81.641 Y96.853 E0.00352

G1 X81.537 Y96.770 E0.00346

G1 X81.474 Y96.624 E0.00415

G1 X81.470 Y95.779 E0.02203

G1 X81.514 Y95.651 E0.00351

G1 X81.650 Y95.531 E0.00472

G1 X81.757 Y95.516 E0.00282

G1 X92.792 Y95.530 E0.28754

M204 S1250

G1 X92.857 Y95.691 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.965 Y95.641 E-0.11372

G1 X93.016 Y95.821 E-0.10369

G1 X93.012 Y96.596 E-0.42915

G1 X92.980 Y96.725 E-0.07401

G1 X92.930 Y96.793 E-0.04635

G1 X92.701 Y96.891 E-0.13861

G1 X92.689 Y96.891 E-0.00647

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.099 Y96.203

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y96.206 E0.08013

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y96.206 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.411 Y103.810

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y103.809 E0.00484

G1 X92.595 Y104.327 E0.01348

G1 X91.379 Y104.311 E0.03169

G1 X85.072 Y104.355 E0.16435

G1 X81.894 Y104.359 E0.08279

G1 X81.888 Y103.809 E0.01431

G1 X92.351 Y103.810 E0.27261

M204 S1250

G1 X92.986 Y103.571 F9000.000

M204 S800

G1 F1500.000

G1 X93.015 Y103.675 E0.00282

G1 X93.013 Y104.462 E0.02049

G1 X92.991 Y104.580 E0.00314

G1 X92.885 Y104.703 E0.00422

G1 X92.715 Y104.746 E0.00459

G1 X91.378 Y104.729 E0.03483

G1 X85.073 Y104.773 E0.16428

G1 X81.773 Y104.777 E0.08600

G1 X81.613 Y104.730 E0.00434

G1 X81.478 Y104.528 E0.00633

G1 X81.469 Y103.673 E0.02227

G1 X81.489 Y103.597 E0.00206

G1 X81.542 Y103.502 E0.00285

G1 X81.631 Y103.425 E0.00305

G1 X81.768 Y103.391 E0.00368

G1 X92.710 Y103.391 E0.28509

G1 X92.825 Y103.424 E0.00314

G1 X92.902 Y103.469 E0.00231

G1 X92.948 Y103.524 E0.00188

M204 S1250

G1 X92.926 Y103.660 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.015 Y103.675 E-0.09126

G1 X93.013 Y104.462 E-0.43587

G1 X92.991 Y104.580 E-0.06670

G1 X92.885 Y104.703 E-0.08970

G1 X92.715 Y104.746 E-0.09763

G1 X92.478 Y104.743 E-0.13084

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.100 Y104.084

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y104.067 E0.06123

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y104.070 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.597 Y108.937

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y109.471 E0.01393

G1 X84.243 Y109.484 E0.21762

G1 X81.891 Y109.468 E0.06128

G1 X81.889 Y108.932 E0.01398

G1 X92.537 Y108.937 E0.27745

M204 S1250

G1 X92.852 Y108.536 F9000.000

M204 S800

G1 F1500.000

G1 X92.965 Y108.639 E0.00398

G1 X93.016 Y108.819 E0.00486

G1 X93.012 Y109.593 E0.02018

G1 X92.980 Y109.723 E0.00349

G1 X92.930 Y109.790 E0.00219

G1 X92.701 Y109.889 E0.00651

G1 X84.242 Y109.902 E0.22040

G1 X81.771 Y109.885 E0.06437

G1 X81.641 Y109.851 E0.00352

G1 X81.537 Y109.768 E0.00346

G1 X81.474 Y109.622 E0.00415

G1 X81.470 Y108.776 E0.02203

G1 X81.514 Y108.649 E0.00351

G1 X81.650 Y108.529 E0.00471

G1 X81.757 Y108.514 E0.00282

G1 X92.792 Y108.528 E0.28754

M204 S1250

G1 X92.857 Y108.689 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.965 Y108.639 E-0.11368

G1 X93.016 Y108.819 E-0.10347

G1 X93.012 Y109.593 E-0.42914

G1 X92.980 Y109.723 E-0.07418

G1 X92.930 Y109.790 E-0.04655

G1 X92.701 Y109.889 E-0.13856

G1 X92.689 Y109.889 E-0.00642

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.099 Y109.201

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y109.204 E0.08004

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y109.204 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X92.413 Y116.807

G1 Z6.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y116.806 E0.00479

G1 X92.595 Y117.325 E0.01351

G1 X91.379 Y117.309 E0.03169

G1 X85.072 Y117.353 E0.16435

G1 X81.894 Y117.357 E0.08279

G1 X81.888 Y116.807 E0.01431

G1 X92.353 Y116.807 E0.27265

M204 S1250

G1 X92.986 Y116.569 F9000.000

M204 S800

G1 F1500.000

G1 X93.015 Y116.673 E0.00282

G1 X93.013 Y117.460 E0.02049

G1 X92.991 Y117.578 E0.00314

G1 X92.885 Y117.701 E0.00422

G1 X92.715 Y117.744 E0.00459

G1 X91.378 Y117.727 E0.03483

G1 X85.073 Y117.771 E0.16428

G1 X81.773 Y117.774 E0.08599

G1 X81.613 Y117.728 E0.00435

G1 X81.478 Y117.526 E0.00633

G1 X81.469 Y116.671 E0.02227

G1 X81.489 Y116.595 E0.00206

G1 X81.542 Y116.500 E0.00285

G1 X81.631 Y116.423 E0.00305

G1 X81.768 Y116.389 E0.00368

G1 X92.709 Y116.388 E0.28508

G1 X92.825 Y116.422 E0.00314

G1 X92.902 Y116.467 E0.00233

G1 X92.948 Y116.522 E0.00189

M204 S1250

G1 X92.926 Y116.658 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.015 Y116.673 E-0.09126

G1 X93.013 Y117.460 E-0.43587

G1 X92.991 Y117.578 E-0.06670

G1 X92.885 Y117.701 E-0.08970

G1 X92.715 Y117.744 E-0.09763

G1 X92.478 Y117.741 E-0.13084

G1 E-0.04800 F4200.00000

G1 Z6.550 F9000.000

G1 X82.100 Y117.082

G1 Z6.350

G1 E3.20000 F2400.00000

G1 X92.387 Y117.064 E0.06180

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;6.5

G1 Z6.500 F9000.000

;AFTER\_LAYER\_CHANGE

;6.5

G1 X92.596 Y116.855

M204 S800

G1 F1500.000

G1 X92.595 Y117.362 E0.01322

G1 X91.799 Y117.351 E0.02073

G1 X86.274 Y117.387 E0.14396

G1 X81.899 Y117.380 E0.11400

G1 X81.899 Y116.862 E0.01351

G1 X92.536 Y116.855 E0.27714

M204 S1250

G1 X92.986 Y116.622 F9000.000

M204 S800

G1 F1500.000

G1 X93.014 Y116.712 E0.00245

G1 X93.013 Y117.491 E0.02029

G1 X92.990 Y117.617 E0.00335

G1 X92.876 Y117.751 E0.00459

G1 X92.715 Y117.781 E0.00428

G1 X91.798 Y117.769 E0.02388

G1 X86.275 Y117.805 E0.14390

G1 X81.713 Y117.798 E0.11888

G1 X81.609 Y117.756 E0.00291

G1 X81.481 Y117.569 E0.00590

G1 X81.482 Y116.691 E0.02288

G1 X81.559 Y116.532 E0.00460

G1 X81.616 Y116.491 E0.00184

G1 X81.774 Y116.444 E0.00428

G1 X92.709 Y116.437 E0.28493

G1 X92.896 Y116.506 E0.00521

G1 X92.949 Y116.575 E0.00225

M204 S1250

G1 X92.939 Y116.704 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.014 Y116.712 E-0.08417

G1 X93.013 Y117.491 E-0.43145

G1 X92.990 Y117.617 E-0.07133

G1 X92.876 Y117.751 E-0.09752

G1 X92.715 Y117.781 E-0.09096

G1 X92.468 Y117.778 E-0.13657

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.108 Y117.121

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.387 Y117.107 E0.05511

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y117.109 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.596 Y109.421

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.686 Y109.428 E0.25822

G1 X81.889 Y109.410 E0.02076

G1 X81.887 Y108.905 E0.01318

G1 X92.598 Y108.909 E0.27909

G1 X92.596 Y109.361 E0.01178

M204 S1250

G1 X92.988 Y109.660 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y109.739 E0.00270

G1 X92.720 Y109.839 E0.00586

G1 X82.681 Y109.846 E0.26157

G1 X81.773 Y109.826 E0.02368

G1 X81.615 Y109.784 E0.00425

G1 X81.544 Y109.731 E0.00230

G1 X81.472 Y109.562 E0.00480

G1 X81.468 Y108.766 E0.02073

G1 X81.519 Y108.607 E0.00436

G1 X81.626 Y108.511 E0.00375

G1 X81.698 Y108.487 E0.00198

G1 X92.730 Y108.492 E0.28746

G1 X92.854 Y108.504 E0.00323

G1 X92.909 Y108.540 E0.00173

G1 X92.976 Y108.626 E0.00285

G1 X93.007 Y108.711 E0.00234

G1 X93.002 Y109.601 E0.02321

M204 S1250

G1 X92.885 Y109.666 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y109.739 E-0.08852

G1 X92.720 Y109.839 E-0.12468

G1 X91.459 Y109.840 E-0.69880

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.097 Y109.160

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.388 Y109.165 E0.06742

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y109.164 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.451 Y104.362

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.274 Y104.389 E0.16093

G1 X81.899 Y104.382 E0.11400

G1 X81.899 Y103.864 E0.01351

G1 X92.596 Y103.858 E0.27870

G1 X92.595 Y104.364 E0.01319

G1 X92.511 Y104.363 E0.00220

M204 S1250

G1 X92.862 Y104.746 F9000.000

M204 S800

G1 F1500.000

G1 X92.715 Y104.783 E0.00397

G1 X91.798 Y104.771 E0.02388

G1 X86.275 Y104.807 E0.14390

G1 X81.712 Y104.800 E0.11889

G1 X81.609 Y104.759 E0.00290

G1 X81.481 Y104.571 E0.00591

G1 X81.482 Y103.693 E0.02289

G1 X81.559 Y103.534 E0.00460

G1 X81.616 Y103.493 E0.00184

G1 X81.774 Y103.446 E0.00428

G1 X92.709 Y103.440 E0.28494

G1 X92.897 Y103.508 E0.00520

G1 X92.986 Y103.624 E0.00381

G1 X93.014 Y103.714 E0.00245

G1 X93.013 Y104.493 E0.02029

G1 X92.990 Y104.619 E0.00335

G1 X92.905 Y104.719 E0.00343

M204 S1250

G1 X92.731 Y104.668 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.715 Y104.783 E-0.11124

G1 X91.798 Y104.771 E-0.50792

G1 X91.270 Y104.775 E-0.29284

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.108 Y104.123

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.387 Y104.109 E0.05450

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y104.112 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.596 Y96.424

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.686 Y96.431 E0.25822

M73 P65 R24

G1 X81.889 Y96.412 E0.02077

G1 X81.887 Y95.907 E0.01318

G1 X92.598 Y95.911 E0.27909

G1 X92.596 Y96.364 E0.01179

M204 S1250

G1 X92.988 Y96.662 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y96.742 E0.00270

G1 X92.719 Y96.842 E0.00588

G1 X82.681 Y96.849 E0.26156

G1 X81.773 Y96.828 E0.02367

G1 X81.615 Y96.786 E0.00425

G1 X81.544 Y96.734 E0.00229

G1 X81.472 Y96.564 E0.00480

G1 X81.468 Y95.769 E0.02071

G1 X81.519 Y95.609 E0.00438

G1 X81.626 Y95.513 E0.00374

G1 X81.698 Y95.489 E0.00198

G1 X92.730 Y95.494 E0.28745

G1 X92.854 Y95.506 E0.00325

G1 X92.909 Y95.542 E0.00172

G1 X92.976 Y95.629 E0.00285

G1 X93.007 Y95.713 E0.00233

G1 X93.002 Y96.604 E0.02322

M204 S1250

G1 X92.885 Y96.669 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y96.742 E-0.08848

G1 X92.719 Y96.842 E-0.12503

G1 X91.459 Y96.842 E-0.69849

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.097 Y96.162

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.388 Y96.167 E0.06777

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y96.167 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.451 Y91.364

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.274 Y91.391 E0.16093

G1 X81.899 Y91.384 E0.11400

G1 X81.899 Y90.866 E0.01351

G1 X92.596 Y90.860 E0.27870

G1 X92.595 Y91.366 E0.01319

G1 X92.511 Y91.365 E0.00220

M204 S1250

G1 X92.862 Y91.748 F9000.000

M204 S800

G1 F1500.000

G1 X92.715 Y91.785 E0.00397

G1 X91.798 Y91.773 E0.02388

G1 X86.275 Y91.809 E0.14390

G1 X81.712 Y91.802 E0.11889

G1 X81.609 Y91.760 E0.00290

G1 X81.481 Y91.574 E0.00589

G1 X81.482 Y90.695 E0.02290

G1 X81.559 Y90.537 E0.00460

G1 X81.617 Y90.495 E0.00186

G1 X81.774 Y90.448 E0.00427

G1 X92.709 Y90.442 E0.28494

G1 X92.897 Y90.510 E0.00520

G1 X92.986 Y90.626 E0.00381

G1 X93.014 Y90.716 E0.00245

G1 X93.013 Y91.495 E0.02030

G1 X92.990 Y91.622 E0.00334

G1 X92.905 Y91.722 E0.00343

M204 S1250

G1 X92.731 Y91.670 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.715 Y91.785 E-0.11117

G1 X91.798 Y91.773 E-0.50792

G1 X91.270 Y91.777 E-0.29291

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.108 Y91.125

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.387 Y91.111 E0.05450

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y91.114 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.596 Y83.426

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.686 Y83.433 E0.25823

G1 X81.889 Y83.415 E0.02076

G1 X81.887 Y82.909 E0.01320

G1 X92.598 Y82.913 E0.27909

G1 X92.596 Y83.366 E0.01179

M204 S1250

G1 X92.988 Y83.665 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y83.744 E0.00269

G1 X92.719 Y83.844 E0.00588

G1 X82.681 Y83.851 E0.26156

G1 X81.773 Y83.831 E0.02366

G1 X81.615 Y83.788 E0.00426

G1 X81.544 Y83.736 E0.00229

G1 X81.472 Y83.566 E0.00481

G1 X81.468 Y82.771 E0.02072

G1 X81.519 Y82.611 E0.00437

G1 X81.626 Y82.515 E0.00376

G1 X81.698 Y82.491 E0.00197

G1 X92.730 Y82.496 E0.28744

G1 X92.854 Y82.508 E0.00325

G1 X92.909 Y82.545 E0.00174

G1 X92.976 Y82.631 E0.00284

G1 X93.007 Y82.715 E0.00233

G1 X93.002 Y83.606 E0.02323

M204 S1250

G1 X92.885 Y83.671 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y83.744 E-0.08826

G1 X92.719 Y83.844 E-0.12512

G1 X91.459 Y83.844 E-0.69863

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.097 Y83.164

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.388 Y83.169 E0.06777

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y83.169 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.451 Y78.366

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.274 Y78.393 E0.16093

G1 X81.899 Y78.386 E0.11400

G1 X81.899 Y77.868 E0.01351

G1 X92.596 Y77.862 E0.27870

G1 X92.595 Y78.368 E0.01319

G1 X92.511 Y78.367 E0.00220

M204 S1250

G1 X92.862 Y78.750 F9000.000

M204 S800

G1 F1500.000

G1 X92.715 Y78.787 E0.00397

G1 X91.798 Y78.775 E0.02388

G1 X86.275 Y78.811 E0.14390

G1 X81.712 Y78.804 E0.11889

G1 X81.609 Y78.762 E0.00290

G1 X81.481 Y78.576 E0.00589

G1 X81.482 Y77.697 E0.02290

G1 X81.559 Y77.539 E0.00460

G1 X81.617 Y77.497 E0.00185

G1 X81.774 Y77.450 E0.00427

G1 X92.709 Y77.444 E0.28494

G1 X92.896 Y77.512 E0.00518

G1 X92.985 Y77.629 E0.00382

G1 X93.014 Y77.719 E0.00247

G1 X93.013 Y78.497 E0.02028

G1 X92.990 Y78.624 E0.00335

G1 X92.905 Y78.724 E0.00343

M204 S1250

G1 X92.731 Y78.672 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.715 Y78.787 E-0.11118

G1 X91.798 Y78.775 E-0.50793

G1 X91.270 Y78.779 E-0.29290

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.108 Y78.127

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.387 Y78.113 E0.05450

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y78.116 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.596 Y70.428

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.686 Y70.435 E0.25823

G1 X81.889 Y70.417 E0.02076

G1 X81.887 Y69.909 E0.01323

G1 X84.181 Y69.897 E0.05980

G1 X92.598 Y69.915 E0.21929

G1 X92.596 Y70.368 E0.01179

M204 S1250

G1 X92.988 Y70.667 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y70.746 E0.00269

G1 X92.719 Y70.846 E0.00588

G1 X82.681 Y70.853 E0.26156

G1 X81.773 Y70.833 E0.02366

G1 X81.615 Y70.790 E0.00426

G1 X81.544 Y70.738 E0.00229

G1 X81.472 Y70.568 E0.00481

G1 X81.468 Y69.773 E0.02071

G1 X81.519 Y69.613 E0.00437

G1 X81.626 Y69.517 E0.00377

G1 X81.698 Y69.493 E0.00198

G1 X84.181 Y69.479 E0.06468

G1 X92.730 Y69.498 E0.22275

G1 X92.854 Y69.510 E0.00325

G1 X92.909 Y69.547 E0.00174

G1 X92.976 Y69.633 E0.00284

G1 X93.007 Y69.717 E0.00233

G1 X93.002 Y70.608 E0.02323

M204 S1250

G1 X92.885 Y70.673 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y70.746 E-0.08831

G1 X92.719 Y70.846 E-0.12507

G1 X91.459 Y70.847 E-0.69863

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.097 Y70.165

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.388 Y70.172 E0.06755

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y70.170 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.450 Y65.369

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.274 Y65.396 E0.16092

G1 X81.899 Y65.389 E0.11400

G1 X81.899 Y64.870 E0.01353

G1 X92.596 Y64.864 E0.27870

G1 X92.595 Y65.370 E0.01321

G1 X92.510 Y65.369 E0.00221

M204 S1250

G1 X92.863 Y65.752 F9000.000

M204 S800

G1 F1500.000

G1 X92.714 Y65.790 E0.00398

G1 X91.798 Y65.778 E0.02388

G1 X86.275 Y65.814 E0.14390

G1 X81.713 Y65.807 E0.11888

G1 X81.609 Y65.765 E0.00291

G1 X81.481 Y65.578 E0.00590

G1 X81.482 Y64.700 E0.02289

G1 X81.559 Y64.541 E0.00461

G1 X81.617 Y64.499 E0.00185

G1 X81.774 Y64.452 E0.00426

G1 X92.709 Y64.446 E0.28493

G1 X92.896 Y64.515 E0.00521

G1 X92.986 Y64.631 E0.00382

G1 X93.014 Y64.721 E0.00245

G1 X93.013 Y65.499 E0.02028

G1 X92.990 Y65.626 E0.00335

G1 X92.905 Y65.725 E0.00342

M204 S1250

G1 X92.731 Y65.674 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.714 Y65.790 E-0.11154

G1 X91.798 Y65.778 E-0.50790

G1 X91.270 Y65.781 E-0.29256

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.108 Y65.130

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.387 Y65.116 E0.05495

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y65.118 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.596 Y57.430

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.686 Y57.437 E0.25823

G1 X81.889 Y57.419 E0.02076

G1 X81.887 Y56.911 E0.01323

G1 X84.181 Y56.899 E0.05980

G1 X92.598 Y56.917 E0.21929

G1 X92.596 Y57.370 E0.01179

M204 S1250

G1 X92.988 Y57.669 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y57.748 E0.00269

G1 X92.719 Y57.848 E0.00588

G1 X82.681 Y57.855 E0.26156

G1 X81.773 Y57.835 E0.02367

G1 X81.615 Y57.793 E0.00425

G1 X81.545 Y57.740 E0.00229

G1 X81.472 Y57.570 E0.00482

G1 X81.468 Y56.775 E0.02071

G1 X81.519 Y56.616 E0.00436

G1 X81.626 Y56.519 E0.00377

G1 X81.699 Y56.495 E0.00199

G1 X84.181 Y56.481 E0.06468

G1 X92.730 Y56.500 E0.22275

G1 X92.853 Y56.512 E0.00324

G1 X92.909 Y56.549 E0.00174

G1 X92.976 Y56.635 E0.00285

G1 X93.007 Y56.720 E0.00234

G1 X93.002 Y57.610 E0.02321

M204 S1250

G1 X92.885 Y57.675 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y57.748 E-0.08831

G1 X92.719 Y57.848 E-0.12507

G1 X91.459 Y57.849 E-0.69863

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.097 Y57.167

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.388 Y57.174 E0.06755

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y57.172 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.451 Y52.371

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.274 Y52.398 E0.16093

G1 X81.899 Y52.391 E0.11400

G1 X81.899 Y51.872 E0.01353

G1 X92.596 Y51.866 E0.27870

G1 X92.595 Y52.373 E0.01322

G1 X92.511 Y52.372 E0.00220

M204 S1250

G1 X92.862 Y52.755 F9000.000

M204 S800

G1 F1500.000

G1 X92.715 Y52.792 E0.00397

G1 X91.798 Y52.780 E0.02388

G1 X86.275 Y52.816 E0.14390

G1 X81.713 Y52.809 E0.11889

G1 X81.609 Y52.767 E0.00291

G1 X81.481 Y52.580 E0.00590

G1 X81.482 Y51.702 E0.02288

G1 X81.559 Y51.543 E0.00462

G1 X81.617 Y51.501 E0.00185

G1 X81.774 Y51.454 E0.00426

G1 X92.709 Y51.448 E0.28493

G1 X92.896 Y51.517 E0.00521

G1 X92.986 Y51.633 E0.00382

G1 X93.014 Y51.723 E0.00245

G1 X93.013 Y52.502 E0.02028

G1 X92.990 Y52.628 E0.00334

G1 X92.905 Y52.728 E0.00343

M204 S1250

G1 X92.731 Y52.677 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.715 Y52.792 E-0.11123

G1 X91.798 Y52.780 E-0.50792

G1 X91.270 Y52.784 E-0.29285

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.108 Y52.132

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.387 Y52.118 E0.05513

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y52.120 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X92.596 Y44.432

G1 Z6.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.686 Y44.439 E0.25822

G1 X81.889 Y44.421 E0.02076

G1 X81.887 Y43.914 E0.01322

G1 X84.181 Y43.901 E0.05980

G1 X92.598 Y43.920 E0.21929

G1 X92.596 Y44.372 E0.01178

M204 S1250

G1 X92.988 Y44.671 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y44.750 E0.00270

G1 X92.720 Y44.850 E0.00586

G1 X82.681 Y44.857 E0.26157

G1 X81.773 Y44.837 E0.02368

G1 X81.615 Y44.795 E0.00425

G1 X81.544 Y44.742 E0.00230

G1 X81.472 Y44.573 E0.00480

G1 X81.468 Y43.777 E0.02074

G1 X81.519 Y43.618 E0.00436

G1 X81.626 Y43.522 E0.00376

G1 X81.699 Y43.497 E0.00200

G1 X84.181 Y43.483 E0.06467

G1 X92.730 Y43.503 E0.22276

G1 X92.854 Y43.515 E0.00323

G1 X92.909 Y43.551 E0.00173

G1 X92.976 Y43.637 E0.00285

G1 X93.007 Y43.722 E0.00234

G1 X93.002 Y44.612 E0.02321

M204 S1250

G1 X92.885 Y44.677 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y44.750 E-0.08851

G1 X92.720 Y44.850 E-0.12468

G1 X91.459 Y44.851 E-0.69881

G1 E-0.04800 F4200.00000

G1 Z6.700 F9000.000

G1 X82.097 Y44.169

G1 Z6.500

G1 E3.20000 F2400.00000

G1 X92.388 Y44.176 E0.06743

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;6.65

G1 Z6.650 F9000.000

;AFTER\_LAYER\_CHANGE

;6.65

G1 E-3.20000 F4200.00000

G1 Z6.850 F9000.000

G1 X92.428 Y116.903

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y116.903 E0.00436

G1 X92.595 Y117.401 E0.01298

G1 X88.173 Y117.415 E0.11522

G1 X81.897 Y117.402 E0.16352

G1 X81.894 Y116.901 E0.01306

G1 X92.368 Y116.903 E0.27292

M204 S1250

G1 X92.893 Y116.543 F9000.000

M204 S800

G1 F1500.000

G1 X92.987 Y116.669 E0.00410

G1 X93.013 Y116.748 E0.00215

G1 X93.013 Y117.521 E0.02015

G1 X92.990 Y117.651 E0.00345

G1 X92.885 Y117.780 E0.00434

G1 X92.713 Y117.819 E0.00459

G1 X88.173 Y117.833 E0.11828

G1 X81.685 Y117.819 E0.16906

G1 X81.597 Y117.777 E0.00255

G1 X81.481 Y117.599 E0.00553

G1 X81.475 Y116.783 E0.02126

G1 X81.563 Y116.561 E0.00624

G1 X81.607 Y116.529 E0.00141

G1 X81.769 Y116.483 E0.00438

G1 X92.707 Y116.485 E0.28499

G1 X92.836 Y116.526 E0.00352

M204 S1250

G1 X92.878 Y116.700 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.987 Y116.669 E-0.11578

G1 X93.013 Y116.748 E-0.04563

G1 X93.013 Y117.521 E-0.42853

G1 X92.990 Y117.651 E-0.07342

G1 X92.885 Y117.780 E-0.09221

G1 X92.713 Y117.819 E-0.09771

G1 X92.607 Y117.819 E-0.05872

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.104 Y117.152

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.386 Y117.153 E0.05849

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y117.153 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.597 Y109.371

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y109.368 E0.27902

G1 X81.885 Y108.860 E0.01324

G1 X92.598 Y108.893 E0.27914

G1 X92.597 Y109.311 E0.01091

M204 S1250

G1 X92.929 Y109.695 F9000.000

M204 S800

G1 F1500.000

G1 X92.794 Y109.775 E0.00410

G1 X92.720 Y109.789 E0.00196

G1 X81.769 Y109.784 E0.28534

G1 X81.623 Y109.750 E0.00390

G1 X81.551 Y109.696 E0.00234

G1 X81.471 Y109.519 E0.00507

G1 X81.466 Y108.757 E0.01985

G1 X81.529 Y108.561 E0.00537

G1 X81.588 Y108.507 E0.00208

G1 X81.778 Y108.442 E0.00523

G1 X92.849 Y108.476 E0.28845

G1 X92.906 Y108.509 E0.00172

G1 X92.998 Y108.649 E0.00436

G1 X93.016 Y108.751 E0.00271

G1 X93.014 Y109.526 E0.02020

G1 X92.965 Y109.647 E0.00339

M204 S1250

G1 X92.775 Y109.664 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.794 Y109.775 E-0.11854

G1 X92.720 Y109.789 E-0.04167

G1 X91.363 Y109.789 E-0.75179

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.095 Y109.117

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.388 Y109.132 E0.05463

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y109.129 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.595 Y104.403

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.173 Y104.417 E0.11522

G1 X81.897 Y104.404 E0.16352

G1 X81.894 Y103.903 E0.01306

G1 X92.595 Y103.906 E0.27884

G1 X92.595 Y104.343 E0.01139

M204 S1250

G1 X92.885 Y104.782 F9000.000

M204 S800

G1 F1500.000

G1 X92.713 Y104.821 E0.00459

G1 X88.173 Y104.835 E0.11828

G1 X81.685 Y104.821 E0.16907

G1 X81.596 Y104.779 E0.00255

G1 X81.481 Y104.602 E0.00552

G1 X81.475 Y103.785 E0.02127

G1 X81.563 Y103.563 E0.00624

G1 X81.607 Y103.531 E0.00141

G1 X81.769 Y103.485 E0.00439

G1 X92.707 Y103.488 E0.28500

G1 X92.922 Y103.569 E0.00597

G1 X93.013 Y103.750 E0.00528

G1 X93.013 Y104.523 E0.02015

G1 X92.990 Y104.653 E0.00345

G1 X92.923 Y104.736 E0.00277

M204 S1250

G1 X92.733 Y104.693 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.713 Y104.821 E-0.12551

G1 X91.294 Y104.825 E-0.78649

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.104 Y104.154

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.386 Y104.155 E0.05833

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y104.155 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.597 Y96.374

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y96.371 E0.27902

G1 X81.885 Y95.862 E0.01325

G1 X92.598 Y95.896 E0.27914

G1 X92.597 Y96.314 E0.01091

M204 S1250

G1 X92.929 Y96.698 F9000.000

M204 S800

G1 F1500.000

G1 X92.794 Y96.778 E0.00410

G1 X92.719 Y96.792 E0.00197

G1 X81.770 Y96.786 E0.28531

G1 X81.623 Y96.752 E0.00391

G1 X81.551 Y96.699 E0.00234

G1 X81.471 Y96.521 E0.00508

G1 X81.466 Y95.760 E0.01983

G1 X81.529 Y95.563 E0.00539

G1 X81.588 Y95.509 E0.00208

G1 X81.778 Y95.444 E0.00523

G1 X92.849 Y95.479 E0.28847

G1 X92.906 Y95.511 E0.00171

G1 X92.998 Y95.651 E0.00435

G1 X93.016 Y95.754 E0.00273

G1 X93.014 Y96.529 E0.02020

G1 X92.965 Y96.650 E0.00339

M204 S1250

G1 X92.775 Y96.667 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.794 Y96.778 E-0.11854

G1 X92.719 Y96.792 E-0.04195

G1 X91.363 Y96.791 E-0.75151

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.095 Y96.119

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.388 Y96.134 E0.05515

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y96.132 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.595 Y91.405

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.173 Y91.419 E0.11522

G1 X81.897 Y91.406 E0.16352

G1 X81.894 Y90.905 E0.01306

G1 X92.595 Y90.908 E0.27884

G1 X92.595 Y91.345 E0.01139

M204 S1250

G1 X92.867 Y91.799 F9000.000

M204 S800

G1 F1500.000

G1 X92.713 Y91.823 E0.00407

G1 X88.173 Y91.837 E0.11828

G1 X81.685 Y91.823 E0.16907

G1 X81.596 Y91.781 E0.00255

G1 X81.481 Y91.604 E0.00551

G1 X81.475 Y90.787 E0.02128

G1 X81.563 Y90.565 E0.00623

G1 X81.608 Y90.533 E0.00143

G1 X81.769 Y90.487 E0.00437

G1 X92.707 Y90.490 E0.28500

G1 X92.922 Y90.571 E0.00597

G1 X93.013 Y90.752 E0.00528

G1 X93.013 Y91.525 E0.02016

G1 X92.990 Y91.653 E0.00338

G1 X92.906 Y91.753 E0.00341

M204 S1250

G1 X92.737 Y91.713 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.713 Y91.823 E-0.11378

G1 X91.272 Y91.827 E-0.79822

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.104 Y91.156

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.386 Y91.157 E0.05833

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y91.157 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.597 Y83.376

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y83.373 E0.27902

G1 X81.885 Y82.864 E0.01326

G1 X92.598 Y82.898 E0.27914

G1 X92.597 Y83.316 E0.01091

M204 S1250

G1 X92.929 Y83.700 F9000.000

M204 S800

G1 F1500.000

G1 X92.794 Y83.780 E0.00410

G1 X92.719 Y83.794 E0.00197

G1 X81.770 Y83.789 E0.28531

G1 X81.623 Y83.754 E0.00392

G1 X81.551 Y83.701 E0.00234

G1 X81.471 Y83.524 E0.00507

G1 X81.466 Y82.762 E0.01984

G1 X81.529 Y82.565 E0.00539

G1 X81.588 Y82.511 E0.00208

G1 X81.778 Y82.446 E0.00523

G1 X92.849 Y82.481 E0.28845

G1 X92.906 Y82.514 E0.00172

G1 X92.998 Y82.653 E0.00434

G1 X93.016 Y82.756 E0.00273

G1 X93.014 Y83.531 E0.02019

G1 X92.965 Y83.652 E0.00339

M204 S1250

G1 X92.775 Y83.669 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.794 Y83.780 E-0.11859

G1 X92.719 Y83.794 E-0.04199

G1 X91.364 Y83.793 E-0.75143

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.095 Y83.121

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.388 Y83.136 E0.05515

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y83.134 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.595 Y78.407

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.173 Y78.422 E0.11522

G1 X81.897 Y78.408 E0.16352

G1 X81.894 Y77.907 E0.01306

G1 X92.595 Y77.910 E0.27884

G1 X92.595 Y78.347 E0.01139

M204 S1250

G1 X92.867 Y78.801 F9000.000

M204 S800

G1 F1500.000

G1 X92.713 Y78.825 E0.00408

G1 X88.173 Y78.839 E0.11828

G1 X81.685 Y78.825 E0.16907

G1 X81.596 Y78.783 E0.00255

G1 X81.481 Y78.606 E0.00551

G1 X81.475 Y77.789 E0.02128

G1 X81.563 Y77.567 E0.00623

G1 X81.608 Y77.535 E0.00143

G1 X81.769 Y77.489 E0.00437

G1 X92.707 Y77.492 E0.28500

G1 X92.922 Y77.573 E0.00597

G1 X93.013 Y77.754 E0.00528

G1 X93.013 Y78.527 E0.02014

G1 X92.990 Y78.656 E0.00340

G1 X92.906 Y78.755 E0.00339

M204 S1250

G1 X92.737 Y78.715 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.713 Y78.825 E-0.11396

G1 X91.273 Y78.829 E-0.79804

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.104 Y78.158

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.386 Y78.159 E0.05885

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y78.159 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.597 Y70.378

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y70.375 E0.27902

G1 X81.885 Y69.866 E0.01326

G1 X92.598 Y69.900 E0.27914

G1 X92.597 Y70.318 E0.01091

M204 S1250

G1 X92.929 Y70.702 F9000.000

M204 S800

G1 F1500.000

G1 X92.794 Y70.782 E0.00410

G1 X92.719 Y70.796 E0.00197

G1 X81.770 Y70.791 E0.28531

G1 X81.623 Y70.756 E0.00392

G1 X81.551 Y70.703 E0.00234

G1 X81.471 Y70.526 E0.00507

G1 X81.466 Y69.764 E0.01983

G1 X81.529 Y69.568 E0.00538

G1 X81.588 Y69.513 E0.00210

G1 X81.778 Y69.448 E0.00522

G1 X92.849 Y69.483 E0.28845

G1 X92.906 Y69.516 E0.00172

G1 X92.998 Y69.655 E0.00434

G1 X93.016 Y69.758 E0.00273

G1 X93.014 Y70.533 E0.02019

G1 X92.965 Y70.654 E0.00339

M204 S1250

G1 X92.775 Y70.671 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.794 Y70.782 E-0.11859

G1 X92.719 Y70.796 E-0.04199

G1 X91.364 Y70.795 E-0.75143

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.095 Y70.123

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.388 Y70.138 E0.05476

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y70.136 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.595 Y65.410

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.173 Y65.424 E0.11522

G1 X81.897 Y65.411 E0.16352

G1 X81.894 Y64.909 E0.01307

G1 X92.595 Y64.912 E0.27884

G1 X92.595 Y65.350 E0.01141

M204 S1250

G1 X92.885 Y65.789 F9000.000

M204 S800

G1 F1500.000

G1 X92.713 Y65.828 E0.00459

G1 X88.173 Y65.842 E0.11828

G1 X81.685 Y65.828 E0.16905

G1 X81.597 Y65.786 E0.00256

G1 X81.481 Y65.608 E0.00553

G1 X81.475 Y64.792 E0.02126

G1 X81.563 Y64.569 E0.00625

G1 X81.608 Y64.537 E0.00143

G1 X81.769 Y64.491 E0.00436

G1 X92.707 Y64.494 E0.28501

G1 X92.922 Y64.576 E0.00598

G1 X93.013 Y64.757 E0.00528

G1 X93.013 Y65.529 E0.02014

G1 X92.990 Y65.660 E0.00346

G1 X92.923 Y65.743 E0.00277

M204 S1250

G1 X92.733 Y65.700 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.713 Y65.828 E-0.12550

G1 X91.293 Y65.832 E-0.78650

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.104 Y65.160

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.386 Y65.162 E0.05884

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y65.161 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.597 Y57.380

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y57.377 E0.27902

G1 X81.885 Y56.868 E0.01326

G1 X92.598 Y56.902 E0.27914

G1 X92.597 Y57.320 E0.01091

M204 S1250

G1 X92.929 Y57.704 F9000.000

M204 S800

G1 F1500.000

G1 X92.794 Y57.784 E0.00410

G1 X92.719 Y57.798 E0.00197

G1 X81.769 Y57.793 E0.28532

G1 X81.623 Y57.759 E0.00390

G1 X81.551 Y57.706 E0.00234

G1 X81.471 Y57.528 E0.00509

G1 X81.466 Y56.766 E0.01983

G1 X81.529 Y56.570 E0.00537

G1 X81.588 Y56.515 E0.00209

G1 X81.778 Y56.450 E0.00523

G1 X92.848 Y56.485 E0.28845

G1 X92.906 Y56.518 E0.00172

G1 X92.998 Y56.658 E0.00436

G1 X93.016 Y56.760 E0.00271

G1 X93.014 Y57.535 E0.02019

G1 X92.965 Y57.656 E0.00339

M204 S1250

G1 X92.775 Y57.673 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.794 Y57.784 E-0.11859

G1 X92.719 Y57.798 E-0.04199

G1 X91.364 Y57.797 E-0.75143

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.095 Y57.125

G1 Z6.650

G1 E3.20000 F2400.00000

M73 P66 R23

G1 X92.388 Y57.140 E0.05476

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y57.138 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.595 Y52.412

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.173 Y52.426 E0.11522

G1 X81.897 Y52.413 E0.16352

G1 X81.894 Y51.911 E0.01307

G1 X92.595 Y51.914 E0.27884

G1 X92.595 Y52.352 E0.01142

M204 S1250

G1 X92.885 Y52.791 F9000.000

M204 S800

G1 F1500.000

G1 X92.713 Y52.830 E0.00459

G1 X88.173 Y52.844 E0.11828

G1 X81.685 Y52.830 E0.16906

G1 X81.597 Y52.788 E0.00255

G1 X81.481 Y52.610 E0.00553

G1 X81.475 Y51.795 E0.02126

G1 X81.563 Y51.572 E0.00624

G1 X81.608 Y51.539 E0.00143

G1 X81.769 Y51.493 E0.00438

G1 X92.707 Y51.496 E0.28498

G1 X92.922 Y51.578 E0.00599

G1 X93.013 Y51.759 E0.00527

G1 X93.013 Y52.532 E0.02015

G1 X92.990 Y52.662 E0.00345

G1 X92.923 Y52.745 E0.00277

M204 S1250

G1 X92.733 Y52.702 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.713 Y52.830 E-0.12551

G1 X91.294 Y52.834 E-0.78649

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.104 Y52.162

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.386 Y52.164 E0.05849

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.741 Y52.164 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X92.597 Y44.382

G1 Z6.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y44.379 E0.27902

G1 X81.885 Y43.871 E0.01326

G1 X92.598 Y43.904 E0.27914

G1 X92.597 Y44.322 E0.01091

M204 S1250

G1 X92.929 Y44.706 F9000.000

M204 S800

G1 F1500.000

G1 X92.794 Y44.786 E0.00410

G1 X92.720 Y44.800 E0.00196

G1 X81.769 Y44.795 E0.28534

G1 X81.623 Y44.761 E0.00390

G1 X81.551 Y44.707 E0.00234

G1 X81.471 Y44.530 E0.00507

G1 X81.466 Y43.768 E0.01985

G1 X81.529 Y43.572 E0.00537

G1 X81.588 Y43.518 E0.00209

G1 X81.778 Y43.453 E0.00524

G1 X92.849 Y43.487 E0.28844

G1 X92.906 Y43.520 E0.00172

G1 X92.998 Y43.660 E0.00436

G1 X93.016 Y43.762 E0.00271

G1 X93.014 Y44.537 E0.02019

G1 X92.965 Y44.658 E0.00340

M204 S1250

G1 X92.775 Y44.675 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.794 Y44.786 E-0.11854

G1 X92.720 Y44.800 E-0.04167

G1 X91.363 Y44.800 E-0.75179

G1 E-0.04800 F4200.00000

G1 Z6.850 F9000.000

G1 X82.095 Y44.127

G1 Z6.650

G1 E3.20000 F2400.00000

G1 X92.388 Y44.143 E0.05463

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;6.8

G1 Z6.800 F9000.000

;AFTER\_LAYER\_CHANGE

;6.8

G1 X92.597 Y44.338

M204 S800

G1 F1500.000

G1 X81.890 Y44.338 E0.27899

G1 X81.892 Y43.851 E0.01270

G1 X92.598 Y43.873 E0.27894

G1 X92.597 Y44.278 E0.01057

M204 S1250

G1 X92.843 Y44.729 F9000.000

M204 S800

G1 F1500.000

G1 X92.717 Y44.756 E0.00337

G1 X81.764 Y44.755 E0.28538

G1 X81.633 Y44.728 E0.00349

G1 X81.558 Y44.673 E0.00243

G1 X81.471 Y44.489 E0.00531

G1 X81.475 Y43.714 E0.02019

G1 X81.552 Y43.512 E0.00563

G1 X81.771 Y43.433 E0.00607

G1 X92.801 Y43.456 E0.28740

G1 X92.921 Y43.512 E0.00345

G1 X92.987 Y43.607 E0.00300

G1 X93.016 Y43.739 E0.00353

G1 X93.014 Y44.508 E0.02004

G1 X93.000 Y44.565 E0.00154

G1 X92.895 Y44.699 E0.00442

M204 S1250

G1 X92.737 Y44.656 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.717 Y44.756 E-0.10382

G1 X91.259 Y44.756 E-0.80818

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.100 Y44.094

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X91.322 Y44.104 E0.04516

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.677 Y44.102 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.595 Y51.960

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y52.450 E0.01277

G1 X81.895 Y52.432 E0.27878

G1 X81.901 Y51.950 E0.01256

G1 X92.535 Y51.960 E0.27708

M204 S1250

G1 X92.889 Y51.588 F9000.000

M204 S800

G1 F1500.000

G1 X92.925 Y51.612 E0.00111

G1 X93.013 Y51.790 E0.00516

G1 X93.013 Y52.562 E0.02012

G1 X92.991 Y52.687 E0.00330

G1 X92.932 Y52.778 E0.00283

G1 X92.846 Y52.834 E0.00267

G1 X92.727 Y52.868 E0.00322

G1 X81.675 Y52.850 E0.28798

G1 X81.586 Y52.813 E0.00250

G1 X81.480 Y52.641 E0.00526

G1 X81.469 Y51.803 E0.02184

G1 X81.539 Y51.727 E0.00268

G1 X81.591 Y51.582 E0.00402

G1 X81.770 Y51.532 E0.00484

G1 X92.712 Y51.542 E0.28510

G1 X92.831 Y51.573 E0.00320

M204 S1250

G1 X92.895 Y51.630 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y51.612 E-0.05609

G1 X93.013 Y51.790 E-0.10984

G1 X93.013 Y52.562 E-0.42800

G1 X92.991 Y52.687 E-0.07024

G1 X92.932 Y52.778 E-0.06028

G1 X92.846 Y52.834 E-0.05671

G1 X92.727 Y52.868 E-0.06858

G1 X92.615 Y52.868 E-0.06225

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.101 Y52.192

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X92.386 Y52.205 E0.04616

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y52.203 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.598 Y56.870

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y57.336 E0.01215

G1 X81.890 Y57.336 E0.27899

G1 X81.892 Y56.848 E0.01271

G1 X92.538 Y56.870 E0.27738

M204 S1250

G1 X92.921 Y56.510 F9000.000

M204 S800

G1 F1500.000

G1 X92.987 Y56.605 E0.00301

G1 X93.016 Y56.737 E0.00353

G1 X93.014 Y57.506 E0.02004

G1 X93.000 Y57.563 E0.00154

G1 X92.912 Y57.687 E0.00397

G1 X92.844 Y57.726 E0.00204

G1 X92.717 Y57.754 E0.00339

G1 X81.764 Y57.753 E0.28537

G1 X81.633 Y57.726 E0.00349

G1 X81.558 Y57.671 E0.00243

G1 X81.471 Y57.486 E0.00532

G1 X81.475 Y56.712 E0.02018

G1 X81.552 Y56.510 E0.00564

G1 X81.772 Y56.430 E0.00608

G1 X92.801 Y56.453 E0.28738

G1 X92.867 Y56.484 E0.00190

M204 S1250

G1 X92.907 Y56.625 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.987 Y56.605 E-0.09436

G1 X93.016 Y56.737 E-0.07504

G1 X93.014 Y57.506 E-0.42620

G1 X93.000 Y57.563 E-0.03274

G1 X92.912 Y57.687 E-0.08436

G1 X92.844 Y57.726 E-0.04348

G1 X92.717 Y57.754 E-0.07207

G1 X92.565 Y57.754 E-0.08375

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.100 Y57.092

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X91.377 Y57.102 E0.04522

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.731 Y57.100 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.595 Y64.958

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y65.448 E0.01277

G1 X81.895 Y65.430 E0.27878

G1 X81.900 Y64.948 E0.01256

G1 X92.535 Y64.958 E0.27710

M204 S1250

G1 X92.889 Y64.585 F9000.000

M204 S800

G1 F1500.000

G1 X92.924 Y64.609 E0.00111

G1 X93.013 Y64.788 E0.00518

G1 X93.013 Y65.559 E0.02011

G1 X92.991 Y65.685 E0.00332

G1 X92.932 Y65.776 E0.00283

G1 X92.846 Y65.832 E0.00267

G1 X92.727 Y65.866 E0.00323

G1 X81.675 Y65.848 E0.28797

G1 X81.586 Y65.811 E0.00250

G1 X81.480 Y65.639 E0.00526

G1 X81.469 Y64.801 E0.02184

G1 X81.539 Y64.724 E0.00269

G1 X81.592 Y64.580 E0.00402

G1 X81.770 Y64.530 E0.00483

G1 X92.713 Y64.540 E0.28512

G1 X92.831 Y64.571 E0.00319

M204 S1250

G1 X92.895 Y64.628 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.924 Y64.609 E-0.05595

G1 X93.013 Y64.788 E-0.11022

G1 X93.013 Y65.559 E-0.42771

G1 X92.991 Y65.685 E-0.07057

G1 X92.932 Y65.776 E-0.06012

G1 X92.846 Y65.832 E-0.05672

G1 X92.727 Y65.866 E-0.06877

G1 X92.615 Y65.866 E-0.06194

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.101 Y65.190

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X92.386 Y65.203 E0.04619

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y65.201 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.598 Y69.868

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y70.334 E0.01215

G1 X81.890 Y70.334 E0.27899

G1 X81.892 Y69.846 E0.01271

G1 X92.538 Y69.868 E0.27738

M204 S1250

G1 X92.921 Y69.508 F9000.000

M204 S800

G1 F1500.000

G1 X92.987 Y69.602 E0.00298

G1 X93.016 Y69.735 E0.00355

G1 X93.014 Y70.504 E0.02004

G1 X93.000 Y70.561 E0.00154

G1 X92.912 Y70.685 E0.00397

G1 X92.844 Y70.724 E0.00204

G1 X92.717 Y70.752 E0.00339

G1 X81.765 Y70.751 E0.28535

G1 X81.633 Y70.724 E0.00351

G1 X81.558 Y70.668 E0.00243

G1 X81.471 Y70.484 E0.00530

G1 X81.475 Y69.710 E0.02018

G1 X81.552 Y69.507 E0.00566

G1 X81.772 Y69.428 E0.00607

G1 X92.801 Y69.451 E0.28738

G1 X92.867 Y69.483 E0.00190

M204 S1250

G1 X92.908 Y69.622 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.987 Y69.602 E-0.09388

G1 X93.016 Y69.735 E-0.07541

G1 X93.014 Y70.504 E-0.42626

G1 X93.000 Y70.561 E-0.03274

G1 X92.912 Y70.685 E-0.08436

G1 X92.844 Y70.724 E-0.04348

G1 X92.717 Y70.752 E-0.07207

G1 X92.565 Y70.752 E-0.08380

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.100 Y70.090

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X91.377 Y70.100 E0.04522

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.732 Y70.098 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.595 Y77.956

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y78.445 E0.01274

G1 X81.895 Y78.427 E0.27878

G1 X81.900 Y77.946 E0.01255

G1 X92.535 Y77.956 E0.27709

M204 S1250

G1 X92.889 Y77.583 F9000.000

M204 S800

G1 F1500.000

G1 X92.924 Y77.607 E0.00111

G1 X93.013 Y77.786 E0.00519

G1 X93.013 Y78.557 E0.02011

G1 X92.991 Y78.683 E0.00331

G1 X92.932 Y78.773 E0.00282

G1 X92.846 Y78.830 E0.00267

G1 X92.727 Y78.863 E0.00322

G1 X81.674 Y78.845 E0.28801

G1 X81.586 Y78.809 E0.00247

G1 X81.480 Y78.637 E0.00526

G1 X81.469 Y77.798 E0.02187

G1 X81.539 Y77.722 E0.00267

G1 X81.591 Y77.578 E0.00401

G1 X81.771 Y77.528 E0.00484

G1 X92.713 Y77.538 E0.28511

G1 X92.831 Y77.568 E0.00318

M204 S1250

G1 X92.895 Y77.625 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.924 Y77.607 E-0.05596

G1 X93.013 Y77.786 E-0.11033

G1 X93.013 Y78.557 E-0.42771

G1 X92.991 Y78.683 E-0.07043

G1 X92.932 Y78.773 E-0.05999

G1 X92.846 Y78.830 E-0.05677

G1 X92.727 Y78.863 E-0.06839

G1 X92.615 Y78.863 E-0.06243

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.101 Y78.187

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X92.386 Y78.200 E0.04554

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y78.198 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.598 Y82.866

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y83.332 E0.01215

G1 X81.890 Y83.332 E0.27899

G1 X81.892 Y82.844 E0.01271

G1 X92.538 Y82.866 E0.27738

M204 S1250

G1 X92.921 Y82.506 F9000.000

M204 S800

G1 F1500.000

G1 X92.987 Y82.600 E0.00298

G1 X93.016 Y82.733 E0.00355

G1 X93.014 Y83.502 E0.02004

G1 X93.000 Y83.559 E0.00154

G1 X92.912 Y83.683 E0.00397

G1 X92.844 Y83.722 E0.00204

G1 X92.717 Y83.750 E0.00339

G1 X81.765 Y83.749 E0.28535

G1 X81.633 Y83.722 E0.00351

G1 X81.558 Y83.666 E0.00243

G1 X81.471 Y83.482 E0.00530

G1 X81.475 Y82.708 E0.02019

G1 X81.552 Y82.505 E0.00564

G1 X81.772 Y82.426 E0.00609

G1 X92.801 Y82.449 E0.28738

G1 X92.867 Y82.481 E0.00190

M204 S1250

G1 X92.908 Y82.620 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.987 Y82.600 E-0.09388

G1 X93.016 Y82.733 E-0.07541

G1 X93.014 Y83.502 E-0.42626

G1 X93.000 Y83.559 E-0.03274

G1 X92.912 Y83.683 E-0.08436

G1 X92.844 Y83.722 E-0.04348

G1 X92.717 Y83.750 E-0.07207

G1 X92.565 Y83.750 E-0.08380

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.100 Y83.088

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X91.419 Y83.098 E0.04594

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.773 Y83.096 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.595 Y90.954

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y91.443 E0.01274

G1 X81.895 Y91.425 E0.27878

G1 X81.900 Y90.944 E0.01255

G1 X92.535 Y90.954 E0.27709

M204 S1250

G1 X92.890 Y90.581 F9000.000

M204 S800

G1 F1500.000

G1 X92.924 Y90.605 E0.00109

G1 X93.013 Y90.783 E0.00518

G1 X93.013 Y91.555 E0.02013

G1 X92.991 Y91.680 E0.00331

G1 X92.932 Y91.771 E0.00283

G1 X92.846 Y91.828 E0.00267

G1 X92.727 Y91.861 E0.00322

G1 X81.674 Y91.843 E0.28801

G1 X81.586 Y91.807 E0.00247

G1 X81.480 Y91.635 E0.00526

G1 X81.469 Y90.796 E0.02187

G1 X81.539 Y90.720 E0.00267

G1 X81.591 Y90.576 E0.00401

G1 X81.771 Y90.526 E0.00484

G1 X92.713 Y90.536 E0.28511

G1 X92.832 Y90.567 E0.00319

M204 S1250

G1 X92.895 Y90.623 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.924 Y90.605 E-0.05567

G1 X93.013 Y90.783 E-0.11011

G1 X93.013 Y91.555 E-0.42809

G1 X92.991 Y91.680 E-0.07031

G1 X92.932 Y91.771 E-0.06016

G1 X92.846 Y91.828 E-0.05672

G1 X92.727 Y91.861 E-0.06839

G1 X92.615 Y91.861 E-0.06255

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.101 Y91.185

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X92.386 Y91.198 E0.04554

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y91.196 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.598 Y95.864

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y96.330 E0.01215

G1 X81.890 Y96.330 E0.27899

G1 X81.892 Y95.842 E0.01271

G1 X92.538 Y95.864 E0.27738

M204 S1250

G1 X92.921 Y95.504 F9000.000

M204 S800

G1 F1500.000

G1 X92.987 Y95.598 E0.00299

G1 X93.016 Y95.730 E0.00353

G1 X93.014 Y96.500 E0.02005

G1 X93.000 Y96.557 E0.00152

G1 X92.912 Y96.681 E0.00398

G1 X92.843 Y96.720 E0.00205

G1 X92.716 Y96.748 E0.00338

G1 X81.765 Y96.747 E0.28535

G1 X81.633 Y96.720 E0.00351

G1 X81.558 Y96.664 E0.00242

G1 X81.471 Y96.480 E0.00532

G1 X81.475 Y95.706 E0.02017

G1 X81.552 Y95.503 E0.00564

G1 X81.772 Y95.424 E0.00609

G1 X92.801 Y95.447 E0.28739

G1 X92.867 Y95.478 E0.00189

M204 S1250

G1 X92.908 Y95.618 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.987 Y95.598 E-0.09404

G1 X93.016 Y95.730 E-0.07518

G1 X93.014 Y96.500 E-0.42651

G1 X93.000 Y96.557 E-0.03237

G1 X92.912 Y96.681 E-0.08472

G1 X92.843 Y96.720 E-0.04356

G1 X92.716 Y96.748 E-0.07196

G1 X92.566 Y96.748 E-0.08365

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.100 Y96.086

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X91.400 Y96.096 E0.04560

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.754 Y96.094 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.595 Y103.952

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y104.441 E0.01275

G1 X81.895 Y104.423 E0.27878

G1 X81.900 Y103.942 E0.01255

G1 X92.535 Y103.952 E0.27709

M204 S1250

G1 X92.890 Y103.579 F9000.000

M204 S800

G1 F1500.000

G1 X92.924 Y103.603 E0.00109

G1 X93.013 Y103.781 E0.00518

G1 X93.013 Y104.553 E0.02012

G1 X92.991 Y104.678 E0.00330

G1 X92.932 Y104.769 E0.00283

G1 X92.846 Y104.825 E0.00267

G1 X92.727 Y104.859 E0.00322

G1 X81.674 Y104.841 E0.28800

G1 X81.586 Y104.805 E0.00247

G1 X81.480 Y104.633 E0.00526

G1 X81.469 Y103.794 E0.02186

G1 X81.539 Y103.718 E0.00267

G1 X81.592 Y103.573 E0.00402

G1 X81.771 Y103.524 E0.00484

G1 X92.713 Y103.534 E0.28511

G1 X92.832 Y103.564 E0.00319

M204 S1250

G1 X92.895 Y103.621 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.924 Y103.603 E-0.05568

G1 X93.013 Y103.781 E-0.11011

G1 X93.013 Y104.553 E-0.42785

G1 X92.991 Y104.678 E-0.07025

G1 X92.932 Y104.769 E-0.06028

G1 X92.846 Y104.825 E-0.05671

G1 X92.727 Y104.859 E-0.06858

G1 X92.614 Y104.859 E-0.06254

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.101 Y104.183

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X92.386 Y104.196 E0.04555

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y104.194 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.598 Y108.862

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y109.327 E0.01214

G1 X81.890 Y109.327 E0.27899

G1 X81.892 Y108.840 E0.01269

G1 X92.538 Y108.861 E0.27738

M204 S1250

G1 X92.921 Y108.501 F9000.000

M204 S800

G1 F1500.000

G1 X92.987 Y108.596 E0.00300

G1 X93.016 Y108.728 E0.00353

G1 X93.014 Y109.497 E0.02005

G1 X93.000 Y109.554 E0.00153

G1 X92.911 Y109.679 E0.00398

G1 X92.843 Y109.718 E0.00204

G1 X92.717 Y109.745 E0.00337

G1 X81.764 Y109.744 E0.28538

G1 X81.633 Y109.717 E0.00349

G1 X81.558 Y109.662 E0.00243

G1 X81.471 Y109.478 E0.00531

G1 X81.475 Y108.703 E0.02019

G1 X81.552 Y108.501 E0.00563

G1 X81.771 Y108.422 E0.00607

G1 X92.801 Y108.445 E0.28740

G1 X92.867 Y108.476 E0.00189

M204 S1250

G1 X92.907 Y108.616 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.987 Y108.596 E-0.09424

G1 X93.016 Y108.728 E-0.07504

G1 X93.014 Y109.497 E-0.42636

G1 X93.000 Y109.554 E-0.03254

G1 X92.911 Y109.679 E-0.08472

G1 X92.843 Y109.718 E-0.04344

G1 X92.717 Y109.745 E-0.07166

G1 X92.565 Y109.745 E-0.08400

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.100 Y109.084

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X91.323 Y109.093 E0.04517

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.677 Y109.091 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X92.595 Y116.949

G1 Z6.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y117.439 E0.01277

G1 X81.895 Y117.421 E0.27878

G1 X81.900 Y116.940 E0.01256

G1 X92.535 Y116.949 E0.27709

M204 S1250

G1 X92.889 Y116.577 F9000.000

M204 S800

G1 F1500.000

G1 X92.925 Y116.601 E0.00111

G1 X93.013 Y116.779 E0.00516

G1 X93.013 Y117.551 E0.02012

G1 X92.991 Y117.676 E0.00330

G1 X92.932 Y117.767 E0.00283

G1 X92.846 Y117.823 E0.00267

G1 X92.727 Y117.857 E0.00322

G1 X81.675 Y117.839 E0.28798

G1 X81.586 Y117.802 E0.00250

G1 X81.480 Y117.630 E0.00526

G1 X81.469 Y116.792 E0.02184

G1 X81.539 Y116.716 E0.00267

G1 X81.592 Y116.571 E0.00402

G1 X81.771 Y116.522 E0.00484

G1 X92.712 Y116.531 E0.28510

G1 X92.831 Y116.562 E0.00320

M204 S1250

G1 X92.895 Y116.619 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y116.601 E-0.05608

G1 X93.013 Y116.779 E-0.10985

G1 X93.013 Y117.551 E-0.42800

G1 X92.991 Y117.676 E-0.07024

G1 X92.932 Y117.767 E-0.06028

G1 X92.846 Y117.823 E-0.05671

G1 X92.727 Y117.857 E-0.06858

G1 X92.615 Y117.857 E-0.06225

G1 E-0.04800 F4200.00000

G1 Z7.000 F9000.000

G1 X82.101 Y117.181

G1 Z6.800

G1 E3.20000 F2400.00000

G1 X92.386 Y117.194 E0.04616

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;6.95

G1 Z6.950 F9000.000

;AFTER\_LAYER\_CHANGE

;6.95

G1 E-3.20000 F4200.00000

G1 Z7.150 F9000.000

G1 X92.411 Y44.312

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.309 E0.27421

G1 X81.885 Y43.831 E0.01245

G1 X92.598 Y43.838 E0.27912

G1 X92.597 Y44.312 E0.01236

G1 X92.471 Y44.312 E0.00328

M204 S1250

G1 X92.893 Y44.674 F9000.000

M204 S800

G1 F1500.000

G1 X92.709 Y44.730 E0.00503

G1 X81.766 Y44.726 E0.28512

G1 X81.639 Y44.698 E0.00338

G1 X81.560 Y44.645 E0.00249

G1 X81.470 Y44.453 E0.00553

G1 X81.467 Y43.727 E0.01892

G1 X81.528 Y43.531 E0.00534

G1 X81.559 Y43.487 E0.00142

G1 X81.778 Y43.413 E0.00602

G1 X92.715 Y43.420 E0.28496

G1 X92.848 Y43.452 E0.00358

G1 X92.933 Y43.504 E0.00258

G1 X92.976 Y43.560 E0.00184

G1 X93.016 Y43.716 E0.00420

G1 X93.015 Y44.479 E0.01988

G1 X92.927 Y44.625 E0.00444

M204 S1250

G1 X92.713 Y44.605 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.709 Y44.730 E-0.13458

G1 X91.306 Y44.730 E-0.77742

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X82.095 Y44.070

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.389 Y44.075 E0.03849

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y44.074 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.594 Y51.985

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y52.468 E0.01258

G1 X81.894 Y52.452 E0.27881

G1 X81.888 Y51.989 E0.01206

G1 X92.534 Y51.985 E0.27741

M204 S1250

G1 X92.930 Y51.646 F9000.000

M204 S800

G1 F1500.000

G1 X92.992 Y51.748 E0.00312

G1 X93.012 Y51.820 E0.00194

G1 X93.012 Y52.591 E0.02008

G1 X92.990 Y52.711 E0.00319

G1 X92.945 Y52.788 E0.00232

G1 X92.882 Y52.842 E0.00218

G1 X92.719 Y52.886 E0.00438

G1 X81.700 Y52.869 E0.28711

G1 X81.577 Y52.827 E0.00340

G1 X81.479 Y52.676 E0.00468

G1 X81.475 Y51.802 E0.02278

G1 X81.622 Y51.608 E0.00634

G1 X81.769 Y51.571 E0.00396

G1 X92.710 Y51.567 E0.28507

G1 X92.878 Y51.616 E0.00456

M204 S1250

G1 X92.911 Y51.764 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.992 Y51.748 E-0.09683

G1 X93.012 Y51.820 E-0.04128

G1 X93.012 Y52.591 E-0.42717

G1 X92.990 Y52.711 E-0.06791

G1 X92.945 Y52.788 E-0.04930

G1 X92.882 Y52.842 E-0.04631

G1 X92.719 Y52.886 E-0.09310

G1 X92.557 Y52.886 E-0.09009

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X85.713 Y52.222

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.386 Y52.226 E0.02701

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y52.225 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.598 Y56.835

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y57.310 E0.01239

G1 X81.887 Y57.307 E0.27906

G1 X81.885 Y56.828 E0.01247

G1 X92.538 Y56.835 E0.27756

M204 S1250

G1 X92.848 Y56.450 F9000.000

M204 S800

G1 F1500.000

G1 X92.933 Y56.502 E0.00259

G1 X92.976 Y56.558 E0.00184

G1 X93.016 Y56.714 E0.00420

G1 X93.015 Y57.477 E0.01988

G1 X92.894 Y57.672 E0.00598

G1 X92.708 Y57.728 E0.00505

G1 X81.766 Y57.724 E0.28511

G1 X81.639 Y57.696 E0.00338

G1 X81.560 Y57.643 E0.00249

G1 X81.470 Y57.451 E0.00553

G1 X81.467 Y56.725 E0.01892

G1 X81.528 Y56.529 E0.00534

G1 X81.559 Y56.485 E0.00142

G1 X81.778 Y56.410 E0.00603

G1 X92.714 Y56.417 E0.28494

G1 X92.789 Y56.436 E0.00202

M204 S1250

G1 X92.863 Y56.548 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.933 Y56.502 E-0.08739

G1 X92.976 Y56.558 E-0.03924

G1 X93.016 Y56.714 E-0.08931

G1 X93.015 Y57.477 E-0.42283

G1 X92.894 Y57.672 E-0.12729

G1 X92.708 Y57.728 E-0.10736

G1 X92.639 Y57.728 E-0.03859

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X82.095 Y57.068

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.389 Y57.073 E0.03895

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y57.072 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.594 Y64.983

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y65.466 E0.01259

G1 X81.894 Y65.450 E0.27881

G1 X81.888 Y64.987 E0.01206

G1 X92.534 Y64.983 E0.27741

M204 S1250

G1 X92.930 Y64.643 F9000.000

M204 S800

G1 F1500.000

G1 X92.992 Y64.746 E0.00314

G1 X93.012 Y64.818 E0.00194

G1 X93.012 Y65.588 E0.02007

G1 X92.990 Y65.710 E0.00321

G1 X92.945 Y65.786 E0.00232

G1 X92.882 Y65.840 E0.00216

G1 X92.719 Y65.884 E0.00441

G1 X81.701 Y65.867 E0.28709

G1 X81.577 Y65.824 E0.00340

G1 X81.479 Y65.674 E0.00467

G1 X81.475 Y64.800 E0.02278

G1 X81.622 Y64.606 E0.00634

G1 X81.769 Y64.569 E0.00395

G1 X92.710 Y64.565 E0.28509

G1 X92.878 Y64.613 E0.00454

M204 S1250

G1 X92.910 Y64.762 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.992 Y64.746 E-0.09725

G1 X93.012 Y64.818 E-0.04137

G1 X93.012 Y65.588 E-0.42682

G1 X92.990 Y65.710 E-0.06830

G1 X92.945 Y65.786 E-0.04925

G1 X92.882 Y65.840 E-0.04593

G1 X92.719 Y65.884 E-0.09372

G1 X92.558 Y65.884 E-0.08936

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X85.584 Y65.220

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.386 Y65.224 E0.02755

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y65.223 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.598 Y69.833

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y70.308 E0.01239

G1 X81.887 Y70.305 E0.27906

G1 X81.885 Y69.826 E0.01247

G1 X92.538 Y69.833 E0.27756

M204 S1250

G1 X92.848 Y69.448 F9000.000

M204 S800

G1 F1500.000

G1 X92.933 Y69.500 E0.00260

G1 X92.976 Y69.555 E0.00183

G1 X93.016 Y69.712 E0.00421

G1 X93.015 Y70.475 E0.01988

G1 X92.894 Y70.670 E0.00598

G1 X92.708 Y70.726 E0.00505

G1 X81.766 Y70.722 E0.28510

G1 X81.639 Y70.694 E0.00339

G1 X81.560 Y70.641 E0.00249

G1 X81.470 Y70.449 E0.00551

G1 X81.467 Y69.723 E0.01893

G1 X81.528 Y69.527 E0.00534

G1 X81.559 Y69.482 E0.00143

G1 X81.778 Y69.408 E0.00601

G1 X92.714 Y69.415 E0.28495

M73 P68 R22

G1 X92.789 Y69.434 E0.00202

M204 S1250

G1 X92.863 Y69.546 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.933 Y69.500 E-0.08755

G1 X92.976 Y69.555 E-0.03891

G1 X93.016 Y69.712 E-0.08949

G1 X93.015 Y70.475 E-0.42287

G1 X92.894 Y70.670 E-0.12729

G1 X92.708 Y70.726 E-0.10736

G1 X92.639 Y70.726 E-0.03853

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X82.095 Y70.066

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.389 Y70.071 E0.03895

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y70.070 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.594 Y77.981

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y78.463 E0.01256

G1 X81.894 Y78.447 E0.27881

G1 X81.887 Y77.984 E0.01206

G1 X92.534 Y77.981 E0.27741

M204 S1250

G1 X92.930 Y77.641 F9000.000

M204 S800

G1 F1500.000

G1 X92.992 Y77.744 E0.00314

G1 X93.012 Y77.816 E0.00194

G1 X93.012 Y78.586 E0.02007

G1 X92.990 Y78.707 E0.00320

G1 X92.945 Y78.783 E0.00232

G1 X92.882 Y78.838 E0.00218

G1 X92.720 Y78.881 E0.00437

G1 X81.700 Y78.864 E0.28713

G1 X81.577 Y78.822 E0.00338

G1 X81.479 Y78.672 E0.00467

G1 X81.475 Y77.797 E0.02280

G1 X81.622 Y77.604 E0.00633

G1 X81.769 Y77.566 E0.00397

G1 X92.710 Y77.563 E0.28508

G1 X92.878 Y77.611 E0.00454

M204 S1250

G1 X92.910 Y77.760 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X93.012 Y77.816 E-0.04137

G1 X93.012 Y78.586 E-0.42680

G1 X92.990 Y78.707 E-0.06799

G1 X92.945 Y78.783 E-0.04926

G1 X92.882 Y78.838 E-0.04643

G1 X92.720 Y78.881 E-0.09289

G1 X92.557 Y78.881 E-0.09000

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X85.852 Y78.217

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.386 Y78.222 E0.02605

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y78.221 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.598 Y82.831

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y83.306 E0.01239

G1 X81.887 Y83.303 E0.27906

G1 X81.885 Y82.824 E0.01247

G1 X92.538 Y82.831 E0.27756

M204 S1250

G1 X92.848 Y82.446 F9000.000

M204 S800

G1 F1500.000

G1 X92.933 Y82.498 E0.00260

G1 X92.976 Y82.553 E0.00183

G1 X93.016 Y82.710 E0.00421

G1 X93.015 Y83.473 E0.01988

G1 X92.894 Y83.668 E0.00598

G1 X92.708 Y83.724 E0.00505

G1 X81.766 Y83.720 E0.28510

G1 X81.639 Y83.692 E0.00339

G1 X81.560 Y83.639 E0.00249

G1 X81.470 Y83.447 E0.00551

G1 X81.467 Y82.721 E0.01893

G1 X81.528 Y82.525 E0.00535

G1 X81.559 Y82.480 E0.00142

G1 X81.778 Y82.406 E0.00602

G1 X92.714 Y82.413 E0.28495

G1 X92.789 Y82.432 E0.00202

M204 S1250

G1 X92.863 Y82.544 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.933 Y82.498 E-0.08755

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G1 X93.016 Y82.710 E-0.08949

G1 X93.015 Y83.473 E-0.42287

G1 X92.894 Y83.668 E-0.12729

G1 X92.708 Y83.724 E-0.10736

G1 X92.639 Y83.724 E-0.03853

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X82.095 Y83.064

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.389 Y83.069 E0.03895

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y83.068 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.594 Y90.979

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y91.461 E0.01256

G1 X81.894 Y91.445 E0.27881

G1 X81.887 Y90.982 E0.01206

G1 X92.534 Y90.979 E0.27741

M204 S1250

G1 X92.930 Y90.639 F9000.000

M204 S800

G1 F1500.000

G1 X92.993 Y90.742 E0.00315

G1 X93.012 Y90.813 E0.00192

G1 X93.012 Y91.584 E0.02009

G1 X92.990 Y91.705 E0.00320

G1 X92.945 Y91.781 E0.00232

G1 X92.882 Y91.836 E0.00218

G1 X92.720 Y91.879 E0.00437

G1 X81.700 Y91.862 E0.28713

G1 X81.577 Y91.820 E0.00338

G1 X81.479 Y91.670 E0.00467

G1 X81.475 Y90.795 E0.02280

G1 X81.622 Y90.602 E0.00633

G1 X81.769 Y90.564 E0.00397

G1 X92.710 Y90.561 E0.28508

G1 X92.878 Y90.609 E0.00454

M204 S1250

G1 X92.910 Y90.758 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.993 Y90.742 E-0.09739

G1 X93.012 Y90.813 E-0.04090

G1 X93.012 Y91.584 E-0.42723

G1 X92.990 Y91.705 E-0.06799

G1 X92.945 Y91.781 E-0.04926

G1 X92.882 Y91.836 E-0.04643

G1 X92.720 Y91.879 E-0.09289

G1 X92.557 Y91.879 E-0.08991

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X85.853 Y91.215

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.386 Y91.220 E0.02605

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y91.219 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.598 Y95.829

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y96.304 E0.01239

G1 X81.887 Y96.300 E0.27906

G1 X81.885 Y95.822 E0.01245

G1 X92.538 Y95.829 E0.27756

M204 S1250

G1 X92.848 Y95.444 F9000.000

M204 S800

G1 F1500.000

G1 X92.933 Y95.495 E0.00259

G1 X92.976 Y95.551 E0.00183

G1 X93.016 Y95.707 E0.00420

G1 X93.015 Y96.470 E0.01990

G1 X92.894 Y96.665 E0.00598

G1 X92.708 Y96.722 E0.00505

G1 X81.766 Y96.718 E0.28510

G1 X81.639 Y96.689 E0.00339

G1 X81.560 Y96.637 E0.00247

G1 X81.470 Y96.444 E0.00554

G1 X81.467 Y95.719 E0.01891

G1 X81.528 Y95.523 E0.00535

G1 X81.559 Y95.478 E0.00142

G1 X81.778 Y95.404 E0.00602

G1 X92.714 Y95.411 E0.28495

G1 X92.790 Y95.430 E0.00203

M204 S1250

G1 X92.864 Y95.542 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.933 Y95.495 E-0.08732

G1 X92.976 Y95.551 E-0.03888

G1 X93.016 Y95.707 E-0.08924

G1 X93.015 Y96.470 E-0.42321

G1 X92.894 Y96.665 E-0.12723

G1 X92.708 Y96.722 E-0.10748

G1 X92.638 Y96.722 E-0.03865

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X82.095 Y96.061

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.389 Y96.067 E0.03855

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y96.066 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.594 Y103.977

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y104.459 E0.01257

G1 X81.894 Y104.443 E0.27881

G1 X81.887 Y103.980 E0.01206

G1 X92.534 Y103.977 E0.27741

M204 S1250

G1 X92.930 Y103.637 F9000.000

M204 S800

G1 F1500.000

G1 X92.993 Y103.740 E0.00315

G1 X93.012 Y103.811 E0.00192

G1 X93.012 Y104.582 E0.02008

G1 X92.990 Y104.702 E0.00319

G1 X92.945 Y104.779 E0.00232

G1 X92.882 Y104.833 E0.00218

G1 X92.719 Y104.877 E0.00438

G1 X81.700 Y104.860 E0.28713

G1 X81.577 Y104.818 E0.00338

G1 X81.479 Y104.668 E0.00467

G1 X81.475 Y103.793 E0.02280

G1 X81.622 Y103.600 E0.00633

G1 X81.769 Y103.562 E0.00397

G1 X92.710 Y103.559 E0.28508

G1 X92.878 Y103.607 E0.00454

M204 S1250

G1 X92.910 Y103.756 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.993 Y103.740 E-0.09739

G1 X93.012 Y103.811 E-0.04090

G1 X93.012 Y104.582 E-0.42705

G1 X92.990 Y104.702 E-0.06791

G1 X92.945 Y104.779 E-0.04930

G1 X92.882 Y104.833 E-0.04631

G1 X92.719 Y104.877 E-0.09310

G1 X92.557 Y104.877 E-0.09004

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X85.852 Y104.213

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.386 Y104.218 E0.02621

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y104.216 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.598 Y108.827

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y109.301 E0.01236

G1 X81.887 Y109.298 E0.27906

G1 X81.885 Y108.820 E0.01244

G1 X92.538 Y108.827 E0.27756

M204 S1250

G1 X92.848 Y108.441 F9000.000

M204 S800

G1 F1500.000

G1 X92.933 Y108.493 E0.00258

G1 X92.976 Y108.549 E0.00184

G1 X93.016 Y108.705 E0.00420

G1 X93.015 Y109.468 E0.01989

G1 X92.893 Y109.663 E0.00599

G1 X92.709 Y109.719 E0.00503

G1 X81.766 Y109.715 E0.28512

G1 X81.639 Y109.687 E0.00338

G1 X81.560 Y109.634 E0.00249

G1 X81.470 Y109.442 E0.00553

G1 X81.467 Y108.716 E0.01892

G1 X81.528 Y108.520 E0.00534

G1 X81.559 Y108.476 E0.00142

G1 X81.778 Y108.402 E0.00602

G1 X92.715 Y108.409 E0.28496

G1 X92.790 Y108.427 E0.00201

M204 S1250

G1 X92.864 Y108.539 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.933 Y108.493 E-0.08705

G1 X92.976 Y108.549 E-0.03924

G1 X93.016 Y108.705 E-0.08931

G1 X93.015 Y109.468 E-0.42303

G1 X92.893 Y109.663 E-0.12743

G1 X92.709 Y109.719 E-0.10701

G1 X92.638 Y109.719 E-0.03894

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X82.095 Y109.059

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.389 Y109.064 E0.03831

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.743 Y109.063 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X92.594 Y116.974

G1 Z6.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y117.457 E0.01259

G1 X81.894 Y117.441 E0.27881

G1 X81.887 Y116.978 E0.01206

G1 X92.534 Y116.974 E0.27741

M204 S1250

G1 X92.930 Y116.635 F9000.000

M204 S800

G1 F1500.000

G1 X92.992 Y116.738 E0.00313

G1 X93.012 Y116.809 E0.00193

G1 X93.012 Y117.580 E0.02008

G1 X92.990 Y117.700 E0.00319

G1 X92.945 Y117.777 E0.00232

G1 X92.882 Y117.831 E0.00218

G1 X92.719 Y117.875 E0.00438

G1 X81.700 Y117.858 E0.28711

G1 X81.577 Y117.816 E0.00340

G1 X81.479 Y117.665 E0.00468

G1 X81.475 Y116.791 E0.02278

G1 X81.622 Y116.598 E0.00633

G1 X81.769 Y116.560 E0.00397

G1 X92.710 Y116.556 E0.28507

G1 X92.878 Y116.605 E0.00456

M204 S1250

G1 X92.911 Y116.754 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.992 Y116.738 E-0.09706

G1 X93.012 Y116.809 E-0.04113

G1 X93.012 Y117.580 E-0.42712

G1 X92.990 Y117.700 E-0.06791

G1 X92.945 Y117.777 E-0.04930

G1 X92.882 Y117.831 E-0.04631

G1 X92.719 Y117.875 E-0.09310

G1 X92.557 Y117.875 E-0.09007

G1 E-0.04800 F4200.00000

G1 Z7.150 F9000.000

G1 X85.720 Y117.211

G1 Z6.950

G1 E3.20000 F2400.00000

G1 X92.386 Y117.215 E0.02698

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;7.1

G1 Z7.100 F9000.000

;AFTER\_LAYER\_CHANGE

;7.1

G1 X92.594 Y116.999

M204 S800

G1 F1500.000

G1 X92.594 Y117.470 E0.01227

G1 X81.892 Y117.460 E0.27885

G1 X81.886 Y116.998 E0.01205

G1 X92.534 Y116.999 E0.27744

M204 S1250

G1 X92.931 Y116.662 F9000.000

M204 S800

G1 F1500.000

G1 X92.991 Y116.759 E0.00296

G1 X93.011 Y116.840 E0.00218

G1 X93.012 Y117.608 E0.02000

G1 X92.989 Y117.724 E0.00308

G1 X92.947 Y117.789 E0.00203

G1 X92.880 Y117.850 E0.00237

G1 X92.796 Y117.884 E0.00235

G1 X81.726 Y117.878 E0.28844

G1 X81.628 Y117.860 E0.00258

G1 X81.569 Y117.826 E0.00178

G1 X81.515 Y117.764 E0.00216

G1 X81.477 Y117.652 E0.00309

G1 X81.474 Y116.816 E0.02179

G1 X81.616 Y116.630 E0.00609

G1 X81.776 Y116.580 E0.00436

G1 X92.717 Y116.581 E0.28509

G1 X92.879 Y116.633 E0.00443

M204 S1250

G1 X92.914 Y116.775 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.991 Y116.759 E-0.09369

G1 X93.011 Y116.840 E-0.04644

G1 X93.012 Y117.608 E-0.42540

G1 X92.989 Y117.724 E-0.06541

G1 X92.947 Y117.789 E-0.04311

G1 X92.880 Y117.850 E-0.05036

G1 X92.796 Y117.884 E-0.05005

G1 X92.548 Y117.884 E-0.13754

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y109.276

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y109.275 E0.27897

G1 X81.886 Y108.801 E0.01236

G1 X92.586 Y108.802 E0.27879

G1 X92.593 Y109.216 E0.01079

M204 S1250

G1 X92.999 Y109.496 F9000.000

M204 S800

G1 F1500.000

G1 X92.897 Y109.626 E0.00429

G1 X92.703 Y109.694 E0.00535

G1 X81.762 Y109.693 E0.28508

G1 X81.626 Y109.668 E0.00361

G1 X81.552 Y109.616 E0.00234

G1 X81.470 Y109.440 E0.00505

G1 X81.468 Y108.694 E0.01944

G1 X81.543 Y108.479 E0.00594

G1 X81.611 Y108.432 E0.00215

G1 X81.774 Y108.383 E0.00445

G1 X92.712 Y108.384 E0.28500

G1 X92.841 Y108.423 E0.00352

G1 X92.952 Y108.494 E0.00341

G1 X93.000 Y108.584 E0.00267

G1 X93.014 Y109.438 E0.02227

M204 S1250

G1 X92.835 Y109.512 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.897 Y109.626 E-0.12263

G1 X92.703 Y109.694 E-0.11389

G1 X91.484 Y109.693 E-0.67548

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X82.095 Y109.038

G1 Z7.100

G1 E3.20000 F2400.00000

G1 X92.381 Y109.039 E0.03632

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y109.039 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y104.472

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y104.462 E0.27885

G1 X81.886 Y104.000 E0.01205

G1 X92.594 Y104.001 E0.27900

G1 X92.594 Y104.412 E0.01071

M204 S1250

G1 X92.947 Y104.791 F9000.000

M204 S800

G1 F1500.000

G1 X92.878 Y104.853 E0.00241

G1 X92.731 Y104.890 E0.00397

G1 X81.725 Y104.880 E0.28675

G1 X81.628 Y104.862 E0.00259

G1 X81.569 Y104.829 E0.00176

G1 X81.515 Y104.767 E0.00215

G1 X81.477 Y104.655 E0.00309

G1 X81.466 Y103.877 E0.02026

G1 X81.474 Y103.818 E0.00155

G1 X81.616 Y103.632 E0.00610

G1 X81.775 Y103.582 E0.00436

G1 X92.717 Y103.583 E0.28509

G1 X92.833 Y103.608 E0.00310

G1 X92.931 Y103.664 E0.00293

G1 X92.991 Y103.761 E0.00297

G1 X93.011 Y103.842 E0.00218

G1 X93.012 Y104.610 E0.02000

G1 X92.979 Y104.741 E0.00351

M204 S1250

G1 X92.854 Y104.786 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.878 Y104.853 E-0.08389

G1 X92.731 Y104.890 E-0.08434

G1 X91.388 Y104.889 E-0.74378

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y96.279

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.277 E0.27897

G1 X81.886 Y95.803 E0.01236

G1 X92.586 Y95.804 E0.27879

G1 X92.593 Y96.219 E0.01082

M204 S1250

G1 X92.999 Y96.498 F9000.000

M204 S800

G1 F1500.000

G1 X92.897 Y96.628 E0.00431

G1 X92.703 Y96.697 E0.00536

G1 X81.762 Y96.695 E0.28507

G1 X81.625 Y96.669 E0.00363

G1 X81.552 Y96.619 E0.00232

G1 X81.470 Y96.443 E0.00506

G1 X81.468 Y95.697 E0.01943

G1 X81.543 Y95.482 E0.00593

G1 X81.611 Y95.435 E0.00217

G1 X81.774 Y95.385 E0.00445

G1 X92.712 Y95.386 E0.28498

G1 X92.841 Y95.426 E0.00353

G1 X92.952 Y95.497 E0.00343

G1 X93.000 Y95.586 E0.00264

G1 X93.014 Y96.440 E0.02226

M204 S1250

G1 X92.834 Y96.514 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.897 Y96.628 E-0.12287

G1 X92.703 Y96.697 E-0.11408

G1 X91.485 Y96.696 E-0.67506

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X82.095 Y96.040

G1 Z7.100

G1 E3.20000 F2400.00000

G1 X92.381 Y96.041 E0.03669

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y96.041 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y91.474

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y91.464 E0.27885

G1 X81.886 Y91.002 E0.01205

G1 X92.594 Y91.004 E0.27900

G1 X92.594 Y91.414 E0.01069

M204 S1250

G1 X92.947 Y91.793 F9000.000

M204 S800

G1 F1500.000

G1 X92.880 Y91.855 E0.00237

G1 X92.734 Y91.892 E0.00392

G1 X81.725 Y91.882 E0.28683

G1 X81.628 Y91.864 E0.00259

G1 X81.569 Y91.831 E0.00176

G1 X81.515 Y91.769 E0.00215

G1 X81.477 Y91.657 E0.00309

G1 X81.466 Y90.879 E0.02026

G1 X81.474 Y90.820 E0.00155

G1 X81.616 Y90.634 E0.00610

G1 X81.776 Y90.584 E0.00436

G1 X92.718 Y90.586 E0.28511

G1 X92.834 Y90.611 E0.00310

G1 X92.931 Y90.666 E0.00292

G1 X92.991 Y90.763 E0.00297

G1 X93.011 Y90.844 E0.00218

G1 X93.012 Y91.612 E0.02000

G1 X92.979 Y91.743 E0.00352

M204 S1250

G1 X92.856 Y91.789 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.880 Y91.855 E-0.08296

G1 X92.734 Y91.892 E-0.08339

G1 X91.388 Y91.891 E-0.74565

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y83.281

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y83.280 E0.27897

G1 X81.886 Y82.805 E0.01239

G1 X92.586 Y82.806 E0.27879

G1 X92.593 Y83.221 E0.01082

M204 S1250

G1 X92.999 Y83.501 F9000.000

M204 S800

G1 F1500.000

G1 X92.897 Y83.631 E0.00430

G1 X92.703 Y83.699 E0.00535

G1 X81.762 Y83.698 E0.28507

G1 X81.626 Y83.672 E0.00363

G1 X81.552 Y83.620 E0.00234

G1 X81.470 Y83.445 E0.00504

G1 X81.468 Y82.699 E0.01945

G1 X81.543 Y82.484 E0.00593

G1 X81.611 Y82.437 E0.00217

G1 X81.774 Y82.387 E0.00445

G1 X92.712 Y82.388 E0.28498

G1 X92.841 Y82.428 E0.00353

G1 X92.952 Y82.499 E0.00342

G1 X93.000 Y82.588 E0.00265

G1 X93.014 Y83.443 E0.02228

M204 S1250

G1 X92.835 Y83.517 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.897 Y83.631 E-0.12272

G1 X92.703 Y83.699 E-0.11385

G1 X91.484 Y83.698 E-0.67543

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X82.095 Y83.043

G1 Z7.100

G1 E3.20000 F2400.00000

G1 X92.381 Y83.043 E0.03692

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y83.043 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y78.476

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y78.466 E0.27885

G1 X81.886 Y78.004 E0.01205

G1 X92.594 Y78.006 E0.27900

G1 X92.594 Y78.416 E0.01069

M204 S1250

G1 X92.947 Y78.795 F9000.000

M204 S800

G1 F1500.000

G1 X92.880 Y78.857 E0.00237

G1 X92.734 Y78.894 E0.00392

G1 X81.725 Y78.884 E0.28683

G1 X81.628 Y78.866 E0.00259

G1 X81.569 Y78.833 E0.00176

G1 X81.515 Y78.771 E0.00215

G1 X81.477 Y78.659 E0.00309

G1 X81.466 Y77.881 E0.02026

G1 X81.474 Y77.822 E0.00155

G1 X81.616 Y77.636 E0.00610

G1 X81.775 Y77.586 E0.00436

G1 X92.718 Y77.588 E0.28511

G1 X92.834 Y77.613 E0.00309

G1 X92.931 Y77.669 E0.00292

G1 X92.991 Y77.765 E0.00296

G1 X93.011 Y77.847 E0.00220

G1 X93.012 Y78.614 E0.01998

G1 X92.979 Y78.745 E0.00352

M204 S1250

G1 X92.856 Y78.791 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.880 Y78.857 E-0.08296

G1 X92.734 Y78.894 E-0.08339

G1 X91.388 Y78.893 E-0.74565

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y70.283

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y70.282 E0.27897

G1 X81.886 Y69.807 E0.01239

G1 X92.586 Y69.808 E0.27879

G1 X92.593 Y70.223 E0.01082

M204 S1250

G1 X92.999 Y70.503 F9000.000

M204 S800

G1 F1500.000

G1 X92.897 Y70.633 E0.00430

G1 X92.703 Y70.701 E0.00535

G1 X81.762 Y70.700 E0.28507

G1 X81.626 Y70.674 E0.00363

G1 X81.552 Y70.622 E0.00234

G1 X81.470 Y70.447 E0.00504

G1 X81.468 Y69.701 E0.01945

G1 X81.543 Y69.486 E0.00593

G1 X81.611 Y69.439 E0.00216

G1 X81.774 Y69.389 E0.00445

G1 X92.712 Y69.390 E0.28498

G1 X92.841 Y69.430 E0.00353

G1 X92.952 Y69.501 E0.00342

G1 X93.000 Y69.590 E0.00265

G1 X93.014 Y70.445 E0.02228

M204 S1250

G1 X92.835 Y70.519 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.897 Y70.633 E-0.12272

G1 X92.703 Y70.701 E-0.11385

G1 X91.484 Y70.700 E-0.67543

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X82.095 Y70.045

G1 Z7.100

G1 E3.20000 F2400.00000

G1 X92.381 Y70.045 E0.03691

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y70.045 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y65.479

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y65.469 E0.27885

G1 X81.886 Y65.006 E0.01206

G1 X92.594 Y65.008 E0.27900

G1 X92.594 Y65.419 E0.01071

M204 S1250

G1 X92.947 Y65.798 F9000.000

M204 S800

G1 F1500.000

G1 X92.880 Y65.859 E0.00235

G1 X92.733 Y65.897 E0.00396

G1 X81.726 Y65.887 E0.28679

G1 X81.628 Y65.869 E0.00259

G1 X81.569 Y65.835 E0.00178

G1 X81.515 Y65.773 E0.00215

G1 X81.477 Y65.661 E0.00309

G1 X81.466 Y64.883 E0.02026

G1 X81.474 Y64.824 E0.00154

G1 X81.616 Y64.638 E0.00610

G1 X81.775 Y64.589 E0.00435

G1 X92.717 Y64.590 E0.28511

G1 X92.834 Y64.615 E0.00310

G1 X92.931 Y64.671 E0.00292

G1 X92.991 Y64.767 E0.00296

G1 X93.011 Y64.849 E0.00220

G1 X93.012 Y65.616 E0.01999

G1 X92.979 Y65.748 E0.00353

M204 S1250

G1 X92.857 Y65.793 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.880 Y65.859 E-0.08260

G1 X92.733 Y65.897 E-0.08431

G1 X91.388 Y65.896 E-0.74509

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y57.285

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y57.284 E0.27897

G1 X81.886 Y56.809 E0.01239

G1 X92.586 Y56.810 E0.27879

G1 X92.593 Y57.225 E0.01082

M204 S1250

G1 X92.999 Y57.505 F9000.000

M204 S800

G1 F1500.000

G1 X92.897 Y57.635 E0.00430

G1 X92.703 Y57.703 E0.00535

G1 X81.762 Y57.702 E0.28508

G1 X81.626 Y57.677 E0.00361

G1 X81.552 Y57.625 E0.00234

G1 X81.470 Y57.449 E0.00505

G1 X81.468 Y56.703 E0.01944

G1 X81.543 Y56.488 E0.00594

G1 X81.611 Y56.441 E0.00216

G1 X81.775 Y56.391 E0.00445

G1 X92.712 Y56.392 E0.28497

G1 X92.841 Y56.432 E0.00353

G1 X92.952 Y56.503 E0.00342

G1 X93.000 Y56.592 E0.00265

G1 X93.014 Y57.447 E0.02228

M204 S1250

G1 X92.835 Y57.521 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.897 Y57.635 E-0.12272

G1 X92.703 Y57.703 E-0.11385

G1 X91.484 Y57.702 E-0.67543

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X82.095 Y57.047

G1 Z7.100

G1 E3.20000 F2400.00000

G1 X92.381 Y57.047 E0.03691

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.735 Y57.047 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y52.481

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y52.471 E0.27885

G1 X81.886 Y52.009 E0.01205

G1 X92.594 Y52.010 E0.27900

G1 X92.594 Y52.421 E0.01071

M204 S1250

G1 X92.947 Y52.800 F9000.000

M204 S800

G1 F1500.000

G1 X92.880 Y52.861 E0.00237

G1 X92.734 Y52.899 E0.00393

G1 X81.726 Y52.889 E0.28682

G1 X81.628 Y52.871 E0.00258

G1 X81.569 Y52.837 E0.00178

G1 X81.515 Y52.775 E0.00216

G1 X81.477 Y52.663 E0.00309

G1 X81.466 Y51.885 E0.02027

G1 X81.474 Y51.827 E0.00153

G1 X81.616 Y51.641 E0.00609

G1 X81.775 Y51.591 E0.00436

G1 X92.717 Y51.592 E0.28509

G1 X92.833 Y51.617 E0.00310

G1 X92.931 Y51.674 E0.00294

G1 X92.991 Y51.769 E0.00294

G1 X93.011 Y51.851 E0.00220

G1 X93.012 Y52.619 E0.02001

G1 X92.979 Y52.750 E0.00351

M204 S1250

G1 X92.856 Y52.795 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.880 Y52.861 E-0.08293

G1 X92.734 Y52.899 E-0.08350

G1 X91.388 Y52.898 E-0.74557

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X92.594 Y44.287

G1 Z7.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.286 E0.27897

G1 X81.886 Y43.812 E0.01236

G1 X92.586 Y43.813 E0.27879

G1 X92.593 Y44.227 E0.01079

M204 S1250

G1 X92.999 Y44.507 F9000.000

M204 S800

G1 F1500.000

G1 X92.897 Y44.637 E0.00430

G1 X92.703 Y44.705 E0.00535

G1 X81.762 Y44.704 E0.28508

G1 X81.626 Y44.679 E0.00361

G1 X81.552 Y44.627 E0.00234

G1 X81.470 Y44.451 E0.00505

G1 X81.468 Y43.705 E0.01944

G1 X81.543 Y43.490 E0.00594

G1 X81.611 Y43.443 E0.00215

G1 X81.774 Y43.394 E0.00445

G1 X92.712 Y43.395 E0.28500

G1 X92.841 Y43.434 E0.00352

G1 X92.952 Y43.505 E0.00341

G1 X93.000 Y43.595 E0.00267

G1 X93.014 Y44.449 E0.02226

M204 S1250

G1 X92.835 Y44.523 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.897 Y44.637 E-0.12271

G1 X92.703 Y44.705 E-0.11385

G1 X91.484 Y44.704 E-0.67543

G1 E-0.04800 F4200.00000

G1 Z7.300 F9000.000

G1 X82.095 Y44.049

G1 Z7.100

G1 E3.20000 F2400.00000

G1 X92.381 Y44.050 E0.03628

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;7.25

G1 Z7.250 F9000.000

;AFTER\_LAYER\_CHANGE

;7.25

G1 E-3.20000 F4200.00000

G1 Z7.450 F9000.000

G1 X92.593 Y117.009

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y117.483 E0.01236

G1 X81.893 Y117.480 E0.27871

G1 X81.895 Y117.013 E0.01217

G1 X84.241 Y116.998 E0.06111

G1 X92.533 Y117.009 E0.21605

M204 S1250

G1 X92.935 Y116.691 F9000.000

M204 S800

G1 F1500.000

G1 X92.992 Y116.776 E0.00268

G1 X93.011 Y116.856 E0.00213

G1 X93.007 Y117.643 E0.02051

G1 X92.934 Y117.810 E0.00475

G1 X92.891 Y117.847 E0.00148

G1 X92.709 Y117.901 E0.00496

G1 X81.759 Y117.897 E0.28532

G1 X81.574 Y117.838 E0.00505

G1 X81.507 Y117.747 E0.00296

G1 X81.475 Y117.643 E0.00282

G1 X81.478 Y116.838 E0.02099

G1 X81.611 Y116.638 E0.00624

G1 X81.767 Y116.596 E0.00423

G1 X84.241 Y116.580 E0.06445

G1 X92.717 Y116.591 E0.22084

G1 X92.787 Y116.606 E0.00188

G1 X92.883 Y116.661 E0.00287

M204 S1250

G1 X92.907 Y116.790 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.992 Y116.776 E-0.08800

G1 X93.011 Y116.856 E-0.04536

G1 X93.007 Y117.643 E-0.43622

G1 X92.934 Y117.810 E-0.10104

G1 X92.891 Y117.847 E-0.03147

G1 X92.709 Y117.901 E-0.10541

G1 X92.520 Y117.901 E-0.10451

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X82.584 Y117.244

G1 Z7.250

G1 E3.20000 F2400.00000

G1 X92.382 Y117.246 E0.03439

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y117.246 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.595 Y109.262

G1 Z7.250

G1 E3.20000 F2400.00000

M73 P69 R21

M204 S800

G1 F1500.000

G1 X81.887 Y109.268 E0.27901

G1 X81.886 Y108.797 E0.01227

G1 X92.589 Y108.796 E0.27887

G1 X92.594 Y109.202 E0.01059

M204 S1250

G1 X92.985 Y109.513 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y109.621 E0.00368

G1 X92.707 Y109.680 E0.00512

G1 X81.766 Y109.686 E0.28507

G1 X81.619 Y109.653 E0.00393

G1 X81.551 Y109.602 E0.00221

G1 X81.485 Y109.496 E0.00327

G1 X81.470 Y109.439 E0.00153

G1 X81.468 Y108.672 E0.01998

G1 X81.531 Y108.492 E0.00498

G1 X81.646 Y108.405 E0.00375

G1 X81.765 Y108.380 E0.00317

G1 X92.719 Y108.378 E0.28542

G1 X92.841 Y108.409 E0.00328

G1 X92.939 Y108.474 E0.00305

G1 X93.004 Y108.604 E0.00381

G1 X93.015 Y109.409 E0.02098

G1 X93.002 Y109.455 E0.00125

M204 S1250

G1 X92.844 Y109.520 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y109.621 E-0.10953

G1 X92.707 Y109.680 E-0.10882

G1 X91.455 Y109.680 E-0.69365

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.590 Y104.485

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y104.482 E0.27871

G1 X81.895 Y104.015 E0.01217

G1 X84.241 Y104.000 E0.06111

G1 X92.593 Y104.011 E0.21761

G1 X92.590 Y104.425 E0.01079

M204 S1250

G1 X92.934 Y104.812 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y104.850 E0.00148

G1 X92.709 Y104.903 E0.00495

G1 X81.758 Y104.899 E0.28533

G1 X81.574 Y104.840 E0.00505

G1 X81.507 Y104.749 E0.00294

G1 X81.475 Y104.646 E0.00283

G1 X81.478 Y103.840 E0.02099

G1 X81.611 Y103.641 E0.00624

G1 X81.768 Y103.598 E0.00425

G1 X84.241 Y103.582 E0.06444

G1 X92.717 Y103.593 E0.22084

G1 X92.787 Y103.609 E0.00188

G1 X92.935 Y103.693 E0.00443

G1 X92.992 Y103.778 E0.00268

G1 X93.011 Y103.858 E0.00213

G1 X93.007 Y104.645 E0.02051

G1 X92.958 Y104.757 E0.00319

M204 S1250

G1 X92.878 Y104.808 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.891 Y104.850 E-0.06314

G1 X92.709 Y104.903 E-0.10524

G1 X91.367 Y104.902 E-0.74362

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X82.585 Y104.246

G1 Z7.250

G1 E3.20000 F2400.00000

G1 X92.382 Y104.248 E0.03434

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y104.248 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.595 Y96.265

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.270 E0.27901

G1 X81.886 Y95.799 E0.01227

G1 X92.589 Y95.798 E0.27887

G1 X92.594 Y96.205 E0.01061

M204 S1250

G1 X92.985 Y96.515 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y96.624 E0.00369

G1 X92.707 Y96.682 E0.00512

G1 X81.766 Y96.688 E0.28506

G1 X81.619 Y96.655 E0.00394

G1 X81.551 Y96.605 E0.00218

G1 X81.485 Y96.498 E0.00328

G1 X81.470 Y96.441 E0.00153

G1 X81.468 Y95.675 E0.01998

G1 X81.531 Y95.495 E0.00497

G1 X81.646 Y95.408 E0.00376

G1 X81.766 Y95.382 E0.00318

G1 X92.719 Y95.380 E0.28539

G1 X92.841 Y95.412 E0.00329

G1 X92.939 Y95.477 E0.00307

G1 X93.005 Y95.606 E0.00379

G1 X93.015 Y96.412 E0.02098

G1 X93.002 Y96.457 E0.00125

M204 S1250

G1 X92.844 Y96.522 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y96.624 E-0.10978

G1 X92.707 Y96.682 E-0.10886

G1 X91.455 Y96.683 E-0.69337

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.590 Y91.487

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y91.484 E0.27871

G1 X81.895 Y91.017 E0.01217

G1 X84.241 Y91.002 E0.06111

G1 X92.593 Y91.014 E0.21761

G1 X92.590 Y91.427 E0.01077

M204 S1250

G1 X92.934 Y91.815 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y91.852 E0.00149

G1 X92.709 Y91.905 E0.00493

G1 X81.758 Y91.901 E0.28533

G1 X81.574 Y91.842 E0.00505

G1 X81.507 Y91.752 E0.00294

G1 X81.475 Y91.648 E0.00283

G1 X81.478 Y90.842 E0.02099

G1 X81.611 Y90.643 E0.00624

G1 X81.768 Y90.600 E0.00425

G1 X84.241 Y90.584 E0.06444

G1 X92.717 Y90.596 E0.22086

G1 X92.788 Y90.611 E0.00187

G1 X92.935 Y90.695 E0.00441

G1 X92.992 Y90.780 E0.00268

G1 X93.011 Y90.860 E0.00213

G1 X93.007 Y91.647 E0.02051

G1 X92.958 Y91.760 E0.00320

M204 S1250

G1 X92.877 Y91.810 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.891 Y91.852 E-0.06326

G1 X92.709 Y91.905 E-0.10493

G1 X91.367 Y91.904 E-0.74381

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X82.585 Y91.248

G1 Z7.250

G1 E3.20000 F2400.00000

G1 X92.382 Y91.250 E0.03381

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y91.250 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.595 Y83.267

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y83.273 E0.27901

G1 X81.886 Y82.801 E0.01229

G1 X92.589 Y82.800 E0.27887

G1 X92.594 Y83.207 E0.01061

M204 S1250

G1 X92.985 Y83.518 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y83.626 E0.00369

G1 X92.707 Y83.685 E0.00511

G1 X81.766 Y83.691 E0.28506

G1 X81.619 Y83.657 E0.00394

G1 X81.551 Y83.607 E0.00220

G1 X81.485 Y83.501 E0.00327

G1 X81.470 Y83.444 E0.00153

G1 X81.468 Y82.677 E0.02000

G1 X81.531 Y82.497 E0.00497

G1 X81.646 Y82.410 E0.00376

G1 X81.766 Y82.384 E0.00318

G1 X92.719 Y82.382 E0.28539

G1 X92.841 Y82.414 E0.00329

G1 X92.939 Y82.479 E0.00307

G1 X93.005 Y82.609 E0.00380

G1 X93.015 Y83.414 E0.02097

G1 X93.002 Y83.460 E0.00126

M204 S1250

G1 X92.843 Y83.525 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y83.626 E-0.10975

G1 X92.707 Y83.685 E-0.10872

G1 X91.455 Y83.685 E-0.69353

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.590 Y78.489

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y78.486 E0.27871

G1 X81.895 Y78.019 E0.01217

G1 X84.241 Y78.004 E0.06111

G1 X92.593 Y78.016 E0.21761

G1 X92.590 Y78.429 E0.01077

M204 S1250

G1 X92.934 Y78.817 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y78.854 E0.00149

G1 X92.709 Y78.907 E0.00493

G1 X81.758 Y78.903 E0.28533

G1 X81.574 Y78.844 E0.00505

G1 X81.507 Y78.754 E0.00294

G1 X81.475 Y78.650 E0.00283

G1 X81.478 Y77.844 E0.02099

G1 X81.611 Y77.645 E0.00624

G1 X81.768 Y77.602 E0.00424

G1 X84.241 Y77.586 E0.06444

G1 X92.717 Y77.598 E0.22086

G1 X92.788 Y77.613 E0.00187

G1 X92.935 Y77.697 E0.00441

G1 X92.992 Y77.782 E0.00267

G1 X93.011 Y77.863 E0.00216

G1 X93.007 Y78.649 E0.02049

G1 X92.958 Y78.762 E0.00320

M204 S1250

G1 X92.877 Y78.812 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.891 Y78.854 E-0.06326

G1 X92.709 Y78.907 E-0.10493

G1 X91.367 Y78.906 E-0.74381

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X82.585 Y78.250

G1 Z7.250

G1 E3.20000 F2400.00000

G1 X92.382 Y78.252 E0.03381

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y78.252 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.595 Y70.269

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y70.275 E0.27901

G1 X81.886 Y69.803 E0.01229

G1 X92.589 Y69.802 E0.27887

G1 X92.594 Y70.209 E0.01061

M204 S1250

G1 X92.985 Y70.520 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y70.628 E0.00369

G1 X92.707 Y70.687 E0.00511

G1 X81.766 Y70.693 E0.28506

G1 X81.619 Y70.659 E0.00394

G1 X81.551 Y70.609 E0.00220

G1 X81.485 Y70.503 E0.00327

G1 X81.470 Y70.446 E0.00153

G1 X81.468 Y69.679 E0.01999

G1 X81.531 Y69.498 E0.00497

G1 X81.646 Y69.412 E0.00376

G1 X81.766 Y69.386 E0.00318

G1 X92.719 Y69.384 E0.28539

G1 X92.841 Y69.416 E0.00329

G1 X92.939 Y69.481 E0.00307

G1 X93.005 Y69.611 E0.00380

G1 X93.015 Y70.416 E0.02097

G1 X93.002 Y70.462 E0.00126

M204 S1250

G1 X92.843 Y70.527 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y70.628 E-0.10975

G1 X92.707 Y70.687 E-0.10872

G1 X91.455 Y70.687 E-0.69353

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.590 Y65.492

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y65.489 E0.27871

G1 X81.895 Y65.021 E0.01219

G1 X84.241 Y65.006 E0.06111

G1 X92.593 Y65.018 E0.21761

G1 X92.590 Y65.432 E0.01079

M204 S1250

G1 X92.934 Y65.819 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y65.856 E0.00148

G1 X92.709 Y65.910 E0.00496

G1 X81.759 Y65.906 E0.28531

G1 X81.574 Y65.846 E0.00507

G1 X81.507 Y65.756 E0.00294

G1 X81.475 Y65.652 E0.00283

G1 X81.478 Y64.846 E0.02099

G1 X81.611 Y64.647 E0.00624

G1 X81.768 Y64.604 E0.00425

G1 X84.241 Y64.588 E0.06444

G1 X92.717 Y64.600 E0.22084

G1 X92.787 Y64.615 E0.00189

G1 X92.935 Y64.699 E0.00442

G1 X92.992 Y64.784 E0.00267

G1 X93.011 Y64.865 E0.00215

G1 X93.007 Y65.651 E0.02050

G1 X92.958 Y65.764 E0.00321

M204 S1250

G1 X92.878 Y65.815 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.891 Y65.856 E-0.06299

G1 X92.709 Y65.910 E-0.10541

G1 X91.367 Y65.909 E-0.74360

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X82.464 Y65.253

G1 Z7.250

G1 E3.20000 F2400.00000

G1 X92.382 Y65.255 E0.03485

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y65.255 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.595 Y57.271

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y57.277 E0.27901

G1 X81.886 Y56.806 E0.01228

G1 X92.589 Y56.804 E0.27887

G1 X92.594 Y57.211 E0.01061

M204 S1250

G1 X92.985 Y57.522 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y57.630 E0.00369

G1 X92.707 Y57.689 E0.00511

G1 X81.766 Y57.695 E0.28507

G1 X81.619 Y57.662 E0.00393

G1 X81.551 Y57.611 E0.00220

G1 X81.485 Y57.505 E0.00327

G1 X81.470 Y57.448 E0.00153

G1 X81.468 Y56.681 E0.01998

G1 X81.531 Y56.500 E0.00498

G1 X81.646 Y56.414 E0.00375

G1 X81.765 Y56.388 E0.00318

G1 X92.719 Y56.386 E0.28540

G1 X92.841 Y56.418 E0.00328

G1 X92.939 Y56.483 E0.00307

G1 X93.005 Y56.613 E0.00380

G1 X93.015 Y57.418 E0.02097

G1 X93.002 Y57.464 E0.00126

M204 S1250

G1 X92.843 Y57.529 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.894 Y57.630 E-0.10975

G1 X92.707 Y57.689 E-0.10872

G1 X91.455 Y57.689 E-0.69353

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.590 Y52.494

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y52.491 E0.27871

G1 X81.895 Y52.024 E0.01215

G1 X92.593 Y52.020 E0.27872

G1 X92.590 Y52.434 E0.01079

M204 S1250

G1 X92.934 Y52.821 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y52.858 E0.00148

G1 X92.709 Y52.912 E0.00496

G1 X81.759 Y52.908 E0.28532

G1 X81.574 Y52.849 E0.00505

G1 X81.507 Y52.758 E0.00296

G1 X81.475 Y52.654 E0.00282

G1 X81.478 Y51.849 E0.02099

G1 X81.611 Y51.649 E0.00624

G1 X81.767 Y51.607 E0.00421

G1 X92.717 Y51.602 E0.28531

G1 X92.787 Y51.617 E0.00188

G1 X92.935 Y51.702 E0.00444

G1 X92.992 Y51.787 E0.00266

G1 X93.011 Y51.867 E0.00215

G1 X93.007 Y52.654 E0.02051

G1 X92.958 Y52.766 E0.00319

M204 S1250

G1 X92.878 Y52.817 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.891 Y52.858 E-0.06308

G1 X92.709 Y52.912 E-0.10541

G1 X91.367 Y52.911 E-0.74352

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X85.416 Y52.256

G1 Z7.250

G1 E3.20000 F2400.00000

G1 X92.382 Y52.257 E0.02446

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y52.257 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.450 F9000.000

G1 X92.595 Y44.273

G1 Z7.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.279 E0.27901

G1 X81.886 Y43.808 E0.01226

G1 X92.589 Y43.807 E0.27887

G1 X92.594 Y44.213 E0.01059

M204 S1250

G1 X92.985 Y44.524 F9000.000

M204 S800

G1 F1500.000

G1 X92.894 Y44.632 E0.00369

G1 X92.707 Y44.691 E0.00511

G1 X81.766 Y44.697 E0.28507

G1 X81.619 Y44.664 E0.00393

G1 X81.551 Y44.613 E0.00220

G1 X81.485 Y44.507 E0.00327

G1 X81.470 Y44.450 E0.00153

G1 X81.468 Y43.683 E0.01998

G1 X81.531 Y43.503 E0.00498

G1 X81.646 Y43.416 E0.00375

G1 X81.765 Y43.391 E0.00317

G1 X92.719 Y43.389 E0.28542

G1 X92.841 Y43.420 E0.00328

G1 X92.939 Y43.485 E0.00305

G1 X93.004 Y43.615 E0.00381

G1 X93.015 Y44.420 E0.02096

G1 X93.002 Y44.466 E0.00126

M204 S1250

G1 X92.843 Y44.531 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;7.4

G1 Z7.400 F9000.000

;AFTER\_LAYER\_CHANGE

;7.4

G1 E-3.20000 F4200.00000

G1 Z7.600 F9000.000

G1 X92.594 Y117.005

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y117.486 E0.01253

G1 X86.091 Y117.472 E0.16945

G1 X81.890 Y117.488 E0.10946

G1 X81.891 Y117.026 E0.01204

G1 X84.243 Y116.998 E0.06127

G1 X87.336 Y117.021 E0.08062

G1 X92.534 Y117.005 E0.13543

M204 S1250

G1 X92.941 Y116.704 F9000.000

M204 S800

G1 F1500.000

G1 X92.993 Y116.783 E0.00248

G1 X93.012 Y116.853 E0.00188

G1 X93.012 Y117.628 E0.02020

G1 X92.928 Y117.825 E0.00557

G1 X92.892 Y117.854 E0.00122

G1 X92.741 Y117.904 E0.00414

G1 X86.091 Y117.890 E0.17326

G1 X81.765 Y117.906 E0.11274

G1 X81.627 Y117.876 E0.00368

G1 X81.578 Y117.845 E0.00152

G1 X81.497 Y117.726 E0.00375

G1 X81.472 Y117.633 E0.00250

G1 X81.474 Y116.851 E0.02038

G1 X81.558 Y116.691 E0.00470

G1 X81.620 Y116.645 E0.00202

G1 X81.758 Y116.610 E0.00371

G1 X84.242 Y116.580 E0.06471

G1 X87.337 Y116.603 E0.08066

G1 X92.709 Y116.587 E0.13996

G1 X92.890 Y116.673 E0.00522

M204 S1250

G1 X92.928 Y116.798 F9000.000

G1 X92.385 Y117.245

G1 F2400.000

G1 X90.784 Y117.246 E0.00618

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.385 Y117.245 E-0.88746

G1 E-0.07254 F4200.00000

G1 Z7.600 F9000.000

G1 X85.096 Y117.240

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X83.085 Y117.248 E0.00792

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.731 Y117.241 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X81.887 Y109.261

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y108.794 E0.01218

G1 X92.592 Y108.790 E0.27894

G1 X92.596 Y109.255 E0.01210

G1 X81.947 Y109.261 E0.27748

M204 S1250

G1 X81.613 Y109.638 F9000.000

M204 S800

G1 F1500.000

G1 X81.547 Y109.586 E0.00217

G1 X81.489 Y109.505 E0.00260

G1 X81.469 Y109.428 E0.00207

G1 X81.469 Y108.649 E0.02029

G1 X81.517 Y108.507 E0.00392

G1 X81.650 Y108.404 E0.00438

G1 X81.767 Y108.376 E0.00315

G1 X92.719 Y108.373 E0.28536

G1 X92.827 Y108.394 E0.00286

G1 X92.943 Y108.470 E0.00362

G1 X93.008 Y108.610 E0.00401

G1 X93.015 Y109.380 E0.02006

G1 X92.971 Y109.530 E0.00408

G1 X92.891 Y109.619 E0.00312

G1 X92.709 Y109.672 E0.00495

G1 X81.770 Y109.679 E0.28502

G1 X81.671 Y109.653 E0.00267

M204 S1250

G1 X81.606 Y109.555 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.547 Y109.586 E-0.07780

G1 X81.489 Y109.505 E-0.05533

G1 X81.469 Y109.428 E-0.04400

G1 X81.469 Y108.649 E-0.43163

G1 X81.517 Y108.507 E-0.08336

G1 X81.650 Y108.404 E-0.09306

G1 X81.767 Y108.376 E-0.06696

G1 X81.875 Y108.376 E-0.05986

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X81.890 Y104.490

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.891 Y104.028 E0.01204

G1 X84.243 Y104.000 E0.06127

G1 X87.336 Y104.023 E0.08062

G1 X92.594 Y104.007 E0.13700

G1 X92.594 Y104.488 E0.01252

G1 X86.091 Y104.475 E0.16945

G1 X81.950 Y104.490 E0.10789

M204 S1250

G1 X81.578 Y104.847 F9000.000

M204 S800

G1 F1500.000

G1 X81.497 Y104.728 E0.00374

G1 X81.472 Y104.635 E0.00251

G1 X81.474 Y103.854 E0.02037

G1 X81.558 Y103.694 E0.00470

G1 X81.620 Y103.648 E0.00201

G1 X81.759 Y103.612 E0.00373

G1 X84.242 Y103.582 E0.06470

G1 X87.337 Y103.605 E0.08066

G1 X92.709 Y103.589 E0.13997

G1 X92.783 Y103.611 E0.00202

G1 X92.941 Y103.706 E0.00480

G1 X92.993 Y103.785 E0.00248

G1 X93.012 Y103.855 E0.00188

G1 X93.012 Y104.630 E0.02020

G1 X92.928 Y104.827 E0.00558

G1 X92.891 Y104.857 E0.00122

G1 X92.741 Y104.906 E0.00412

G1 X86.091 Y104.893 E0.17326

G1 X81.765 Y104.908 E0.11274

G1 X81.628 Y104.879 E0.00363

M204 S1250

G1 X81.596 Y104.705 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.497 Y104.728 E-0.11061

G1 X81.472 Y104.635 E-0.05342

G1 X81.474 Y103.854 E-0.43319

G1 X81.558 Y103.694 E-0.10002

G1 X81.620 Y103.648 E-0.04283

G1 X81.759 Y103.612 E-0.07942

G1 X81.926 Y103.610 E-0.09251

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X83.057 Y104.250

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X85.148 Y104.242 E0.00829

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.502 Y104.248 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X90.775 Y104.248

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X92.385 Y104.247 E0.00620

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.775 Y104.248 E-0.89239

G1 E-0.06761 F4200.00000

G1 Z7.600 F9000.000

G1 X92.596 Y96.257

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.263 E0.27904

G1 X81.887 Y95.796 E0.01218

G1 X92.592 Y95.792 E0.27894

G1 X92.596 Y96.197 E0.01054

M204 S1250

G1 X92.971 Y96.532 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y96.621 E0.00313

G1 X92.709 Y96.675 E0.00494

G1 X81.770 Y96.681 E0.28502

G1 X81.612 Y96.640 E0.00425

G1 X81.547 Y96.589 E0.00215

G1 X81.489 Y96.508 E0.00261

G1 X81.469 Y96.431 E0.00206

G1 X81.469 Y95.652 E0.02030

G1 X81.517 Y95.510 E0.00391

G1 X81.650 Y95.406 E0.00438

G1 X81.768 Y95.378 E0.00316

G1 X92.719 Y95.375 E0.28533

G1 X92.826 Y95.396 E0.00287

G1 X92.943 Y95.473 E0.00365

G1 X93.008 Y95.612 E0.00399

G1 X93.015 Y96.382 E0.02006

G1 X92.988 Y96.474 E0.00252

M204 S1250

G1 X92.851 Y96.535 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.891 Y96.621 E-0.09768

G1 X92.709 Y96.675 E-0.10514

G1 X91.429 Y96.676 E-0.70918

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X92.594 Y91.490

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.091 Y91.477 E0.16945

G1 X81.890 Y91.492 E0.10946

G1 X81.891 Y91.030 E0.01204

G1 X84.243 Y91.002 E0.06127

G1 X87.336 Y91.025 E0.08061

G1 X92.594 Y91.010 E0.13700

G1 X92.594 Y91.430 E0.01094

M204 S1250

G1 X92.891 Y91.859 F9000.000

M204 S800

G1 F1500.000

G1 X92.741 Y91.908 E0.00411

G1 X86.091 Y91.895 E0.17327

G1 X81.765 Y91.910 E0.11274

G1 X81.626 Y91.880 E0.00369

G1 X81.578 Y91.849 E0.00150

G1 X81.497 Y91.731 E0.00373

G1 X81.472 Y91.637 E0.00252

G1 X81.474 Y90.856 E0.02037

G1 X81.558 Y90.696 E0.00470

G1 X81.620 Y90.650 E0.00201

G1 X81.759 Y90.614 E0.00373

G1 X84.242 Y90.584 E0.06470

G1 X87.337 Y90.607 E0.08066

G1 X92.710 Y90.592 E0.13998

G1 X92.784 Y90.613 E0.00201

G1 X92.941 Y90.708 E0.00479

G1 X92.993 Y90.788 E0.00247

G1 X93.012 Y90.857 E0.00187

G1 X93.012 Y91.632 E0.02020

G1 X92.933 Y91.817 E0.00525

M204 S1250

G1 X92.743 Y91.804 F9000.000

G1 X92.385 Y91.250

G1 F2400.000

G1 X90.872 Y91.250 E0.00576

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.385 Y91.250 E-0.83875

G1 E-0.12125 F4200.00000

G1 Z7.600 F9000.000

G1 X85.148 Y91.244

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X83.057 Y91.252 E0.00829

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.703 Y91.246 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X81.887 Y83.266

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y82.798 E0.01219

G1 X92.592 Y82.794 E0.27894

G1 X92.596 Y83.260 E0.01212

G1 X81.947 Y83.265 E0.27748

M204 S1250

G1 X81.612 Y83.642 F9000.000

M204 S800

G1 F1500.000

G1 X81.547 Y83.591 E0.00216

G1 X81.489 Y83.510 E0.00260

G1 X81.469 Y83.433 E0.00206

G1 X81.469 Y82.654 E0.02031

G1 X81.517 Y82.512 E0.00391

G1 X81.650 Y82.408 E0.00438

G1 X81.768 Y82.380 E0.00316

G1 X92.719 Y82.377 E0.28533

G1 X92.826 Y82.398 E0.00287

G1 X92.943 Y82.475 E0.00364

G1 X93.008 Y82.615 E0.00401

G1 X93.015 Y83.384 E0.02004

G1 X92.971 Y83.534 E0.00409

G1 X92.891 Y83.624 E0.00314

G1 X92.709 Y83.677 E0.00494

G1 X81.770 Y83.683 E0.28502

G1 X81.670 Y83.658 E0.00268

M204 S1250

G1 X81.606 Y83.560 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.547 Y83.591 E-0.07758

G1 X81.489 Y83.510 E-0.05539

G1 X81.469 Y83.433 E-0.04392

G1 X81.469 Y82.654 E-0.43201

G1 X81.517 Y82.512 E-0.08319

G1 X81.650 Y82.408 E-0.09315

G1 X81.768 Y82.380 E-0.06718

G1 X81.875 Y82.380 E-0.05959

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X81.890 Y78.494

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.891 Y78.032 E0.01204

G1 X84.243 Y78.004 E0.06127

G1 X87.336 Y78.027 E0.08061

G1 X92.594 Y78.012 E0.13700

G1 X92.594 Y78.492 E0.01251

G1 X86.091 Y78.479 E0.16945

G1 X81.950 Y78.494 E0.10789

M204 S1250

G1 X81.578 Y78.851 F9000.000

M204 S800

G1 F1500.000

G1 X81.497 Y78.733 E0.00373

G1 X81.472 Y78.639 E0.00252

G1 X81.474 Y77.858 E0.02037

G1 X81.558 Y77.698 E0.00470

G1 X81.620 Y77.652 E0.00203

G1 X81.759 Y77.616 E0.00372

G1 X84.242 Y77.586 E0.06470

G1 X87.337 Y77.609 E0.08066

G1 X92.710 Y77.594 E0.13998

G1 X92.784 Y77.615 E0.00201

G1 X92.941 Y77.710 E0.00479

G1 X92.993 Y77.789 E0.00247

G1 X93.012 Y77.860 E0.00190

G1 X93.012 Y78.634 E0.02018

G1 X92.928 Y78.831 E0.00559

G1 X92.891 Y78.861 E0.00123

G1 X92.741 Y78.910 E0.00412

G1 X86.091 Y78.897 E0.17326

G1 X81.765 Y78.912 E0.11274

G1 X81.628 Y78.883 E0.00363

M204 S1250

G1 X81.596 Y78.709 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.497 Y78.733 E-0.11046

G1 X81.472 Y78.639 E-0.05358

G1 X81.474 Y77.858 E-0.43314

G1 X81.558 Y77.698 E-0.09987

G1 X81.620 Y77.652 E-0.04319

G1 X81.759 Y77.616 E-0.07917

G1 X81.926 Y77.614 E-0.09258

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X83.047 Y78.254

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X85.167 Y78.247 E0.00842

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.521 Y78.252 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X90.811 Y78.253

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X92.385 Y78.252 E0.00602

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.811 Y78.253 E-0.87259

G1 E-0.08741 F4200.00000

G1 Z7.600 F9000.000

G1 X92.596 Y70.262

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y70.268 E0.27904

G1 X81.887 Y69.800 E0.01219

G1 X92.592 Y69.796 E0.27894

G1 X92.596 Y70.202 E0.01056

M204 S1250

G1 X92.971 Y70.536 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y70.626 E0.00314

G1 X92.709 Y70.679 E0.00494

G1 X81.770 Y70.685 E0.28502

G1 X81.612 Y70.644 E0.00424

G1 X81.547 Y70.593 E0.00216

G1 X81.489 Y70.512 E0.00260

G1 X81.469 Y70.435 E0.00207

G1 X81.469 Y69.656 E0.02031

G1 X81.517 Y69.514 E0.00391

G1 X81.650 Y69.410 E0.00438

G1 X81.768 Y69.382 E0.00316

G1 X92.719 Y69.379 E0.28533

G1 X92.826 Y69.400 E0.00287

G1 X92.943 Y69.477 E0.00364

G1 X93.008 Y69.617 E0.00401

G1 X93.015 Y70.386 E0.02004

G1 X92.988 Y70.479 E0.00252

M204 S1250

G1 X92.851 Y70.539 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.891 Y70.626 E-0.09785

G1 X92.709 Y70.679 E-0.10511

G1 X91.429 Y70.680 E-0.70904

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X92.594 Y65.495

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.091 Y65.481 E0.16945

G1 X81.890 Y65.497 E0.10946

G1 X81.891 Y65.034 E0.01206

G1 X84.243 Y65.006 E0.06127

G1 X87.336 Y65.029 E0.08061

G1 X92.594 Y65.014 E0.13700

G1 X92.594 Y65.435 E0.01097

M204 S1250

G1 X92.892 Y65.863 F9000.000

M204 S800

G1 F1500.000

G1 X92.741 Y65.913 E0.00414

G1 X86.091 Y65.899 E0.17326

G1 X81.765 Y65.915 E0.11272

G1 X81.627 Y65.885 E0.00370

G1 X81.578 Y65.853 E0.00152

G1 X81.497 Y65.735 E0.00373

G1 X81.472 Y65.641 E0.00252

G1 X81.474 Y64.860 E0.02036

G1 X81.558 Y64.700 E0.00470

G1 X81.620 Y64.654 E0.00203

G1 X81.759 Y64.618 E0.00372

G1 X84.242 Y64.588 E0.06470

G1 X87.337 Y64.611 E0.08066

G1 X92.709 Y64.596 E0.13996

G1 X92.784 Y64.618 E0.00203

G1 X92.941 Y64.712 E0.00479

G1 X92.993 Y64.792 E0.00248

G1 X93.012 Y64.862 E0.00189

G1 X93.012 Y65.636 E0.02019

G1 X92.933 Y65.822 E0.00525

M204 S1250

G1 X92.743 Y65.809 F9000.000

G1 X92.385 Y65.254

G1 F2400.000

G1 X90.711 Y65.255 E0.00647

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.357 Y65.254 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X85.186 Y65.249

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X82.962 Y65.257 E0.00890

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.608 Y65.251 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X81.887 Y57.270

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y56.802 E0.01217

G1 X92.592 Y56.799 E0.27894

G1 X92.596 Y57.264 E0.01211

G1 X81.947 Y57.270 E0.27748

M204 S1250

G1 X81.612 Y57.647 F9000.000

M204 S800

G1 F1500.000

G1 X81.547 Y57.595 E0.00216

G1 X81.489 Y57.514 E0.00261

G1 X81.469 Y57.437 E0.00207

G1 X81.469 Y56.658 E0.02029

G1 X81.517 Y56.516 E0.00393

G1 X81.650 Y56.413 E0.00437

G1 X81.768 Y56.385 E0.00315

G1 X92.719 Y56.381 E0.28535

G1 X92.827 Y56.403 E0.00286

G1 X92.943 Y56.479 E0.00363

G1 X93.008 Y56.619 E0.00401

G1 X93.015 Y57.388 E0.02004

G1 X92.971 Y57.538 E0.00409

G1 X92.891 Y57.628 E0.00314

G1 X92.709 Y57.681 E0.00494

G1 X81.770 Y57.687 E0.28502

G1 X81.670 Y57.662 E0.00267

M204 S1250

G1 X81.606 Y57.564 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.547 Y57.595 E-0.07758

G1 X81.489 Y57.514 E-0.05547

G1 X81.469 Y57.437 E-0.04392

G1 X81.469 Y56.658 E-0.43161

G1 X81.517 Y56.516 E-0.08359

G1 X81.650 Y56.413 E-0.09295

G1 X81.768 Y56.385 E-0.06710

G1 X81.875 Y56.385 E-0.05979

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X81.890 Y52.499

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.891 Y52.037 E0.01204

G1 X84.243 Y52.009 E0.06127

G1 X87.336 Y52.031 E0.08061

G1 X92.594 Y52.016 E0.13700

G1 X92.594 Y52.497 E0.01253

G1 X86.091 Y52.483 E0.16945

G1 X81.950 Y52.499 E0.10789

M204 S1250

G1 X81.578 Y52.856 F9000.000

M204 S800

G1 F1500.000

G1 X81.497 Y52.737 E0.00375

G1 X81.472 Y52.644 E0.00250

G1 X81.474 Y51.862 E0.02038

G1 X81.558 Y51.702 E0.00470

G1 X81.620 Y51.656 E0.00202

G1 X81.758 Y51.621 E0.00371

G1 X84.242 Y51.591 E0.06471

M73 P71 R20

G1 X87.337 Y51.613 E0.08066

G1 X92.709 Y51.598 E0.13996

G1 X92.783 Y51.619 E0.00202

G1 X92.941 Y51.715 E0.00481

G1 X92.993 Y51.794 E0.00247

G1 X93.012 Y51.864 E0.00188

G1 X93.012 Y52.639 E0.02020

G1 X92.928 Y52.836 E0.00557

G1 X92.892 Y52.865 E0.00122

G1 X92.741 Y52.915 E0.00414

G1 X86.091 Y52.901 E0.17326

G1 X81.765 Y52.917 E0.11274

G1 X81.628 Y52.888 E0.00363

M204 S1250

G1 X81.597 Y52.713 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.497 Y52.737 E-0.11092

G1 X81.472 Y52.644 E-0.05326

G1 X81.474 Y51.862 E-0.43335

G1 X81.558 Y51.702 E-0.09987

G1 X81.620 Y51.656 E-0.04296

G1 X81.758 Y51.621 E-0.07900

G1 X81.925 Y51.619 E-0.09263

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X83.086 Y52.259

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X85.114 Y52.251 E0.00799

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.468 Y52.257 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X90.732 Y52.257

G1 Z7.400

G1 E3.20000 F2400.00000

G1 X92.385 Y52.256 E0.00639

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y52.257 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.600 F9000.000

G1 X92.596 Y44.266

G1 Z7.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.272 E0.27904

G1 X81.887 Y43.805 E0.01216

G1 X92.592 Y43.801 E0.27894

G1 X92.596 Y44.206 E0.01053

M204 S1250

G1 X92.971 Y44.540 F9000.000

M204 S800

G1 F1500.000

G1 X92.891 Y44.630 E0.00314

G1 X92.709 Y44.683 E0.00494

G1 X81.770 Y44.689 E0.28502

G1 X81.612 Y44.649 E0.00423

G1 X81.547 Y44.597 E0.00216

G1 X81.489 Y44.516 E0.00260

G1 X81.469 Y44.439 E0.00207

G1 X81.469 Y43.660 E0.02029

G1 X81.517 Y43.518 E0.00392

G1 X81.650 Y43.415 E0.00438

G1 X81.767 Y43.387 E0.00315

G1 X92.719 Y43.384 E0.28536

G1 X92.827 Y43.405 E0.00286

G1 X92.943 Y43.481 E0.00362

G1 X93.008 Y43.621 E0.00401

G1 X93.015 Y44.390 E0.02004

G1 X92.988 Y44.483 E0.00252

M204 S1250

G1 X92.851 Y44.543 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;7.55

G1 Z7.550 F9000.000

;AFTER\_LAYER\_CHANGE

;7.55

G1 E-3.20000 F4200.00000

G1 Z7.750 F9000.000

G1 X92.595 Y117.001

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y117.479 E0.01246

G1 X86.673 Y117.468 E0.15429

G1 X81.888 Y117.486 E0.12470

G1 X81.889 Y117.021 E0.01212

G1 X84.242 Y116.998 E0.06131

G1 X88.043 Y117.026 E0.09905

G1 X92.535 Y117.001 E0.11704

M204 S1250

G1 X92.947 Y116.711 F9000.000

M204 S800

G1 F1500.000

G1 X93.013 Y116.850 E0.00401

G1 X93.013 Y117.632 E0.02039

G1 X92.955 Y117.788 E0.00433

G1 X92.876 Y117.868 E0.00293

G1 X92.804 Y117.897 E0.00200

G1 X86.674 Y117.886 E0.15973

G1 X81.768 Y117.904 E0.12783

G1 X81.579 Y117.849 E0.00513

G1 X81.488 Y117.704 E0.00446

G1 X81.470 Y117.624 E0.00215

G1 X81.471 Y116.843 E0.02034

G1 X81.486 Y116.793 E0.00136

G1 X81.535 Y116.711 E0.00249

G1 X81.606 Y116.653 E0.00239

G1 X81.774 Y116.604 E0.00455

G1 X84.241 Y116.580 E0.06429

G1 X88.044 Y116.608 E0.09907

G1 X92.705 Y116.582 E0.12146

G1 X92.799 Y116.614 E0.00259

G1 X92.897 Y116.678 E0.00304

M204 S1250

G1 X92.888 Y116.853 F9000.000

G1 X92.386 Y117.240

G1 F2400.000

G1 X91.687 Y117.241 E0.00256

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.386 Y117.240 E-0.38708

G1 E-0.57292 F4200.00000

G1 Z7.750 F9000.000

G1 X84.953 Y117.239

G1 Z7.550

G1 E3.20000 F2400.00000

G1 X82.973 Y117.246 E0.00760

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.618 Y117.240 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X81.887 Y109.254

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y108.790 E0.01208

G1 X92.588 Y108.795 E0.27881

G1 X92.596 Y109.248 E0.01180

G1 X81.947 Y109.254 E0.27747

M204 S1250

G1 X81.602 Y109.622 F9000.000

M204 S800

G1 F1500.000

G1 X81.492 Y109.513 E0.00403

G1 X81.469 Y109.417 E0.00256

G1 X81.469 Y108.633 E0.02044

G1 X81.506 Y108.521 E0.00307

G1 X81.653 Y108.402 E0.00492

G1 X81.770 Y108.372 E0.00313

G1 X92.756 Y108.377 E0.28625

G1 X92.873 Y108.413 E0.00320

G1 X92.940 Y108.462 E0.00216

G1 X93.002 Y108.599 E0.00391

G1 X93.016 Y109.338 E0.01927

G1 X92.965 Y109.537 E0.00535

G1 X92.888 Y109.616 E0.00289

G1 X92.711 Y109.665 E0.00479

G1 X81.773 Y109.672 E0.28498

G1 X81.660 Y109.639 E0.00308

M204 S1250

G1 X81.602 Y109.467 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.492 Y109.513 E-0.11607

G1 X81.469 Y109.417 E-0.05445

G1 X81.469 Y108.633 E-0.43463

G1 X81.506 Y108.521 E-0.06536

G1 X81.653 Y108.402 E-0.10467

G1 X81.770 Y108.372 E-0.06653

G1 X81.896 Y108.373 E-0.07029

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X81.888 Y104.488

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.889 Y104.023 E0.01212

G1 X84.242 Y104.000 E0.06131

G1 X88.043 Y104.028 E0.09905

G1 X92.595 Y104.003 E0.11860

G1 X92.595 Y104.481 E0.01245

G1 X86.673 Y104.471 E0.15429

G1 X81.948 Y104.488 E0.12314

M204 S1250

G1 X81.603 Y104.866 F9000.000

M204 S800

G1 F1500.000

G1 X81.488 Y104.707 E0.00513

G1 X81.470 Y104.626 E0.00216

G1 X81.471 Y103.846 E0.02033

G1 X81.535 Y103.714 E0.00381

G1 X81.606 Y103.656 E0.00239

G1 X81.774 Y103.606 E0.00458

G1 X84.241 Y103.582 E0.06428

G1 X88.044 Y103.610 E0.09907

G1 X92.705 Y103.585 E0.12147

G1 X92.800 Y103.616 E0.00259

G1 X92.947 Y103.713 E0.00459

G1 X93.013 Y103.852 E0.00401

G1 X93.013 Y104.634 E0.02039

G1 X92.955 Y104.790 E0.00433

G1 X92.876 Y104.871 E0.00295

G1 X92.805 Y104.899 E0.00198

G1 X86.674 Y104.889 E0.15975

G1 X81.768 Y104.906 E0.12783

G1 X81.662 Y104.880 E0.00285

M204 S1250

G1 X81.625 Y104.670 F9000.000

G1 X82.949 Y104.249

G1 F2400.000

G1 X84.988 Y104.241 E0.00786

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.342 Y104.247 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X91.722 Y104.244

G1 Z7.550

G1 E3.20000 F2400.00000

G1 X92.386 Y104.242 E0.00242

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.722 Y104.244 E-0.36817

G1 E-0.59183 F4200.00000

G1 Z7.750 F9000.000

G1 X92.596 Y96.250

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.256 E0.27903

G1 X81.887 Y95.792 E0.01208

G1 X92.588 Y95.797 E0.27881

G1 X92.595 Y96.190 E0.01023

M204 S1250

G1 X92.965 Y96.539 F9000.000

M204 S800

G1 F1500.000

G1 X92.888 Y96.619 E0.00289

G1 X92.711 Y96.667 E0.00478

G1 X81.773 Y96.674 E0.28499

G1 X81.601 Y96.624 E0.00466

G1 X81.492 Y96.515 E0.00401

G1 X81.469 Y96.420 E0.00255

G1 X81.469 Y95.635 E0.02045

G1 X81.506 Y95.523 E0.00307

G1 X81.654 Y95.405 E0.00492

G1 X81.770 Y95.374 E0.00314

G1 X92.755 Y95.379 E0.28623

G1 X92.872 Y95.415 E0.00320

G1 X92.940 Y95.465 E0.00218

G1 X93.002 Y95.601 E0.00389

G1 X93.016 Y96.340 E0.01927

G1 X92.980 Y96.481 E0.00379

M204 S1250

G1 X92.854 Y96.539 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y96.619 E-0.09184

G1 X92.711 Y96.667 E-0.10164

G1 X91.414 Y96.668 E-0.71852

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X92.595 Y91.483

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.673 Y91.473 E0.15429

G1 X81.888 Y91.490 E0.12470

G1 X81.889 Y91.025 E0.01211

G1 X84.242 Y91.002 E0.06132

G1 X88.043 Y91.030 E0.09904

G1 X92.595 Y91.006 E0.11860

G1 X92.595 Y91.423 E0.01087

M204 S1250

G1 X92.955 Y91.792 F9000.000

M204 S800

G1 F1500.000

G1 X92.876 Y91.873 E0.00294

G1 X92.805 Y91.901 E0.00198

G1 X86.674 Y91.891 E0.15975

G1 X81.768 Y91.908 E0.12784

G1 X81.579 Y91.854 E0.00512

G1 X81.488 Y91.709 E0.00445

G1 X81.470 Y91.628 E0.00217

G1 X81.471 Y90.848 E0.02033

G1 X81.535 Y90.716 E0.00382

G1 X81.610 Y90.654 E0.00252

G1 X81.763 Y90.609 E0.00416

G1 X84.241 Y90.584 E0.06458

G1 X88.044 Y90.612 E0.09907

G1 X92.715 Y90.587 E0.12171

G1 X92.793 Y90.614 E0.00216

G1 X92.947 Y90.716 E0.00481

G1 X93.013 Y90.854 E0.00398

G1 X93.013 Y91.636 E0.02039

G1 X92.976 Y91.736 E0.00277

M204 S1250

G1 X92.842 Y91.791 F9000.000

G1 X92.386 Y91.245

G1 F2400.000

G1 X91.784 Y91.246 E0.00217

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.386 Y91.245 E-0.33371

G1 E-0.62629 F4200.00000

G1 Z7.750 F9000.000

G1 X84.988 Y91.243

G1 Z7.550

G1 E3.20000 F2400.00000

G1 X82.985 Y91.250 E0.00772

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.631 Y91.245 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X81.887 Y83.258

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y82.794 E0.01209

G1 X92.588 Y82.799 E0.27881

G1 X92.596 Y83.253 E0.01182

G1 X81.947 Y83.258 E0.27747

M204 S1250

G1 X81.602 Y83.627 F9000.000

M204 S800

G1 F1500.000

G1 X81.492 Y83.517 E0.00403

G1 X81.469 Y83.422 E0.00255

G1 X81.469 Y82.637 E0.02046

G1 X81.506 Y82.525 E0.00307

G1 X81.654 Y82.407 E0.00492

G1 X81.770 Y82.376 E0.00314

G1 X92.755 Y82.381 E0.28623

G1 X92.872 Y82.417 E0.00320

G1 X92.940 Y82.467 E0.00218

G1 X93.002 Y82.603 E0.00391

G1 X93.016 Y83.342 E0.01925

G1 X92.965 Y83.541 E0.00536

G1 X92.888 Y83.621 E0.00290

G1 X92.711 Y83.670 E0.00478

G1 X81.773 Y83.676 E0.28499

G1 X81.659 Y83.643 E0.00308

M204 S1250

G1 X81.602 Y83.472 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.492 Y83.517 E-0.11596

G1 X81.469 Y83.422 E-0.05432

G1 X81.469 Y82.637 E-0.43506

G1 X81.506 Y82.525 E-0.06523

G1 X81.654 Y82.407 E-0.10464

G1 X81.770 Y82.376 E-0.06679

G1 X81.896 Y82.377 E-0.06999

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X81.888 Y78.492

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.889 Y78.027 E0.01211

G1 X84.242 Y78.004 E0.06132

G1 X88.043 Y78.032 E0.09904

G1 X92.595 Y78.008 E0.11860

G1 X92.595 Y78.486 E0.01246

G1 X86.674 Y78.475 E0.15428

G1 X81.948 Y78.492 E0.12314

M204 S1250

G1 X81.604 Y78.871 F9000.000

M204 S800

G1 F1500.000

G1 X81.488 Y78.711 E0.00513

G1 X81.470 Y78.630 E0.00217

G1 X81.471 Y77.850 E0.02033

G1 X81.535 Y77.718 E0.00381

G1 X81.610 Y77.656 E0.00253

G1 X81.763 Y77.611 E0.00416

G1 X84.241 Y77.586 E0.06458

G1 X88.044 Y77.614 E0.09907

G1 X92.715 Y77.589 E0.12171

G1 X92.793 Y77.616 E0.00216

G1 X92.947 Y77.718 E0.00481

G1 X93.013 Y77.856 E0.00400

G1 X93.013 Y78.638 E0.02038

G1 X92.955 Y78.794 E0.00434

G1 X92.875 Y78.876 E0.00296

G1 X92.804 Y78.904 E0.00199

G1 X86.674 Y78.893 E0.15974

G1 X81.768 Y78.910 E0.12784

G1 X81.662 Y78.885 E0.00283

M204 S1250

G1 X81.625 Y78.675 F9000.000

G1 X82.968 Y78.253

G1 F2400.000

G1 X85.013 Y78.245 E0.00791

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.367 Y78.251 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X91.666 Y78.248

G1 Z7.550

G1 E3.20000 F2400.00000

G1 X92.386 Y78.247 E0.00264

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.666 Y78.248 E-0.39919

G1 E-0.56081 F4200.00000

G1 Z7.750 F9000.000

G1 X92.596 Y70.255

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y70.260 E0.27903

G1 X81.887 Y69.796 E0.01209

G1 X92.588 Y69.801 E0.27881

G1 X92.595 Y70.195 E0.01026

M204 S1250

G1 X92.965 Y70.543 F9000.000

M204 S800

G1 F1500.000

G1 X92.888 Y70.623 E0.00290

G1 X92.711 Y70.672 E0.00478

G1 X81.773 Y70.678 E0.28499

G1 X81.602 Y70.629 E0.00464

G1 X81.492 Y70.519 E0.00403

G1 X81.469 Y70.424 E0.00255

G1 X81.469 Y69.639 E0.02046

G1 X81.506 Y69.527 E0.00307

G1 X81.654 Y69.409 E0.00492

G1 X81.770 Y69.378 E0.00314

G1 X92.755 Y69.383 E0.28622

G1 X92.872 Y69.420 E0.00320

G1 X92.940 Y69.469 E0.00218

G1 X93.002 Y69.605 E0.00390

G1 X93.016 Y70.344 E0.01925

G1 X92.980 Y70.485 E0.00379

M204 S1250

G1 X92.854 Y70.543 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y70.623 E-0.09210

G1 X92.711 Y70.672 E-0.10174

G1 X91.415 Y70.673 E-0.71816

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X92.595 Y65.488

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.673 Y65.477 E0.15429

G1 X81.888 Y65.495 E0.12470

G1 X81.889 Y65.029 E0.01213

G1 X84.242 Y65.006 E0.06132

G1 X88.043 Y65.034 E0.09904

G1 X92.595 Y65.010 E0.11860

G1 X92.595 Y65.428 E0.01090

M204 S1250

G1 X92.955 Y65.797 F9000.000

M204 S800

G1 F1500.000

G1 X92.876 Y65.877 E0.00293

G1 X92.804 Y65.906 E0.00200

G1 X86.674 Y65.895 E0.15973

G1 X81.768 Y65.913 E0.12783

G1 X81.579 Y65.858 E0.00514

G1 X81.488 Y65.713 E0.00445

G1 X81.470 Y65.632 E0.00217

G1 X81.471 Y64.852 E0.02033

G1 X81.535 Y64.720 E0.00381

G1 X81.610 Y64.658 E0.00253

G1 X81.763 Y64.613 E0.00416

G1 X84.241 Y64.588 E0.06458

G1 X88.044 Y64.616 E0.09907

G1 X92.705 Y64.591 E0.12146

G1 X92.799 Y64.623 E0.00260

G1 X92.947 Y64.720 E0.00459

G1 X93.013 Y64.859 E0.00401

G1 X93.013 Y65.641 E0.02037

G1 X92.975 Y65.741 E0.00279

M204 S1250

G1 X92.842 Y65.796 F9000.000

G1 X92.386 Y65.249

G1 F2400.000

G1 X91.656 Y65.250 E0.00267

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.386 Y65.249 E-0.40435

G1 E-0.55565 F4200.00000

G1 Z7.750 F9000.000

G1 X85.044 Y65.248

G1 Z7.550

G1 E3.20000 F2400.00000

G1 X82.849 Y65.256 E0.00856

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.494 Y65.250 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X81.887 Y57.262

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y56.799 E0.01206

G1 X92.588 Y56.804 E0.27882

G1 X92.596 Y57.257 E0.01180

G1 X81.947 Y57.262 E0.27747

M204 S1250

G1 X81.602 Y57.631 F9000.000

M204 S800

G1 F1500.000

G1 X81.492 Y57.521 E0.00403

G1 X81.469 Y57.426 E0.00255

G1 X81.469 Y56.642 E0.02043

G1 X81.506 Y56.529 E0.00309

G1 X81.653 Y56.411 E0.00491

G1 X81.770 Y56.381 E0.00313

G1 X92.756 Y56.386 E0.28625

G1 X92.873 Y56.422 E0.00320

G1 X92.940 Y56.471 E0.00216

G1 X93.002 Y56.607 E0.00390

G1 X93.016 Y57.346 E0.01925

G1 X92.965 Y57.546 E0.00536

G1 X92.888 Y57.625 E0.00290

G1 X92.711 Y57.674 E0.00479

G1 X81.773 Y57.680 E0.28499

G1 X81.659 Y57.647 E0.00308

M204 S1250

G1 X81.602 Y57.476 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.492 Y57.521 E-0.11597

G1 X81.469 Y57.426 E-0.05432

G1 X81.469 Y56.642 E-0.43461

G1 X81.506 Y56.529 E-0.06566

G1 X81.653 Y56.411 E-0.10438

G1 X81.770 Y56.381 E-0.06667

G1 X81.897 Y56.381 E-0.07040

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X81.888 Y52.497

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.889 Y52.032 E0.01212

G1 X84.242 Y52.009 E0.06132

G1 X88.043 Y52.036 E0.09905

G1 X92.595 Y52.012 E0.11860

G1 X92.595 Y52.490 E0.01246

G1 X86.673 Y52.479 E0.15429

G1 X81.948 Y52.497 E0.12314

M204 S1250

G1 X81.579 Y52.860 F9000.000

M204 S800

G1 F1500.000

G1 X81.488 Y52.715 E0.00446

G1 X81.470 Y52.635 E0.00215

G1 X81.471 Y51.854 E0.02034

G1 X81.535 Y51.722 E0.00382

G1 X81.606 Y51.664 E0.00238

G1 X81.774 Y51.615 E0.00456

G1 X84.241 Y51.591 E0.06429

G1 X88.044 Y51.618 E0.09907

G1 X92.705 Y51.593 E0.12146

G1 X92.799 Y51.625 E0.00259

G1 X92.947 Y51.722 E0.00460

G1 X93.013 Y51.861 E0.00401

G1 X93.013 Y52.643 E0.02037

G1 X92.955 Y52.799 E0.00435

G1 X92.876 Y52.879 E0.00293

G1 X92.804 Y52.908 E0.00200

G1 X86.674 Y52.897 E0.15973

G1 X81.768 Y52.915 E0.12783

G1 X81.634 Y52.883 E0.00359

M204 S1250

G1 X81.605 Y52.691 F9000.000

G1 X82.973 Y52.257

G1 F2400.000

G1 X84.968 Y52.250 E0.00765

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.322 Y52.256 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.750 F9000.000

G1 X91.659 Y52.252

G1 Z7.550

G1 E3.20000 F2400.00000

G1 X92.386 Y52.251 E0.00266

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.659 Y52.252 E-0.40256

G1 E-0.55744 F4200.00000

G1 Z7.750 F9000.000

G1 X92.596 Y44.259

G1 Z7.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.264 E0.27903

G1 X81.887 Y43.801 E0.01206

G1 X92.588 Y43.806 E0.27881

G1 X92.595 Y44.199 E0.01024

M204 S1250

G1 X92.965 Y44.548 F9000.000

M204 S800

G1 F1500.000

G1 X92.888 Y44.627 E0.00290

G1 X92.711 Y44.676 E0.00479

G1 X81.773 Y44.682 E0.28499

G1 X81.602 Y44.633 E0.00464

G1 X81.492 Y44.524 E0.00403

G1 X81.469 Y44.428 E0.00256

G1 X81.469 Y43.644 E0.02044

G1 X81.506 Y43.532 E0.00307

G1 X81.653 Y43.413 E0.00492

G1 X81.770 Y43.383 E0.00313

G1 X92.756 Y43.388 E0.28625

G1 X92.873 Y43.424 E0.00320

G1 X92.940 Y43.473 E0.00216

G1 X93.002 Y43.610 E0.00391

G1 X93.016 Y44.348 E0.01925

G1 X92.980 Y44.489 E0.00380

M204 S1250

G1 X92.854 Y44.547 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;7.7

G1 Z7.700 F9000.000

;AFTER\_LAYER\_CHANGE

;7.7

G1 E-3.20000 F4200.00000

G1 Z7.900 F9000.000

G1 X92.595 Y116.996

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y117.474 E0.01245

G1 X87.256 Y117.465 E0.13912

G1 X81.888 Y117.484 E0.13988

G1 X81.896 Y117.018 E0.01215

G1 X84.242 Y116.998 E0.06111

G1 X86.445 Y117.014 E0.05740

G1 X92.535 Y116.996 E0.15870

M204 S1250

G1 X92.950 Y116.708 F9000.000

M204 S800

G1 F1500.000

G1 X93.013 Y116.844 E0.00390

G1 X93.013 Y117.637 E0.02068

G1 X92.981 Y117.740 E0.00280

G1 X92.876 Y117.859 E0.00414

G1 X92.787 Y117.892 E0.00249

G1 X87.256 Y117.883 E0.14409

G1 X81.770 Y117.903 E0.14294

G1 X81.578 Y117.843 E0.00524

G1 X81.478 Y117.681 E0.00495

G1 X81.467 Y117.618 E0.00168

G1 X81.482 Y116.826 E0.02063

G1 X81.542 Y116.699 E0.00367

G1 X81.585 Y116.660 E0.00151

G1 X81.776 Y116.601 E0.00519

G1 X84.241 Y116.580 E0.06424

G1 X86.446 Y116.596 E0.05744

G1 X92.713 Y116.578 E0.16331

G1 X92.814 Y116.613 E0.00279

G1 X92.900 Y116.674 E0.00274

M204 S1250

G1 X92.891 Y116.846 F9000.000

G1 X92.386 Y117.235

G1 F2400.000

G1 X91.248 Y117.236 E0.00419

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.386 Y117.235 E-0.63109

G1 E-0.32891 F4200.00000

G1 Z7.900 F9000.000

G1 X84.803 Y117.238

G1 Z7.700

G1 E3.20000 F2400.00000

G1 X83.023 Y117.244 E0.00664

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.669 Y117.238 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X81.888 Y104.486

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y104.020 E0.01215

G1 X84.242 Y104.000 E0.06111

G1 X86.445 Y104.016 E0.05740

G1 X92.595 Y103.998 E0.16026

G1 X92.595 Y104.476 E0.01244

G1 X87.256 Y104.467 E0.13912

G1 X81.948 Y104.486 E0.13832

M204 S1250

G1 X81.595 Y104.858 F9000.000

M204 S800

G1 F1500.000

G1 X81.478 Y104.683 E0.00547

G1 X81.467 Y104.620 E0.00168

G1 X81.482 Y103.828 E0.02063

G1 X81.542 Y103.701 E0.00366

G1 X81.585 Y103.663 E0.00151

G1 X81.776 Y103.603 E0.00521

G1 X84.241 Y103.582 E0.06423

G1 X86.445 Y103.598 E0.05743

G1 X92.713 Y103.580 E0.16332

G1 X92.815 Y103.616 E0.00279

G1 X92.950 Y103.710 E0.00429

G1 X93.013 Y103.846 E0.00390

G1 X93.013 Y104.639 E0.02068

G1 X92.981 Y104.742 E0.00281

G1 X92.876 Y104.862 E0.00414

G1 X92.787 Y104.894 E0.00248

G1 X87.256 Y104.885 E0.14410

G1 X81.770 Y104.905 E0.14294

G1 X81.653 Y104.873 E0.00316

M204 S1250

G1 X81.623 Y104.649 F9000.000

G1 X83.002 Y104.247

G1 F2400.000

G1 X84.825 Y104.240 E0.00682

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.179 Y104.246 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X91.328 Y104.238

G1 Z7.700

G1 E3.20000 F2400.00000

G1 X92.386 Y104.237 E0.00386

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.328 Y104.238 E-0.58669

G1 E-0.37331 F4200.00000

G1 Z7.900 F9000.000

G1 X92.593 Y108.800

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y109.263 E0.01206

G1 X81.887 Y109.259 E0.27894

G1 X81.886 Y108.795 E0.01210

G1 X92.533 Y108.800 E0.27740

M204 S1250

G1 X92.855 Y108.417 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y108.454 E0.00200

G1 X93.011 Y108.637 E0.00529

G1 X93.010 Y109.417 E0.02034

G1 X92.974 Y109.530 E0.00308

G1 X92.875 Y109.630 E0.00367

G1 X92.707 Y109.681 E0.00456

G1 X81.769 Y109.677 E0.28500

G1 X81.619 Y109.638 E0.00403

G1 X81.495 Y109.518 E0.00451

G1 X81.469 Y109.407 E0.00297

G1 X81.469 Y108.652 E0.01966

G1 X81.500 Y108.543 E0.00295

G1 X81.657 Y108.403 E0.00550

G1 X81.768 Y108.377 E0.00295

G1 X92.714 Y108.382 E0.28521

G1 X92.797 Y108.403 E0.00222

M204 S1250

G1 X92.869 Y108.493 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y108.454 E-0.07504

G1 X93.011 Y108.637 E-0.11244

G1 X93.010 Y109.417 E-0.43255

G1 X92.974 Y109.530 E-0.06548

G1 X92.875 Y109.630 E-0.07816

G1 X92.707 Y109.681 E-0.09702

G1 X92.615 Y109.681 E-0.05132

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X92.592 Y96.265

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.261 E0.27894

G1 X81.886 Y95.797 E0.01210

G1 X92.593 Y95.802 E0.27897

G1 X92.593 Y96.205 E0.01050

M204 S1250

G1 X92.974 Y96.532 F9000.000

M204 S800

G1 F1500.000

G1 X92.875 Y96.632 E0.00368

G1 X92.708 Y96.683 E0.00455

G1 X81.769 Y96.679 E0.28501

G1 X81.619 Y96.640 E0.00403

G1 X81.495 Y96.519 E0.00452

G1 X81.469 Y96.409 E0.00294

G1 X81.469 Y95.654 E0.01968

G1 X81.500 Y95.546 E0.00294

G1 X81.658 Y95.406 E0.00550

G1 X81.768 Y95.379 E0.00296

G1 X92.713 Y95.384 E0.28519

G1 X92.855 Y95.420 E0.00380

G1 X92.922 Y95.457 E0.00200

G1 X93.011 Y95.639 E0.00527

G1 X93.010 Y96.419 E0.02034

G1 X92.992 Y96.475 E0.00152

M204 S1250

G1 X92.833 Y96.531 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.875 Y96.632 E-0.10893

G1 X92.708 Y96.683 E-0.09670

G1 X91.433 Y96.683 E-0.70637

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X92.595 Y91.478

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.256 Y91.469 E0.13912

G1 X81.888 Y91.488 E0.13988

G1 X81.896 Y91.023 E0.01213

G1 X84.242 Y91.002 E0.06112

G1 X86.444 Y91.018 E0.05738

G1 X92.595 Y91.013 E0.16028

G1 X92.595 Y91.418 E0.01055

M204 S1250

G1 X92.876 Y91.864 F9000.000

M204 S800

G1 F1500.000

G1 X92.787 Y91.896 E0.00248

G1 X87.256 Y91.887 E0.14410

G1 X81.770 Y91.907 E0.14295

G1 X81.578 Y91.847 E0.00523

G1 X81.478 Y91.686 E0.00495

G1 X81.482 Y90.830 E0.02229

G1 X81.542 Y90.703 E0.00367

G1 X81.585 Y90.665 E0.00150

G1 X81.776 Y90.606 E0.00521

G1 X84.241 Y90.584 E0.06424

G1 X86.445 Y90.600 E0.05743

G1 X92.751 Y90.595 E0.16430

G1 X92.950 Y90.713 E0.00602

G1 X93.013 Y90.848 E0.00387

G1 X93.013 Y91.641 E0.02068

G1 X92.981 Y91.744 E0.00281

G1 X92.916 Y91.818 E0.00258

M204 S1250

G1 X92.792 Y91.820 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.787 Y91.896 E-0.08333

G1 X91.292 Y91.894 E-0.82867

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X83.079 Y91.248

G1 Z7.700

G1 E3.20000 F2400.00000

G1 X84.825 Y91.242 E0.00654

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.179 Y91.248 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X81.887 Y83.263

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y82.799 E0.01210

G1 X92.593 Y82.804 E0.27897

G1 X92.592 Y83.268 E0.01208

G1 X81.947 Y83.263 E0.27738

M204 S1250

G1 X81.619 Y83.643 F9000.000

M204 S800

G1 F1500.000

G1 X81.495 Y83.522 E0.00451

G1 X81.469 Y83.412 E0.00296

G1 X81.469 Y82.656 E0.01968

G1 X81.500 Y82.548 E0.00294

G1 X81.658 Y82.408 E0.00550

G1 X81.768 Y82.381 E0.00296

G1 X92.713 Y82.386 E0.28519

G1 X92.855 Y82.422 E0.00380

G1 X92.922 Y82.459 E0.00200

G1 X93.011 Y82.641 E0.00529

G1 X93.010 Y83.422 E0.02033

G1 X92.974 Y83.534 E0.00307

G1 X92.875 Y83.635 E0.00369

G1 X92.708 Y83.686 E0.00455

G1 X81.769 Y83.681 E0.28501

G1 X81.677 Y83.658 E0.00246

M204 S1250

G1 X81.618 Y83.470 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.495 Y83.522 E-0.12577

G1 X81.469 Y83.412 E-0.06291

G1 X81.469 Y82.656 E-0.41862

G1 X81.500 Y82.548 E-0.06245

G1 X81.658 Y82.408 E-0.11706

G1 X81.768 Y82.381 E-0.06296

G1 X81.880 Y82.381 E-0.06224

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X81.888 Y78.490

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y78.025 E0.01213

G1 X84.242 Y78.004 E0.06112

G1 X86.444 Y78.020 E0.05738

G1 X92.595 Y78.015 E0.16028

G1 X92.595 Y78.481 E0.01213

G1 X87.256 Y78.472 E0.13912

G1 X81.948 Y78.490 E0.13832

M204 S1250

G1 X81.596 Y78.862 F9000.000

M204 S800

G1 F1500.000

G1 X81.478 Y78.688 E0.00547

G1 X81.467 Y78.624 E0.00170

G1 X81.482 Y77.832 E0.02062

G1 X81.542 Y77.705 E0.00367

G1 X81.585 Y77.667 E0.00150

G1 X81.776 Y77.608 E0.00521

G1 X84.241 Y77.586 E0.06424

G1 X86.445 Y77.602 E0.05743

G1 X92.751 Y77.597 E0.16430

G1 X92.950 Y77.715 E0.00603

G1 X93.013 Y77.850 E0.00388

G1 X93.013 Y78.643 E0.02066

G1 X92.981 Y78.746 E0.00281

G1 X92.876 Y78.866 E0.00415

G1 X92.786 Y78.899 E0.00248

G1 X87.256 Y78.890 E0.14409

G1 X81.770 Y78.909 E0.14295

G1 X81.654 Y78.878 E0.00314

M204 S1250

G1 X81.623 Y78.654 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.478 Y78.688 E-0.14312

G1 X81.467 Y78.624 E-0.03614

G1 X81.482 Y77.832 E-0.43864

G1 X81.542 Y77.705 E-0.07806

G1 X81.585 Y77.667 E-0.03186

G1 X81.776 Y77.608 E-0.11072

G1 X81.908 Y77.607 E-0.07347

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X84.854 Y78.244

G1 Z7.700

G1 E3.20000 F2400.00000

G1 X83.053 Y78.250 E0.00677

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.698 Y78.245 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X81.888 Y65.493

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y65.027 E0.01215

G1 X84.242 Y65.006 E0.06112

G1 X86.445 Y65.022 E0.05740

G1 X92.595 Y65.005 E0.16027

G1 X92.595 Y65.483 E0.01245

G1 X87.256 Y65.474 E0.13912

G1 X81.948 Y65.493 E0.13832

M204 S1250

G1 X81.596 Y65.865 F9000.000

M204 S800

G1 F1500.000

G1 X81.478 Y65.690 E0.00548

G1 X81.467 Y65.626 E0.00170

G1 X81.482 Y64.834 E0.02062

G1 X81.542 Y64.707 E0.00367

G1 X81.585 Y64.669 E0.00150

G1 X81.776 Y64.610 E0.00521

G1 X84.241 Y64.588 E0.06424

G1 X86.445 Y64.604 E0.05743

G1 X92.713 Y64.587 E0.16331

G1 X92.814 Y64.622 E0.00279

G1 X92.950 Y64.717 E0.00431

G1 X93.013 Y64.852 E0.00389

G1 X93.013 Y65.645 E0.02066

G1 X92.981 Y65.748 E0.00281

G1 X92.876 Y65.868 E0.00415

G1 X92.786 Y65.901 E0.00249

G1 X87.256 Y65.892 E0.14409

G1 X81.770 Y65.912 E0.14294

G1 X81.654 Y65.880 E0.00314

M204 S1250

G1 X81.623 Y65.656 F9000.000

G1 X82.908 Y65.254

G1 F2400.000

G1 X84.895 Y65.247 E0.00754

G1 E-2.24000 F4200.00000

M73 P72 R19

G1 F7200.000

G1 X83.249 Y65.253 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X91.196 Y65.245

G1 Z7.700

G1 E3.20000 F2400.00000

G1 X92.386 Y65.244 E0.00439

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.196 Y65.245 E-0.65980

G1 E-0.30020 F4200.00000

G1 Z7.900 F9000.000

G1 X92.593 Y69.806

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y70.270 E0.01209

G1 X81.887 Y70.265 E0.27894

G1 X81.886 Y69.801 E0.01210

G1 X92.533 Y69.806 E0.27740

M204 S1250

G1 X92.854 Y69.424 F9000.000

M204 S800

G1 F1500.000

G1 X92.922 Y69.461 E0.00201

G1 X93.011 Y69.643 E0.00528

G1 X93.010 Y70.424 E0.02033

G1 X92.974 Y70.536 E0.00307

G1 X92.875 Y70.637 E0.00370

G1 X92.707 Y70.688 E0.00455

G1 X81.769 Y70.683 E0.28501

G1 X81.619 Y70.645 E0.00403

G1 X81.495 Y70.524 E0.00451

G1 X81.469 Y70.414 E0.00296

G1 X81.469 Y69.658 E0.01968

G1 X81.500 Y69.550 E0.00294

G1 X81.658 Y69.410 E0.00550

G1 X81.768 Y69.383 E0.00296

G1 X92.713 Y69.388 E0.28519

G1 X92.796 Y69.409 E0.00222

M204 S1250

G1 X92.868 Y69.500 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.922 Y69.461 E-0.07538

G1 X93.011 Y69.643 E-0.11236

G1 X93.010 Y70.424 E-0.43240

G1 X92.974 Y70.536 E-0.06537

G1 X92.875 Y70.637 E-0.07860

G1 X92.707 Y70.688 E-0.09683

G1 X92.615 Y70.688 E-0.05105

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X92.592 Y57.272

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y57.267 E0.27894

G1 X81.886 Y56.804 E0.01207

G1 X92.593 Y56.809 E0.27897

G1 X92.593 Y57.212 E0.01050

M204 S1250

G1 X92.974 Y57.539 F9000.000

M204 S800

G1 F1500.000

G1 X92.875 Y57.639 E0.00368

G1 X92.707 Y57.690 E0.00456

G1 X81.769 Y57.685 E0.28501

G1 X81.619 Y57.647 E0.00403

G1 X81.495 Y57.526 E0.00451

G1 X81.469 Y57.416 E0.00296

G1 X81.469 Y56.661 E0.01966

G1 X81.500 Y56.552 E0.00296

G1 X81.657 Y56.412 E0.00549

G1 X81.768 Y56.386 E0.00295

G1 X92.714 Y56.391 E0.28521

G1 X92.855 Y56.426 E0.00379

G1 X92.922 Y56.463 E0.00200

G1 X93.011 Y56.645 E0.00528

G1 X93.010 Y57.426 E0.02033

G1 X92.992 Y57.481 E0.00152

M204 S1250

G1 X92.833 Y57.537 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.875 Y57.639 E-0.10891

G1 X92.707 Y57.690 E-0.09695

G1 X91.433 Y57.689 E-0.70615

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X92.595 Y52.485

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.256 Y52.476 E0.13912

G1 X81.888 Y52.495 E0.13988

G1 X81.896 Y52.029 E0.01215

G1 X84.242 Y52.009 E0.06112

G1 X86.445 Y52.025 E0.05740

G1 X92.595 Y52.007 E0.16026

G1 X92.595 Y52.425 E0.01089

M204 S1250

G1 X92.876 Y52.870 F9000.000

M204 S800

G1 F1500.000

G1 X92.786 Y52.903 E0.00249

G1 X87.256 Y52.894 E0.14409

G1 X81.770 Y52.914 E0.14294

G1 X81.578 Y52.854 E0.00524

G1 X81.478 Y52.692 E0.00495

G1 X81.482 Y51.837 E0.02228

G1 X81.542 Y51.709 E0.00368

G1 X81.585 Y51.671 E0.00149

G1 X81.776 Y51.612 E0.00520

G1 X84.241 Y51.591 E0.06424

G1 X86.446 Y51.607 E0.05743

G1 X92.713 Y51.589 E0.16331

G1 X92.814 Y51.624 E0.00279

G1 X92.950 Y51.719 E0.00430

G1 X93.013 Y51.855 E0.00390

G1 X93.013 Y52.647 E0.02065

G1 X92.981 Y52.750 E0.00281

G1 X92.916 Y52.825 E0.00259

M204 S1250

G1 X92.791 Y52.827 F9000.000

G1 X92.386 Y52.246

G1 F2400.000

G1 X91.221 Y52.247 E0.00429

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.386 Y52.246 E-0.64574

G1 E-0.31426 F4200.00000

G1 Z7.900 F9000.000

G1 X84.815 Y52.249

G1 Z7.700

G1 E3.20000 F2400.00000

G1 X83.023 Y52.255 E0.00669

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.669 Y52.249 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z7.900 F9000.000

G1 X81.887 Y44.269

G1 Z7.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y43.806 E0.01208

G1 X92.593 Y43.811 E0.27897

G1 X92.592 Y44.274 E0.01206

G1 X81.947 Y44.269 E0.27738

M204 S1250

G1 X81.619 Y44.649 F9000.000

M204 S800

G1 F1500.000

G1 X81.495 Y44.528 E0.00450

G1 X81.469 Y44.418 E0.00297

G1 X81.469 Y43.663 E0.01966

G1 X81.500 Y43.554 E0.00295

G1 X81.657 Y43.414 E0.00550

G1 X81.768 Y43.388 E0.00295

G1 X92.714 Y43.393 E0.28521

G1 X92.855 Y43.428 E0.00379

G1 X92.922 Y43.465 E0.00200

G1 X93.011 Y43.648 E0.00528

G1 X93.010 Y44.428 E0.02033

G1 X92.974 Y44.541 E0.00308

G1 X92.875 Y44.641 E0.00368

G1 X92.707 Y44.692 E0.00456

G1 X81.769 Y44.687 E0.28501

G1 X81.677 Y44.664 E0.00247

M204 S1250

G1 X81.618 Y44.476 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;7.85

G1 Z7.850 F9000.000

;AFTER\_LAYER\_CHANGE

;7.85

G1 E-3.20000 F4200.00000

G1 Z8.050 F9000.000

G1 X81.896 Y117.005

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y116.998 E0.27879

G1 X92.595 Y117.469 E0.01228

G1 X81.887 Y117.479 E0.27901

G1 X81.895 Y117.065 E0.01077

M204 S1250

G1 X81.542 Y116.678 F9000.000

M204 S800

G1 F1500.000

G1 X81.582 Y116.639 E0.00146

G1 X81.771 Y116.588 E0.00511

G1 X92.734 Y116.580 E0.28566

G1 X92.835 Y116.610 E0.00274

G1 X92.943 Y116.685 E0.00343

G1 X93.014 Y116.850 E0.00466

G1 X93.013 Y117.621 E0.02010

G1 X92.993 Y117.712 E0.00242

G1 X92.882 Y117.845 E0.00452

G1 X92.755 Y117.887 E0.00350

G1 X81.771 Y117.897 E0.28620

G1 X81.599 Y117.851 E0.00463

G1 X81.475 Y117.669 E0.00573

G1 X81.482 Y116.823 E0.02205

G1 X81.519 Y116.734 E0.00251

M204 S1250

G1 X81.598 Y116.680 F9000.000

G1 X82.638 Y117.241

G1 F2400.000

G1 X82.101 Y117.242 E0.00184

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.638 Y117.241 E-0.29763

G1 E-0.66237 F4200.00000

G1 Z8.050 F9000.000

G1 X82.060 Y109.285

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y109.286 E0.00452

G1 X81.886 Y108.812 E0.01235

G1 X92.593 Y108.821 E0.27898

G1 X92.589 Y109.279 E0.01193

G1 X85.753 Y109.266 E0.17812

G1 X82.120 Y109.284 E0.09466

M204 S1250

G1 X81.628 Y109.658 F9000.000

M204 S800

G1 F1500.000

G1 X81.502 Y109.544 E0.00444

G1 X81.469 Y109.421 E0.00329

G1 X81.468 Y108.677 E0.01941

G1 X81.516 Y108.521 E0.00424

G1 X81.655 Y108.404 E0.00474

G1 X81.753 Y108.394 E0.00255

G1 X92.706 Y108.403 E0.28541

G1 X92.919 Y108.456 E0.00571

G1 X92.989 Y108.580 E0.00372

G1 X93.012 Y108.662 E0.00223

G1 X93.005 Y109.463 E0.02085

G1 X92.981 Y109.530 E0.00186

G1 X92.858 Y109.656 E0.00459

G1 X92.711 Y109.697 E0.00398

G1 X85.754 Y109.684 E0.18128

G1 X81.775 Y109.704 E0.10367

G1 X81.685 Y109.676 E0.00245

M204 S1250

G1 X81.623 Y109.488 F9000.000

G1 X82.284 Y109.048

G1 F2400.000

G1 X82.095 Y109.048 E0.00065

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.284 Y109.048 E-0.10464

G1 E-0.85536 F4200.00000

G1 Z8.050 F9000.000

G1 X81.887 Y104.481

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y104.007 E0.01235

G1 X92.596 Y104.000 E0.27879

G1 X92.595 Y104.471 E0.01227

G1 X81.947 Y104.481 E0.27745

M204 S1250

G1 X81.598 Y104.852 F9000.000

M204 S800

G1 F1500.000

G1 X81.475 Y104.671 E0.00571

G1 X81.467 Y104.611 E0.00157

G1 X81.482 Y103.825 E0.02050

G1 X81.542 Y103.680 E0.00407

G1 X81.581 Y103.642 E0.00144

G1 X81.771 Y103.590 E0.00514

G1 X92.735 Y103.583 E0.28566

G1 X92.836 Y103.612 E0.00273

G1 X92.943 Y103.687 E0.00342

G1 X93.014 Y103.852 E0.00466

G1 X93.013 Y104.623 E0.02010

G1 X92.993 Y104.714 E0.00242

G1 X92.882 Y104.847 E0.00452

G1 X92.755 Y104.889 E0.00350

G1 X81.771 Y104.899 E0.28619

G1 X81.656 Y104.868 E0.00310

M204 S1250

G1 X81.626 Y104.635 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.475 Y104.671 E-0.14811

G1 X81.467 Y104.611 E-0.03347

G1 X81.482 Y103.825 E-0.43608

G1 X81.542 Y103.680 E-0.08658

G1 X81.581 Y103.642 E-0.03066

G1 X81.771 Y103.590 E-0.10928

G1 X81.894 Y103.589 E-0.06781

G1 E-0.04800 F4200.00000

G1 Z8.050 F9000.000

G1 X89.474 Y104.238

G1 Z7.850

G1 E3.20000 F2400.00000

G1 X82.101 Y104.244 E0.02569

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.746 Y104.243 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.050 F9000.000

G1 X82.060 Y96.287

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.288 E0.00452

G1 X81.886 Y95.814 E0.01235

G1 X92.593 Y95.823 E0.27898

G1 X92.589 Y96.281 E0.01193

G1 X85.753 Y96.268 E0.17812

G1 X82.120 Y96.286 E0.09466

M204 S1250

G1 X81.628 Y96.660 F9000.000

M204 S800

G1 F1500.000

G1 X81.502 Y96.546 E0.00443

G1 X81.469 Y96.424 E0.00329

G1 X81.468 Y95.679 E0.01942

G1 X81.516 Y95.524 E0.00423

G1 X81.656 Y95.406 E0.00474

G1 X81.753 Y95.396 E0.00256

G1 X92.706 Y95.405 E0.28538

G1 X92.919 Y95.458 E0.00572

G1 X92.989 Y95.582 E0.00372

G1 X93.012 Y95.664 E0.00222

G1 X93.005 Y96.465 E0.02085

G1 X92.981 Y96.532 E0.00187

G1 X92.858 Y96.659 E0.00460

G1 X92.711 Y96.699 E0.00397

G1 X85.754 Y96.686 E0.18129

G1 X81.775 Y96.706 E0.10367

G1 X81.685 Y96.678 E0.00245

M204 S1250

G1 X81.622 Y96.490 F9000.000

G1 X82.284 Y96.050

G1 F2400.000

G1 X82.095 Y96.050 E0.00064

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.284 Y96.050 E-0.10446

G1 E-0.85554 F4200.00000

G1 Z8.050 F9000.000

G1 X81.887 Y91.483

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y91.010 E0.01232

G1 X92.596 Y91.002 E0.27879

G1 X92.595 Y91.473 E0.01227

G1 X81.947 Y91.483 E0.27745

M204 S1250

G1 X81.598 Y91.855 F9000.000

M204 S800

G1 F1500.000

G1 X81.475 Y91.674 E0.00571

G1 X81.467 Y91.614 E0.00159

G1 X81.482 Y90.827 E0.02049

G1 X81.542 Y90.682 E0.00410

G1 X81.581 Y90.644 E0.00143

G1 X81.771 Y90.592 E0.00513

G1 X92.735 Y90.585 E0.28566

G1 X92.835 Y90.614 E0.00273

G1 X92.943 Y90.690 E0.00344

G1 X93.014 Y90.854 E0.00465

G1 X93.013 Y91.625 E0.02010

G1 X92.993 Y91.716 E0.00242

G1 X92.882 Y91.849 E0.00452

G1 X92.755 Y91.891 E0.00350

G1 X81.770 Y91.901 E0.28620

G1 X81.656 Y91.871 E0.00307

M204 S1250

G1 X81.626 Y91.638 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.475 Y91.674 E-0.14818

G1 X81.467 Y91.614 E-0.03376

G1 X81.482 Y90.827 E-0.43573

G1 X81.542 Y90.682 E-0.08710

G1 X81.581 Y90.644 E-0.03037

G1 X81.771 Y90.592 E-0.10916

G1 X81.893 Y90.592 E-0.06770

G1 E-0.04800 F4200.00000

G1 Z8.050 F9000.000

G1 X88.075 Y91.242

G1 Z7.850

G1 E3.20000 F2400.00000

G1 X82.101 Y91.246 E0.02051

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.746 Y91.245 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.050 F9000.000

G1 X82.061 Y83.289

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y83.290 E0.00454

G1 X81.886 Y82.816 E0.01235

G1 X92.593 Y82.825 E0.27898

G1 X92.589 Y83.283 E0.01194

G1 X85.753 Y83.270 E0.17812

G1 X82.121 Y83.289 E0.09464

M204 S1250

G1 X81.628 Y83.663 F9000.000

M204 S800

G1 F1500.000

G1 X81.502 Y83.548 E0.00444

G1 X81.469 Y83.426 E0.00328

G1 X81.468 Y82.681 E0.01943

G1 X81.516 Y82.526 E0.00423

G1 X81.656 Y82.408 E0.00474

G1 X81.753 Y82.398 E0.00256

G1 X92.706 Y82.407 E0.28538

G1 X92.919 Y82.460 E0.00572

G1 X92.989 Y82.585 E0.00373

G1 X93.012 Y82.667 E0.00223

G1 X93.005 Y83.467 E0.02085

G1 X92.981 Y83.534 E0.00185

G1 X92.858 Y83.661 E0.00461

G1 X92.711 Y83.701 E0.00397

G1 X85.754 Y83.688 E0.18129

G1 X81.775 Y83.708 E0.10368

G1 X81.685 Y83.680 E0.00245

M204 S1250

G1 X81.623 Y83.492 F9000.000

G1 X82.294 Y83.052

G1 F2400.000

G1 X82.095 Y83.052 E0.00068

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.294 Y83.052 E-0.11041

G1 E-0.84959 F4200.00000

G1 Z8.050 F9000.000

G1 X81.887 Y78.485

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y78.012 E0.01232

G1 X92.596 Y78.004 E0.27879

G1 X92.595 Y78.476 E0.01228

G1 X81.947 Y78.485 E0.27745

M204 S1250

G1 X81.598 Y78.857 F9000.000

M204 S800

G1 F1500.000

G1 X81.475 Y78.676 E0.00571

G1 X81.467 Y78.616 E0.00159

G1 X81.482 Y77.829 E0.02049

G1 X81.542 Y77.684 E0.00410

G1 X81.581 Y77.646 E0.00143

G1 X81.771 Y77.594 E0.00513

G1 X92.734 Y77.587 E0.28565

G1 X92.835 Y77.617 E0.00274

G1 X92.943 Y77.692 E0.00344

G1 X93.014 Y77.856 E0.00465

G1 X93.013 Y78.627 E0.02009

G1 X92.993 Y78.718 E0.00242

G1 X92.882 Y78.852 E0.00452

G1 X92.754 Y78.894 E0.00351

G1 X81.770 Y78.903 E0.28620

G1 X81.656 Y78.873 E0.00307

M204 S1250

G1 X81.626 Y78.640 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.475 Y78.676 E-0.14814

G1 X81.467 Y78.616 E-0.03381

G1 X81.482 Y77.829 E-0.43574

G1 X81.542 Y77.684 E-0.08710

G1 X81.581 Y77.646 E-0.03037

G1 X81.771 Y77.594 E-0.10916

G1 X81.893 Y77.594 E-0.06769

G1 E-0.04800 F4200.00000

G1 Z8.050 F9000.000

G1 X89.811 Y78.242

G1 Z7.850

G1 E3.20000 F2400.00000

G1 X82.101 Y78.248 E0.02648

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.746 Y78.247 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.050 F9000.000

G1 X82.061 Y70.291

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y70.292 E0.00454

G1 X81.886 Y69.818 E0.01235

G1 X92.593 Y69.827 E0.27898

G1 X92.589 Y70.286 E0.01195

G1 X85.753 Y70.272 E0.17812

G1 X82.121 Y70.291 E0.09464

M204 S1250

G1 X81.628 Y70.665 F9000.000

M204 S800

G1 F1500.000

G1 X81.502 Y70.550 E0.00444

G1 X81.469 Y70.428 E0.00328

G1 X81.468 Y69.683 E0.01943

G1 X81.516 Y69.528 E0.00423

G1 X81.656 Y69.410 E0.00474

G1 X81.753 Y69.400 E0.00256

G1 X92.706 Y69.409 E0.28538

G1 X92.919 Y69.462 E0.00573

G1 X92.989 Y69.587 E0.00371

G1 X93.012 Y69.669 E0.00223

G1 X93.005 Y70.469 E0.02085

G1 X92.981 Y70.536 E0.00185

G1 X92.858 Y70.663 E0.00462

G1 X92.711 Y70.704 E0.00397

G1 X85.754 Y70.690 E0.18128

G1 X81.775 Y70.710 E0.10368

G1 X81.685 Y70.682 E0.00245

M204 S1250

G1 X81.623 Y70.494 F9000.000

G1 X82.278 Y70.054

G1 F2400.000

G1 X82.095 Y70.054 E0.00062

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.278 Y70.054 E-0.10129

G1 E-0.85871 F4200.00000

G1 Z8.050 F9000.000

G1 X82.082 Y65.487

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y65.488 E0.00507

G1 X81.896 Y65.014 E0.01234

G1 X92.596 Y65.007 E0.27879

G1 X92.595 Y65.478 E0.01228

G1 X82.142 Y65.487 E0.27238

M204 S1250

G1 X81.599 Y65.859 F9000.000

M204 S800

G1 F1500.000

G1 X81.475 Y65.678 E0.00572

G1 X81.467 Y65.618 E0.00159

G1 X81.482 Y64.831 E0.02049

G1 X81.542 Y64.686 E0.00410

G1 X81.581 Y64.648 E0.00143

G1 X81.771 Y64.596 E0.00513

G1 X92.734 Y64.589 E0.28566

G1 X92.835 Y64.619 E0.00274

G1 X92.943 Y64.694 E0.00343

G1 X93.014 Y64.858 E0.00465

G1 X93.013 Y65.629 E0.02009

G1 X92.993 Y65.720 E0.00242

G1 X92.882 Y65.854 E0.00453

G1 X92.754 Y65.896 E0.00350

G1 X81.771 Y65.906 E0.28619

G1 X81.657 Y65.875 E0.00307

M204 S1250

G1 X81.626 Y65.642 F9000.000

G1 X82.686 Y65.249

G1 F2400.000

G1 X82.101 Y65.250 E0.00202

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.686 Y65.249 E-0.32444

G1 E-0.63556 F4200.00000

G1 Z8.050 F9000.000

G1 X82.062 Y57.293

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y57.294 E0.00457

G1 X81.886 Y56.820 E0.01233

G1 X92.593 Y56.830 E0.27897

G1 X92.589 Y57.288 E0.01193

G1 X85.753 Y57.275 E0.17812

G1 X82.122 Y57.293 E0.09461

M204 S1250

G1 X81.628 Y57.667 F9000.000

M204 S800

G1 F1500.000

G1 X81.502 Y57.552 E0.00444

G1 X81.469 Y57.430 E0.00328

G1 X81.468 Y56.685 E0.01941

G1 X81.516 Y56.529 E0.00426

G1 X81.655 Y56.413 E0.00472

G1 X81.753 Y56.402 E0.00256

G1 X92.706 Y56.412 E0.28540

G1 X92.919 Y56.465 E0.00572

G1 X92.989 Y56.589 E0.00370

G1 X93.012 Y56.671 E0.00223

G1 X93.005 Y57.472 E0.02086

G1 X92.981 Y57.539 E0.00186

G1 X92.858 Y57.665 E0.00459

G1 X92.711 Y57.706 E0.00398

G1 X85.754 Y57.693 E0.18128

G1 X81.775 Y57.712 E0.10368

G1 X81.685 Y57.684 E0.00245

M204 S1250

G1 X81.623 Y57.496 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.502 Y57.552 E-0.12532

G1 X81.469 Y57.430 E-0.06977

G1 X81.468 Y56.685 E-0.41282

G1 X81.516 Y56.529 E-0.09050

G1 X81.655 Y56.413 E-0.10042

G1 X81.753 Y56.402 E-0.05443

G1 X81.859 Y56.403 E-0.05874

G1 E-0.04800 F4200.00000

G1 Z8.050 F9000.000

G1 X81.887 Y52.490

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y52.016 E0.01234

G1 X92.596 Y52.009 E0.27879

G1 X92.595 Y52.480 E0.01228

G1 X81.947 Y52.489 E0.27745

M204 S1250

G1 X81.599 Y52.861 F9000.000

M204 S800

G1 F1500.000

G1 X81.475 Y52.680 E0.00572

G1 X81.467 Y52.620 E0.00157

G1 X81.482 Y51.833 E0.02051

G1 X81.542 Y51.688 E0.00410

G1 X81.581 Y51.650 E0.00143

G1 X81.771 Y51.599 E0.00513

G1 X92.734 Y51.591 E0.28566

G1 X92.835 Y51.621 E0.00274

G1 X92.943 Y51.696 E0.00343

G1 X93.014 Y51.861 E0.00466

G1 X93.013 Y52.631 E0.02007

G1 X92.993 Y52.722 E0.00242

G1 X92.882 Y52.856 E0.00453

G1 X92.754 Y52.898 E0.00350

G1 X81.771 Y52.908 E0.28619

G1 X81.657 Y52.877 E0.00307

M204 S1250

G1 X81.626 Y52.644 F9000.000

G1 X82.617 Y52.252

G1 F2400.000

G1 X82.101 Y52.253 E0.00177

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.617 Y52.252 E-0.28629

G1 E-0.67371 F4200.00000

G1 Z8.050 F9000.000

G1 X82.062 Y44.295

G1 Z7.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.296 E0.00456

G1 X81.886 Y43.822 E0.01234

G1 X92.593 Y43.832 E0.27897

G1 X92.589 Y44.290 E0.01193

G1 X85.753 Y44.277 E0.17812

G1 X82.122 Y44.295 E0.09462

M204 S1250

G1 X81.628 Y44.669 F9000.000

M204 S800

G1 F1500.000

G1 X81.502 Y44.555 E0.00442

G1 X81.469 Y44.432 E0.00329

G1 X81.468 Y43.688 E0.01941

G1 X81.516 Y43.532 E0.00424

G1 X81.655 Y43.415 E0.00474

G1 X81.753 Y43.404 E0.00255

G1 X92.706 Y43.414 E0.28540

G1 X92.919 Y43.467 E0.00571

G1 X92.989 Y43.591 E0.00372

G1 X93.012 Y43.673 E0.00222

G1 X93.005 Y44.474 E0.02086

G1 X92.981 Y44.541 E0.00186

G1 X92.858 Y44.667 E0.00459

G1 X92.711 Y44.708 E0.00398

G1 X85.754 Y44.695 E0.18128

G1 X81.775 Y44.714 E0.10368

G1 X81.685 Y44.686 E0.00245

M204 S1250

G1 X81.622 Y44.499 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;8

G1 Z8.000 F9000.000

;AFTER\_LAYER\_CHANGE

;8

G1 E-3.20000 F4200.00000

G1 Z8.200 F9000.000

G1 X81.887 Y116.982

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y116.986 E0.27904

G1 X92.595 Y117.465 E0.01246

G1 X81.885 Y117.461 E0.27905

G1 X81.887 Y117.042 E0.01091

M204 S1250

G1 X81.529 Y116.683 F9000.000

M204 S800

G1 F1500.000

G1 X81.596 Y116.611 E0.00255

G1 X81.771 Y116.565 E0.00470

G1 X92.713 Y116.569 E0.28511

G1 X92.865 Y116.607 E0.00408

G1 X92.943 Y116.660 E0.00246

G1 X93.014 Y116.831 E0.00482

G1 X93.013 Y117.595 E0.01992

G1 X92.992 Y117.698 E0.00273

G1 X92.888 Y117.827 E0.00431

G1 X92.707 Y117.882 E0.00493

G1 X81.763 Y117.879 E0.28517

G1 X81.624 Y117.852 E0.00369

G1 X81.591 Y117.829 E0.00104

G1 X81.480 Y117.668 E0.00510

G1 X81.470 Y116.833 E0.02176

G1 X81.507 Y116.738 E0.00264

M204 S1250

G1 X81.627 Y116.682 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.596 Y116.611 E-0.08605

G1 X81.771 Y116.565 E-0.10003

G1 X83.081 Y116.565 E-0.72592

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X92.387 Y117.225

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y117.222 E0.04005

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y117.222 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X82.042 Y109.312

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y109.313 E0.00404

G1 X81.885 Y108.829 E0.01262

G1 X92.594 Y108.842 E0.27903

G1 X92.592 Y109.295 E0.01181

G1 X87.138 Y109.278 E0.14211

G1 X82.102 Y109.312 E0.13123

M204 S1250

G1 X81.644 Y109.681 F9000.000

M204 S800

G1 F1500.000

G1 X81.501 Y109.543 E0.00518

G1 X81.469 Y109.436 E0.00290

G1 X81.467 Y108.696 E0.01929

G1 X81.514 Y108.536 E0.00433

G1 X81.645 Y108.423 E0.00452

G1 X81.753 Y108.411 E0.00285

G1 X92.706 Y108.424 E0.28539

G1 X92.832 Y108.464 E0.00343

G1 X92.896 Y108.459 E0.00168

G1 X92.961 Y108.523 E0.00237

G1 X93.013 Y108.689 E0.00454

G1 X93.009 Y109.460 E0.02009

G1 X92.976 Y109.558 E0.00268

G1 X92.848 Y109.681 E0.00464

G1 X92.715 Y109.713 E0.00357

G1 X89.813 Y109.716 E0.07561

G1 X87.138 Y109.695 E0.06971

G1 X81.781 Y109.732 E0.13958

G1 X81.700 Y109.701 E0.00224

M204 S1250

G1 X81.642 Y109.482 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.501 Y109.543 E-0.14137

G1 X81.469 Y109.436 E-0.06163

G1 X81.467 Y108.696 E-0.41017

G1 X81.514 Y108.536 E-0.09210

G1 X81.645 Y108.423 E-0.09604

G1 X81.753 Y108.411 E-0.06069

G1 X81.844 Y108.411 E-0.04999

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X83.544 Y109.066

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y109.070 E0.00584

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.544 Y109.066 E-0.80321

G1 E-0.15679 F4200.00000

G1 Z8.200 F9000.000

G1 X81.885 Y104.463

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y103.984 E0.01247

G1 X92.596 Y103.989 E0.27904

G1 X92.595 Y104.467 E0.01243

G1 X81.945 Y104.463 E0.27749

M204 S1250

G1 X81.591 Y104.831 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y104.670 E0.00511

G1 X81.467 Y104.595 E0.00198

G1 X81.470 Y103.835 E0.01980

G1 X81.529 Y103.685 E0.00420

G1 X81.596 Y103.614 E0.00254

G1 X81.771 Y103.567 E0.00472

G1 X92.714 Y103.572 E0.28512

G1 X92.865 Y103.609 E0.00407

G1 X92.943 Y103.662 E0.00245

G1 X93.014 Y103.833 E0.00481

G1 X93.013 Y104.597 E0.01993

G1 X92.992 Y104.700 E0.00272

G1 X92.888 Y104.829 E0.00431

G1 X92.707 Y104.884 E0.00493

G1 X81.763 Y104.881 E0.28517

G1 X81.644 Y104.858 E0.00316

M204 S1250

G1 X81.615 Y104.637 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.480 Y104.670 E-0.13808

G1 X81.467 Y104.595 E-0.04218

G1 X81.470 Y103.835 E-0.42122

G1 X81.529 Y103.685 E-0.08924

G1 X81.596 Y103.614 E-0.05406

G1 X81.771 Y103.567 E-0.10041

G1 X81.892 Y103.567 E-0.06680

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X92.387 Y104.228

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y104.224 E0.03990

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y104.224 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X82.042 Y96.314

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.315 E0.00404

G1 X81.885 Y95.831 E0.01262

G1 X92.594 Y95.844 E0.27903

G1 X92.592 Y96.297 E0.01181

G1 X87.138 Y96.280 E0.14211

G1 X82.102 Y96.314 E0.13123

M204 S1250

G1 X81.644 Y96.683 F9000.000

M204 S800

G1 F1500.000

G1 X81.501 Y96.545 E0.00518

G1 X81.469 Y96.439 E0.00289

G1 X81.467 Y95.698 E0.01929

G1 X81.514 Y95.539 E0.00432

G1 X81.645 Y95.425 E0.00452

G1 X81.754 Y95.413 E0.00286

G1 X92.706 Y95.426 E0.28536

G1 X92.831 Y95.466 E0.00344

G1 X92.896 Y95.462 E0.00170

G1 X92.961 Y95.525 E0.00236

G1 X93.013 Y95.691 E0.00453

G1 X93.009 Y96.462 E0.02009

G1 X92.976 Y96.560 E0.00269

G1 X92.848 Y96.683 E0.00463

G1 X92.715 Y96.715 E0.00357

G1 X89.813 Y96.718 E0.07561

G1 X87.138 Y96.697 E0.06971

G1 X81.781 Y96.734 E0.13958

G1 X81.700 Y96.703 E0.00224

M204 S1250

G1 X81.642 Y96.484 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.501 Y96.545 E-0.14140

G1 X81.469 Y96.439 E-0.06143

G1 X81.467 Y95.698 E-0.41036

G1 X81.514 Y95.539 E-0.09196

G1 X81.645 Y95.425 E-0.09603

G1 X81.754 Y95.413 E-0.06092

G1 X81.844 Y95.413 E-0.04990

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X83.544 Y96.068

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y96.072 E0.00584

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.544 Y96.068 E-0.80307

G1 E-0.15693 F4200.00000

G1 Z8.200 F9000.000

G1 X81.885 Y91.465

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y90.987 E0.01246

G1 X92.596 Y90.991 E0.27904

G1 X92.595 Y91.469 E0.01243

G1 X81.945 Y91.465 E0.27749

M204 S1250

G1 X81.591 Y91.834 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y91.672 E0.00510

G1 X81.467 Y91.597 E0.00199

G1 X81.470 Y90.837 E0.01980

G1 X81.529 Y90.687 E0.00420

G1 X81.596 Y90.616 E0.00255

G1 X81.771 Y90.569 E0.00471

G1 X92.714 Y90.574 E0.28512

G1 X92.864 Y90.611 E0.00405

G1 X92.943 Y90.665 E0.00249

G1 X93.014 Y90.835 E0.00479

G1 X93.013 Y91.599 E0.01993

G1 X92.992 Y91.702 E0.00272

G1 X92.888 Y91.831 E0.00431

G1 X92.707 Y91.886 E0.00493

G1 X81.763 Y91.883 E0.28517

G1 X81.644 Y91.860 E0.00316

M204 S1250

G1 X81.615 Y91.639 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.480 Y91.672 E-0.13789

G1 X81.467 Y91.597 E-0.04227

G1 X81.470 Y90.837 E-0.42108

G1 X81.529 Y90.687 E-0.08939

G1 X81.596 Y90.616 E-0.05418

G1 X81.771 Y90.569 E-0.10020

G1 X81.892 Y90.569 E-0.06698

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X92.387 Y91.230

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y91.226 E0.03990

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y91.227 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X82.042 Y83.316

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y83.317 E0.00404

G1 X81.885 Y82.833 E0.01262

G1 X92.594 Y82.846 E0.27903

G1 X92.592 Y83.299 E0.01182

G1 X89.814 Y83.303 E0.07237

M73 P73 R18

G1 X87.138 Y83.282 E0.06974

G1 X82.102 Y83.316 E0.13123

M204 S1250

G1 X81.644 Y83.685 F9000.000

M204 S800

G1 F1500.000

G1 X81.501 Y83.547 E0.00518

G1 X81.469 Y83.441 E0.00288

G1 X81.467 Y82.700 E0.01931

G1 X81.514 Y82.541 E0.00432

G1 X81.645 Y82.427 E0.00452

G1 X81.754 Y82.415 E0.00286

G1 X92.706 Y82.428 E0.28536

G1 X92.831 Y82.468 E0.00344

G1 X92.896 Y82.464 E0.00170

G1 X92.961 Y82.527 E0.00236

G1 X93.013 Y82.694 E0.00454

G1 X93.009 Y83.465 E0.02009

G1 X92.976 Y83.562 E0.00268

G1 X92.848 Y83.686 E0.00464

G1 X92.715 Y83.717 E0.00356

G1 X89.813 Y83.721 E0.07562

G1 X87.138 Y83.699 E0.06971

G1 X81.781 Y83.736 E0.13958

G1 X81.700 Y83.706 E0.00224

M204 S1250

G1 X81.642 Y83.486 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.501 Y83.547 E-0.14141

G1 X81.469 Y83.441 E-0.06117

G1 X81.467 Y82.700 E-0.41064

G1 X81.514 Y82.541 E-0.09191

G1 X81.645 Y82.427 E-0.09609

G1 X81.754 Y82.415 E-0.06089

G1 X81.844 Y82.415 E-0.04989

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X83.544 Y83.070

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y83.074 E0.00584

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.544 Y83.070 E-0.80311

G1 E-0.15689 F4200.00000

G1 Z8.200 F9000.000

G1 X81.885 Y78.467

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y77.989 E0.01246

G1 X92.596 Y77.993 E0.27904

G1 X92.595 Y78.470 E0.01243

G1 X81.945 Y78.467 E0.27749

M204 S1250

G1 X81.591 Y78.836 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y78.675 E0.00509

G1 X81.467 Y78.599 E0.00200

G1 X81.470 Y77.839 E0.01980

G1 X81.529 Y77.689 E0.00420

G1 X81.596 Y77.618 E0.00255

G1 X81.771 Y77.571 E0.00471

G1 X92.713 Y77.576 E0.28511

G1 X92.865 Y77.614 E0.00408

G1 X92.943 Y77.667 E0.00246

G1 X93.014 Y77.837 E0.00479

G1 X93.013 Y78.601 E0.01993

G1 X92.992 Y78.704 E0.00273

G1 X92.887 Y78.834 E0.00435

G1 X92.719 Y78.888 E0.00459

G1 X81.763 Y78.885 E0.28549

G1 X81.643 Y78.862 E0.00316

M204 S1250

G1 X81.615 Y78.642 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.480 Y78.675 E-0.13768

G1 X81.467 Y78.599 E-0.04246

G1 X81.470 Y77.839 E-0.42111

G1 X81.529 Y77.689 E-0.08939

G1 X81.596 Y77.618 E-0.05418

G1 X81.771 Y77.571 E-0.10020

G1 X81.892 Y77.571 E-0.06698

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X92.387 Y78.232

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y78.228 E0.03987

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y78.229 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X82.042 Y70.318

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y70.319 E0.00404

G1 X81.885 Y69.835 E0.01262

G1 X92.594 Y69.848 E0.27903

G1 X92.592 Y70.302 E0.01183

G1 X87.138 Y70.284 E0.14211

G1 X82.102 Y70.318 E0.13123

M204 S1250

G1 X81.644 Y70.687 F9000.000

M204 S800

G1 F1500.000

G1 X81.501 Y70.549 E0.00518

G1 X81.469 Y70.443 E0.00288

G1 X81.467 Y69.702 E0.01931

G1 X81.514 Y69.543 E0.00432

G1 X81.645 Y69.429 E0.00452

G1 X81.754 Y69.417 E0.00286

G1 X92.706 Y69.430 E0.28536

G1 X92.831 Y69.470 E0.00344

G1 X92.896 Y69.466 E0.00168

G1 X92.961 Y69.530 E0.00237

G1 X93.013 Y69.696 E0.00454

G1 X93.009 Y70.467 E0.02009

G1 X92.976 Y70.564 E0.00268

G1 X92.848 Y70.688 E0.00465

G1 X92.715 Y70.720 E0.00357

G1 X87.138 Y70.701 E0.14532

G1 X81.781 Y70.738 E0.13958

G1 X81.700 Y70.708 E0.00224

M204 S1250

G1 X81.642 Y70.488 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.501 Y70.549 E-0.14141

G1 X81.469 Y70.443 E-0.06117

G1 X81.467 Y69.702 E-0.41064

G1 X81.514 Y69.543 E-0.09191

G1 X81.645 Y69.429 E-0.09609

G1 X81.754 Y69.417 E-0.06088

G1 X81.844 Y69.417 E-0.04990

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X83.501 Y70.072

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y70.076 E0.00566

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.501 Y70.072 E-0.77920

G1 E-0.18080 F4200.00000

G1 Z8.200 F9000.000

G1 X81.885 Y65.470

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y64.991 E0.01248

G1 X92.596 Y64.995 E0.27904

G1 X92.595 Y65.474 E0.01246

G1 X81.945 Y65.470 E0.27749

M204 S1250

G1 X81.591 Y65.838 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y65.677 E0.00509

G1 X81.467 Y65.601 E0.00200

G1 X81.470 Y64.842 E0.01979

G1 X81.529 Y64.691 E0.00421

G1 X81.596 Y64.620 E0.00255

G1 X81.771 Y64.573 E0.00471

G1 X92.713 Y64.578 E0.28511

G1 X92.865 Y64.616 E0.00408

G1 X92.943 Y64.669 E0.00246

G1 X93.014 Y64.839 E0.00480

G1 X93.013 Y65.603 E0.01992

G1 X92.992 Y65.706 E0.00273

G1 X92.888 Y65.835 E0.00431

G1 X92.707 Y65.891 E0.00494

G1 X81.763 Y65.888 E0.28515

G1 X81.643 Y65.864 E0.00318

M204 S1250

G1 X81.615 Y65.644 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.480 Y65.677 E-0.13774

G1 X81.467 Y65.601 E-0.04246

G1 X81.470 Y64.842 E-0.42095

G1 X81.529 Y64.691 E-0.08957

G1 X81.596 Y64.620 E-0.05415

G1 X81.771 Y64.573 E-0.10020

G1 X81.892 Y64.573 E-0.06693

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X92.387 Y65.234

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y65.230 E0.04040

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y65.231 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X82.043 Y57.320

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y57.321 E0.00408

G1 X81.885 Y56.837 E0.01260

G1 X92.594 Y56.851 E0.27903

G1 X92.592 Y57.303 E0.01179

G1 X87.136 Y57.287 E0.14215

G1 X82.103 Y57.320 E0.13115

M204 S1250

G1 X81.644 Y57.689 F9000.000

M204 S800

G1 F1500.000

G1 X81.501 Y57.551 E0.00518

G1 X81.469 Y57.445 E0.00288

G1 X81.467 Y56.705 E0.01928

G1 X81.514 Y56.545 E0.00435

G1 X81.645 Y56.432 E0.00451

G1 X81.754 Y56.419 E0.00286

G1 X92.706 Y56.433 E0.28538

G1 X92.832 Y56.473 E0.00343

G1 X92.896 Y56.468 E0.00168

G1 X92.961 Y56.532 E0.00237

G1 X93.013 Y56.698 E0.00453

G1 X93.009 Y57.469 E0.02010

G1 X92.976 Y57.567 E0.00268

G1 X92.848 Y57.690 E0.00464

G1 X92.715 Y57.721 E0.00356

G1 X87.137 Y57.704 E0.14534

G1 X81.781 Y57.740 E0.13956

G1 X81.700 Y57.710 E0.00224

M204 S1250

G1 X81.642 Y57.490 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.501 Y57.551 E-0.14141

G1 X81.469 Y57.445 E-0.06117

G1 X81.467 Y56.705 E-0.41015

G1 X81.514 Y56.545 E-0.09242

G1 X81.645 Y56.432 E-0.09582

G1 X81.754 Y56.419 E-0.06086

G1 X81.844 Y56.420 E-0.05018

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X83.464 Y57.075

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y57.079 E0.00547

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.464 Y57.075 E-0.75865

G1 E-0.20135 F4200.00000

G1 Z8.200 F9000.000

G1 X81.885 Y52.472

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y51.993 E0.01247

G1 X92.596 Y51.997 E0.27904

G1 X92.595 Y52.476 E0.01246

G1 X81.945 Y52.472 E0.27749

M204 S1250

G1 X81.591 Y52.840 F9000.000

M204 S800

G1 F1500.000

G1 X81.480 Y52.679 E0.00509

G1 X81.467 Y52.604 E0.00198

G1 X81.470 Y51.844 E0.01981

G1 X81.529 Y51.693 E0.00421

G1 X81.596 Y51.622 E0.00254

G1 X81.771 Y51.576 E0.00471

G1 X92.713 Y51.580 E0.28511

G1 X92.865 Y51.618 E0.00408

G1 X92.943 Y51.671 E0.00246

G1 X93.014 Y51.842 E0.00482

G1 X93.013 Y52.605 E0.01990

G1 X92.992 Y52.708 E0.00273

G1 X92.888 Y52.837 E0.00431

G1 X92.707 Y52.893 E0.00494

G1 X81.763 Y52.890 E0.28515

G1 X81.643 Y52.866 E0.00318

M204 S1250

G1 X81.615 Y52.646 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.480 Y52.679 E-0.13779

G1 X81.467 Y52.604 E-0.04211

G1 X81.470 Y51.844 E-0.42126

G1 X81.529 Y51.693 E-0.08957

G1 X81.596 Y51.622 E-0.05404

G1 X81.771 Y51.576 E-0.10012

G1 X81.892 Y51.576 E-0.06712

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X92.387 Y52.236

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y52.233 E0.03991

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y52.233 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X82.043 Y44.322

G1 Z8.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y44.323 E0.00406

G1 X81.885 Y43.839 E0.01261

G1 X92.594 Y43.853 E0.27903

G1 X92.592 Y44.306 E0.01181

G1 X87.138 Y44.289 E0.14211

G1 X82.103 Y44.322 E0.13121

M204 S1250

G1 X81.644 Y44.691 F9000.000

M204 S800

G1 F1500.000

G1 X81.501 Y44.554 E0.00517

G1 X81.469 Y44.447 E0.00289

G1 X81.467 Y43.707 E0.01929

G1 X81.514 Y43.547 E0.00433

G1 X81.645 Y43.434 E0.00452

G1 X81.754 Y43.421 E0.00285

G1 X92.706 Y43.435 E0.28538

G1 X92.832 Y43.475 E0.00343

G1 X92.896 Y43.470 E0.00168

G1 X92.961 Y43.534 E0.00237

G1 X93.013 Y43.700 E0.00453

G1 X93.009 Y44.471 E0.02010

G1 X92.976 Y44.569 E0.00268

G1 X92.848 Y44.692 E0.00464

G1 X92.715 Y44.724 E0.00357

G1 X89.813 Y44.727 E0.07561

G1 X87.138 Y44.706 E0.06971

G1 X81.781 Y44.742 E0.13957

G1 X81.700 Y44.712 E0.00225

M204 S1250

G1 X81.641 Y44.492 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.501 Y44.554 E-0.14113

G1 X81.469 Y44.447 E-0.06149

G1 X81.467 Y43.707 E-0.41017

G1 X81.514 Y43.547 E-0.09210

G1 X81.645 Y43.434 E-0.09619

G1 X81.754 Y43.421 E-0.06072

G1 X81.844 Y43.422 E-0.05020

G1 E-0.04800 F4200.00000

G1 Z8.200 F9000.000

G1 X83.500 Y44.077

G1 Z8.000

G1 E3.20000 F2400.00000

G1 X82.095 Y44.081 E0.00564

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;8.15

G1 Z8.150 F9000.000

;AFTER\_LAYER\_CHANGE

;8.15

G1 E-3.20000 F4200.00000

G1 Z8.350 F9000.000

G1 X81.887 Y116.959

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.588 Y116.953 E0.27884

G1 X92.593 Y117.449 E0.01294

G1 X81.886 Y117.443 E0.27899

G1 X81.887 Y117.019 E0.01104

M204 S1250

G1 X81.522 Y116.675 F9000.000

M204 S800

G1 F1500.000

G1 X81.593 Y116.588 E0.00291

G1 X81.770 Y116.542 E0.00477

G1 X92.707 Y116.535 E0.28497

G1 X92.850 Y116.575 E0.00387

G1 X92.945 Y116.647 E0.00310

G1 X93.005 Y116.799 E0.00426

G1 X93.013 Y117.571 E0.02013

G1 X92.992 Y117.680 E0.00287

G1 X92.891 Y117.804 E0.00417

G1 X92.704 Y117.867 E0.00514

G1 X81.764 Y117.861 E0.28505

G1 X81.618 Y117.831 E0.00389

G1 X81.552 Y117.781 E0.00214

G1 X81.487 Y117.678 E0.00319

G1 X81.468 Y117.579 E0.00263

G1 X81.469 Y116.812 E0.01998

G1 X81.501 Y116.731 E0.00226

M204 S1250

G1 X81.634 Y116.670 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.593 Y116.588 E-0.09410

G1 X81.770 Y116.542 E-0.10144

G1 X83.063 Y116.541 E-0.71647

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X92.382 Y117.201

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y117.201 E0.05034

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y117.201 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X82.044 Y109.340

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y109.341 E0.00410

G1 X81.885 Y108.846 E0.01289

G1 X92.596 Y108.862 E0.27909

G1 X92.595 Y109.312 E0.01172

G1 X88.839 Y109.315 E0.09787

G1 X87.677 Y109.305 E0.03026

G1 X87.119 Y109.277 E0.01458

G1 X86.687 Y109.309 E0.01128

G1 X82.104 Y109.339 E0.11941

M204 S1250

G1 X81.616 Y109.695 F9000.000

M204 S800

G1 F1500.000

G1 X81.510 Y109.578 E0.00413

G1 X81.469 Y109.452 E0.00346

G1 X81.467 Y108.718 E0.01911

G1 X81.514 Y108.558 E0.00434

G1 X81.647 Y108.442 E0.00460

G1 X81.756 Y108.428 E0.00286

G1 X92.706 Y108.445 E0.28533

G1 X92.810 Y108.477 E0.00283

G1 X92.877 Y108.473 E0.00175

G1 X92.923 Y108.501 E0.00142

G1 X92.959 Y108.538 E0.00134

G1 X93.014 Y108.719 E0.00492

G1 X93.012 Y109.456 E0.01922

G1 X92.973 Y109.585 E0.00350

G1 X92.838 Y109.706 E0.00472

G1 X92.719 Y109.730 E0.00317

G1 X88.837 Y109.733 E0.10114

G1 X87.665 Y109.723 E0.03054

G1 X87.124 Y109.696 E0.01412

G1 X86.703 Y109.727 E0.01098

G1 X81.782 Y109.759 E0.12823

G1 X81.672 Y109.717 E0.00307

M204 S1250

G1 X81.622 Y109.537 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.510 Y109.578 E-0.11853

G1 X81.469 Y109.452 E-0.07355

G1 X81.467 Y108.718 E-0.40645

G1 X81.514 Y108.558 E-0.09237

G1 X81.647 Y108.442 E-0.09791

G1 X81.756 Y108.428 E-0.06083

G1 X81.868 Y108.428 E-0.06236

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X84.972 Y109.085

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y109.093 E0.01010

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y109.088 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X81.886 Y104.445

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y103.961 E0.01261

G1 X92.588 Y103.955 E0.27884

G1 X92.593 Y104.451 E0.01292

G1 X81.946 Y104.445 E0.27743

M204 S1250

G1 X81.552 Y104.784 F9000.000

M204 S800

G1 F1500.000

G1 X81.487 Y104.680 E0.00320

G1 X81.468 Y104.581 E0.00264

G1 X81.469 Y103.814 E0.01998

G1 X81.522 Y103.677 E0.00382

G1 X81.593 Y103.591 E0.00290

G1 X81.771 Y103.544 E0.00479

G1 X92.708 Y103.538 E0.28497

G1 X92.850 Y103.577 E0.00386

G1 X92.945 Y103.649 E0.00311

G1 X93.005 Y103.801 E0.00425

G1 X93.013 Y104.574 E0.02013

G1 X92.992 Y104.682 E0.00286

G1 X92.891 Y104.806 E0.00418

G1 X92.704 Y104.869 E0.00514

G1 X81.764 Y104.863 E0.28505

G1 X81.600 Y104.820 E0.00441

M204 S1250

G1 X81.571 Y104.663 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.487 Y104.680 E-0.09972

G1 X81.468 Y104.581 E-0.05614

G1 X81.469 Y103.814 E-0.42499

G1 X81.522 Y103.677 E-0.08123

G1 X81.593 Y103.591 E-0.06169

G1 X81.771 Y103.544 E-0.10189

G1 X81.927 Y103.544 E-0.08634

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X92.382 Y104.203

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y104.203 E0.04986

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y104.203 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X82.044 Y96.342

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y96.343 E0.00410

G1 X81.885 Y95.848 E0.01289

G1 X92.596 Y95.864 E0.27909

G1 X92.595 Y96.314 E0.01172

G1 X88.839 Y96.317 E0.09787

G1 X87.677 Y96.307 E0.03026

G1 X87.119 Y96.279 E0.01458

G1 X86.687 Y96.311 E0.01128

G1 X82.104 Y96.341 E0.11941

M204 S1250

G1 X81.616 Y96.697 F9000.000

M204 S800

G1 F1500.000

G1 X81.510 Y96.580 E0.00413

G1 X81.469 Y96.454 E0.00346

G1 X81.467 Y95.720 E0.01911

G1 X81.514 Y95.560 E0.00434

G1 X81.647 Y95.444 E0.00460

G1 X81.756 Y95.430 E0.00287

G1 X92.706 Y95.447 E0.28531

G1 X92.809 Y95.480 E0.00284

G1 X92.877 Y95.475 E0.00177

G1 X92.923 Y95.504 E0.00142

G1 X92.959 Y95.540 E0.00134

G1 X93.014 Y95.721 E0.00492

G1 X93.012 Y96.459 E0.01922

G1 X92.973 Y96.587 E0.00351

G1 X92.838 Y96.708 E0.00471

G1 X92.719 Y96.732 E0.00317

G1 X88.837 Y96.735 E0.10115

G1 X87.665 Y96.725 E0.03054

G1 X87.124 Y96.698 E0.01412

G1 X86.703 Y96.729 E0.01098

G1 X81.782 Y96.761 E0.12823

G1 X81.672 Y96.719 E0.00307

M204 S1250

G1 X81.622 Y96.539 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.510 Y96.580 E-0.11853

G1 X81.469 Y96.454 E-0.07350

G1 X81.467 Y95.720 E-0.40649

G1 X81.514 Y95.560 E-0.09228

G1 X81.647 Y95.444 E-0.09791

G1 X81.756 Y95.430 E-0.06098

G1 X81.868 Y95.430 E-0.06231

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X84.972 Y96.087

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y96.095 E0.01010

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y96.090 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X81.886 Y91.447

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y90.964 E0.01260

G1 X92.588 Y90.958 E0.27884

G1 X92.593 Y91.453 E0.01291

G1 X81.946 Y91.447 E0.27743

M204 S1250

G1 X81.552 Y91.786 F9000.000

M204 S800

G1 F1500.000

G1 X81.487 Y91.682 E0.00320

G1 X81.468 Y91.583 E0.00263

G1 X81.469 Y90.816 E0.01998

G1 X81.522 Y90.679 E0.00382

G1 X81.593 Y90.593 E0.00291

G1 X81.771 Y90.546 E0.00478

G1 X92.707 Y90.540 E0.28497

G1 X92.850 Y90.579 E0.00386

G1 X92.945 Y90.651 E0.00311

G1 X93.005 Y90.803 E0.00424

G1 X93.013 Y91.576 E0.02013

G1 X92.992 Y91.684 E0.00287

G1 X92.891 Y91.808 E0.00418

G1 X92.704 Y91.871 E0.00514

G1 X81.764 Y91.865 E0.28506

G1 X81.600 Y91.822 E0.00440

M204 S1250

G1 X81.571 Y91.665 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.487 Y91.682 E-0.09977

G1 X81.468 Y91.583 E-0.05592

G1 X81.469 Y90.816 E-0.42500

G1 X81.522 Y90.679 E-0.08118

G1 X81.593 Y90.593 E-0.06199

G1 X81.771 Y90.546 E-0.10173

G1 X81.927 Y90.546 E-0.08641

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X92.382 Y91.205

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y91.205 E0.04971

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y91.205 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X82.044 Y83.344

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y83.345 E0.00410

G1 X81.885 Y82.850 E0.01289

G1 X92.596 Y82.866 E0.27909

G1 X92.595 Y83.316 E0.01172

G1 X88.839 Y83.320 E0.09787

G1 X87.677 Y83.309 E0.03026

G1 X87.119 Y83.281 E0.01458

G1 X86.687 Y83.313 E0.01129

G1 X82.104 Y83.343 E0.11941

M204 S1250

G1 X81.616 Y83.699 F9000.000

M204 S800

G1 F1500.000

G1 X81.510 Y83.582 E0.00413

G1 X81.469 Y83.456 E0.00343

G1 X81.467 Y82.722 E0.01913

G1 X81.513 Y82.563 E0.00433

G1 X81.647 Y82.446 E0.00461

G1 X81.756 Y82.432 E0.00286

G1 X92.706 Y82.449 E0.28531

G1 X92.809 Y82.482 E0.00284

G1 X92.877 Y82.477 E0.00177

G1 X92.923 Y82.506 E0.00142

G1 X92.959 Y82.542 E0.00134

G1 X93.014 Y82.723 E0.00492

G1 X93.012 Y83.461 E0.01922

G1 X92.973 Y83.590 E0.00351

G1 X92.838 Y83.711 E0.00471

G1 X92.719 Y83.734 E0.00316

G1 X88.837 Y83.737 E0.10116

G1 X87.665 Y83.727 E0.03054

G1 X87.124 Y83.700 E0.01412

G1 X86.703 Y83.731 E0.01098

G1 X81.782 Y83.763 E0.12823

G1 X81.672 Y83.721 E0.00307

M204 S1250

G1 X81.622 Y83.540 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.510 Y83.582 E-0.11862

G1 X81.469 Y83.456 E-0.07303

G1 X81.467 Y82.722 E-0.40688

G1 X81.513 Y82.563 E-0.09213

G1 X81.647 Y82.446 E-0.09808

G1 X81.756 Y82.432 E-0.06091

G1 X81.868 Y82.432 E-0.06235

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X84.972 Y83.089

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y83.097 E0.01010

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y83.092 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X81.886 Y78.449

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y77.966 E0.01260

G1 X92.588 Y77.960 E0.27884

G1 X92.593 Y78.455 E0.01291

G1 X81.946 Y78.449 E0.27743

M204 S1250

G1 X81.552 Y78.788 F9000.000

M204 S800

G1 F1500.000

G1 X81.487 Y78.685 E0.00318

G1 X81.468 Y78.585 E0.00264

G1 X81.469 Y77.818 E0.01999

G1 X81.522 Y77.681 E0.00382

G1 X81.593 Y77.595 E0.00291

G1 X81.771 Y77.548 E0.00478

G1 X92.707 Y77.542 E0.28496

G1 X92.850 Y77.582 E0.00387

G1 X92.945 Y77.654 E0.00311

G1 X93.005 Y77.805 E0.00424

G1 X93.013 Y78.578 E0.02013

G1 X92.992 Y78.686 E0.00288

G1 X92.892 Y78.810 E0.00416

G1 X92.704 Y78.873 E0.00514

G1 X81.764 Y78.867 E0.28506

G1 X81.600 Y78.824 E0.00441

M204 S1250

G1 X81.571 Y78.667 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.487 Y78.685 E-0.09937

G1 X81.468 Y78.585 E-0.05621

G1 X81.469 Y77.818 E-0.42506

G1 X81.522 Y77.681 E-0.08118

G1 X81.593 Y77.595 E-0.06199

G1 X81.771 Y77.548 E-0.10173

G1 X81.927 Y77.548 E-0.08646

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X92.382 Y78.207

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y78.207 E0.04971

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y78.207 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X82.045 Y70.346

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y70.347 E0.00414

G1 X81.885 Y69.852 E0.01289

G1 X92.596 Y69.868 E0.27909

G1 X92.595 Y70.319 E0.01174

G1 X88.839 Y70.322 E0.09787

G1 X87.677 Y70.311 E0.03026

G1 X87.118 Y70.283 E0.01460

G1 X86.686 Y70.316 E0.01129

G1 X82.105 Y70.345 E0.11935

M204 S1250

G1 X81.617 Y70.702 F9000.000

M204 S800

G1 F1500.000

G1 X81.510 Y70.584 E0.00415

G1 X81.469 Y70.458 E0.00343

G1 X81.467 Y69.724 E0.01913

G1 X81.513 Y69.565 E0.00433

G1 X81.647 Y69.448 E0.00461

G1 X81.756 Y69.434 E0.00286

G1 X92.706 Y69.451 E0.28531

G1 X92.809 Y69.484 E0.00284

G1 X92.882 Y69.479 E0.00189

G1 X92.961 Y69.550 E0.00278

G1 X93.014 Y69.725 E0.00476

G1 X93.012 Y70.463 E0.01922

G1 X92.973 Y70.592 E0.00351

G1 X92.838 Y70.713 E0.00472

G1 X92.719 Y70.737 E0.00317

G1 X88.837 Y70.739 E0.10114

G1 X87.665 Y70.729 E0.03054

G1 X87.123 Y70.702 E0.01413

G1 X86.703 Y70.734 E0.01098

G1 X81.782 Y70.765 E0.12822

G1 X81.673 Y70.723 E0.00306

M204 S1250

G1 X81.622 Y70.542 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.510 Y70.584 E-0.11886

G1 X81.469 Y70.458 E-0.07303

G1 X81.467 Y69.724 E-0.40688

G1 X81.513 Y69.565 E-0.09213

G1 X81.647 Y69.448 E-0.09808

G1 X81.756 Y69.434 E-0.06090

G1 X81.868 Y69.434 E-0.06212

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X84.985 Y70.091

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y70.099 E0.01015

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y70.094 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X81.886 Y65.452

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y64.968 E0.01261

G1 X92.588 Y64.962 E0.27884

G1 X92.593 Y65.458 E0.01293

G1 X81.946 Y65.452 E0.27743

M204 S1250

G1 X81.552 Y65.790 F9000.000

M204 S800

G1 F1500.000

G1 X81.487 Y65.687 E0.00318

G1 X81.468 Y65.587 E0.00264

G1 X81.469 Y64.821 E0.01997

G1 X81.522 Y64.683 E0.00383

G1 X81.593 Y64.597 E0.00291

G1 X81.771 Y64.550 E0.00478

G1 X92.707 Y64.544 E0.28496

G1 X92.850 Y64.584 E0.00387

G1 X92.945 Y64.656 E0.00310

G1 X93.005 Y64.807 E0.00424

G1 X93.013 Y65.580 E0.02013

G1 X92.992 Y65.688 E0.00288

G1 X92.891 Y65.813 E0.00417

G1 X92.704 Y65.876 E0.00515

G1 X81.764 Y65.869 E0.28505

G1 X81.600 Y65.826 E0.00442

M204 S1250

G1 X81.571 Y65.669 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.487 Y65.687 E-0.09937

G1 X81.468 Y65.587 E-0.05621

G1 X81.469 Y64.821 E-0.42480

G1 X81.522 Y64.683 E-0.08148

G1 X81.593 Y64.597 E-0.06193

G1 X81.771 Y64.550 E-0.10173

G1 X81.927 Y64.550 E-0.08648

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X92.382 Y65.210

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y65.210 E0.05019

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y65.210 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X82.045 Y57.348

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y57.349 E0.00414

G1 X81.885 Y56.854 E0.01288

G1 X92.596 Y56.871 E0.27909

G1 X92.595 Y57.321 E0.01172

G1 X88.839 Y57.324 E0.09787

G1 X87.677 Y57.314 E0.03026

G1 X87.118 Y57.286 E0.01457

G1 X86.687 Y57.318 E0.01128

G1 X82.105 Y57.347 E0.11937

M204 S1250

G1 X81.617 Y57.704 F9000.000

M204 S800

G1 F1500.000

G1 X81.510 Y57.586 E0.00415

G1 X81.469 Y57.460 E0.00343

G1 X81.467 Y56.727 E0.01911

G1 X81.514 Y56.567 E0.00435

G1 X81.647 Y56.451 E0.00460

G1 X81.756 Y56.436 E0.00287

G1 X92.706 Y56.454 E0.28532

G1 X92.810 Y56.486 E0.00283

G1 X92.877 Y56.482 E0.00175

G1 X92.923 Y56.511 E0.00143

G1 X92.959 Y56.547 E0.00133

G1 X93.014 Y56.727 E0.00491

G1 X93.012 Y57.465 E0.01924

G1 X92.973 Y57.594 E0.00350

G1 X92.838 Y57.715 E0.00472

G1 X92.719 Y57.739 E0.00317

G1 X88.837 Y57.741 E0.10115

G1 X87.665 Y57.732 E0.03054

G1 X87.124 Y57.705 E0.01412

G1 X86.703 Y57.736 E0.01098

G1 X81.782 Y57.767 E0.12823

G1 X81.673 Y57.725 E0.00306

M204 S1250

G1 X81.622 Y57.544 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.510 Y57.586 E-0.11886

G1 X81.469 Y57.460 E-0.07303

G1 X81.467 Y56.727 E-0.40640

G1 X81.514 Y56.567 E-0.09259

G1 X81.647 Y56.451 E-0.09786

G1 X81.756 Y56.436 E-0.06098

G1 X81.868 Y56.436 E-0.06229

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X84.928 Y57.094

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y57.101 E0.00988

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y57.097 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X81.886 Y52.454

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y51.970 E0.01259

G1 X92.588 Y51.964 E0.27884

G1 X92.593 Y52.460 E0.01293

G1 X81.946 Y52.454 E0.27743

M204 S1250

G1 X81.552 Y52.792 F9000.000

M204 S800

G1 F1500.000

G1 X81.487 Y52.689 E0.00318

G1 X81.468 Y52.590 E0.00263

G1 X81.469 Y51.823 E0.01998

G1 X81.522 Y51.685 E0.00383

G1 X81.593 Y51.599 E0.00290

G1 X81.770 Y51.553 E0.00478

G1 X92.707 Y51.546 E0.28497

G1 X92.850 Y51.586 E0.00387

G1 X92.945 Y51.658 E0.00310

G1 X93.005 Y51.810 E0.00426

G1 X93.013 Y52.582 E0.02011

G1 X92.992 Y52.690 E0.00288

G1 X92.891 Y52.815 E0.00417

G1 X92.704 Y52.878 E0.00515

G1 X81.764 Y52.871 E0.28505

G1 X81.600 Y52.828 E0.00442

M204 S1250

G1 X81.571 Y52.671 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.487 Y52.689 E-0.09940

G1 X81.468 Y52.590 E-0.05598

G1 X81.469 Y51.823 E-0.42500

G1 X81.522 Y51.685 E-0.08148

G1 X81.593 Y51.599 E-0.06177

G1 X81.770 Y51.553 E-0.10158

G1 X81.927 Y51.553 E-0.08678

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X92.382 Y52.212

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y52.212 E0.05017

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y52.212 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X82.045 Y44.350

G1 Z8.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y44.351 E0.00412

G1 X81.885 Y43.856 E0.01290

G1 X92.596 Y43.873 E0.27909

G1 X92.595 Y44.323 E0.01172

G1 X88.839 Y44.326 E0.09787

G1 X87.677 Y44.316 E0.03026

G1 X87.118 Y44.288 E0.01458

G1 X86.687 Y44.320 E0.01129

G1 X82.105 Y44.350 E0.11939

M204 S1250

G1 X81.616 Y44.705 F9000.000

M204 S800

G1 F1500.000

G1 X81.510 Y44.589 E0.00411

G1 X81.469 Y44.463 E0.00345

G1 X81.467 Y43.729 E0.01911

G1 X81.514 Y43.569 E0.00434

G1 X81.647 Y43.453 E0.00461

G1 X81.756 Y43.438 E0.00286

G1 X92.706 Y43.456 E0.28532

G1 X92.810 Y43.488 E0.00283

G1 X92.877 Y43.484 E0.00175

G1 X92.923 Y43.512 E0.00142

G1 X92.959 Y43.549 E0.00134

G1 X93.014 Y43.729 E0.00490

G1 X93.012 Y44.467 E0.01924

G1 X92.973 Y44.596 E0.00350

G1 X92.838 Y44.717 E0.00472

G1 X92.719 Y44.741 E0.00317

G1 X88.837 Y44.744 E0.10114

G1 X87.665 Y44.734 E0.03054

G1 X87.124 Y44.707 E0.01412

G1 X86.703 Y44.738 E0.01098

G1 X81.782 Y44.770 E0.12822

G1 X81.672 Y44.727 E0.00309

M204 S1250

G1 X81.621 Y44.548 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.510 Y44.589 E-0.11817

G1 X81.469 Y44.463 E-0.07348

G1 X81.467 Y43.729 E-0.40644

G1 X81.514 Y43.569 E-0.09237

G1 X81.647 Y43.453 E-0.09812

G1 X81.756 Y43.438 E-0.06088

G1 X81.869 Y43.438 E-0.06254

G1 E-0.04800 F4200.00000

G1 Z8.350 F9000.000

G1 X84.954 Y44.096

G1 Z8.150

G1 E3.20000 F2400.00000

G1 X82.095 Y44.103 E0.01001

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;8.3

G1 Z8.300 F9000.000

;AFTER\_LAYER\_CHANGE

;8.3

G1 X81.886 Y43.873

M204 S800

G1 F1500.000

G1 X92.597 Y43.894 E0.27910

G1 X92.596 Y44.362 E0.01220

G1 X88.496 Y44.360 E0.10683

G1 X87.942 Y44.351 E0.01446

G1 X87.555 Y44.300 E0.01015

G1 X87.099 Y44.289 E0.01190

G1 X86.826 Y44.310 E0.00713

G1 X86.637 Y44.349 E0.00504

G1 X85.702 Y44.372 E0.02435

G1 X81.887 Y44.380 E0.09942

G1 X81.886 Y43.933 E0.01164

M204 S1250

G1 X81.517 Y43.579 F9000.000

M204 S800

G1 F1500.000

G1 X81.629 Y43.475 E0.00400

G1 X81.758 Y43.455 E0.00339

G1 X92.706 Y43.477 E0.28526

G1 X92.787 Y43.502 E0.00222

G1 X92.858 Y43.497 E0.00185

G1 X92.970 Y43.590 E0.00377

G1 X93.015 Y43.753 E0.00442

G1 X93.014 Y44.486 E0.01910

G1 X92.970 Y44.625 E0.00380

G1 X92.824 Y44.756 E0.00511

G1 X92.716 Y44.780 E0.00290

G1 X88.493 Y44.778 E0.11003

G1 X87.911 Y44.768 E0.01517

G1 X87.523 Y44.718 E0.01019

G1 X87.109 Y44.708 E0.01078

G1 X86.885 Y44.724 E0.00587

G1 X86.685 Y44.766 E0.00532

G1 X85.708 Y44.790 E0.02547

G1 X81.776 Y44.798 E0.10245

G1 X81.668 Y44.763 E0.00294

G1 X81.542 Y44.675 E0.00402

G1 X81.469 Y44.490 E0.00517

G1 X81.468 Y43.744 E0.01946

G1 X81.500 Y43.637 E0.00291

M204 S1250

G1 X81.670 Y43.586 F9000.000

G1 X82.095 Y44.126

G1 F2400.000

G1 X86.573 Y44.115 E0.02140

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.927 Y44.119 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X88.187 Y44.119

G1 Z8.300

G1 E3.20000 F2400.00000

M73 P75 R17

G1 X90.674 Y44.125 E0.00897

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.028 Y44.121 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.597 Y51.927

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y52.438 E0.01332

G1 X81.886 Y52.435 E0.27903

G1 X81.887 Y51.942 E0.01285

G1 X92.537 Y51.927 E0.27751

M204 S1250

G1 X92.824 Y51.550 F9000.000

M204 S800

G1 F1500.000

G1 X92.946 Y51.641 E0.00397

G1 X93.016 Y51.834 E0.00535

G1 X93.013 Y52.553 E0.01872

G1 X92.990 Y52.671 E0.00314

G1 X92.895 Y52.791 E0.00399

G1 X92.704 Y52.856 E0.00526

G1 X81.771 Y52.853 E0.28487

G1 X81.592 Y52.806 E0.00482

G1 X81.561 Y52.777 E0.00110

G1 X81.499 Y52.689 E0.00280

G1 X81.468 Y52.571 E0.00318

G1 X81.469 Y51.796 E0.02019

G1 X81.502 Y51.692 E0.00285

G1 X81.606 Y51.571 E0.00415

G1 X81.772 Y51.525 E0.00449

G1 X92.699 Y51.509 E0.28470

G1 X92.767 Y51.531 E0.00187

M204 S1250

G1 X92.839 Y51.702 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.946 Y51.641 E-0.11646

G1 X93.016 Y51.834 E-0.11377

G1 X93.013 Y52.553 E-0.39825

G1 X92.990 Y52.671 E-0.06683

G1 X92.895 Y52.791 E-0.08483

G1 X92.704 Y52.856 E-0.11186

G1 X92.668 Y52.856 E-0.01999

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X82.096 Y52.189

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X92.387 Y52.183 E0.05960

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y52.184 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.597 Y56.892

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y57.360 E0.01219

G1 X88.496 Y57.357 E0.10684

G1 X87.941 Y57.349 E0.01446

G1 X87.555 Y57.298 E0.01014

G1 X87.099 Y57.287 E0.01190

G1 X86.826 Y57.308 E0.00713

G1 X86.637 Y57.347 E0.00504

G1 X85.702 Y57.370 E0.02435

G1 X81.887 Y57.377 E0.09943

G1 X81.886 Y56.871 E0.01318

G1 X92.537 Y56.892 E0.27754

M204 S1250

G1 X92.859 Y56.495 F9000.000

M204 S800

G1 F1500.000

G1 X92.970 Y56.587 E0.00375

G1 X93.015 Y56.751 E0.00443

G1 X93.014 Y57.484 E0.01910

G1 X92.970 Y57.623 E0.00380

G1 X92.824 Y57.753 E0.00510

G1 X92.716 Y57.778 E0.00289

G1 X88.493 Y57.775 E0.11004

G1 X87.911 Y57.766 E0.01517

G1 X87.523 Y57.716 E0.01019

G1 X87.109 Y57.706 E0.01078

G1 X86.885 Y57.722 E0.00587

G1 X86.685 Y57.764 E0.00532

G1 X85.708 Y57.788 E0.02547

G1 X81.782 Y57.795 E0.10229

G1 X81.603 Y57.727 E0.00499

G1 X81.548 Y57.681 E0.00186

G1 X81.469 Y57.488 E0.00543

G1 X81.468 Y56.742 E0.01945

G1 X81.517 Y56.577 E0.00448

G1 X81.592 Y56.496 E0.00288

G1 X81.629 Y56.473 E0.00115

G1 X81.758 Y56.453 E0.00339

G1 X92.706 Y56.475 E0.28526

G1 X92.799 Y56.499 E0.00250

M204 S1250

G1 X92.868 Y56.639 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.970 Y56.587 E-0.10642

G1 X93.015 Y56.751 E-0.09428

G1 X93.014 Y57.484 E-0.40628

G1 X92.970 Y57.623 E-0.08072

G1 X92.824 Y57.753 E-0.10847

G1 X92.716 Y57.778 E-0.06152

G1 X92.618 Y57.778 E-0.05432

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X90.333 Y57.123

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X88.218 Y57.117 E0.00753

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.864 Y57.121 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X86.573 Y57.113

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X82.095 Y57.124 E0.02140

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y57.120 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X81.888 Y64.939

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y64.925 E0.27896

G1 X92.595 Y65.436 E0.01331

G1 X81.889 Y65.433 E0.27894

G1 X81.888 Y64.999 E0.01132

M204 S1250

G1 X81.502 Y64.690 F9000.000

M204 S800

G1 F1500.000

G1 X81.606 Y64.569 E0.00416

G1 X81.773 Y64.522 E0.00451

G1 X92.700 Y64.507 E0.28471

G1 X92.846 Y64.553 E0.00400

G1 X92.945 Y64.634 E0.00331

G1 X93.012 Y64.818 E0.00511

G1 X93.013 Y65.551 E0.01910

G1 X92.990 Y65.669 E0.00313

G1 X92.895 Y65.789 E0.00399

G1 X92.704 Y65.854 E0.00526

G1 X81.771 Y65.851 E0.28487

G1 X81.591 Y65.803 E0.00484

G1 X81.498 Y65.685 E0.00392

G1 X81.472 Y65.593 E0.00250

G1 X81.469 Y64.794 E0.02082

G1 X81.484 Y64.747 E0.00128

M204 S1250

G1 X81.662 Y64.684 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.606 Y64.569 E-0.11986

G1 X81.773 Y64.522 E-0.09603

G1 X83.029 Y64.520 E-0.69611

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.385 Y65.181

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X82.097 Y65.185 E0.05907

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y65.185 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X81.886 Y69.869

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y69.889 E0.27910

G1 X92.596 Y70.358 E0.01222

G1 X88.497 Y70.355 E0.10683

G1 X87.941 Y70.346 E0.01448

G1 X87.555 Y70.296 E0.01013

G1 X87.098 Y70.284 E0.01191

G1 X86.825 Y70.306 E0.00714

G1 X86.637 Y70.345 E0.00501

G1 X85.702 Y70.368 E0.02435

G1 X81.887 Y70.375 E0.09943

G1 X81.886 Y69.929 E0.01162

M204 S1250

G1 X81.517 Y69.575 F9000.000

M204 S800

G1 F1500.000

G1 X81.630 Y69.470 E0.00402

G1 X81.758 Y69.451 E0.00338

G1 X92.706 Y69.472 E0.28526

G1 X92.787 Y69.498 E0.00223

G1 X92.859 Y69.492 E0.00186

G1 X92.970 Y69.584 E0.00376

G1 X93.015 Y69.749 E0.00444

G1 X93.014 Y70.481 E0.01908

G1 X92.970 Y70.621 E0.00382

G1 X92.824 Y70.751 E0.00510

G1 X92.716 Y70.776 E0.00289

G1 X88.493 Y70.773 E0.11004

G1 X87.911 Y70.764 E0.01517

G1 X87.523 Y70.714 E0.01019

G1 X87.109 Y70.703 E0.01079

G1 X86.884 Y70.720 E0.00588

G1 X86.685 Y70.762 E0.00530

G1 X85.708 Y70.786 E0.02547

G1 X81.782 Y70.793 E0.10229

G1 X81.603 Y70.725 E0.00499

G1 X81.548 Y70.679 E0.00186

G1 X81.469 Y70.486 E0.00543

G1 X81.468 Y69.739 E0.01947

G1 X81.499 Y69.633 E0.00289

M204 S1250

G1 X81.671 Y69.582 F9000.000

G1 X82.095 Y70.122

G1 F2400.000

G1 X86.587 Y70.111 E0.02155

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.942 Y70.115 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X88.208 Y70.115

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X90.804 Y70.121 E0.00933

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.159 Y70.117 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.594 Y77.923

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y78.434 E0.01330

G1 X81.889 Y78.431 E0.27894

G1 X81.888 Y77.937 E0.01288

G1 X92.534 Y77.924 E0.27740

M204 S1250

G1 X92.846 Y77.551 F9000.000

M204 S800

G1 F1500.000

G1 X92.945 Y77.632 E0.00331

G1 X93.012 Y77.816 E0.00511

G1 X93.013 Y78.549 E0.01910

G1 X92.990 Y78.667 E0.00313

G1 X92.895 Y78.787 E0.00399

G1 X92.704 Y78.852 E0.00526

G1 X81.771 Y78.849 E0.28488

G1 X81.591 Y78.801 E0.00484

G1 X81.498 Y78.683 E0.00392

G1 X81.472 Y78.591 E0.00250

G1 X81.469 Y77.791 E0.02084

G1 X81.502 Y77.688 E0.00282

G1 X81.606 Y77.567 E0.00417

G1 X81.773 Y77.520 E0.00451

G1 X92.700 Y77.505 E0.28471

G1 X92.789 Y77.533 E0.00244

M204 S1250

G1 X92.855 Y77.678 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.945 Y77.632 E-0.10207

G1 X93.012 Y77.816 E-0.10863

G1 X93.013 Y78.549 E-0.40633

G1 X92.990 Y78.667 E-0.06649

G1 X92.895 Y78.787 E-0.08476

G1 X92.704 Y78.852 E-0.11180

G1 X92.646 Y78.852 E-0.03192

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X82.097 Y78.183

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X92.385 Y78.179 E0.05886

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y78.180 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.597 Y82.887

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y83.355 E0.01220

G1 X88.496 Y83.353 E0.10683

G1 X87.941 Y83.344 E0.01448

G1 X87.555 Y83.294 E0.01013

G1 X87.100 Y83.283 E0.01187

G1 X86.826 Y83.303 E0.00715

G1 X86.636 Y83.343 E0.00505

G1 X85.702 Y83.366 E0.02434

G1 X81.887 Y83.373 E0.09942

G1 X81.886 Y82.867 E0.01319

G1 X92.537 Y82.887 E0.27754

M204 S1250

G1 X92.859 Y82.490 F9000.000

M204 S800

G1 F1500.000

G1 X92.970 Y82.582 E0.00376

G1 X93.015 Y82.747 E0.00444

G1 X93.014 Y83.479 E0.01908

G1 X92.970 Y83.619 E0.00382

G1 X92.825 Y83.749 E0.00509

G1 X92.716 Y83.773 E0.00289

G1 X88.493 Y83.771 E0.11004

G1 X87.911 Y83.762 E0.01517

G1 X87.523 Y83.712 E0.01019

G1 X87.110 Y83.701 E0.01077

G1 X86.885 Y83.717 E0.00588

G1 X86.685 Y83.759 E0.00532

G1 X85.708 Y83.784 E0.02546

G1 X81.776 Y83.791 E0.10245

G1 X81.668 Y83.757 E0.00294

G1 X81.542 Y83.668 E0.00402

G1 X81.469 Y83.484 E0.00516

G1 X81.468 Y82.737 E0.01947

G1 X81.513 Y82.586 E0.00410

G1 X81.607 Y82.482 E0.00365

G1 X81.758 Y82.449 E0.00403

G1 X92.706 Y82.470 E0.28526

G1 X92.799 Y82.495 E0.00251

M204 S1250

G1 X92.867 Y82.634 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.970 Y82.582 E-0.10647

G1 X93.015 Y82.747 E-0.09445

G1 X93.014 Y83.479 E-0.40586

G1 X92.970 Y83.619 E-0.08119

G1 X92.825 Y83.749 E-0.10820

G1 X92.716 Y83.773 E-0.06145

G1 X92.618 Y83.773 E-0.05439

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X90.741 Y83.119

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X88.175 Y83.112 E0.00929

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.821 Y83.116 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X86.587 Y83.108

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X82.095 Y83.120 E0.02175

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y83.116 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X81.888 Y90.935

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y90.921 E0.27896

G1 X92.595 Y91.432 E0.01330

G1 X81.889 Y91.429 E0.27894

G1 X81.888 Y90.995 E0.01132

M204 S1250

G1 X81.502 Y90.686 F9000.000

M204 S800

G1 F1500.000

G1 X81.606 Y90.565 E0.00415

G1 X81.773 Y90.518 E0.00452

G1 X92.700 Y90.503 E0.28471

G1 X92.846 Y90.549 E0.00400

G1 X92.945 Y90.630 E0.00331

G1 X93.012 Y90.814 E0.00511

G1 X93.013 Y91.547 E0.01910

G1 X92.990 Y91.664 E0.00311

G1 X92.895 Y91.785 E0.00401

G1 X92.704 Y91.850 E0.00525

G1 X81.771 Y91.847 E0.28488

G1 X81.591 Y91.799 E0.00484

G1 X81.498 Y91.681 E0.00393

G1 X81.472 Y91.589 E0.00248

G1 X81.469 Y90.789 E0.02083

G1 X81.484 Y90.743 E0.00126

M204 S1250

G1 X81.662 Y90.680 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.606 Y90.565 E-0.11970

G1 X81.773 Y90.518 E-0.09610

G1 X83.029 Y90.516 E-0.69620

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.385 Y91.177

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X82.097 Y91.181 E0.05886

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y91.181 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X81.886 Y95.865

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y95.885 E0.27910

G1 X92.596 Y96.353 E0.01220

G1 X88.496 Y96.351 E0.10683

G1 X87.941 Y96.342 E0.01448

G1 X87.555 Y96.292 E0.01013

G1 X87.100 Y96.281 E0.01187

G1 X86.826 Y96.301 E0.00715

G1 X86.636 Y96.341 E0.00505

G1 X85.702 Y96.363 E0.02435

G1 X81.887 Y96.371 E0.09942

G1 X81.886 Y95.925 E0.01162

M204 S1250

G1 X81.517 Y95.570 F9000.000

M204 S800

G1 F1500.000

G1 X81.629 Y95.466 E0.00399

G1 X81.758 Y95.447 E0.00339

G1 X92.706 Y95.468 E0.28526

G1 X92.787 Y95.494 E0.00223

G1 X92.859 Y95.488 E0.00186

G1 X92.970 Y95.580 E0.00376

G1 X93.015 Y95.745 E0.00444

G1 X93.014 Y96.477 E0.01908

G1 X92.970 Y96.616 E0.00381

G1 X92.824 Y96.747 E0.00509

G1 X92.716 Y96.771 E0.00290

G1 X88.493 Y96.769 E0.11003

G1 X87.911 Y96.759 E0.01517

G1 X87.523 Y96.710 E0.01018

G1 X87.110 Y96.699 E0.01077

G1 X86.885 Y96.715 E0.00588

G1 X86.685 Y96.757 E0.00532

G1 X85.708 Y96.781 E0.02546

G1 X81.776 Y96.789 E0.10245

G1 X81.668 Y96.755 E0.00294

G1 X81.542 Y96.666 E0.00402

G1 X81.469 Y96.481 E0.00517

G1 X81.468 Y95.735 E0.01946

G1 X81.500 Y95.628 E0.00291

M204 S1250

G1 X81.670 Y95.577 F9000.000

G1 X82.095 Y96.118

G1 F2400.000

G1 X86.584 Y96.106 E0.02155

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.939 Y96.110 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X88.187 Y96.110

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X90.674 Y96.116 E0.00897

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.028 Y96.112 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.594 Y103.919

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y104.430 E0.01331

G1 X81.889 Y104.427 E0.27894

G1 X81.888 Y103.932 E0.01289

G1 X92.534 Y103.919 E0.27740

M204 S1250

G1 X92.846 Y103.546 F9000.000

M204 S800

G1 F1500.000

G1 X92.945 Y103.627 E0.00332

G1 X93.012 Y103.812 E0.00512

G1 X93.013 Y104.545 E0.01910

G1 X92.990 Y104.662 E0.00310

G1 X92.895 Y104.782 E0.00400

G1 X92.704 Y104.848 E0.00526

G1 X81.771 Y104.845 E0.28486

G1 X81.591 Y104.797 E0.00484

G1 X81.498 Y104.679 E0.00392

G1 X81.472 Y104.586 E0.00251

G1 X81.469 Y103.787 E0.02082

G1 X81.502 Y103.683 E0.00283

G1 X81.606 Y103.563 E0.00415

G1 X81.773 Y103.515 E0.00452

G1 X92.700 Y103.501 E0.28472

G1 X92.789 Y103.528 E0.00242

M204 S1250

G1 X92.854 Y103.674 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.945 Y103.627 E-0.10224

G1 X93.012 Y103.812 E-0.10886

G1 X93.013 Y104.545 E-0.40628

G1 X92.990 Y104.662 E-0.06600

G1 X92.895 Y104.782 E-0.08506

G1 X92.704 Y104.848 E-0.11192

G1 X92.647 Y104.848 E-0.03164

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X82.097 Y104.179

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X92.385 Y104.175 E0.05917

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y104.175 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.597 Y108.883

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.596 Y109.351 E0.01220

G1 X88.496 Y109.349 E0.10683

G1 X87.942 Y109.340 E0.01446

G1 X87.555 Y109.289 E0.01015

G1 X87.099 Y109.279 E0.01189

G1 X86.826 Y109.299 E0.00712

G1 X86.637 Y109.338 E0.00504

G1 X85.702 Y109.361 E0.02436

G1 X81.887 Y109.369 E0.09942

G1 X81.886 Y108.863 E0.01319

G1 X92.537 Y108.883 E0.27754

M204 S1250

G1 X92.858 Y108.486 F9000.000

M204 S800

G1 F1500.000

G1 X92.970 Y108.578 E0.00377

G1 X93.015 Y108.743 E0.00444

G1 X93.014 Y109.475 E0.01908

G1 X92.970 Y109.614 E0.00379

G1 X92.824 Y109.745 E0.00511

G1 X92.716 Y109.769 E0.00289

G1 X88.493 Y109.767 E0.11003

G1 X87.911 Y109.758 E0.01517

G1 X87.523 Y109.707 E0.01019

G1 X87.109 Y109.697 E0.01078

G1 X86.885 Y109.713 E0.00587

G1 X86.685 Y109.755 E0.00532

G1 X85.708 Y109.779 E0.02547

G1 X81.776 Y109.787 E0.10245

G1 X81.668 Y109.753 E0.00294

G1 X81.542 Y109.664 E0.00402

G1 X81.469 Y109.479 E0.00517

G1 X81.468 Y108.733 E0.01946

G1 X81.517 Y108.568 E0.00447

G1 X81.592 Y108.487 E0.00289

G1 X81.629 Y108.464 E0.00113

G1 X81.758 Y108.445 E0.00339

G1 X92.706 Y108.466 E0.28527

G1 X92.798 Y108.490 E0.00249

M204 S1250

G1 X92.867 Y108.631 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.970 Y108.578 E-0.10669

G1 X93.015 Y108.743 E-0.09443

G1 X93.014 Y109.475 E-0.40582

G1 X92.970 Y109.614 E-0.08068

G1 X92.824 Y109.745 E-0.10861

G1 X92.716 Y109.769 E-0.06156

G1 X92.618 Y109.769 E-0.05421

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X90.674 Y109.114

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X88.187 Y109.108 E0.00897

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.833 Y109.112 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X86.573 Y109.104

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X82.095 Y109.116 E0.02140

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.741 Y109.112 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X81.887 Y116.931

G1 Z8.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.597 Y116.916 E0.27907

G1 X92.595 Y117.428 E0.01333

G1 X81.886 Y117.425 E0.27903

G1 X81.887 Y116.991 E0.01131

M204 S1250

G1 X81.502 Y116.681 F9000.000

M204 S800

G1 F1500.000

G1 X81.606 Y116.560 E0.00415

G1 X81.772 Y116.514 E0.00449

G1 X92.699 Y116.498 E0.28470

G1 X92.824 Y116.539 E0.00343

G1 X92.946 Y116.630 E0.00397

G1 X93.016 Y116.823 E0.00535

G1 X93.013 Y117.542 E0.01874

G1 X92.990 Y117.660 E0.00313

G1 X92.895 Y117.780 E0.00400

G1 X92.704 Y117.846 E0.00526

G1 X81.771 Y117.843 E0.28486

G1 X81.592 Y117.795 E0.00482

G1 X81.499 Y117.678 E0.00389

G1 X81.468 Y117.560 E0.00318

G1 X81.469 Y116.785 E0.02019

G1 X81.484 Y116.738 E0.00129

M204 S1250

G1 X81.662 Y116.675 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.606 Y116.560 E-0.11967

G1 X81.772 Y116.514 E-0.09560

G1 X83.029 Y116.512 E-0.69673

G1 E-0.04800 F4200.00000

G1 Z8.500 F9000.000

G1 X92.387 Y117.172

G1 Z8.300

G1 E3.20000 F2400.00000

G1 X82.096 Y117.178 E0.06003

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;8.45

G1 Z8.450 F9000.000

;AFTER\_LAYER\_CHANGE

;8.45

G1 X81.887 Y117.403

M204 S800

G1 F1500.000

G1 X81.887 Y116.890 E0.01337

G1 X92.597 Y116.879 E0.27907

G1 X92.595 Y117.403 E0.01365

G1 X88.693 Y117.386 E0.10168

G1 X81.947 Y117.403 E0.17578

M204 S1250

G1 X81.613 Y117.777 F9000.000

M204 S800

G1 F1500.000

G1 X81.532 Y117.692 E0.00308

G1 X81.469 Y117.534 E0.00443

G1 X81.469 Y116.755 E0.02030

G1 X81.495 Y116.645 E0.00292

G1 X81.535 Y116.579 E0.00201

G1 X81.601 Y116.519 E0.00233

G1 X81.772 Y116.473 E0.00461

G1 X92.695 Y116.461 E0.28462

G1 X92.870 Y116.516 E0.00478

G1 X92.948 Y116.580 E0.00262

G1 X93.015 Y116.783 E0.00558

G1 X93.013 Y117.514 E0.01903

G1 X92.990 Y117.625 E0.00295

G1 X92.891 Y117.757 E0.00430

G1 X92.704 Y117.821 E0.00516

G1 X88.693 Y117.804 E0.10452

G1 X81.772 Y117.821 E0.18033

G1 X81.671 Y117.793 E0.00271

M204 S1250

G1 X81.615 Y117.659 F9000.000

G1 X82.096 Y117.146

G1 F2400.000

G1 X88.693 Y117.135 E0.03505

G1 X92.387 Y117.141 E0.02410

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y117.138 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X92.394 Y109.391

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.250 Y109.387 E0.10798

G1 X87.545 Y109.288 E0.01855

G1 X87.086 Y109.279 E0.01195

G1 X86.832 Y109.298 E0.00664

G1 X86.472 Y109.373 E0.00959

G1 X85.783 Y109.403 E0.01797

G1 X81.888 Y109.397 E0.10150

G1 X81.890 Y108.880 E0.01347

G1 X92.590 Y108.910 E0.27881

G1 X92.594 Y109.391 E0.01253

G1 X92.454 Y109.391 E0.00365

M204 S1250

G1 X92.959 Y109.675 F9000.000

M204 S800

G1 F1500.000

G1 X92.830 Y109.798 E0.00464

G1 X92.733 Y109.809 E0.00254

G1 X88.221 Y109.805 E0.11756

G1 X87.512 Y109.706 E0.01866

G1 X87.098 Y109.698 E0.01079

G1 X86.891 Y109.713 E0.00541

G1 X86.524 Y109.789 E0.00975

G1 X85.792 Y109.821 E0.01910

G1 X81.770 Y109.815 E0.10478

G1 X81.589 Y109.746 E0.00506

G1 X81.532 Y109.688 E0.00210

G1 X81.469 Y109.513 E0.00484

G1 X81.473 Y108.727 E0.02050

G1 X81.516 Y108.589 E0.00377

G1 X81.573 Y108.524 E0.00222

G1 X81.634 Y108.486 E0.00188

G1 X81.762 Y108.462 E0.00339

G1 X92.839 Y108.493 E0.28864

G1 X92.968 Y108.597 E0.00431

G1 X93.007 Y108.735 E0.00373

G1 X93.013 Y109.522 E0.02052

G1 X92.979 Y109.619 E0.00268

M204 S1250

G1 X92.781 Y109.670 F9000.000

G1 X92.383 Y109.150

G1 F2400.000

G1 X88.267 Y109.139 E0.01983

G1 X88.068 Y109.125 E0.00096

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.267 Y109.139 E-0.11092

G1 X89.713 Y109.143 E-0.80108

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X86.556 Y109.118

G1 Z8.450

G1 E3.20000 F2400.00000

G1 X85.778 Y109.143 E0.00352

G1 X82.098 Y109.139 E0.01663

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y109.141 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X82.086 Y104.405

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y104.405 E0.00519

G1 X81.887 Y103.892 E0.01337

G1 X92.597 Y103.882 E0.27907

G1 X92.595 Y104.405 E0.01364

G1 X88.693 Y104.389 E0.10168

G1 X82.146 Y104.405 E0.17059

M204 S1250

G1 X81.613 Y104.780 F9000.000

M204 S800

G1 F1500.000

G1 X81.532 Y104.695 E0.00305

G1 X81.469 Y104.536 E0.00445

G1 X81.469 Y103.757 E0.02030

G1 X81.495 Y103.648 E0.00292

G1 X81.535 Y103.582 E0.00201

G1 X81.601 Y103.522 E0.00232

G1 X81.772 Y103.475 E0.00463

G1 X92.695 Y103.464 E0.28461

G1 X92.870 Y103.518 E0.00477

G1 X92.948 Y103.583 E0.00264

G1 X93.015 Y103.786 E0.00557

G1 X93.013 Y104.516 E0.01904

G1 X92.990 Y104.627 E0.00294

G1 X92.891 Y104.759 E0.00430

G1 X92.704 Y104.823 E0.00516

G1 X88.693 Y104.807 E0.10452

G1 X81.771 Y104.823 E0.18034

G1 X81.671 Y104.796 E0.00272

M204 S1250

G1 X81.615 Y104.662 F9000.000

G1 X82.096 Y104.148

G1 F2400.000

G1 X88.693 Y104.137 E0.03518

G1 X92.387 Y104.143 E0.02407

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y104.140 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X92.394 Y96.393

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.250 Y96.389 E0.10799

G1 X87.545 Y96.292 E0.01853

G1 X87.087 Y96.281 E0.01194

G1 X86.832 Y96.300 E0.00667

G1 X86.472 Y96.376 E0.00959

G1 X85.783 Y96.406 E0.01796

G1 X81.888 Y96.399 E0.10150

G1 X81.890 Y95.882 E0.01347

G1 X92.590 Y95.912 E0.27881

G1 X92.594 Y96.393 E0.01253

G1 X92.454 Y96.393 E0.00365

M204 S1250

G1 X92.829 Y96.794 F9000.000

M204 S800

G1 F1500.000

G1 X92.723 Y96.811 E0.00280

G1 X88.221 Y96.807 E0.11732

G1 X87.512 Y96.709 E0.01864

G1 X87.098 Y96.700 E0.01079

G1 X86.890 Y96.715 E0.00543

G1 X86.524 Y96.792 E0.00976

G1 X85.792 Y96.824 E0.01910

G1 X81.770 Y96.817 E0.10479

G1 X81.589 Y96.748 E0.00506

G1 X81.532 Y96.690 E0.00210

G1 X81.469 Y96.515 E0.00484

G1 X81.473 Y95.729 E0.02050

G1 X81.516 Y95.591 E0.00377

G1 X81.573 Y95.526 E0.00222

G1 X81.634 Y95.488 E0.00188

G1 X81.762 Y95.464 E0.00339

G1 X92.839 Y95.495 E0.28863

G1 X92.968 Y95.599 E0.00432

G1 X93.007 Y95.737 E0.00372

G1 X93.013 Y96.524 E0.02052

G1 X92.960 Y96.675 E0.00418

G1 X92.874 Y96.754 E0.00302

M204 S1250

G1 X92.742 Y96.732 F9000.000

G1 X92.383 Y96.152

G1 F2400.000

G1 X88.267 Y96.141 E0.01984

G1 X88.065 Y96.127 E0.00097

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.267 Y96.141 E-0.11192

G1 X89.711 Y96.145 E-0.80008

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X86.558 Y96.120

G1 Z8.450

G1 E3.20000 F2400.00000

G1 X85.778 Y96.146 E0.00355

G1 X82.098 Y96.141 E0.01676

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y96.143 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X82.086 Y91.407

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y91.407 E0.00519

G1 X81.887 Y90.895 E0.01334

G1 X92.597 Y90.884 E0.27907

G1 X92.595 Y91.407 E0.01362

G1 X88.693 Y91.391 E0.10168

G1 X82.146 Y91.407 E0.17059

M204 S1250

G1 X81.613 Y91.782 F9000.000

M204 S800

G1 F1500.000

G1 X81.532 Y91.697 E0.00307

G1 X81.469 Y91.539 E0.00443

G1 X81.469 Y90.759 E0.02033

G1 X81.495 Y90.650 E0.00292

G1 X81.535 Y90.584 E0.00201

G1 X81.601 Y90.525 E0.00232

G1 X81.772 Y90.478 E0.00462

G1 X92.695 Y90.466 E0.28462

G1 X92.871 Y90.521 E0.00479

G1 X92.948 Y90.585 E0.00262

G1 X93.015 Y90.788 E0.00556

G1 X93.013 Y91.518 E0.01904

G1 X92.990 Y91.629 E0.00295

G1 X92.891 Y91.762 E0.00431

G1 X92.704 Y91.825 E0.00515

G1 X88.693 Y91.809 E0.10453

G1 X81.771 Y91.825 E0.18034

G1 X81.671 Y91.798 E0.00271

M204 S1250

G1 X81.615 Y91.664 F9000.000

G1 X82.096 Y91.151

G1 F2400.000

G1 X88.693 Y91.140 E0.03482

G1 X92.387 Y91.145 E0.02388

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y91.143 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X92.594 Y83.395

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.250 Y83.391 E0.11319

G1 X87.546 Y83.294 E0.01853

G1 X87.087 Y83.283 E0.01194

G1 X86.832 Y83.302 E0.00667

G1 X86.471 Y83.378 E0.00959

G1 X85.783 Y83.408 E0.01796

G1 X81.888 Y83.401 E0.10150

G1 X81.890 Y82.884 E0.01347

G1 X92.590 Y82.914 E0.27881

G1 X92.594 Y83.335 E0.01097

M204 S1250

G1 X92.959 Y83.680 F9000.000

M204 S800

G1 F1500.000

G1 X92.830 Y83.803 E0.00465

G1 X92.733 Y83.813 E0.00252

G1 X88.221 Y83.809 E0.11758

G1 X87.512 Y83.711 E0.01865

G1 X87.098 Y83.702 E0.01079

G1 X86.890 Y83.717 E0.00543

G1 X86.524 Y83.794 E0.00976

G1 X85.792 Y83.826 E0.01910

G1 X81.770 Y83.819 E0.10478

G1 X81.589 Y83.750 E0.00506

G1 X81.532 Y83.692 E0.00210

G1 X81.469 Y83.517 E0.00484

G1 X81.473 Y82.731 E0.02049

G1 X81.516 Y82.593 E0.00377

G1 X81.573 Y82.528 E0.00224

G1 X81.634 Y82.490 E0.00187

G1 X81.762 Y82.466 E0.00339

G1 X92.839 Y82.497 E0.28863

G1 X92.968 Y82.601 E0.00432

G1 X93.007 Y82.739 E0.00372

G1 X93.013 Y83.526 E0.02052

G1 X92.979 Y83.623 E0.00269

M204 S1250

G1 X92.780 Y83.674 F9000.000

G1 X92.383 Y83.154

G1 F2400.000

G1 X88.267 Y83.144 E0.01997

G1 X88.063 Y83.129 E0.00099

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.267 Y83.144 E-0.11362

G1 X89.708 Y83.147 E-0.79838

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X86.558 Y83.122

G1 Z8.450

G1 E3.20000 F2400.00000

G1 X85.777 Y83.148 E0.00356

G1 X82.098 Y83.143 E0.01677

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y83.145 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X82.086 Y78.409

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y78.409 E0.00520

G1 X81.887 Y77.897 E0.01334

G1 X92.597 Y77.886 E0.27907

G1 X92.595 Y78.409 E0.01362

G1 X88.693 Y78.393 E0.10168

G1 X82.146 Y78.409 E0.17058

M204 S1250

G1 X81.613 Y78.784 F9000.000

M204 S800

G1 F1500.000

G1 X81.532 Y78.699 E0.00307

G1 X81.469 Y78.541 E0.00443

G1 X81.469 Y77.761 E0.02033

G1 X81.495 Y77.652 E0.00291

G1 X81.535 Y77.586 E0.00202

G1 X81.601 Y77.527 E0.00231

G1 X81.772 Y77.480 E0.00462

G1 X92.695 Y77.468 E0.28462

G1 X92.871 Y77.523 E0.00479

G1 X92.948 Y77.587 E0.00262

G1 X93.015 Y77.790 E0.00556

G1 X93.013 Y78.520 E0.01904

G1 X92.990 Y78.632 E0.00296

G1 X92.891 Y78.764 E0.00429

G1 X92.704 Y78.827 E0.00515

G1 X88.693 Y78.811 E0.10453

G1 X81.771 Y78.827 E0.18034

G1 X81.671 Y78.800 E0.00271

M204 S1250

G1 X81.615 Y78.666 F9000.000

G1 X82.096 Y78.153

G1 F2400.000

G1 X88.693 Y78.142 E0.03505

G1 X92.387 Y78.147 E0.02389

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y78.145 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X92.594 Y70.397

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.250 Y70.393 E0.11319

G1 X87.546 Y70.296 E0.01853

G1 X87.086 Y70.285 E0.01198

G1 X86.831 Y70.305 E0.00667

G1 X86.472 Y70.380 E0.00955

G1 X85.783 Y70.410 E0.01796

G1 X81.888 Y70.403 E0.10150

G1 X81.890 Y69.886 E0.01347

G1 X92.590 Y69.916 E0.27881

G1 X92.594 Y70.337 E0.01097

M204 S1250

G1 X92.959 Y70.682 F9000.000

M204 S800

G1 F1500.000

G1 X92.830 Y70.805 E0.00465

G1 X92.733 Y70.815 E0.00252

G1 X88.221 Y70.811 E0.11757

G1 X87.512 Y70.713 E0.01865

G1 X87.098 Y70.704 E0.01080

G1 X86.890 Y70.720 E0.00543

G1 X86.524 Y70.796 E0.00974

G1 X85.792 Y70.828 E0.01910

G1 X81.770 Y70.821 E0.10479

G1 X81.589 Y70.752 E0.00505

G1 X81.532 Y70.694 E0.00210

G1 X81.469 Y70.519 E0.00485

G1 X81.473 Y69.733 E0.02049

G1 X81.516 Y69.596 E0.00376

G1 X81.573 Y69.531 E0.00224

G1 X81.634 Y69.492 E0.00190

G1 X81.762 Y69.468 E0.00338

G1 X92.839 Y69.499 E0.28863

G1 X92.968 Y69.603 E0.00432

G1 X93.007 Y69.741 E0.00372

G1 X93.013 Y70.528 E0.02052

G1 X92.979 Y70.625 E0.00269

M204 S1250

G1 X92.780 Y70.676 F9000.000

G1 X92.383 Y70.156

G1 F2400.000

G1 X88.267 Y70.146 E0.01981

G1 X88.068 Y70.132 E0.00096

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.267 Y70.146 E-0.11090

G1 X89.713 Y70.149 E-0.80110

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X86.556 Y70.125

G1 Z8.450

G1 E3.20000 F2400.00000

G1 X85.778 Y70.150 E0.00353

G1 X82.098 Y70.145 E0.01666

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y70.147 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X82.086 Y65.411

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y65.411 E0.00520

G1 X81.887 Y64.899 E0.01334

G1 X92.597 Y64.888 E0.27907

G1 X92.595 Y65.411 E0.01362

G1 X88.693 Y65.395 E0.10168

M73 P76 R16

G1 X82.146 Y65.411 E0.17058

M204 S1250

G1 X81.613 Y65.786 F9000.000

M204 S800

G1 F1500.000

G1 X81.532 Y65.701 E0.00307

G1 X81.469 Y65.543 E0.00443

G1 X81.469 Y64.764 E0.02030

G1 X81.495 Y64.654 E0.00292

G1 X81.535 Y64.588 E0.00201

G1 X81.601 Y64.528 E0.00233

G1 X81.772 Y64.482 E0.00461

G1 X92.695 Y64.470 E0.28462

G1 X92.871 Y64.525 E0.00479

G1 X92.948 Y64.589 E0.00262

G1 X93.015 Y64.792 E0.00556

G1 X93.013 Y65.522 E0.01904

G1 X92.990 Y65.634 E0.00296

G1 X92.891 Y65.766 E0.00429

G1 X92.704 Y65.829 E0.00515

G1 X88.693 Y65.813 E0.10453

G1 X81.771 Y65.829 E0.18034

G1 X81.671 Y65.802 E0.00271

M204 S1250

G1 X81.615 Y65.668 F9000.000

G1 X82.096 Y65.155

G1 F2400.000

G1 X88.693 Y65.144 E0.03505

G1 X92.387 Y65.149 E0.02389

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y65.147 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X92.594 Y57.399

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.250 Y57.396 E0.11319

G1 X87.545 Y57.298 E0.01855

G1 X87.087 Y57.288 E0.01195

G1 X86.832 Y57.307 E0.00665

G1 X86.472 Y57.382 E0.00958

G1 X85.783 Y57.412 E0.01796

G1 X81.888 Y57.405 E0.10150

G1 X81.890 Y56.888 E0.01347

G1 X92.590 Y56.919 E0.27881

G1 X92.594 Y57.339 E0.01095

M204 S1250

G1 X92.959 Y57.684 F9000.000

M204 S800

G1 F1500.000

G1 X92.830 Y57.807 E0.00465

G1 X92.733 Y57.817 E0.00253

G1 X88.221 Y57.814 E0.11757

G1 X87.512 Y57.715 E0.01865

G1 X87.098 Y57.706 E0.01079

G1 X86.890 Y57.722 E0.00542

G1 X86.524 Y57.798 E0.00975

G1 X85.792 Y57.830 E0.01910

G1 X81.770 Y57.823 E0.10479

G1 X81.589 Y57.754 E0.00505

G1 X81.532 Y57.696 E0.00210

G1 X81.469 Y57.521 E0.00485

G1 X81.473 Y56.736 E0.02048

G1 X81.516 Y56.597 E0.00378

G1 X81.573 Y56.533 E0.00222

G1 X81.634 Y56.494 E0.00190

G1 X81.762 Y56.470 E0.00340

G1 X92.840 Y56.502 E0.28863

G1 X92.968 Y56.605 E0.00429

G1 X93.007 Y56.743 E0.00372

G1 X93.013 Y57.531 E0.02053

G1 X92.979 Y57.627 E0.00267

M204 S1250

G1 X92.780 Y57.678 F9000.000

G1 X92.383 Y57.158

G1 F2400.000

G1 X88.267 Y57.148 E0.01983

G1 X88.068 Y57.134 E0.00096

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.267 Y57.148 E-0.11087

G1 X89.713 Y57.152 E-0.80113

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X86.556 Y57.127

G1 Z8.450

G1 E3.20000 F2400.00000

G1 X85.778 Y57.152 E0.00352

G1 X82.098 Y57.147 E0.01663

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.743 Y57.149 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X82.086 Y52.413

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y52.413 E0.00520

G1 X81.887 Y51.901 E0.01334

G1 X92.597 Y51.890 E0.27907

G1 X92.595 Y52.413 E0.01362

G1 X88.693 Y52.397 E0.10168

G1 X82.146 Y52.413 E0.17058

M204 S1250

G1 X81.613 Y52.788 F9000.000

M204 S800

G1 F1500.000

G1 X81.532 Y52.703 E0.00307

G1 X81.469 Y52.545 E0.00443

G1 X81.469 Y51.766 E0.02030

G1 X81.495 Y51.656 E0.00292

G1 X81.535 Y51.590 E0.00201

G1 X81.601 Y51.530 E0.00233

G1 X81.772 Y51.484 E0.00461

G1 X92.695 Y51.472 E0.28462

G1 X92.871 Y51.527 E0.00478

G1 X92.948 Y51.591 E0.00262

G1 X93.015 Y51.794 E0.00558

G1 X93.013 Y52.524 E0.01902

G1 X92.990 Y52.636 E0.00296

G1 X92.891 Y52.768 E0.00429

G1 X92.704 Y52.831 E0.00515

G1 X88.693 Y52.815 E0.10453

G1 X81.771 Y52.831 E0.18034

G1 X81.671 Y52.804 E0.00271

M204 S1250

G1 X81.615 Y52.670 F9000.000

G1 X82.096 Y52.157

G1 F2400.000

G1 X88.693 Y52.146 E0.03505

G1 X92.387 Y52.151 E0.02389

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y52.149 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X92.394 Y44.402

G1 Z8.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.250 Y44.398 E0.10798

G1 X87.545 Y44.300 E0.01855

G1 X87.087 Y44.290 E0.01195

G1 X86.832 Y44.309 E0.00665

G1 X86.472 Y44.384 E0.00958

G1 X85.783 Y44.414 E0.01797

G1 X81.888 Y44.408 E0.10150

G1 X81.890 Y43.890 E0.01350

G1 X92.590 Y43.921 E0.27881

G1 X92.594 Y44.402 E0.01253

G1 X92.454 Y44.402 E0.00365

M204 S1250

G1 X92.959 Y44.686 F9000.000

M204 S800

G1 F1500.000

G1 X92.829 Y44.809 E0.00466

G1 X92.733 Y44.820 E0.00253

G1 X88.221 Y44.816 E0.11756

G1 X87.512 Y44.717 E0.01865

G1 X87.098 Y44.708 E0.01079

G1 X86.890 Y44.724 E0.00542

G1 X86.524 Y44.800 E0.00975

G1 X85.792 Y44.832 E0.01910

G1 X81.770 Y44.826 E0.10479

G1 X81.589 Y44.757 E0.00505

G1 X81.532 Y44.698 E0.00212

G1 X81.469 Y44.524 E0.00483

G1 X81.473 Y43.738 E0.02049

G1 X81.516 Y43.600 E0.00377

G1 X81.573 Y43.535 E0.00222

G1 X81.634 Y43.496 E0.00190

G1 X81.762 Y43.472 E0.00340

G1 X92.839 Y43.504 E0.28862

G1 X92.968 Y43.608 E0.00431

G1 X93.007 Y43.745 E0.00371

G1 X93.013 Y44.533 E0.02053

G1 X92.979 Y44.629 E0.00267

M204 S1250

G1 X92.780 Y44.680 F9000.000

G1 X92.383 Y44.161

G1 F2400.000

G1 X88.267 Y44.150 E0.01983

G1 X88.068 Y44.136 E0.00096

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.267 Y44.150 E-0.11091

G1 X89.713 Y44.154 E-0.80109

G1 E-0.04800 F4200.00000

G1 Z8.650 F9000.000

G1 X86.556 Y44.129

G1 Z8.450

G1 E3.20000 F2400.00000

G1 X85.778 Y44.154 E0.00352

G1 X82.098 Y44.149 E0.01663

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;8.6

G1 Z8.600 F9000.000

;AFTER\_LAYER\_CHANGE

;8.6

G1 E-3.20000 F4200.00000

G1 Z8.800 F9000.000

G1 X81.887 Y116.838

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y116.835 E0.27901

G1 X92.595 Y117.368 E0.01387

G1 X88.594 Y117.355 E0.10425

G1 X81.892 Y117.367 E0.17461

G1 X81.888 Y116.898 E0.01222

M204 S1250

G1 X81.502 Y116.585 F9000.000

M204 S800

G1 F1500.000

G1 X81.615 Y116.466 E0.00428

G1 X81.792 Y116.420 E0.00477

G1 X92.681 Y116.417 E0.28371

G1 X92.837 Y116.449 E0.00417

G1 X92.931 Y116.516 E0.00301

G1 X93.000 Y116.644 E0.00378

G1 X93.012 Y117.485 E0.02192

G1 X92.991 Y117.585 E0.00266

G1 X92.881 Y117.731 E0.00477

G1 X92.707 Y117.786 E0.00475

G1 X88.593 Y117.773 E0.10718

G1 X81.765 Y117.785 E0.17792

G1 X81.589 Y117.731 E0.00480

G1 X81.476 Y117.524 E0.00615

G1 X81.468 Y116.723 E0.02087

G1 X81.487 Y116.643 E0.00215

M204 S1250

G1 X81.666 Y116.584 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.615 Y116.466 E-0.12103

G1 X81.792 Y116.420 E-0.10135

G1 X83.036 Y116.420 E-0.68963

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.386 Y117.101

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X82.098 Y117.102 E0.07268

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.744 Y117.102 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X81.886 Y109.441

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y108.914 E0.01373

G1 X88.144 Y108.907 E0.16310

G1 X92.598 Y108.925 E0.11604

G1 X92.596 Y109.446 E0.01358

G1 X88.528 Y109.435 E0.10600

G1 X88.245 Y109.414 E0.00738

G1 X87.726 Y109.307 E0.01381

G1 X87.082 Y109.280 E0.01679

G1 X86.838 Y109.298 E0.00639

G1 X86.302 Y109.410 E0.01428

G1 X85.857 Y109.445 E0.01163

G1 X81.946 Y109.441 E0.10188

M204 S1250

G1 X81.658 Y109.824 F9000.000

M204 S800

G1 F1500.000

G1 X81.528 Y109.735 E0.00410

G1 X81.469 Y109.564 E0.00471

G1 X81.466 Y108.803 E0.01983

G1 X81.507 Y108.637 E0.00445

G1 X81.636 Y108.524 E0.00448

G1 X81.765 Y108.496 E0.00343

G1 X88.145 Y108.490 E0.16624

G1 X92.737 Y108.507 E0.11963

G1 X92.885 Y108.545 E0.00399

G1 X92.930 Y108.582 E0.00153

G1 X92.973 Y108.644 E0.00195

G1 X93.016 Y108.818 E0.00468

G1 X93.013 Y109.568 E0.01954

G1 X92.947 Y109.741 E0.00483

G1 X92.800 Y109.864 E0.00500

G1 X88.511 Y109.853 E0.11174

G1 X88.187 Y109.828 E0.00848

G1 X87.675 Y109.723 E0.01362

G1 X87.089 Y109.698 E0.01528

G1 X86.896 Y109.712 E0.00504

G1 X86.361 Y109.824 E0.01424

G1 X85.873 Y109.863 E0.01276

G1 X81.774 Y109.858 E0.10681

G1 X81.715 Y109.841 E0.00159

M204 S1250

G1 X81.639 Y109.668 F9000.000

G1 X82.094 Y109.177

G1 F2400.000

G1 X85.846 Y109.178 E0.01979

G1 X86.442 Y109.142 E0.00315

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.846 Y109.178 E-0.33063

G1 X84.797 Y109.177 E-0.58137

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X88.075 Y109.141

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X88.144 Y109.147 E0.00027

G1 X88.538 Y109.173 E0.00253

G1 X92.388 Y109.185 E0.02465

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y109.180 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.595 Y104.370

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y104.369 E0.27886

G1 X81.887 Y103.840 E0.01379

G1 X92.595 Y103.837 E0.27901

G1 X92.595 Y104.310 E0.01232

M204 S1250

G1 X92.991 Y104.588 F9000.000

M204 S800

G1 F1500.000

G1 X92.881 Y104.733 E0.00476

G1 X92.706 Y104.788 E0.00476

G1 X81.765 Y104.787 E0.28509

G1 X81.589 Y104.734 E0.00479

G1 X81.476 Y104.526 E0.00616

G1 X81.468 Y103.725 E0.02087

G1 X81.526 Y103.549 E0.00483

G1 X81.615 Y103.469 E0.00313

G1 X81.792 Y103.422 E0.00478

G1 X92.681 Y103.419 E0.28370

G1 X92.837 Y103.451 E0.00417

G1 X92.931 Y103.519 E0.00301

G1 X93.000 Y103.646 E0.00378

G1 X93.013 Y103.707 E0.00161

G1 X93.004 Y104.529 E0.02143

M204 S1250

G1 X92.809 Y104.603 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.881 Y104.733 E-0.13202

G1 X92.706 Y104.788 E-0.10127

G1 X91.482 Y104.788 E-0.67870

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X82.098 Y104.105

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X92.386 Y104.104 E0.07351

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y104.104 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.406 Y96.448

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.528 Y96.437 E0.10106

G1 X88.245 Y96.416 E0.00738

G1 X87.726 Y96.309 E0.01381

G1 X87.082 Y96.282 E0.01679

G1 X86.837 Y96.300 E0.00640

G1 X86.301 Y96.412 E0.01428

G1 X85.857 Y96.448 E0.01162

G1 X81.886 Y96.443 E0.10345

G1 X81.884 Y95.916 E0.01373

G1 X88.144 Y95.909 E0.16310

G1 X92.598 Y95.927 E0.11604

G1 X92.596 Y96.448 E0.01358

G1 X92.466 Y96.448 E0.00337

M204 S1250

G1 X92.852 Y96.837 F9000.000

M204 S800

G1 F1500.000

G1 X92.800 Y96.866 E0.00157

G1 X88.511 Y96.855 E0.11174

G1 X88.187 Y96.830 E0.00848

G1 X87.675 Y96.725 E0.01362

G1 X87.089 Y96.700 E0.01528

G1 X86.896 Y96.714 E0.00504

G1 X86.361 Y96.827 E0.01425

G1 X85.873 Y96.866 E0.01275

G1 X81.774 Y96.860 E0.10681

G1 X81.658 Y96.827 E0.00313

G1 X81.544 Y96.752 E0.00356

G1 X81.469 Y96.566 E0.00523

G1 X81.466 Y95.805 E0.01982

G1 X81.507 Y95.639 E0.00447

G1 X81.636 Y95.526 E0.00448

G1 X81.765 Y95.498 E0.00343

G1 X88.145 Y95.492 E0.16624

G1 X92.794 Y95.512 E0.12113

G1 X92.930 Y95.585 E0.00403

G1 X92.973 Y95.646 E0.00194

G1 X93.016 Y95.820 E0.00467

G1 X93.013 Y96.570 E0.01954

G1 X92.947 Y96.743 E0.00483

G1 X92.895 Y96.795 E0.00191

M204 S1250

G1 X92.796 Y96.816 F9000.000

G1 X92.388 Y96.187

G1 F2400.000

G1 X88.538 Y96.175 E0.02465

G1 X88.144 Y96.149 E0.00253

G1 X88.075 Y96.143 E0.00027

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.144 Y96.149 E-0.03805

G1 E-0.92195 F4200.00000

G1 Z8.800 F9000.000

G1 X86.444 Y96.144

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X85.846 Y96.180 E0.00319

G1 X82.094 Y96.179 E0.01998

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y96.180 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X81.892 Y91.372

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y90.843 E0.01378

G1 X92.595 Y90.840 E0.27901

G1 X92.595 Y91.372 E0.01386

G1 X81.952 Y91.372 E0.27730

M204 S1250

G1 X81.625 Y91.759 F9000.000

M204 S800

G1 F1500.000

G1 X81.562 Y91.704 E0.00219

G1 X81.476 Y91.539 E0.00484

G1 X81.468 Y90.727 E0.02115

G1 X81.526 Y90.551 E0.00483

G1 X81.614 Y90.471 E0.00312

G1 X81.792 Y90.425 E0.00478

G1 X92.681 Y90.422 E0.28372

G1 X92.838 Y90.453 E0.00416

G1 X92.931 Y90.521 E0.00300

G1 X93.013 Y90.709 E0.00535

G1 X93.012 Y91.490 E0.02036

G1 X92.991 Y91.590 E0.00265

G1 X92.881 Y91.735 E0.00476

G1 X92.707 Y91.790 E0.00475

G1 X81.765 Y91.789 E0.28509

G1 X81.684 Y91.772 E0.00217

M204 S1250

G1 X81.621 Y91.675 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.562 Y91.704 E-0.07738

G1 X81.476 Y91.539 E-0.10285

G1 X81.468 Y90.727 E-0.44991

G1 X81.526 Y90.551 E-0.10273

G1 X81.614 Y90.471 E-0.06632

G1 X81.792 Y90.425 E-0.10159

G1 X81.812 Y90.425 E-0.01122

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.386 Y91.106

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X82.098 Y91.107 E0.07291

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.744 Y91.107 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X81.886 Y83.445

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y82.918 E0.01373

G1 X88.144 Y82.911 E0.16310

G1 X92.598 Y82.929 E0.11604

G1 X92.596 Y83.451 E0.01359

G1 X88.529 Y83.440 E0.10597

G1 X88.246 Y83.418 E0.00738

G1 X87.726 Y83.311 E0.01383

G1 X87.082 Y83.284 E0.01679

G1 X86.837 Y83.302 E0.00640

G1 X86.301 Y83.414 E0.01428

G1 X85.856 Y83.450 E0.01162

G1 X81.946 Y83.445 E0.10188

M204 S1250

G1 X81.658 Y83.829 F9000.000

M204 S800

G1 F1500.000

G1 X81.528 Y83.739 E0.00412

G1 X81.469 Y83.568 E0.00471

G1 X81.466 Y82.808 E0.01981

G1 X81.507 Y82.641 E0.00447

G1 X81.636 Y82.528 E0.00448

G1 X81.765 Y82.500 E0.00343

G1 X88.145 Y82.494 E0.16624

G1 X92.737 Y82.511 E0.11963

G1 X92.885 Y82.549 E0.00398

G1 X92.930 Y82.587 E0.00155

G1 X92.973 Y82.648 E0.00194

G1 X93.016 Y82.822 E0.00467

G1 X93.013 Y83.572 E0.01954

G1 X92.946 Y83.745 E0.00484

G1 X92.800 Y83.869 E0.00501

G1 X88.512 Y83.858 E0.11173

G1 X88.187 Y83.832 E0.00848

G1 X87.675 Y83.727 E0.01363

G1 X87.089 Y83.702 E0.01528

G1 X86.896 Y83.716 E0.00504

G1 X86.361 Y83.829 E0.01425

G1 X85.873 Y83.868 E0.01275

G1 X81.774 Y83.863 E0.10681

G1 X81.716 Y83.846 E0.00157

M204 S1250

G1 X81.640 Y83.672 F9000.000

G1 X82.094 Y83.182

G1 F2400.000

G1 X85.846 Y83.182 E0.01999

G1 X86.444 Y83.146 E0.00319

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.846 Y83.182 E-0.33198

G1 X84.799 Y83.182 E-0.58001

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X88.075 Y83.145

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X88.144 Y83.151 E0.00027

G1 X88.539 Y83.177 E0.00256

G1 X92.388 Y83.190 E0.02480

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y83.184 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.595 Y78.374

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y78.374 E0.27886

G1 X81.887 Y77.845 E0.01378

G1 X92.595 Y77.842 E0.27901

G1 X92.595 Y78.314 E0.01230

M204 S1250

G1 X92.991 Y78.592 F9000.000

M204 S800

G1 F1500.000

G1 X92.881 Y78.737 E0.00475

G1 X92.707 Y78.792 E0.00476

G1 X81.765 Y78.791 E0.28509

G1 X81.589 Y78.738 E0.00480

G1 X81.476 Y78.541 E0.00591

G1 X81.468 Y77.729 E0.02116

G1 X81.526 Y77.554 E0.00482

G1 X81.614 Y77.473 E0.00313

G1 X81.792 Y77.427 E0.00477

G1 X92.681 Y77.424 E0.28372

G1 X92.838 Y77.455 E0.00416

G1 X92.931 Y77.523 E0.00300

G1 X93.000 Y77.650 E0.00378

G1 X93.013 Y77.711 E0.00161

G1 X93.004 Y78.534 E0.02144

M204 S1250

G1 X92.810 Y78.608 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.881 Y78.737 E-0.13184

G1 X92.707 Y78.792 E-0.10120

G1 X91.481 Y78.792 E-0.67896

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X82.098 Y78.109

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X92.386 Y78.108 E0.07288

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y78.109 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.406 Y70.452

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.529 Y70.442 E0.10102

G1 X88.246 Y70.420 E0.00738

G1 X87.726 Y70.313 E0.01383

G1 X87.081 Y70.286 E0.01683

G1 X86.836 Y70.305 E0.00639

G1 X86.301 Y70.417 E0.01424

G1 X85.857 Y70.452 E0.01163

G1 X81.886 Y70.447 E0.10345

G1 X81.884 Y69.920 E0.01373

G1 X92.598 Y69.931 E0.27915

G1 X92.596 Y70.453 E0.01359

G1 X92.466 Y70.452 E0.00339

M204 S1250

G1 X92.852 Y70.842 F9000.000

M204 S800

G1 F1500.000

G1 X92.800 Y70.871 E0.00157

G1 X88.512 Y70.860 E0.11173

G1 X88.187 Y70.834 E0.00848

G1 X87.675 Y70.729 E0.01363

G1 X87.088 Y70.704 E0.01529

G1 X86.896 Y70.719 E0.00504

G1 X86.361 Y70.831 E0.01423

G1 X85.873 Y70.870 E0.01276

G1 X81.774 Y70.865 E0.10681

G1 X81.658 Y70.831 E0.00313

G1 X81.544 Y70.757 E0.00356

G1 X81.469 Y70.570 E0.00524

G1 X81.466 Y69.810 E0.01981

G1 X81.507 Y69.644 E0.00445

G1 X81.637 Y69.530 E0.00451

G1 X81.765 Y69.502 E0.00341

G1 X88.145 Y69.496 E0.16624

G1 X92.794 Y69.516 E0.12113

G1 X92.930 Y69.589 E0.00403

G1 X92.973 Y69.650 E0.00194

G1 X93.016 Y69.824 E0.00467

G1 X93.013 Y70.574 E0.01954

G1 X92.946 Y70.747 E0.00484

G1 X92.894 Y70.799 E0.00192

M204 S1250

G1 X92.796 Y70.820 F9000.000

G1 X92.388 Y70.192

G1 F2400.000

G1 X88.539 Y70.179 E0.02481

G1 X88.144 Y70.154 E0.00256

G1 X88.079 Y70.147 E0.00025

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.144 Y70.154 E-0.03595

G1 E-0.92405 F4200.00000

G1 Z8.800 F9000.000

G1 X86.443 Y70.149

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X85.846 Y70.184 E0.00317

G1 X82.094 Y70.184 E0.01989

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y70.184 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X81.892 Y65.376

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y64.847 E0.01378

G1 X92.595 Y64.844 E0.27901

G1 X92.595 Y65.376 E0.01386

G1 X81.952 Y65.376 E0.27730

M204 S1250

G1 X81.625 Y65.763 F9000.000

M204 S800

G1 F1500.000

G1 X81.561 Y65.708 E0.00219

G1 X81.476 Y65.543 E0.00484

G1 X81.468 Y64.732 E0.02113

G1 X81.526 Y64.556 E0.00482

G1 X81.615 Y64.475 E0.00315

G1 X81.792 Y64.429 E0.00477

G1 X92.681 Y64.426 E0.28372

G1 X92.838 Y64.457 E0.00416

G1 X92.931 Y64.525 E0.00300

G1 X93.013 Y64.713 E0.00535

G1 X93.012 Y65.494 E0.02036

G1 X92.991 Y65.594 E0.00266

G1 X92.881 Y65.739 E0.00475

G1 X92.707 Y65.794 E0.00476

G1 X81.765 Y65.793 E0.28509

G1 X81.684 Y65.776 E0.00217

M204 S1250

G1 X81.621 Y65.679 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.561 Y65.708 E-0.07737

G1 X81.476 Y65.543 E-0.10288

G1 X81.468 Y64.732 E-0.44947

G1 X81.526 Y64.556 E-0.10262

G1 X81.615 Y64.475 E-0.06699

G1 X81.792 Y64.429 E-0.10135

G1 X81.812 Y64.429 E-0.01133

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.386 Y65.110

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X82.098 Y65.111 E0.07288

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.744 Y65.111 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X81.886 Y57.449

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y56.922 E0.01373

G1 X88.144 Y56.916 E0.16310

G1 X92.598 Y56.934 E0.11604

G1 X92.596 Y57.455 E0.01357

G1 X88.529 Y57.444 E0.10597

G1 X88.246 Y57.422 E0.00740

G1 X87.726 Y57.315 E0.01383

G1 X87.082 Y57.288 E0.01678

G1 X86.838 Y57.307 E0.00639

G1 X86.301 Y57.419 E0.01427

G1 X85.857 Y57.454 E0.01163

G1 X81.946 Y57.449 E0.10189

M204 S1250

G1 X81.658 Y57.833 F9000.000

M204 S800

G1 F1500.000

G1 X81.529 Y57.743 E0.00411

G1 X81.469 Y57.572 E0.00472

G1 X81.466 Y56.812 E0.01981

G1 X81.507 Y56.646 E0.00446

G1 X81.637 Y56.532 E0.00449

G1 X81.765 Y56.504 E0.00343

G1 X88.145 Y56.499 E0.16623

G1 X92.737 Y56.516 E0.11963

G1 X92.794 Y56.519 E0.00151

G1 X92.930 Y56.591 E0.00401

G1 X92.973 Y56.652 E0.00194

G1 X93.016 Y56.826 E0.00467

G1 X93.013 Y57.576 E0.01954

G1 X92.947 Y57.749 E0.00483

G1 X92.800 Y57.873 E0.00501

G1 X88.511 Y57.862 E0.11173

G1 X88.187 Y57.836 E0.00848

G1 X87.675 Y57.731 E0.01362

G1 X87.089 Y57.707 E0.01528

G1 X86.896 Y57.721 E0.00504

G1 X86.361 Y57.833 E0.01424

G1 X85.873 Y57.872 E0.01276

G1 X81.774 Y57.867 E0.10681

G1 X81.716 Y57.850 E0.00157

M204 S1250

G1 X81.640 Y57.676 F9000.000

G1 X82.094 Y57.186

G1 F2400.000

G1 X85.846 Y57.186 E0.01986

G1 X86.442 Y57.151 E0.00316

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.846 Y57.186 E-0.33106

G1 X84.798 Y57.186 E-0.58094

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X88.078 Y57.150

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X88.143 Y57.156 E0.00025

G1 X88.539 Y57.182 E0.00253

G1 X92.388 Y57.194 E0.02457

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y57.189 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.595 Y52.378

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y52.378 E0.27886

G1 X81.887 Y51.849 E0.01378

G1 X92.595 Y51.846 E0.27901

G1 X92.595 Y52.318 E0.01230

M204 S1250

G1 X92.991 Y52.596 F9000.000

M204 S800

G1 F1500.000

G1 X92.881 Y52.742 E0.00476

G1 X92.707 Y52.796 E0.00475

G1 X81.765 Y52.795 E0.28510

G1 X81.589 Y52.742 E0.00480

G1 X81.476 Y52.535 E0.00615

G1 X81.468 Y51.734 E0.02087

G1 X81.526 Y51.558 E0.00482

G1 X81.615 Y51.477 E0.00315

G1 X81.792 Y51.431 E0.00477

G1 X92.681 Y51.428 E0.28371

G1 X92.837 Y51.460 E0.00417

G1 X92.931 Y51.527 E0.00301

G1 X93.000 Y51.655 E0.00378

G1 X93.013 Y51.715 E0.00160

G1 X93.004 Y52.538 E0.02143

M204 S1250

G1 X92.810 Y52.612 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.881 Y52.742 E-0.13196

G1 X92.707 Y52.796 E-0.10103

G1 X91.482 Y52.796 E-0.67900

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X82.098 Y52.113

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X92.386 Y52.112 E0.07288

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.740 Y52.113 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.800 F9000.000

G1 X92.406 Y44.457

G1 Z8.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.529 Y44.446 E0.10104

G1 X88.246 Y44.424 E0.00740

G1 X87.726 Y44.317 E0.01383

G1 X87.082 Y44.290 E0.01678

G1 X86.838 Y44.309 E0.00639

G1 X86.301 Y44.421 E0.01427

G1 X85.857 Y44.456 E0.01163

G1 X81.886 Y44.452 E0.10345

G1 X81.884 Y43.924 E0.01375

G1 X88.144 Y43.918 E0.16310

G1 X92.598 Y43.936 E0.11604

G1 X92.596 Y44.457 E0.01358

G1 X92.466 Y44.457 E0.00337

M204 S1250

G1 X92.852 Y44.846 F9000.000

M204 S800

G1 F1500.000

G1 X92.799 Y44.875 E0.00157

G1 X88.512 Y44.864 E0.11172

G1 X88.187 Y44.838 E0.00848

G1 X87.675 Y44.733 E0.01362

G1 X87.089 Y44.709 E0.01528

G1 X86.896 Y44.723 E0.00504

G1 X86.361 Y44.835 E0.01424

G1 X85.873 Y44.874 E0.01276

G1 X81.774 Y44.869 E0.10681

G1 X81.658 Y44.835 E0.00315

G1 X81.544 Y44.762 E0.00353

G1 X81.469 Y44.575 E0.00525

G1 X81.466 Y43.814 E0.01983

G1 X81.507 Y43.648 E0.00445

G1 X81.637 Y43.535 E0.00450

G1 X81.766 Y43.506 E0.00343

G1 X88.145 Y43.501 E0.16623

G1 X92.794 Y43.521 E0.12114

G1 X92.930 Y43.593 E0.00401

G1 X92.973 Y43.655 E0.00195

G1 X93.016 Y43.828 E0.00466

G1 X93.013 Y44.578 E0.01954

G1 X92.947 Y44.751 E0.00483

G1 X92.894 Y44.803 E0.00193

M204 S1250

G1 X92.796 Y44.825 F9000.000

G1 X92.388 Y44.196

G1 F2400.000

G1 X88.539 Y44.184 E0.02465

G1 X88.143 Y44.158 E0.00254

G1 X88.078 Y44.152 E0.00025

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.143 Y44.158 E-0.03641

G1 E-0.92359 F4200.00000

G1 Z8.800 F9000.000

G1 X86.442 Y44.153

G1 Z8.600

G1 E3.20000 F2400.00000

G1 X85.846 Y44.188 E0.00316

G1 X82.094 Y44.188 E0.01986

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;8.75

G1 Z8.750 F9000.000

;AFTER\_LAYER\_CHANGE

;8.75

G1 E-3.20000 F4200.00000

G1 Z8.950 F9000.000

G1 X81.912 Y116.777

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.531 Y116.770 E0.27669

G1 X92.589 Y116.783 E0.00155

G1 X92.593 Y117.333 E0.01431

G1 X81.884 Y117.331 E0.27904

G1 X81.884 Y116.815 E0.01343

M204 S1250

G1 X81.510 Y116.529 F9000.000

M204 S800

G1 F1500.000

G1 X81.628 Y116.420 E0.00419

G1 X81.857 Y116.359 E0.00617

G1 X92.579 Y116.352 E0.27939

G1 X92.841 Y116.414 E0.00700

G1 X92.921 Y116.470 E0.00255

G1 X93.005 Y116.634 E0.00480

G1 X93.012 Y117.458 E0.02147

G1 X92.992 Y117.546 E0.00235

G1 X92.870 Y117.705 E0.00523

G1 X92.710 Y117.750 E0.00435

G1 X81.766 Y117.749 E0.28516

G1 X81.633 Y117.719 E0.00354

G1 X81.580 Y117.689 E0.00158

G1 X81.474 Y117.509 E0.00545

G1 X81.467 Y116.686 E0.02144

G1 X81.484 Y116.583 E0.00270

M204 S1250

G1 X81.671 Y116.536 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.628 Y116.420 E-0.12058

G1 X81.857 Y116.359 E-0.13124

G1 X83.048 Y116.358 E-0.66019

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.382 Y117.051

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X82.093 Y117.054 E0.09293

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.739 Y117.053 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X81.886 Y109.500

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y108.956 E0.01418

G1 X92.598 Y108.946 E0.27914

G1 X92.595 Y109.513 E0.01476

G1 X88.684 Y109.495 E0.10192

G1 X88.412 Y109.461 E0.00712

G1 X88.173 Y109.393 E0.00649

G1 X87.704 Y109.305 E0.01243

G1 X87.070 Y109.281 E0.01655

G1 X86.847 Y109.297 E0.00581

G1 X85.826 Y109.498 E0.02712

G1 X81.946 Y109.500 E0.10108

M204 S1250

G1 X81.516 Y109.762 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y109.624 E0.00378

G1 X81.475 Y108.757 E0.02261

G1 X81.506 Y108.678 E0.00221

G1 X81.617 Y108.576 E0.00392

G1 X81.764 Y108.538 E0.00395

G1 X92.730 Y108.529 E0.28572

G1 X92.912 Y108.598 E0.00508

G1 X92.981 Y108.703 E0.00327

G1 X93.016 Y108.858 E0.00416

G1 X93.013 Y109.616 E0.01974

G1 X92.934 Y109.814 E0.00555

G1 X92.877 Y109.871 E0.00208

G1 X92.768 Y109.931 E0.00325

G1 X88.657 Y109.913 E0.10713

G1 X88.329 Y109.872 E0.00860

G1 X88.077 Y109.800 E0.00683

G1 X87.657 Y109.721 E0.01112

G1 X87.077 Y109.699 E0.01513

G1 X86.903 Y109.712 E0.00455

G1 X85.867 Y109.915 E0.02753

G1 X81.769 Y109.918 E0.10677

G1 X81.612 Y109.862 E0.00433

G1 X81.563 Y109.798 E0.00209

M204 S1250

G1 X81.584 Y109.634 F9000.000

G1 X82.094 Y109.228

G1 F2400.000

G1 X85.799 Y109.225 E0.02099

G1 X86.207 Y109.185 E0.00232

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.799 Y109.225 E-0.22712

G1 X84.563 Y109.226 E-0.68488

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X88.278 Y109.182

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X88.464 Y109.208 E0.00116

G1 X88.701 Y109.222 E0.00190

G1 X92.388 Y109.229 E0.03401

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y109.226 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.593 Y104.335

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y104.333 E0.27904

G1 X81.884 Y103.786 E0.01424

G1 X92.530 Y103.772 E0.27738

G1 X92.589 Y103.786 E0.00157

G1 X92.593 Y104.275 E0.01274

M204 S1250

G1 X92.870 Y104.707 F9000.000

M204 S800

G1 F1500.000

G1 X92.710 Y104.752 E0.00435

G1 X81.765 Y104.751 E0.28517

G1 X81.632 Y104.722 E0.00354

G1 X81.581 Y104.692 E0.00156

G1 X81.474 Y104.511 E0.00548

G1 X81.467 Y103.688 E0.02144

G1 X81.510 Y103.531 E0.00423

G1 X81.628 Y103.423 E0.00417

G1 X81.857 Y103.361 E0.00618

G1 X92.579 Y103.354 E0.27938

G1 X92.841 Y103.416 E0.00702

G1 X92.921 Y103.473 E0.00254

G1 X93.005 Y103.637 E0.00481

G1 X93.012 Y104.461 E0.02147

G1 X92.992 Y104.548 E0.00234

G1 X92.907 Y104.659 E0.00365

M204 S1250

G1 X92.725 Y104.625 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.710 Y104.752 E-0.12089

G1 X91.282 Y104.752 E-0.79111

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X82.093 Y104.056

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X92.382 Y104.053 E0.09293

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y104.054 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.415 Y96.514

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.684 Y96.497 E0.09724

G1 X88.412 Y96.463 E0.00712

G1 X88.173 Y96.395 E0.00649

G1 X87.704 Y96.307 E0.01243

G1 X87.070 Y96.283 E0.01655

G1 X86.847 Y96.299 E0.00582

G1 X85.826 Y96.501 E0.02713

G1 X81.886 Y96.502 E0.10264

G1 X81.885 Y95.958 E0.01418

G1 X92.598 Y95.948 E0.27914

M73 P78 R15

G1 X92.595 Y96.515 E0.01476

G1 X92.475 Y96.514 E0.00312

M204 S1250

G1 X92.877 Y96.873 F9000.000

M204 S800

G1 F1500.000

G1 X92.768 Y96.933 E0.00325

G1 X88.657 Y96.915 E0.10713

G1 X88.329 Y96.874 E0.00860

G1 X88.077 Y96.802 E0.00683

G1 X87.657 Y96.723 E0.01112

G1 X87.077 Y96.701 E0.01513

G1 X86.903 Y96.714 E0.00455

G1 X85.866 Y96.918 E0.02753

G1 X81.769 Y96.920 E0.10677

G1 X81.612 Y96.865 E0.00432

G1 X81.516 Y96.764 E0.00364

G1 X81.469 Y96.626 E0.00378

G1 X81.466 Y95.828 E0.02081

G1 X81.506 Y95.680 E0.00399

G1 X81.635 Y95.566 E0.00448

G1 X81.764 Y95.540 E0.00342

G1 X92.730 Y95.531 E0.28572

G1 X92.912 Y95.600 E0.00508

G1 X92.982 Y95.705 E0.00327

G1 X93.016 Y95.860 E0.00415

G1 X93.013 Y96.618 E0.01974

G1 X92.920 Y96.830 E0.00603

M204 S1250

G1 X92.756 Y96.844 F9000.000

G1 X92.388 Y96.231

G1 F2400.000

G1 X88.701 Y96.224 E0.03401

G1 X88.464 Y96.210 E0.00190

G1 X88.278 Y96.184 E0.00116

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.464 Y96.210 E-0.10420

G1 E-0.85580 F4200.00000

G1 Z8.950 F9000.000

G1 X86.210 Y96.187

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X85.799 Y96.227 E0.00235

G1 X82.094 Y96.230 E0.02109

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y96.229 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X81.884 Y91.336

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y90.789 E0.01425

G1 X81.912 Y90.781 E0.00074

G1 X92.531 Y90.775 E0.27669

G1 X92.589 Y90.788 E0.00155

G1 X92.593 Y91.337 E0.01428

G1 X81.944 Y91.336 E0.27747

M204 S1250

G1 X81.581 Y91.694 F9000.000

M204 S800

G1 F1500.000

G1 X81.474 Y91.513 E0.00547

G1 X81.466 Y91.447 E0.00173

G1 X81.467 Y90.690 E0.01973

G1 X81.484 Y90.585 E0.00278

G1 X81.510 Y90.533 E0.00150

G1 X81.628 Y90.425 E0.00417

G1 X81.857 Y90.364 E0.00618

G1 X92.579 Y90.357 E0.27939

G1 X92.841 Y90.419 E0.00701

G1 X92.921 Y90.475 E0.00253

G1 X93.005 Y90.639 E0.00480

G1 X93.012 Y91.463 E0.02147

G1 X92.992 Y91.550 E0.00234

G1 X92.870 Y91.709 E0.00521

G1 X92.710 Y91.754 E0.00435

G1 X81.766 Y91.753 E0.28516

G1 X81.632 Y91.724 E0.00355

M204 S1250

G1 X81.616 Y91.487 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.474 Y91.513 E-0.14624

G1 X81.466 Y91.447 E-0.03672

G1 X81.467 Y90.690 E-0.41971

G1 X81.484 Y90.585 E-0.05906

G1 X81.510 Y90.533 E-0.03180

G1 X81.628 Y90.425 E-0.08859

G1 X81.854 Y90.364 E-0.12989

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.382 Y91.056

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X82.093 Y91.058 E0.09231

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.739 Y91.058 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X81.886 Y83.505

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y82.960 E0.01419

G1 X92.598 Y82.950 E0.27914

G1 X92.595 Y83.517 E0.01477

G1 X88.685 Y83.500 E0.10190

G1 X88.413 Y83.466 E0.00712

G1 X88.173 Y83.397 E0.00651

G1 X87.704 Y83.309 E0.01243

G1 X87.070 Y83.285 E0.01655

G1 X86.847 Y83.301 E0.00582

G1 X85.826 Y83.503 E0.02713

G1 X81.946 Y83.505 E0.10107

M204 S1250

G1 X81.516 Y83.766 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y83.628 E0.00378

G1 X81.475 Y82.761 E0.02259

G1 X81.506 Y82.682 E0.00223

G1 X81.617 Y82.580 E0.00392

G1 X81.764 Y82.542 E0.00395

G1 X92.730 Y82.533 E0.28572

G1 X92.912 Y82.602 E0.00508

G1 X92.982 Y82.707 E0.00327

G1 X93.016 Y82.862 E0.00415

G1 X93.013 Y83.620 E0.01974

G1 X92.934 Y83.818 E0.00555

G1 X92.877 Y83.875 E0.00209

G1 X92.768 Y83.936 E0.00325

G1 X88.657 Y83.918 E0.10712

G1 X88.329 Y83.876 E0.00861

G1 X88.077 Y83.804 E0.00684

G1 X87.657 Y83.725 E0.01112

G1 X87.077 Y83.703 E0.01513

G1 X86.903 Y83.716 E0.00455

G1 X85.866 Y83.920 E0.02753

G1 X81.769 Y83.923 E0.10676

G1 X81.612 Y83.867 E0.00434

G1 X81.563 Y83.802 E0.00211

M204 S1250

G1 X81.584 Y83.638 F9000.000

G1 X82.094 Y83.232

G1 F2400.000

G1 X85.799 Y83.229 E0.02110

G1 X86.210 Y83.189 E0.00235

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.799 Y83.229 E-0.22885

G1 X84.566 Y83.230 E-0.68315

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X88.278 Y83.186

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X88.465 Y83.212 E0.00117

G1 X88.703 Y83.227 E0.00192

G1 X92.388 Y83.233 E0.03412

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y83.230 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.593 Y78.339

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y78.338 E0.27904

G1 X81.884 Y77.791 E0.01424

G1 X92.531 Y77.777 E0.27741

G1 X92.589 Y77.790 E0.00155

G1 X92.593 Y78.279 E0.01272

M204 S1250

G1 X92.992 Y78.553 F9000.000

M204 S800

G1 F1500.000

G1 X92.870 Y78.711 E0.00521

G1 X92.710 Y78.756 E0.00435

G1 X81.766 Y78.755 E0.28516

G1 X81.633 Y78.726 E0.00354

G1 X81.581 Y78.696 E0.00158

G1 X81.474 Y78.515 E0.00547

G1 X81.467 Y77.692 E0.02145

G1 X81.510 Y77.536 E0.00421

G1 X81.628 Y77.427 E0.00418

G1 X81.857 Y77.366 E0.00617

G1 X92.579 Y77.359 E0.27939

G1 X92.841 Y77.421 E0.00701

G1 X92.921 Y77.477 E0.00253

G1 X93.005 Y77.641 E0.00480

G1 X93.006 Y78.494 E0.02224

M204 S1250

G1 X92.794 Y78.574 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.870 Y78.711 E-0.14152

G1 X92.710 Y78.756 E-0.09253

G1 X91.486 Y78.756 E-0.67795

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X82.093 Y78.061

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X92.382 Y78.058 E0.09231

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y78.058 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.414 Y70.518

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.685 Y70.502 E0.09719

G1 X88.412 Y70.467 E0.00715

G1 X88.173 Y70.400 E0.00649

G1 X87.705 Y70.311 E0.01240

G1 X87.068 Y70.287 E0.01661

G1 X86.846 Y70.304 E0.00581

G1 X85.826 Y70.505 E0.02709

G1 X81.886 Y70.507 E0.10264

G1 X81.885 Y69.962 E0.01419

G1 X92.598 Y69.952 E0.27914

G1 X92.595 Y70.519 E0.01477

G1 X92.474 Y70.519 E0.00315

M204 S1250

G1 X92.877 Y70.877 F9000.000

M204 S800

G1 F1500.000

G1 X92.768 Y70.938 E0.00325

G1 X88.657 Y70.920 E0.10712

G1 X88.329 Y70.878 E0.00862

G1 X88.077 Y70.807 E0.00683

G1 X87.658 Y70.727 E0.01112

G1 X87.077 Y70.705 E0.01514

G1 X86.903 Y70.719 E0.00455

G1 X85.867 Y70.922 E0.02751

G1 X81.769 Y70.925 E0.10676

G1 X81.612 Y70.869 E0.00434

G1 X81.516 Y70.768 E0.00364

G1 X81.469 Y70.630 E0.00378

G1 X81.466 Y69.832 E0.02080

G1 X81.506 Y69.685 E0.00397

G1 X81.636 Y69.570 E0.00451

G1 X81.764 Y69.544 E0.00340

G1 X92.730 Y69.535 E0.28572

G1 X92.912 Y69.604 E0.00508

G1 X92.982 Y69.709 E0.00327

G1 X93.016 Y69.865 E0.00416

G1 X93.013 Y70.622 E0.01973

G1 X92.919 Y70.834 E0.00604

M204 S1250

G1 X92.756 Y70.849 F9000.000

G1 X92.388 Y70.235

G1 F2400.000

G1 X88.703 Y70.229 E0.03412

G1 X88.464 Y70.214 E0.00193

G1 X88.275 Y70.188 E0.00117

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.464 Y70.214 E-0.10554

G1 E-0.85446 F4200.00000

G1 Z8.950 F9000.000

G1 X86.211 Y70.191

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X85.799 Y70.231 E0.00236

G1 X82.094 Y70.234 E0.02110

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.740 Y70.233 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X81.884 Y65.340

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y64.793 E0.01424

G1 X81.912 Y64.786 E0.00074

G1 X92.531 Y64.779 E0.27669

G1 X92.589 Y64.792 E0.00155

G1 X92.593 Y65.341 E0.01428

G1 X81.944 Y65.340 E0.27747

M204 S1250

G1 X81.581 Y65.698 F9000.000

M204 S800

G1 F1500.000

G1 X81.474 Y65.517 E0.00547

G1 X81.466 Y65.451 E0.00173

G1 X81.467 Y64.695 E0.01971

G1 X81.484 Y64.589 E0.00279

G1 X81.510 Y64.538 E0.00147

G1 X81.628 Y64.429 E0.00419

G1 X81.857 Y64.368 E0.00617

G1 X92.579 Y64.361 E0.27939

G1 X92.841 Y64.423 E0.00701

G1 X92.921 Y64.479 E0.00253

G1 X93.005 Y64.643 E0.00480

G1 X93.012 Y65.467 E0.02147

G1 X92.992 Y65.555 E0.00235

G1 X92.870 Y65.713 E0.00521

G1 X92.710 Y65.758 E0.00435

G1 X81.766 Y65.757 E0.28516

G1 X81.632 Y65.728 E0.00355

M204 S1250

G1 X81.616 Y65.491 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.474 Y65.517 E-0.14624

G1 X81.466 Y65.451 E-0.03672

G1 X81.467 Y64.695 E-0.41922

G1 X81.484 Y64.589 E-0.05939

G1 X81.510 Y64.538 E-0.03137

G1 X81.628 Y64.429 E-0.08911

G1 X81.854 Y64.368 E-0.12996

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.382 Y65.060

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X82.093 Y65.063 E0.09231

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.739 Y65.062 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X81.886 Y57.509

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y56.964 E0.01419

G1 X92.598 Y56.955 E0.27914

G1 X92.595 Y57.521 E0.01474

G1 X88.684 Y57.504 E0.10191

G1 X88.412 Y57.470 E0.00714

G1 X88.173 Y57.402 E0.00649

G1 X87.705 Y57.313 E0.01241

G1 X87.070 Y57.289 E0.01656

G1 X86.847 Y57.306 E0.00581

G1 X85.826 Y57.507 E0.02712

G1 X81.946 Y57.509 E0.10108

M204 S1250

G1 X81.516 Y57.770 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y57.632 E0.00378

G1 X81.475 Y56.766 E0.02258

G1 X81.506 Y56.687 E0.00221

G1 X81.617 Y56.584 E0.00393

G1 X81.764 Y56.546 E0.00396

G1 X92.730 Y56.538 E0.28571

G1 X92.912 Y56.607 E0.00508

G1 X92.982 Y56.712 E0.00327

G1 X93.016 Y56.867 E0.00414

G1 X93.013 Y57.624 E0.01974

G1 X92.934 Y57.822 E0.00555

G1 X92.877 Y57.879 E0.00209

G1 X92.768 Y57.940 E0.00325

G1 X88.657 Y57.922 E0.10713

G1 X88.329 Y57.881 E0.00861

G1 X88.077 Y57.809 E0.00683

G1 X87.657 Y57.730 E0.01112

G1 X87.077 Y57.708 E0.01513

G1 X86.903 Y57.721 E0.00455

G1 X85.867 Y57.924 E0.02753

G1 X81.769 Y57.927 E0.10676

G1 X81.612 Y57.871 E0.00434

G1 X81.563 Y57.806 E0.00211

M204 S1250

G1 X81.584 Y57.642 F9000.000

G1 X82.094 Y57.236

G1 F2400.000

G1 X85.799 Y57.234 E0.02106

G1 X86.209 Y57.193 E0.00234

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.799 Y57.234 E-0.22844

G1 X84.566 Y57.234 E-0.68356

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X88.277 Y57.190

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X88.464 Y57.216 E0.00116

G1 X88.702 Y57.231 E0.00191

G1 X92.388 Y57.238 E0.03390

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y57.235 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.593 Y52.343

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y52.342 E0.27904

G1 X81.884 Y51.795 E0.01424

G1 X92.531 Y51.781 E0.27741

G1 X92.589 Y51.794 E0.00155

G1 X92.593 Y52.283 E0.01272

M204 S1250

G1 X92.870 Y52.715 F9000.000

M204 S800

G1 F1500.000

G1 X92.710 Y52.760 E0.00434

G1 X81.765 Y52.759 E0.28517

G1 X81.633 Y52.730 E0.00354

G1 X81.580 Y52.700 E0.00158

G1 X81.474 Y52.520 E0.00545

G1 X81.467 Y51.697 E0.02144

G1 X81.510 Y51.540 E0.00422

G1 X81.628 Y51.431 E0.00419

G1 X81.857 Y51.370 E0.00617

G1 X92.579 Y51.363 E0.27939

G1 X92.841 Y51.425 E0.00700

G1 X92.921 Y51.481 E0.00255

G1 X93.005 Y51.645 E0.00480

G1 X93.012 Y52.469 E0.02146

G1 X92.992 Y52.557 E0.00235

G1 X92.907 Y52.668 E0.00365

M204 S1250

G1 X92.725 Y52.633 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.710 Y52.760 E-0.12056

G1 X91.282 Y52.760 E-0.79144

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X82.093 Y52.065

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X92.382 Y52.062 E0.09231

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y52.062 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z8.950 F9000.000

G1 X92.415 Y44.523

G1 Z8.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.684 Y44.506 E0.09723

G1 X88.412 Y44.472 E0.00714

G1 X88.173 Y44.404 E0.00649

G1 X87.705 Y44.315 E0.01241

G1 X87.070 Y44.291 E0.01656

G1 X86.847 Y44.308 E0.00581

G1 X85.826 Y44.509 E0.02712

G1 X81.886 Y44.511 E0.10264

G1 X81.885 Y43.966 E0.01420

G1 X92.598 Y43.957 E0.27914

G1 X92.595 Y44.524 E0.01476

G1 X92.475 Y44.523 E0.00312

M204 S1250

G1 X92.877 Y44.881 F9000.000

M204 S800

G1 F1500.000

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G1 X88.657 Y44.924 E0.10712

G1 X88.329 Y44.883 E0.00861

G1 X88.077 Y44.811 E0.00683

G1 X87.657 Y44.732 E0.01112

G1 X87.077 Y44.710 E0.01513

G1 X86.903 Y44.723 E0.00455

G1 X85.867 Y44.926 E0.02753

G1 X81.769 Y44.929 E0.10677

G1 X81.612 Y44.873 E0.00433

G1 X81.516 Y44.773 E0.00362

G1 X81.469 Y44.635 E0.00379

G1 X81.466 Y43.836 E0.02082

G1 X81.506 Y43.689 E0.00397

G1 X81.636 Y43.575 E0.00449

G1 X81.764 Y43.548 E0.00342

G1 X92.730 Y43.540 E0.28571

G1 X92.912 Y43.609 E0.00508

G1 X92.982 Y43.714 E0.00327

G1 X93.016 Y43.869 E0.00414

G1 X93.013 Y44.626 E0.01974

G1 X92.919 Y44.839 E0.00604

M204 S1250

G1 X92.755 Y44.853 F9000.000

G1 X92.388 Y44.240

G1 F2400.000

G1 X88.702 Y44.233 E0.03400

G1 X88.464 Y44.218 E0.00191

G1 X88.277 Y44.192 E0.00116

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.464 Y44.218 E-0.10470

G1 E-0.85530 F4200.00000

G1 Z8.950 F9000.000

G1 X86.209 Y44.195

G1 Z8.750

G1 E3.20000 F2400.00000

G1 X85.799 Y44.236 E0.00234

G1 X82.094 Y44.238 E0.02106

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;8.9

G1 Z8.900 F9000.000

;AFTER\_LAYER\_CHANGE

;8.9

G1 X81.894 Y44.008

M204 S800

G1 F1500.000

G1 X92.598 Y43.998 E0.27890

G1 X92.595 Y44.591 E0.01545

G1 X88.879 Y44.577 E0.09681

G1 X88.562 Y44.520 E0.00840

G1 X88.182 Y44.407 E0.01034

G1 X87.866 Y44.340 E0.00841

G1 X87.499 Y44.297 E0.00962

G1 X87.049 Y44.293 E0.01173

G1 X86.850 Y44.307 E0.00520

G1 X86.119 Y44.458 E0.01945

G1 X85.902 Y44.531 E0.00597

G1 X85.609 Y44.589 E0.00779

G1 X81.888 Y44.572 E0.09694

G1 X81.893 Y44.068 E0.01315

M204 S1250

G1 X81.508 Y43.732 F9000.000

M204 S800

G1 F1500.000

G1 X81.638 Y43.615 E0.00457

G1 X81.763 Y43.590 E0.00332

G1 X92.710 Y43.580 E0.28523

G1 X92.906 Y43.654 E0.00546

G1 X92.990 Y43.780 E0.00394

G1 X93.016 Y43.910 E0.00345

G1 X93.012 Y44.692 E0.02037

G1 X92.940 Y44.878 E0.00520

G1 X92.891 Y44.929 E0.00183

G1 X92.739 Y45.009 E0.00448

G1 X88.842 Y44.994 E0.10156

G1 X88.465 Y44.927 E0.00996

G1 X88.079 Y44.812 E0.01052

G1 X87.798 Y44.752 E0.00747

G1 X87.473 Y44.714 E0.00853

G1 X87.063 Y44.711 E0.01069

G1 X86.908 Y44.722 E0.00405

G1 X86.228 Y44.862 E0.01808

G1 X86.010 Y44.935 E0.00600

G1 X85.649 Y45.007 E0.00959

G1 X81.765 Y44.990 E0.10121

G1 X81.636 Y44.963 E0.00343

G1 X81.592 Y44.935 E0.00137

G1 X81.518 Y44.843 E0.00306

G1 X81.469 Y44.697 E0.00403

G1 X81.487 Y43.789 E0.02366

M204 S1250

G1 X81.683 Y43.738 F9000.000

G1 X82.100 Y44.291

G1 F2400.000

G1 X85.580 Y44.297 E0.01860

G1 X86.053 Y44.236 E0.00255

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.580 Y44.297 E-0.26416

G1 X84.411 Y44.295 E-0.64784

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X88.414 Y44.234

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X88.518 Y44.249 E0.00053

G1 X88.623 Y44.264 E0.00070

G1 X88.764 Y44.276 E0.00117

G1 X92.387 Y44.294 E0.03929

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y44.286 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.432 Y51.715

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y51.758 E0.00431

G1 X92.594 Y52.307 E0.01430

G1 X81.884 Y52.300 E0.27905

G1 X81.884 Y51.761 E0.01405

G1 X82.052 Y51.711 E0.00458

G1 X92.372 Y51.715 E0.26888

M204 S1250

G1 X92.931 Y51.493 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y51.643 E0.00442

G1 X93.012 Y52.439 E0.02074

G1 X92.994 Y52.517 E0.00209

G1 X92.885 Y52.656 E0.00459

G1 X92.701 Y52.725 E0.00512

G1 X81.769 Y52.718 E0.28484

G1 X81.636 Y52.684 E0.00356

G1 X81.580 Y52.651 E0.00169

G1 X81.474 Y52.475 E0.00536

G1 X81.466 Y52.401 E0.00194

G1 X81.466 Y51.683 E0.01872

G1 X81.508 Y51.530 E0.00413

G1 X81.682 Y51.385 E0.00590

G1 X81.992 Y51.294 E0.00844

G1 X92.481 Y51.297 E0.27330

G1 X92.769 Y51.367 E0.00771

G1 X92.884 Y51.456 E0.00378

M204 S1250

G1 X92.874 Y51.652 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y51.643 E-0.12500

G1 X93.012 Y52.439 E-0.44113

G1 X92.994 Y52.517 E-0.04441

G1 X92.885 Y52.656 E-0.09765

G1 X92.701 Y52.725 E-0.10900

G1 X92.530 Y52.724 E-0.09482

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X82.093 Y52.006

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X92.384 Y52.011 E0.11130

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y52.010 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.598 Y56.996

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y57.588 E0.01544

G1 X88.879 Y57.575 E0.09681

G1 X88.562 Y57.518 E0.00840

G1 X88.182 Y57.405 E0.01034

G1 X87.866 Y57.338 E0.00841

G1 X87.499 Y57.295 E0.00962

G1 X87.049 Y57.291 E0.01173

G1 X86.850 Y57.305 E0.00520

G1 X86.119 Y57.456 E0.01945

G1 X85.902 Y57.529 E0.00597

G1 X85.609 Y57.587 E0.00779

G1 X81.888 Y57.570 E0.09694

G1 X81.894 Y57.006 E0.01471

G1 X92.538 Y56.996 E0.27734

M204 S1250

G1 X92.906 Y56.652 F9000.000

M204 S800

G1 F1500.000

G1 X92.990 Y56.778 E0.00394

G1 X93.016 Y56.908 E0.00346

G1 X93.012 Y57.690 E0.02037

G1 X92.940 Y57.876 E0.00520

G1 X92.891 Y57.926 E0.00183

G1 X92.740 Y58.007 E0.00447

G1 X88.842 Y57.992 E0.10156

G1 X88.465 Y57.925 E0.00996

G1 X88.079 Y57.810 E0.01052

G1 X87.798 Y57.750 E0.00747

G1 X87.473 Y57.712 E0.00853

G1 X87.063 Y57.709 E0.01069

G1 X86.908 Y57.720 E0.00405

G1 X86.228 Y57.860 E0.01808

G1 X86.010 Y57.933 E0.00600

G1 X85.649 Y58.005 E0.00959

G1 X81.765 Y57.988 E0.10120

G1 X81.636 Y57.960 E0.00345

G1 X81.592 Y57.932 E0.00136

G1 X81.518 Y57.841 E0.00306

G1 X81.469 Y57.694 E0.00403

G1 X81.478 Y56.812 E0.02298

G1 X81.508 Y56.730 E0.00228

G1 X81.638 Y56.613 E0.00457

G1 X81.763 Y56.588 E0.00331

G1 X92.710 Y56.578 E0.28524

G1 X92.854 Y56.622 E0.00392

M204 S1250

G1 X92.886 Y56.802 F9000.000

G1 X92.387 Y57.292

G1 F2400.000

G1 X88.764 Y57.274 E0.03915

G1 X88.623 Y57.262 E0.00117

G1 X88.518 Y57.247 E0.00070

G1 X88.414 Y57.232 E0.00053

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.518 Y57.247 E-0.05845

G1 E-0.90155 F4200.00000

G1 Z9.100 F9000.000

G1 X86.053 Y57.234

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X85.580 Y57.295 E0.00255

G1 X82.100 Y57.289 E0.01860

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.746 Y57.292 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X82.052 Y64.709

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.432 Y64.713 E0.27044

G1 X92.592 Y64.756 E0.00431

G1 X92.594 Y65.305 E0.01431

G1 X81.884 Y65.298 E0.27905

G1 X81.884 Y64.759 E0.01405

G1 X81.995 Y64.726 E0.00301

M204 S1250

G1 X81.508 Y64.528 F9000.000

M204 S800

G1 F1500.000

G1 X81.682 Y64.383 E0.00589

G1 X81.992 Y64.292 E0.00844

G1 X92.481 Y64.295 E0.27330

G1 X92.769 Y64.365 E0.00772

G1 X92.931 Y64.490 E0.00532

G1 X93.009 Y64.641 E0.00443

G1 X93.012 Y65.437 E0.02075

G1 X92.994 Y65.515 E0.00208

G1 X92.885 Y65.654 E0.00458

G1 X92.701 Y65.723 E0.00514

G1 X81.769 Y65.716 E0.28483

G1 X81.580 Y65.649 E0.00522

G1 X81.474 Y65.473 E0.00536

G1 X81.466 Y64.681 E0.02064

G1 X81.483 Y64.583 E0.00260

M204 S1250

G1 X81.734 Y64.544 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.682 Y64.383 E-0.15609

G1 X81.992 Y64.292 E-0.17954

G1 X83.032 Y64.292 E-0.57636

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.384 Y65.009

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X82.093 Y65.004 E0.11130

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.739 Y65.005 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X81.894 Y70.004

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y69.993 E0.27890

G1 X92.595 Y70.586 E0.01546

G1 X88.880 Y70.573 E0.09679

G1 X88.553 Y70.513 E0.00867

G1 X87.881 Y70.336 E0.01811

G1 X87.499 Y70.293 E0.01000

G1 X87.048 Y70.288 E0.01175

G1 X86.849 Y70.304 E0.00521

G1 X86.119 Y70.454 E0.01941

G1 X85.902 Y70.527 E0.00597

G1 X85.609 Y70.585 E0.00779

G1 X81.888 Y70.568 E0.09694

G1 X81.893 Y70.064 E0.01315

M204 S1250

G1 X81.508 Y69.728 F9000.000

M204 S800

G1 F1500.000

G1 X81.638 Y69.610 E0.00458

G1 X81.763 Y69.586 E0.00330

G1 X92.710 Y69.575 E0.28525

G1 X92.842 Y69.612 E0.00356

G1 X92.906 Y69.650 E0.00193

G1 X92.990 Y69.776 E0.00395

G1 X93.016 Y69.906 E0.00347

G1 X93.012 Y70.688 E0.02037

G1 X92.940 Y70.874 E0.00520

G1 X92.891 Y70.924 E0.00183

G1 X92.740 Y71.005 E0.00447

G1 X88.842 Y70.990 E0.10156

G1 X88.462 Y70.921 E0.01005

G1 X87.803 Y70.748 E0.01775

G1 X87.473 Y70.710 E0.00866

G1 X87.062 Y70.706 E0.01070

G1 X86.907 Y70.718 E0.00405

G1 X86.228 Y70.858 E0.01807

G1 X86.010 Y70.931 E0.00600

G1 X85.649 Y71.003 E0.00959

G1 X81.765 Y70.986 E0.10120

G1 X81.636 Y70.958 E0.00345

G1 X81.592 Y70.930 E0.00136

G1 X81.518 Y70.839 E0.00306

G1 X81.469 Y70.692 E0.00403

G1 X81.487 Y69.784 E0.02365

M204 S1250

G1 X81.684 Y69.733 F9000.000

G1 X82.100 Y70.287

G1 F2400.000

G1 X85.581 Y70.293 E0.01863

G1 X86.054 Y70.231 E0.00255

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.581 Y70.293 E-0.26433

G1 X84.412 Y70.291 E-0.64767

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X88.389 Y70.230

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X88.499 Y70.244 E0.00055

G1 X88.609 Y70.258 E0.00072

G1 X88.758 Y70.271 E0.00122

G1 X88.907 Y70.285 E0.00162

G1 X92.387 Y70.289 E0.03778

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y70.287 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.432 Y77.711

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y77.753 E0.00429

G1 X92.594 Y78.303 E0.01432

G1 X81.884 Y78.296 E0.27905

G1 X81.884 Y77.757 E0.01405

G1 X82.052 Y77.707 E0.00458

G1 X92.372 Y77.711 E0.26890

M204 S1250

G1 X92.931 Y77.488 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y77.639 E0.00444

G1 X93.012 Y78.435 E0.02075

G1 X92.994 Y78.513 E0.00208

G1 X92.885 Y78.652 E0.00458

G1 X92.701 Y78.721 E0.00514

G1 X81.769 Y78.714 E0.28483

G1 X81.580 Y78.647 E0.00522

G1 X81.474 Y78.471 E0.00536

G1 X81.466 Y78.397 E0.00193

G1 X81.466 Y77.678 E0.01874

G1 X81.508 Y77.526 E0.00411

G1 X81.682 Y77.381 E0.00589

G1 X81.992 Y77.290 E0.00844

G1 X92.482 Y77.293 E0.27330

G1 X92.769 Y77.362 E0.00771

G1 X92.883 Y77.451 E0.00377

M204 S1250

G1 X92.874 Y77.648 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y77.639 E-0.12534

G1 X93.012 Y78.435 E-0.44128

G1 X92.994 Y78.513 E-0.04430

G1 X92.885 Y78.652 E-0.09748

G1 X92.701 Y78.721 E-0.10926

G1 X92.530 Y78.720 E-0.09433

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X82.093 Y78.002

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X92.384 Y78.007 E0.11130

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y78.006 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.598 Y82.991

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y83.584 E0.01546

G1 X88.880 Y83.571 E0.09679

G1 X88.563 Y83.513 E0.00841

G1 X88.182 Y83.400 E0.01036

G1 X87.865 Y83.332 E0.00843

G1 X87.499 Y83.291 E0.00961

G1 X87.050 Y83.286 E0.01170

G1 X86.850 Y83.301 E0.00522

G1 X86.119 Y83.452 E0.01945

G1 X85.902 Y83.525 E0.00596

G1 X85.609 Y83.583 E0.00779

G1 X81.888 Y83.566 E0.09694

G1 X81.894 Y83.002 E0.01471

G1 X92.538 Y82.991 E0.27734

M204 S1250

G1 X92.906 Y82.648 F9000.000

M204 S800

G1 F1500.000

G1 X92.990 Y82.773 E0.00394

G1 X93.016 Y82.903 E0.00346

G1 X93.012 Y83.686 E0.02039

G1 X92.940 Y83.872 E0.00520

G1 X92.891 Y83.922 E0.00183

G1 X92.740 Y84.003 E0.00447

G1 X88.842 Y83.988 E0.10156

G1 X88.466 Y83.920 E0.00996

G1 X88.079 Y83.805 E0.01052

G1 X87.798 Y83.745 E0.00748

G1 X87.473 Y83.708 E0.00852

G1 X87.063 Y83.704 E0.01068

G1 X86.908 Y83.716 E0.00405

G1 X86.228 Y83.856 E0.01808

G1 X86.010 Y83.929 E0.00600

G1 X85.649 Y84.001 E0.00959

G1 X81.765 Y83.984 E0.10120

G1 X81.636 Y83.956 E0.00345

G1 X81.591 Y83.928 E0.00137

G1 X81.518 Y83.837 E0.00306

G1 X81.469 Y83.690 E0.00402

G1 X81.478 Y82.808 E0.02299

G1 X81.508 Y82.725 E0.00229

G1 X81.638 Y82.608 E0.00455

G1 X81.763 Y82.584 E0.00331

G1 X92.710 Y82.573 E0.28525

G1 X92.854 Y82.617 E0.00392

M204 S1250

G1 X92.886 Y82.798 F9000.000

G1 X92.387 Y83.287

G1 F2400.000

G1 X88.765 Y83.270 E0.03931

G1 X88.624 Y83.257 E0.00117

G1 X88.520 Y83.242 E0.00070

G1 X88.416 Y83.227 E0.00053

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.520 Y83.242 E-0.05826

G1 E-0.90174 F4200.00000

G1 Z9.100 F9000.000

G1 X86.054 Y83.229

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X85.581 Y83.291 E0.00255

G1 X82.100 Y83.285 E0.01863

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.746 Y83.287 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X82.053 Y90.705

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.432 Y90.709 E0.27045

G1 X92.592 Y90.751 E0.00429

G1 X92.594 Y91.301 E0.01432

G1 X81.884 Y91.294 E0.27905

G1 X81.884 Y90.755 E0.01405

G1 X81.995 Y90.722 E0.00302

M204 S1250

G1 X81.508 Y90.523 F9000.000

M204 S800

G1 F1500.000

G1 X81.681 Y90.379 E0.00587

G1 X81.993 Y90.287 E0.00845

G1 X92.482 Y90.291 E0.27330

G1 X92.769 Y90.360 E0.00771

G1 X92.931 Y90.486 E0.00533

G1 X93.009 Y90.637 E0.00444

G1 X93.012 Y91.433 E0.02075

G1 X92.994 Y91.511 E0.00208

G1 X92.885 Y91.650 E0.00459

G1 X92.701 Y91.719 E0.00514

G1 X81.769 Y91.712 E0.28483

G1 X81.580 Y91.645 E0.00522

G1 X81.474 Y91.469 E0.00536

G1 X81.466 Y90.676 E0.02067

G1 X81.483 Y90.578 E0.00260

M204 S1250

G1 X81.733 Y90.540 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.681 Y90.379 E-0.15560

G1 X81.993 Y90.287 E-0.17976

G1 X83.033 Y90.288 E-0.57665

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.384 Y91.005

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X82.093 Y91.000 E0.11132

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.739 Y91.001 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X81.894 Y96.000

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y95.989 E0.27890

G1 X92.595 Y96.582 E0.01545

G1 X88.880 Y96.568 E0.09681

G1 X88.562 Y96.511 E0.00840

G1 X88.182 Y96.398 E0.01034

G1 X87.865 Y96.330 E0.00843

G1 X87.499 Y96.289 E0.00961

G1 X87.050 Y96.284 E0.01170

G1 X86.850 Y96.299 E0.00522

G1 X86.119 Y96.450 E0.01945

G1 X85.902 Y96.523 E0.00596

G1 X85.609 Y96.581 E0.00778

G1 X81.888 Y96.564 E0.09694

G1 X81.893 Y96.060 E0.01312

M204 S1250

G1 X81.508 Y95.723 F9000.000

M204 S800

G1 F1500.000

G1 X81.638 Y95.606 E0.00456

G1 X81.763 Y95.582 E0.00331

G1 X92.710 Y95.571 E0.28525

G1 X92.842 Y95.608 E0.00356

G1 X92.906 Y95.646 E0.00194

G1 X92.990 Y95.771 E0.00394

G1 X93.016 Y95.901 E0.00346

G1 X93.012 Y96.684 E0.02039

G1 X92.940 Y96.870 E0.00520

G1 X92.891 Y96.920 E0.00183

G1 X92.740 Y97.000 E0.00447

G1 X88.842 Y96.985 E0.10156

G1 X88.465 Y96.918 E0.00996

G1 X88.079 Y96.803 E0.01052

G1 X87.798 Y96.743 E0.00748

G1 X87.473 Y96.706 E0.00852

G1 X87.063 Y96.702 E0.01068

G1 X86.908 Y96.714 E0.00405

G1 X86.228 Y96.854 E0.01808

G1 X86.010 Y96.927 E0.00600

G1 X85.649 Y96.999 E0.00959

G1 X81.765 Y96.981 E0.10121

G1 X81.636 Y96.954 E0.00344

G1 X81.591 Y96.926 E0.00136

G1 X81.518 Y96.835 E0.00306

G1 X81.469 Y96.688 E0.00402

G1 X81.487 Y95.780 E0.02367

M204 S1250

G1 X81.683 Y95.729 F9000.000

G1 X82.100 Y96.282

G1 F2400.000

G1 X85.581 Y96.289 E0.01863

G1 X86.054 Y96.227 E0.00255

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.581 Y96.289 E-0.26426

G1 X84.412 Y96.286 E-0.64774

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X88.416 Y96.225

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X88.519 Y96.240 E0.00052

G1 X88.623 Y96.255 E0.00070

G1 X88.764 Y96.268 E0.00117

G1 X92.387 Y96.285 E0.03924

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y96.277 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.432 Y103.706

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y103.749 E0.00431

G1 X92.594 Y104.299 E0.01432

G1 X81.884 Y104.291 E0.27905

G1 X81.884 Y103.752 E0.01405

G1 X82.053 Y103.702 E0.00458

G1 X92.372 Y103.706 E0.26887

M204 S1250

G1 X92.931 Y103.484 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y103.635 E0.00444

G1 X93.012 Y104.431 E0.02075

G1 X92.994 Y104.509 E0.00208

G1 X92.885 Y104.648 E0.00459

G1 X92.701 Y104.717 E0.00514

G1 X81.769 Y104.709 E0.28484

G1 X81.636 Y104.676 E0.00356

G1 X81.581 Y104.643 E0.00168

G1 X81.474 Y104.466 E0.00538

G1 X81.466 Y104.393 E0.00191

G1 X81.466 Y103.674 E0.01874

G1 X81.508 Y103.521 E0.00413

G1 X81.682 Y103.376 E0.00588

G1 X81.992 Y103.285 E0.00844

G1 X92.481 Y103.288 E0.27330

G1 X92.769 Y103.358 E0.00771

G1 X92.883 Y103.447 E0.00377

M204 S1250

G1 X92.874 Y103.644 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.009 Y103.635 E-0.12539

G1 X93.012 Y104.431 E-0.44129

G1 X92.994 Y104.509 E-0.04425

G1 X92.885 Y104.648 E-0.09755

G1 X92.701 Y104.717 E-0.10924

G1 X92.531 Y104.716 E-0.09429

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X82.093 Y103.997

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X92.384 Y104.002 E0.11192

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.738 Y104.002 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.598 Y108.987

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y109.580 E0.01545

G1 X88.879 Y109.566 E0.09681

G1 X88.562 Y109.509 E0.00840

G1 X88.182 Y109.396 E0.01034

G1 X87.866 Y109.329 E0.00841

G1 X87.499 Y109.286 E0.00963

G1 X87.049 Y109.282 E0.01173

G1 X86.850 Y109.297 E0.00518

G1 X86.119 Y109.447 E0.01945

G1 X85.902 Y109.520 E0.00598

G1 X85.609 Y109.578 E0.00779

G1 X81.888 Y109.562 E0.09693

G1 X81.894 Y108.998 E0.01469

G1 X92.538 Y108.987 E0.27734

M204 S1250

G1 X92.906 Y108.643 F9000.000

M204 S800

G1 F1500.000

G1 X92.990 Y108.769 E0.00394

G1 X93.016 Y108.899 E0.00346

G1 X93.012 Y109.682 E0.02039

G1 X92.940 Y109.868 E0.00520

G1 X92.891 Y109.918 E0.00182

G1 X92.740 Y109.998 E0.00447

G1 X88.842 Y109.983 E0.10157

M73 P79 R14

G1 X88.465 Y109.916 E0.00996

G1 X88.079 Y109.801 E0.01052

G1 X87.798 Y109.741 E0.00747

G1 X87.473 Y109.703 E0.00853

G1 X87.063 Y109.700 E0.01069

G1 X86.908 Y109.712 E0.00404

G1 X86.228 Y109.851 E0.01808

G1 X86.010 Y109.924 E0.00600

G1 X85.649 Y109.996 E0.00959

G1 X81.765 Y109.979 E0.10121

G1 X81.636 Y109.952 E0.00343

G1 X81.592 Y109.924 E0.00137

G1 X81.518 Y109.832 E0.00306

G1 X81.469 Y109.686 E0.00402

G1 X81.478 Y108.803 E0.02300

G1 X81.508 Y108.721 E0.00228

G1 X81.638 Y108.604 E0.00455

G1 X81.763 Y108.580 E0.00331

G1 X92.710 Y108.569 E0.28524

G1 X92.854 Y108.613 E0.00392

M204 S1250

G1 X92.886 Y108.793 F9000.000

G1 X92.387 Y109.283

G1 F2400.000

G1 X88.764 Y109.266 E0.03928

G1 X88.623 Y109.253 E0.00117

G1 X88.519 Y109.238 E0.00070

G1 X88.415 Y109.223 E0.00053

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.519 Y109.238 E-0.05807

G1 E-0.90193 F4200.00000

G1 Z9.100 F9000.000

G1 X86.051 Y109.225

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X85.580 Y109.286 E0.00253

G1 X82.100 Y109.280 E0.01853

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.746 Y109.283 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X82.052 Y116.700

G1 Z8.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.432 Y116.704 E0.27044

G1 X92.592 Y116.747 E0.00431

G1 X92.594 Y117.297 E0.01432

G1 X81.884 Y117.289 E0.27905

G1 X81.884 Y116.750 E0.01405

G1 X81.995 Y116.717 E0.00301

M204 S1250

G1 X81.508 Y116.519 F9000.000

M204 S800

G1 F1500.000

G1 X81.682 Y116.374 E0.00590

G1 X81.992 Y116.283 E0.00844

G1 X92.481 Y116.286 E0.27330

G1 X92.769 Y116.356 E0.00771

G1 X92.931 Y116.482 E0.00534

G1 X93.009 Y116.632 E0.00442

G1 X93.012 Y117.428 E0.02074

G1 X92.994 Y117.506 E0.00209

G1 X92.885 Y117.646 E0.00460

G1 X92.701 Y117.715 E0.00513

G1 X81.769 Y117.707 E0.28483

G1 X81.637 Y117.674 E0.00356

G1 X81.580 Y117.640 E0.00170

G1 X81.474 Y117.464 E0.00536

G1 X81.466 Y116.672 E0.02064

G1 X81.483 Y116.574 E0.00260

M204 S1250

G1 X81.734 Y116.535 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.682 Y116.374 E-0.15614

G1 X81.992 Y116.283 E-0.17953

G1 X83.032 Y116.283 E-0.57633

G1 E-0.04800 F4200.00000

G1 Z9.100 F9000.000

G1 X92.384 Y117.000

G1 Z8.900

G1 E3.20000 F2400.00000

G1 X82.093 Y116.995 E0.11192

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;9.05

G1 Z9.050 F9000.000

;AFTER\_LAYER\_CHANGE

;9.05

G1 E-3.20000 F4200.00000

G1 Z9.250 F9000.000

G1 X81.888 Y44.655

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.892 Y44.050 E0.01576

G1 X92.598 Y44.047 E0.27894

G1 X92.595 Y44.659 E0.01593

G1 X89.098 Y44.657 E0.09112

G1 X88.752 Y44.594 E0.00918

G1 X88.379 Y44.461 E0.01032

G1 X87.849 Y44.337 E0.01417

G1 X87.485 Y44.296 E0.00953

G1 X87.003 Y44.293 E0.01258

G1 X86.181 Y44.442 E0.02177

G1 X85.747 Y44.589 E0.01193

G1 X85.429 Y44.671 E0.00854

G1 X81.948 Y44.655 E0.09071

M204 S1250

G1 X81.519 Y44.919 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y44.758 E0.00440

G1 X81.476 Y43.875 E0.02300

G1 X81.509 Y43.784 E0.00253

G1 X81.643 Y43.659 E0.00477

G1 X81.766 Y43.632 E0.00327

G1 X92.714 Y43.629 E0.28528

G1 X92.837 Y43.659 E0.00329

G1 X92.899 Y43.702 E0.00196

G1 X93.002 Y43.863 E0.00498

G1 X93.016 Y43.950 E0.00229

G1 X93.013 Y44.744 E0.02070

G1 X92.953 Y44.928 E0.00506

G1 X92.876 Y45.011 E0.00295

G1 X92.719 Y45.076 E0.00443

G1 X89.061 Y45.075 E0.09531

G1 X88.643 Y44.999 E0.01105

G1 X88.260 Y44.863 E0.01060

G1 X87.777 Y44.749 E0.01292

G1 X87.461 Y44.713 E0.00830

G1 X87.039 Y44.711 E0.01098

G1 X86.285 Y44.848 E0.01997

G1 X85.848 Y44.995 E0.01203

G1 X85.445 Y45.089 E0.01078

G1 X81.765 Y45.072 E0.09587

G1 X81.643 Y45.046 E0.00326

G1 X81.556 Y44.966 E0.00307

M204 S1250

G1 X81.601 Y44.772 F9000.000

G1 X82.099 Y44.353

G1 F2400.000

G1 X85.385 Y44.360 E0.03659

G1 X85.537 Y44.335 E0.00171

G1 X85.936 Y44.280 E0.00230

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.537 Y44.335 E-0.22332

G1 E-0.73668 F4200.00000

G1 Z9.250 F9000.000

G1 X88.557 Y44.279

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X88.690 Y44.302 E0.00080

G1 X88.824 Y44.326 E0.00115

G1 X88.975 Y44.339 E0.00155

G1 X89.126 Y44.353 E0.00183

G1 X92.388 Y44.353 E0.03935

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y44.353 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.475 Y51.672

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y51.743 E0.00353

G1 X92.593 Y52.255 E0.01334

G1 X81.891 Y52.251 E0.27885

G1 X81.885 Y51.756 E0.01290

G1 X81.945 Y51.705 E0.00204

G1 X82.185 Y51.635 E0.00651

G1 X92.415 Y51.661 E0.26656

M204 S1250

G1 X92.934 Y51.490 F9000.000

M204 S800

G1 F1500.000

G1 X93.007 Y51.635 E0.00422

G1 X93.012 Y52.385 E0.01954

G1 X92.979 Y52.497 E0.00306

G1 X92.893 Y52.608 E0.00364

G1 X92.707 Y52.673 E0.00512

G1 X81.768 Y52.669 E0.28503

G1 X81.637 Y52.637 E0.00351

G1 X81.582 Y52.603 E0.00168

G1 X81.476 Y52.423 E0.00544

G1 X81.466 Y51.682 E0.01932

G1 X81.481 Y51.592 E0.00238

G1 X81.519 Y51.518 E0.00217

G1 X81.762 Y51.324 E0.00812

G1 X82.126 Y51.217 E0.00986

G1 X92.390 Y51.232 E0.26745

G1 X92.600 Y51.271 E0.00556

G1 X92.728 Y51.328 E0.00364

G1 X92.893 Y51.446 E0.00530

M204 S1250

G1 X92.870 Y51.639 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.007 Y51.635 E-0.12212

G1 X93.012 Y52.385 E-0.41553

G1 X92.979 Y52.497 E-0.06516

G1 X92.893 Y52.608 E-0.07739

G1 X92.707 Y52.673 E-0.10894

G1 X92.486 Y52.673 E-0.12286

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X82.097 Y51.962

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X82.229 Y51.943 E0.00165

G1 X92.383 Y51.952 E0.12492

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y51.951 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.598 Y57.045

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y57.656 E0.01591

G1 X89.098 Y57.655 E0.09112

G1 X88.752 Y57.593 E0.00916

G1 X88.379 Y57.458 E0.01034

G1 X87.848 Y57.335 E0.01418

G1 X87.485 Y57.294 E0.00952

G1 X87.003 Y57.291 E0.01258

G1 X86.181 Y57.440 E0.02177

G1 X85.747 Y57.587 E0.01193

G1 X85.429 Y57.669 E0.00854

G1 X81.888 Y57.653 E0.09227

G1 X81.892 Y57.048 E0.01576

G1 X92.538 Y57.045 E0.27738

M204 S1250

G1 X92.837 Y56.657 F9000.000

M204 S800

G1 F1500.000

G1 X92.899 Y56.700 E0.00195

G1 X93.002 Y56.860 E0.00498

G1 X93.016 Y56.948 E0.00230

G1 X93.013 Y57.742 E0.02070

G1 X92.953 Y57.926 E0.00506

G1 X92.876 Y58.009 E0.00294

G1 X92.719 Y58.074 E0.00442

G1 X89.061 Y58.073 E0.09532

G1 X88.644 Y57.997 E0.01104

G1 X88.260 Y57.860 E0.01061

G1 X87.777 Y57.747 E0.01292

G1 X87.461 Y57.711 E0.00830

G1 X87.039 Y57.709 E0.01098

G1 X86.285 Y57.846 E0.01997

G1 X85.848 Y57.993 E0.01203

G1 X85.445 Y58.087 E0.01078

G1 X81.766 Y58.070 E0.09586

G1 X81.643 Y58.043 E0.00327

G1 X81.586 Y58.003 E0.00182

G1 X81.519 Y57.917 E0.00284

G1 X81.469 Y57.755 E0.00439

G1 X81.476 Y56.873 E0.02300

G1 X81.509 Y56.782 E0.00253

G1 X81.643 Y56.657 E0.00477

G1 X81.765 Y56.630 E0.00326

G1 X92.714 Y56.627 E0.28529

G1 X92.779 Y56.643 E0.00173

M204 S1250

G1 X92.846 Y56.731 F9000.000

G1 X92.388 Y57.350

G1 F2400.000

G1 X89.126 Y57.351 E0.03920

G1 X88.975 Y57.337 E0.00182

G1 X88.824 Y57.324 E0.00155

G1 X88.692 Y57.301 E0.00115

G1 X88.559 Y57.277 E0.00080

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.692 Y57.301 E-0.07459

G1 E-0.88541 F4200.00000

G1 Z9.250 F9000.000

G1 X85.936 Y57.278

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X85.537 Y57.333 E0.00230

G1 X85.385 Y57.358 E0.00171

G1 X82.099 Y57.351 E0.03659

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.745 Y57.354 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X81.945 Y64.704

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.185 Y64.633 E0.00652

G1 X92.352 Y64.648 E0.26490

G1 X92.475 Y64.670 E0.00326

G1 X92.590 Y64.741 E0.00351

G1 X92.593 Y65.253 E0.01336

G1 X81.891 Y65.249 E0.27885

G1 X81.885 Y64.754 E0.01290

G1 X81.899 Y64.742 E0.00047

M204 S1250

G1 X81.519 Y64.515 F9000.000

M204 S800

G1 F1500.000

G1 X81.762 Y64.322 E0.00811

G1 X82.126 Y64.215 E0.00986

G1 X92.390 Y64.230 E0.26745

G1 X92.600 Y64.269 E0.00557

G1 X92.728 Y64.326 E0.00365

G1 X92.934 Y64.487 E0.00681

G1 X93.007 Y64.633 E0.00424

G1 X93.012 Y65.383 E0.01954

G1 X92.979 Y65.495 E0.00306

G1 X92.893 Y65.605 E0.00362

G1 X92.707 Y65.671 E0.00515

G1 X81.768 Y65.667 E0.28501

G1 X81.637 Y65.634 E0.00352

G1 X81.582 Y65.601 E0.00168

G1 X81.476 Y65.422 E0.00542

G1 X81.466 Y64.680 E0.01933

G1 X81.492 Y64.569 E0.00297

M204 S1250

G1 X81.829 Y64.544 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.762 Y64.322 E-0.20323

G1 X82.126 Y64.215 E-0.20967

G1 X83.026 Y64.217 E-0.49910

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.383 Y64.950

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X82.229 Y64.941 E0.12492

G1 X82.097 Y64.960 E0.00165

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.229 Y64.941 E-0.07420

G1 X83.741 Y64.943 E-0.83780

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X81.892 Y70.046

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y70.043 E0.27894

G1 X92.595 Y70.654 E0.01592

G1 X89.099 Y70.653 E0.09111

G1 X88.752 Y70.590 E0.00918

G1 X88.378 Y70.456 E0.01034

G1 X87.848 Y70.332 E0.01419

G1 X87.485 Y70.292 E0.00951

G1 X87.003 Y70.289 E0.01256

G1 X86.180 Y70.438 E0.02178

G1 X85.747 Y70.585 E0.01193

G1 X85.431 Y70.666 E0.00850

G1 X81.888 Y70.651 E0.09231

G1 X81.892 Y70.106 E0.01419

M204 S1250

G1 X81.509 Y69.780 F9000.000

M204 S800

G1 F1500.000

G1 X81.643 Y69.655 E0.00477

G1 X81.765 Y69.628 E0.00326

G1 X92.715 Y69.625 E0.28530

G1 X92.837 Y69.654 E0.00327

G1 X92.899 Y69.697 E0.00196

G1 X93.002 Y69.858 E0.00499

G1 X93.016 Y69.946 E0.00230

G1 X93.013 Y70.740 E0.02070

G1 X92.953 Y70.924 E0.00506

G1 X92.876 Y71.007 E0.00294

G1 X92.719 Y71.072 E0.00442

G1 X89.061 Y71.071 E0.09532

G1 X88.644 Y70.995 E0.01105

G1 X88.260 Y70.858 E0.01061

G1 X87.777 Y70.745 E0.01293

G1 X87.461 Y70.709 E0.00830

G1 X87.039 Y70.707 E0.01098

G1 X86.285 Y70.844 E0.01997

G1 X85.848 Y70.991 E0.01203

G1 X85.445 Y71.084 E0.01076

G1 X81.766 Y71.068 E0.09588

G1 X81.643 Y71.041 E0.00327

G1 X81.586 Y71.001 E0.00182

G1 X81.519 Y70.915 E0.00284

G1 X81.469 Y70.753 E0.00439

G1 X81.488 Y69.836 E0.02391

M204 S1250

G1 X81.692 Y69.783 F9000.000

G1 X82.099 Y70.349

G1 F2400.000

G1 X85.386 Y70.355 E0.04170

G1 X85.537 Y70.331 E0.00193

G1 X85.936 Y70.276 E0.00230

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.537 Y70.331 E-0.22346

G1 E-0.73654 F4200.00000

G1 Z9.250 F9000.000

G1 X88.559 Y70.275

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X88.692 Y70.298 E0.00080

G1 X88.824 Y70.321 E0.00115

G1 X88.975 Y70.335 E0.00155

G1 X89.126 Y70.348 E0.00183

G1 X92.388 Y70.348 E0.03930

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y70.348 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.475 Y77.668

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y77.739 E0.00351

G1 X92.593 Y78.251 E0.01336

G1 X81.891 Y78.247 E0.27885

G1 X81.885 Y77.752 E0.01290

G1 X81.945 Y77.702 E0.00204

G1 X82.185 Y77.631 E0.00652

G1 X92.416 Y77.658 E0.26657

M204 S1250

G1 X92.934 Y77.486 F9000.000

M204 S800

G1 F1500.000

G1 X93.007 Y77.631 E0.00424

G1 X93.012 Y78.381 E0.01955

G1 X92.979 Y78.493 E0.00306

G1 X92.893 Y78.603 E0.00361

G1 X92.707 Y78.669 E0.00515

G1 X81.768 Y78.665 E0.28501

G1 X81.637 Y78.632 E0.00352

G1 X81.582 Y78.599 E0.00168

G1 X81.476 Y78.419 E0.00543

G1 X81.466 Y77.677 E0.01934

G1 X81.481 Y77.588 E0.00235

G1 X81.519 Y77.513 E0.00218

G1 X81.762 Y77.320 E0.00811

G1 X82.126 Y77.213 E0.00986

G1 X92.390 Y77.228 E0.26745

G1 X92.600 Y77.267 E0.00557

G1 X92.728 Y77.324 E0.00365

G1 X92.893 Y77.441 E0.00528

M204 S1250

G1 X92.870 Y77.635 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.007 Y77.631 E-0.12242

G1 X93.012 Y78.381 E-0.41569

G1 X92.979 Y78.493 E-0.06515

G1 X92.893 Y78.603 E-0.07688

G1 X92.707 Y78.669 E-0.10959

G1 X92.486 Y78.669 E-0.12227

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X82.097 Y77.958

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X82.229 Y77.939 E0.00165

G1 X92.383 Y77.948 E0.12492

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y77.947 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.598 Y83.041

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y83.652 E0.01592

G1 X89.099 Y83.651 E0.09111

G1 X88.752 Y83.588 E0.00918

G1 X88.379 Y83.454 E0.01034

G1 X87.848 Y83.330 E0.01420

G1 X87.485 Y83.290 E0.00952

G1 X87.003 Y83.287 E0.01255

G1 X86.180 Y83.436 E0.02178

G1 X85.747 Y83.583 E0.01193

G1 X85.431 Y83.664 E0.00850

G1 X81.888 Y83.649 E0.09231

G1 X81.892 Y83.044 E0.01576

G1 X92.538 Y83.041 E0.27738

M204 S1250

G1 X92.837 Y82.652 F9000.000

M204 S800

G1 F1500.000

G1 X92.899 Y82.695 E0.00197

G1 X93.002 Y82.856 E0.00498

G1 X93.016 Y82.943 E0.00229

G1 X93.013 Y83.738 E0.02072

G1 X92.953 Y83.922 E0.00506

G1 X92.876 Y84.005 E0.00294

G1 X92.719 Y84.070 E0.00442

G1 X89.061 Y84.069 E0.09531

G1 X88.644 Y83.992 E0.01105

G1 X88.260 Y83.856 E0.01061

G1 X87.777 Y83.742 E0.01293

G1 X87.460 Y83.707 E0.00830

G1 X87.039 Y83.705 E0.01097

G1 X86.285 Y83.842 E0.01997

G1 X85.848 Y83.989 E0.01203

G1 X85.445 Y84.082 E0.01076

G1 X81.766 Y84.066 E0.09587

G1 X81.643 Y84.039 E0.00327

G1 X81.586 Y83.998 E0.00184

G1 X81.519 Y83.912 E0.00283

G1 X81.469 Y83.751 E0.00439

G1 X81.476 Y82.869 E0.02300

G1 X81.509 Y82.777 E0.00254

G1 X81.643 Y82.653 E0.00476

G1 X81.765 Y82.626 E0.00326

G1 X92.715 Y82.623 E0.28530

G1 X92.779 Y82.638 E0.00171

M204 S1250

G1 X92.846 Y82.727 F9000.000

G1 X92.388 Y83.346

G1 F2400.000

G1 X89.127 Y83.346 E0.03929

G1 X88.976 Y83.333 E0.00183

G1 X88.824 Y83.319 E0.00155

G1 X88.692 Y83.296 E0.00115

G1 X88.559 Y83.273 E0.00080

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.88545 F4200.00000

G1 Z9.250 F9000.000

G1 X85.936 Y83.274

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X85.537 Y83.329 E0.00230

G1 X85.386 Y83.353 E0.00193

G1 X82.099 Y83.347 E0.04170

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.745 Y83.350 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X81.945 Y90.699

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.186 Y90.629 E0.00653

G1 X92.352 Y90.644 E0.26489

G1 X92.476 Y90.667 E0.00329

G1 X92.590 Y90.736 E0.00348

G1 X92.593 Y91.249 E0.01336

G1 X81.891 Y91.245 E0.27885

G1 X81.885 Y90.749 E0.01291

G1 X81.899 Y90.738 E0.00047

M204 S1250

G1 X81.519 Y90.511 F9000.000

M204 S800

G1 F1500.000

G1 X81.763 Y90.318 E0.00810

G1 X82.126 Y90.211 E0.00986

G1 X92.390 Y90.226 E0.26745

G1 X92.601 Y90.265 E0.00558

G1 X92.728 Y90.322 E0.00363

G1 X92.934 Y90.483 E0.00682

G1 X93.007 Y90.628 E0.00424

G1 X93.012 Y91.379 E0.01955

G1 X92.979 Y91.491 E0.00306

G1 X92.893 Y91.601 E0.00361

G1 X92.707 Y91.667 E0.00515

G1 X81.768 Y91.663 E0.28501

G1 X81.637 Y91.630 E0.00352

G1 X81.582 Y91.597 E0.00168

G1 X81.476 Y91.418 E0.00542

G1 X81.466 Y90.675 E0.01935

G1 X81.492 Y90.564 E0.00296

M204 S1250

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G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.763 Y90.318 E-0.20297

G1 X82.126 Y90.211 E-0.20979

G1 X83.027 Y90.212 E-0.49924

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.383 Y90.946

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X82.230 Y90.937 E0.12554

G1 X82.097 Y90.956 E0.00167

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.230 Y90.937 E-0.07465

G1 X83.741 Y90.938 E-0.83735

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X81.892 Y96.042

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y96.039 E0.27894

G1 X92.595 Y96.650 E0.01592

G1 X89.099 Y96.649 E0.09111

G1 X88.752 Y96.586 E0.00918

G1 X88.379 Y96.452 E0.01033

G1 X87.848 Y96.328 E0.01420

G1 X87.485 Y96.288 E0.00952

G1 X87.003 Y96.285 E0.01255

G1 X86.180 Y96.434 E0.02178

G1 X85.747 Y96.581 E0.01193

G1 X85.429 Y96.662 E0.00853

G1 X81.888 Y96.646 E0.09228

G1 X81.892 Y96.102 E0.01418

M204 S1250

G1 X81.509 Y95.775 F9000.000

M204 S800

G1 F1500.000

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G1 X81.765 Y95.624 E0.00326

G1 X92.715 Y95.621 E0.28530

G1 X92.837 Y95.650 E0.00327

G1 X92.899 Y95.693 E0.00197

G1 X93.002 Y95.854 E0.00498

G1 X93.016 Y95.941 E0.00229

G1 X93.013 Y96.736 E0.02072

G1 X92.953 Y96.920 E0.00504

G1 X92.876 Y97.003 E0.00294

G1 X92.719 Y97.067 E0.00443

G1 X89.061 Y97.067 E0.09531

G1 X88.643 Y96.990 E0.01105

G1 X88.260 Y96.854 E0.01060

G1 X87.777 Y96.740 E0.01293

G1 X87.460 Y96.705 E0.00830

G1 X87.039 Y96.703 E0.01097

G1 X86.285 Y96.840 E0.01997

G1 X85.848 Y96.987 E0.01203

G1 X85.445 Y97.080 E0.01077

G1 X81.766 Y97.063 E0.09587

G1 X81.643 Y97.037 E0.00327

G1 X81.586 Y96.996 E0.00183

G1 X81.519 Y96.910 E0.00283

G1 X81.469 Y96.749 E0.00439

G1 X81.488 Y95.831 E0.02392

M204 S1250

G1 X81.692 Y95.779 F9000.000

G1 X82.099 Y96.344

G1 F2400.000

G1 X85.386 Y96.351 E0.04169

G1 X85.538 Y96.326 E0.00195

G1 X85.936 Y96.272 E0.00230

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.538 Y96.326 E-0.22290

G1 E-0.73710 F4200.00000

G1 Z9.250 F9000.000

G1 X88.559 Y96.271

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X88.692 Y96.294 E0.00080

G1 X88.824 Y96.317 E0.00114

G1 X88.975 Y96.331 E0.00155

G1 X89.126 Y96.344 E0.00183

G1 X92.388 Y96.344 E0.03927

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y96.344 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.474 Y103.663

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y103.734 E0.00353

G1 X92.593 Y104.247 E0.01336

G1 X81.891 Y104.242 E0.27885

G1 X81.885 Y103.747 E0.01291

G1 X81.945 Y103.696 E0.00205

G1 X82.185 Y103.626 E0.00651

G1 X92.415 Y103.652 E0.26656

M204 S1250

G1 X92.934 Y103.481 F9000.000

M204 S800

G1 F1500.000

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G1 X93.012 Y104.377 E0.01955

G1 X92.979 Y104.489 E0.00306

G1 X92.893 Y104.599 E0.00361

G1 X92.707 Y104.665 E0.00515

G1 X81.768 Y104.660 E0.28502

G1 X81.637 Y104.628 E0.00351

G1 X81.582 Y104.595 E0.00168

G1 X81.476 Y104.414 E0.00545

G1 X81.466 Y103.673 E0.01932

G1 X81.481 Y103.584 E0.00236

G1 X81.519 Y103.508 E0.00220

G1 X81.762 Y103.315 E0.00811

G1 X82.126 Y103.208 E0.00986

G1 X92.390 Y103.223 E0.26745

G1 X92.600 Y103.262 E0.00556

G1 X92.728 Y103.319 E0.00364

G1 X92.893 Y103.437 E0.00530

M204 S1250

G1 X92.870 Y103.631 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.007 Y103.626 E-0.12244

G1 X93.012 Y104.377 E-0.41573

G1 X92.979 Y104.489 E-0.06515

G1 X92.893 Y104.599 E-0.07688

G1 X92.707 Y104.665 E-0.10959

G1 X92.486 Y104.665 E-0.12222

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X82.097 Y103.953

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X82.229 Y103.934 E0.00165

G1 X92.383 Y103.944 E0.12525

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.737 Y103.942 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.598 Y109.036

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X89.098 Y109.646 E0.09112

G1 X88.752 Y109.583 E0.00918

G1 X88.379 Y109.450 E0.01032

G1 X87.849 Y109.326 E0.01417

G1 X87.485 Y109.285 E0.00954

G1 X87.003 Y109.283 E0.01257

G1 X86.181 Y109.431 E0.02176

G1 X85.747 Y109.578 E0.01194

G1 X85.429 Y109.660 E0.00855

G1 X81.888 Y109.644 E0.09227

G1 X81.892 Y109.040 E0.01574

G1 X92.538 Y109.036 E0.27738

M204 S1250

G1 X92.837 Y108.648 F9000.000

M204 S800

G1 F1500.000

G1 X92.899 Y108.691 E0.00196

G1 X93.002 Y108.852 E0.00498

G1 X93.016 Y108.939 E0.00230

G1 X93.013 Y109.734 E0.02072

G1 X92.953 Y109.918 E0.00504

G1 X92.876 Y110.001 E0.00294

G1 X92.719 Y110.065 E0.00443

G1 X89.061 Y110.064 E0.09531

G1 X88.643 Y109.988 E0.01105

G1 X88.260 Y109.852 E0.01060

G1 X87.777 Y109.738 E0.01292

G1 X87.461 Y109.702 E0.00831

G1 X87.039 Y109.701 E0.01098

G1 X86.285 Y109.837 E0.01996

G1 X85.848 Y109.984 E0.01203

G1 X85.445 Y110.078 E0.01078

G1 X81.766 Y110.061 E0.09587

G1 X81.643 Y110.035 E0.00326

G1 X81.586 Y109.994 E0.00184

G1 X81.519 Y109.908 E0.00284

G1 X81.469 Y109.747 E0.00438

G1 X81.476 Y108.864 E0.02301

G1 X81.509 Y108.773 E0.00254

G1 X81.643 Y108.649 E0.00475

G1 X81.765 Y108.622 E0.00327

G1 X92.714 Y108.618 E0.28529

G1 X92.779 Y108.634 E0.00172

M204 S1250

G1 X92.846 Y108.722 F9000.000

G1 X92.388 Y109.342

G1 F2400.000

G1 X89.126 Y109.342 E0.03934

G1 X88.975 Y109.328 E0.00183

G1 X88.823 Y109.315 E0.00155

G1 X88.691 Y109.292 E0.00115

G1 X88.559 Y109.269 E0.00080

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.691 Y109.292 E-0.07450

G1 E-0.88550 F4200.00000

G1 Z9.250 F9000.000

G1 X85.934 Y109.270

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X85.537 Y109.324 E0.00228

G1 X85.385 Y109.349 E0.00171

G1 X82.099 Y109.342 E0.03646

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.745 Y109.346 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X81.945 Y116.694

G1 Z9.050

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.185 Y116.624 E0.00651

G1 X92.352 Y116.639 E0.26490

G1 X92.474 Y116.661 E0.00325

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G1 X92.593 Y117.245 E0.01336

G1 X81.891 Y117.240 E0.27885

G1 X81.885 Y116.745 E0.01291

G1 X81.899 Y116.733 E0.00048

M204 S1250

G1 X81.519 Y116.507 F9000.000

M204 S800

G1 F1500.000

G1 X81.762 Y116.313 E0.00812

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G1 X92.390 Y116.221 E0.26745

G1 X92.600 Y116.260 E0.00556

G1 X92.728 Y116.317 E0.00364

G1 X92.934 Y116.479 E0.00684

G1 X93.007 Y116.624 E0.00422

G1 X93.012 Y117.374 E0.01954

G1 X92.979 Y117.486 E0.00306

G1 X92.893 Y117.597 E0.00364

G1 X92.707 Y117.663 E0.00514

G1 X81.768 Y117.658 E0.28501

G1 X81.637 Y117.626 E0.00351

G1 X81.582 Y117.592 E0.00169

G1 X81.476 Y117.413 E0.00543

G1 X81.466 Y116.671 E0.01933

G1 X81.491 Y116.560 E0.00296

M204 S1250

G1 X81.829 Y116.535 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.762 Y116.313 E-0.20337

G1 X82.126 Y116.206 E-0.20963

G1 X83.026 Y116.208 E-0.49900

G1 E-0.04800 F4200.00000

G1 Z9.250 F9000.000

G1 X92.383 Y116.942

G1 Z9.050

G1 E3.20000 F2400.00000

G1 X82.229 Y116.932 E0.12525

G1 X82.097 Y116.951 E0.00165

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;9.2

G1 Z9.200 F9000.000

;AFTER\_LAYER\_CHANGE

;9.2

G1 E-3.20000 F4200.00000

G1 Z9.400 F9000.000

G1 X81.887 Y44.737

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.891 Y44.092 E0.01681

G1 X92.598 Y44.096 E0.27898

G1 X92.595 Y44.736 E0.01666

G1 X89.318 Y44.738 E0.08541

G1 X88.938 Y44.668 E0.01006

G1 X88.588 Y44.526 E0.00984

G1 X88.172 Y44.405 E0.01129

G1 X87.815 Y44.332 E0.00950

G1 X87.471 Y44.295 E0.00901

G1 X86.987 Y44.294 E0.01261

G1 X86.065 Y44.470 E0.02445

G1 X85.289 Y44.740 E0.02142

G1 X84.239 Y44.756 E0.02737

G1 X81.947 Y44.738 E0.05971

M204 S1250

G1 X81.521 Y44.998 F9000.000

M204 S800

G1 F1500.000

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G1 X81.474 Y43.936 E0.02301

G1 X81.509 Y43.837 E0.00274

G1 X81.658 Y43.697 E0.00532

G1 X81.765 Y43.674 E0.00285

G1 X92.719 Y43.679 E0.28541

G1 X92.833 Y43.701 E0.00302

G1 X92.895 Y43.751 E0.00207

G1 X93.002 Y43.918 E0.00516

G1 X93.016 Y44.002 E0.00221

G1 X93.013 Y44.830 E0.02158

G1 X92.969 Y44.976 E0.00399

G1 X92.855 Y45.110 E0.00456

G1 X92.708 Y45.154 E0.00399

G1 X89.280 Y45.156 E0.08933

G1 X88.820 Y45.072 E0.01218

G1 X88.451 Y44.921 E0.01040

G1 X88.072 Y44.811 E0.01026

G1 X87.751 Y44.746 E0.00855

G1 X87.448 Y44.713 E0.00793

G1 X87.027 Y44.712 E0.01099

G1 X86.174 Y44.875 E0.02262

G1 X85.363 Y45.157 E0.02238

G1 X84.240 Y45.174 E0.02925

G1 X81.766 Y45.154 E0.06447

G1 X81.648 Y45.128 E0.00315

G1 X81.557 Y45.046 E0.00320

M204 S1250

G1 X81.614 Y44.837 F9000.000

G1 X82.098 Y44.416

G1 F2400.000

G1 X85.232 Y44.417 E0.03636

G1 X85.505 Y44.371 E0.00321

G1 X85.778 Y44.325 E0.00169

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.505 Y44.371 E-0.15349

G1 E-0.80651 F4200.00000

G1 Z9.400 F9000.000

G1 X88.708 Y44.326

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X88.812 Y44.346 E0.00060

G1 X88.916 Y44.366 E0.00085

G1 X89.020 Y44.387 E0.00110

G1 X89.183 Y44.402 E0.00200

G1 X89.347 Y44.417 E0.00230

G1 X92.388 Y44.416 E0.04271

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y44.416 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.431 Y51.632

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.589 Y51.738 E0.00495

G1 X92.594 Y52.204 E0.01214

G1 X81.887 Y52.201 E0.27896

G1 X81.884 Y51.752 E0.01170

G1 X82.062 Y51.628 E0.00564

G1 X82.314 Y51.559 E0.00681

G1 X90.949 Y51.547 E0.22499

G1 X92.180 Y51.559 E0.03209

G1 X92.377 Y51.605 E0.00528

M204 S1250

G1 X92.945 Y51.505 F9000.000

M204 S800

G1 F1500.000

G1 X93.005 Y51.626 E0.00352

G1 X93.013 Y52.317 E0.01799

G1 X92.984 Y52.422 E0.00284

G1 X92.919 Y52.534 E0.00336

G1 X92.858 Y52.578 E0.00196

G1 X92.709 Y52.622 E0.00406

G1 X81.767 Y52.619 E0.28509

G1 X81.638 Y52.589 E0.00346

G1 X81.584 Y52.555 E0.00167

G1 X81.486 Y52.386 E0.00508

G1 X81.470 Y52.321 E0.00173

G1 X81.466 Y51.683 E0.01663

G1 X81.481 Y51.594 E0.00234

G1 X81.530 Y51.504 E0.00267

G1 X81.683 Y51.376 E0.00520

G1 X81.888 Y51.243 E0.00638

G1 X82.257 Y51.141 E0.00997

G1 X90.950 Y51.129 E0.22651

G1 X92.229 Y51.142 E0.03331

G1 X92.515 Y51.207 E0.00766

G1 X92.642 Y51.270 E0.00368

G1 X92.905 Y51.461 E0.00847

M204 S1250

G1 X92.890 Y51.629 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.005 Y51.626 E-0.10720

G1 X93.013 Y52.317 E-0.38264

G1 X92.984 Y52.422 E-0.06040

G1 X92.919 Y52.534 E-0.07147

G1 X92.858 Y52.578 E-0.04166

G1 X92.709 Y52.622 E-0.08637

G1 X92.416 Y52.621 E-0.16227

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X82.095 Y51.930

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X82.357 Y51.880 E0.00326

G1 X90.947 Y51.875 E0.10468

G1 X92.142 Y51.881 E0.01457

G1 X92.382 Y51.929 E0.00298

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.142 Y51.881 E-0.13531

G1 X90.947 Y51.875 E-0.66237

G1 X90.741 Y51.875 E-0.11432

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.598 Y57.094

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y57.733 E0.01664

G1 X89.318 Y57.736 E0.08541

G1 X88.938 Y57.666 E0.01006

G1 X88.588 Y57.524 E0.00984

G1 X88.172 Y57.403 E0.01129

G1 X87.815 Y57.330 E0.00950

G1 X87.471 Y57.293 E0.00901

G1 X86.987 Y57.292 E0.01261

G1 X86.065 Y57.468 E0.02445

G1 X85.289 Y57.738 E0.02143

G1 X84.239 Y57.754 E0.02736

G1 X81.887 Y57.735 E0.06127

G1 X81.891 Y57.090 E0.01681

G1 X92.538 Y57.094 E0.27742

M204 S1250

G1 X92.895 Y56.749 F9000.000

M204 S800

G1 F1500.000

G1 X93.002 Y56.916 E0.00517

G1 X93.016 Y57.000 E0.00221

G1 X93.013 Y57.828 E0.02158

G1 X92.969 Y57.974 E0.00399

G1 X92.856 Y58.108 E0.00455

G1 X92.709 Y58.151 E0.00399

G1 X89.280 Y58.154 E0.08934

G1 X88.820 Y58.070 E0.01218

G1 X88.451 Y57.919 E0.01040

G1 X88.072 Y57.809 E0.01026

G1 X87.751 Y57.744 E0.00855

G1 X87.448 Y57.711 E0.00793

G1 X87.027 Y57.710 E0.01099

G1 X86.174 Y57.872 E0.02262

G1 X85.363 Y58.155 E0.02238

G1 X84.240 Y58.172 E0.02925

G1 X81.766 Y58.152 E0.06447

G1 X81.648 Y58.126 E0.00315

G1 X81.578 Y58.072 E0.00230

G1 X81.521 Y57.996 E0.00248

G1 X81.469 Y57.817 E0.00486

G1 X81.474 Y56.934 E0.02301

G1 X81.509 Y56.835 E0.00275

G1 X81.658 Y56.695 E0.00532

G1 X81.765 Y56.672 E0.00283

G1 X92.719 Y56.677 E0.28542

G1 X92.848 Y56.711 E0.00348

M204 S1250

G1 X92.866 Y56.945 F9000.000

G1 X92.388 Y57.414

G1 F2400.000

G1 X89.347 Y57.415 E0.04271

G1 X89.183 Y57.400 E0.00230

G1 X89.020 Y57.385 E0.00200

G1 X88.916 Y57.364 E0.00110

G1 X88.812 Y57.344 E0.00085

G1 X88.708 Y57.324 E0.00060

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.812 Y57.344 E-0.05882

G1 E-0.90118 F4200.00000

G1 Z9.400 F9000.000

G1 X85.778 Y57.323

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X85.505 Y57.369 E0.00169

G1 X85.232 Y57.415 E0.00321

G1 X82.098 Y57.414 E0.03636

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.744 Y57.414 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X81.931 Y64.711

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.061 Y64.626 E0.00404

G1 X82.314 Y64.557 E0.00682

G1 X92.180 Y64.557 E0.25707

G1 X92.375 Y64.601 E0.00522

G1 X92.589 Y64.735 E0.00656

G1 X92.594 Y65.202 E0.01216

G1 X81.887 Y65.199 E0.27896

G1 X81.885 Y64.749 E0.01173

M204 S1250

G1 X81.530 Y64.502 F9000.000

M204 S800

G1 F1500.000

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G1 X81.888 Y64.241 E0.00638

G1 X82.257 Y64.139 E0.00997

G1 X92.229 Y64.139 E0.25982

G1 X92.516 Y64.205 E0.00767

G1 X92.642 Y64.267 E0.00368

G1 X92.870 Y64.421 E0.00716

G1 X92.945 Y64.503 E0.00289

G1 X93.005 Y64.624 E0.00354

G1 X93.013 Y65.315 E0.01799

G1 X92.984 Y65.420 E0.00284

G1 X92.920 Y65.531 E0.00334

G1 X92.858 Y65.575 E0.00196

G1 X92.708 Y65.620 E0.00408

G1 X81.768 Y65.617 E0.28506

G1 X81.638 Y65.586 E0.00348

G1 X81.584 Y65.552 E0.00167

G1 X81.486 Y65.384 E0.00507

G1 X81.470 Y65.319 E0.00173

G1 X81.466 Y64.681 E0.01663

G1 X81.501 Y64.555 E0.00342

M204 S1250

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G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X81.888 Y64.241 E-0.13574

G1 X82.257 Y64.139 E-0.21206

G1 X83.019 Y64.139 E-0.42232

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.382 Y64.927

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X92.142 Y64.879 E0.00298

G1 X90.947 Y64.873 E0.01454

G1 X82.357 Y64.878 E0.10452

G1 X82.095 Y64.928 E0.00326

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.357 Y64.878 E-0.14827

G1 X83.736 Y64.877 E-0.76373

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X81.891 Y70.088

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X92.595 Y70.731 E0.01665

G1 X89.318 Y70.734 E0.08540

G1 X88.938 Y70.664 E0.01005

G1 X88.588 Y70.521 E0.00986

G1 X88.172 Y70.400 E0.01129

G1 X87.815 Y70.328 E0.00951

G1 X87.471 Y70.291 E0.00900

G1 X86.988 Y70.290 E0.01260

G1 X86.065 Y70.466 E0.02447

G1 X85.289 Y70.736 E0.02142

G1 X84.239 Y70.751 E0.02737

G1 X81.887 Y70.733 E0.06127

G1 X81.890 Y70.148 E0.01525

M204 S1250

G1 X81.658 Y69.693 F9000.000

M204 S800

G1 F1500.000

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G1 X92.719 Y69.674 E0.28543

G1 X92.833 Y69.696 E0.00301

G1 X92.894 Y69.747 E0.00207

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G1 X92.709 Y71.149 E0.00399

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G1 X88.820 Y71.067 E0.01218

G1 X88.451 Y70.916 E0.01041

G1 X88.072 Y70.806 E0.01026

G1 X87.751 Y70.741 E0.00855

G1 X87.448 Y70.709 E0.00793

G1 X87.027 Y70.708 E0.01098

G1 X86.174 Y70.870 E0.02262

G1 X85.363 Y71.153 E0.02238

G1 X84.240 Y71.169 E0.02925

G1 X81.766 Y71.150 E0.06447

G1 X81.648 Y71.124 E0.00315

G1 X81.578 Y71.070 E0.00230

G1 X81.521 Y70.994 E0.00248

G1 X81.469 Y70.815 E0.00486

G1 X81.474 Y69.932 E0.02301

G1 X81.509 Y69.833 E0.00275

G1 X81.615 Y69.734 E0.00376

M204 S1250

G1 X81.748 Y69.754 F9000.000

G1 X82.098 Y70.411

G1 F2400.000

G1 X85.232 Y70.413 E0.03636

G1 X85.505 Y70.367 E0.00321

G1 X85.778 Y70.321 E0.00169

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.505 Y70.367 E-0.15337

G1 E-0.80663 F4200.00000

G1 Z9.400 F9000.000

G1 X88.709 Y70.321

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X88.813 Y70.342 E0.00060

G1 X88.917 Y70.362 E0.00085

G1 X89.021 Y70.383 E0.00110

G1 X89.184 Y70.398 E0.00200

G1 X89.347 Y70.412 E0.00230

G1 X92.388 Y70.412 E0.04274

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y70.412 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.432 Y77.627

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.589 Y77.733 E0.00493

G1 X92.594 Y78.200 E0.01216

G1 X81.887 Y78.197 E0.27896

M73 P81 R13

G1 X81.884 Y77.748 E0.01171

G1 X82.061 Y77.624 E0.00563

G1 X82.314 Y77.555 E0.00682

G1 X90.949 Y77.543 E0.22499

G1 X92.180 Y77.555 E0.03209

G1 X92.378 Y77.601 E0.00529

M204 S1250

G1 X92.945 Y77.501 F9000.000

M204 S800

G1 F1500.000

G1 X93.005 Y77.622 E0.00353

G1 X93.013 Y78.313 E0.01800

G1 X92.984 Y78.418 E0.00285

G1 X92.920 Y78.529 E0.00334

G1 X92.858 Y78.573 E0.00196

G1 X92.708 Y78.618 E0.00408

G1 X81.768 Y78.615 E0.28506

G1 X81.638 Y78.584 E0.00348

G1 X81.584 Y78.550 E0.00167

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G1 X81.481 Y77.590 E0.00232

G1 X81.530 Y77.500 E0.00268

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G1 X81.888 Y77.239 E0.00638

G1 X82.257 Y77.137 E0.00997

G1 X92.229 Y77.137 E0.25982

G1 X92.516 Y77.202 E0.00766

G1 X92.642 Y77.265 E0.00368

G1 X92.905 Y77.456 E0.00846

M204 S1250

G1 X92.890 Y77.624 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.005 Y77.622 E-0.10735

G1 X93.013 Y78.313 E-0.38274

G1 X92.984 Y78.418 E-0.06064

G1 X92.920 Y78.529 E-0.07096

G1 X92.858 Y78.573 E-0.04177

G1 X92.708 Y78.618 E-0.08681

G1 X92.416 Y78.617 E-0.16173

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X82.095 Y77.926

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X82.357 Y77.876 E0.00326

G1 X90.947 Y77.871 E0.10479

G1 X92.142 Y77.877 E0.01458

G1 X92.382 Y77.925 E0.00298

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.142 Y77.877 E-0.13527

G1 X90.947 Y77.871 E-0.66231

G1 X90.741 Y77.871 E-0.11443

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

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G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X88.938 Y83.662 E0.01006

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G1 X88.172 Y83.398 E0.01129

G1 X87.814 Y83.325 E0.00953

G1 X87.471 Y83.289 E0.00900

G1 X86.988 Y83.288 E0.01258

G1 X86.065 Y83.464 E0.02447

G1 X85.289 Y83.734 E0.02142

G1 X84.239 Y83.749 E0.02737

G1 X81.887 Y83.731 E0.06127

G1 X81.891 Y83.086 E0.01681

G1 X92.538 Y83.090 E0.27742

M204 S1250

G1 X92.895 Y82.745 F9000.000

M204 S800

G1 F1500.000

G1 X93.002 Y82.911 E0.00516

G1 X93.016 Y82.995 E0.00221

G1 X93.013 Y83.824 E0.02160

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G1 X92.856 Y84.104 E0.00455

G1 X92.709 Y84.147 E0.00398

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G1 X88.451 Y83.914 E0.01040

G1 X88.072 Y83.804 E0.01026

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G1 X86.174 Y83.868 E0.02262

G1 X85.363 Y84.151 E0.02238

G1 X84.240 Y84.167 E0.02925

G1 X81.767 Y84.148 E0.06446

G1 X81.648 Y84.122 E0.00315

G1 X81.578 Y84.067 E0.00233

G1 X81.521 Y83.992 E0.00247

G1 X81.469 Y83.813 E0.00485

G1 X81.474 Y82.930 E0.02301

G1 X81.509 Y82.830 E0.00276

G1 X81.658 Y82.691 E0.00531

G1 X81.765 Y82.668 E0.00284

G1 X92.719 Y82.672 E0.28543

G1 X92.848 Y82.707 E0.00347

M204 S1250

G1 X92.866 Y82.941 F9000.000

G1 X92.388 Y83.410

G1 F2400.000

G1 X89.348 Y83.410 E0.04274

G1 X89.184 Y83.395 E0.00231

G1 X89.021 Y83.380 E0.00200

G1 X88.917 Y83.360 E0.00109

G1 X88.813 Y83.340 E0.00085

G1 X88.710 Y83.319 E0.00060

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.813 Y83.340 E-0.05859

G1 E-0.90141 F4200.00000

G1 Z9.400 F9000.000

G1 X85.778 Y83.319

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X85.505 Y83.365 E0.00169

G1 X85.232 Y83.411 E0.00321

G1 X82.098 Y83.409 E0.03636

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.744 Y83.410 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X81.931 Y90.707

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.062 Y90.622 E0.00407

G1 X82.314 Y90.552 E0.00682

G1 X92.180 Y90.553 E0.25706

G1 X92.375 Y90.597 E0.00521

G1 X92.589 Y90.731 E0.00657

G1 X92.594 Y91.198 E0.01217

G1 X81.887 Y91.195 E0.27896

G1 X81.885 Y90.745 E0.01172

M204 S1250

G1 X81.530 Y90.497 F9000.000

M204 S800

G1 F1500.000

G1 X81.683 Y90.370 E0.00518

G1 X81.888 Y90.236 E0.00639

G1 X82.257 Y90.134 E0.00998

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G1 X92.516 Y90.200 E0.00767

G1 X92.642 Y90.263 E0.00368

G1 X92.870 Y90.417 E0.00716

G1 X92.945 Y90.498 E0.00289

G1 X93.005 Y90.620 E0.00353

G1 X93.013 Y91.311 E0.01800

G1 X92.984 Y91.416 E0.00285

G1 X92.920 Y91.527 E0.00334

G1 X92.858 Y91.571 E0.00196

G1 X92.708 Y91.616 E0.00408

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G1 X81.638 Y91.582 E0.00348

G1 X81.584 Y91.548 E0.00167

G1 X81.486 Y91.380 E0.00507

G1 X81.470 Y91.315 E0.00173

G1 X81.466 Y90.676 E0.01665

G1 X81.501 Y90.550 E0.00341

M204 S1250

G1 X81.728 Y90.514 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.683 Y90.370 E-0.14150

G1 X81.888 Y90.236 E-0.13599

G1 X82.257 Y90.134 E-0.21218

G1 X83.019 Y90.134 E-0.42233

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.382 Y90.923

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X92.142 Y90.875 E0.00298

G1 X90.947 Y90.869 E0.01458

G1 X82.358 Y90.874 E0.10476

G1 X82.095 Y90.924 E0.00328

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.358 Y90.874 E-0.14884

G1 X83.735 Y90.873 E-0.76316

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X81.891 Y96.084

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X92.595 Y96.727 E0.01664

G1 X89.318 Y96.730 E0.08539

G1 X88.938 Y96.660 E0.01006

G1 X88.588 Y96.517 E0.00985

G1 X88.172 Y96.396 E0.01129

G1 X87.814 Y96.323 E0.00953

G1 X87.471 Y96.287 E0.00900

G1 X86.988 Y96.286 E0.01258

G1 X86.065 Y96.462 E0.02446

G1 X85.289 Y96.732 E0.02142

G1 X84.239 Y96.747 E0.02737

G1 X81.887 Y96.729 E0.06127

G1 X81.890 Y96.144 E0.01525

M204 S1250

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M204 S800

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G1 X92.855 Y97.101 E0.00456

G1 X92.708 Y97.145 E0.00399

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G1 X87.027 Y96.704 E0.01098

G1 X86.174 Y96.866 E0.02262

G1 X85.363 Y97.149 E0.02237

G1 X84.240 Y97.165 E0.02925

G1 X81.767 Y97.146 E0.06446

G1 X81.648 Y97.120 E0.00315

G1 X81.578 Y97.065 E0.00233

G1 X81.521 Y96.990 E0.00247

G1 X81.469 Y96.811 E0.00485

G1 X81.474 Y95.928 E0.02301

G1 X81.509 Y95.828 E0.00275

G1 X81.614 Y95.730 E0.00375

M204 S1250

G1 X81.748 Y95.750 F9000.000

G1 X82.098 Y96.407

G1 F2400.000

G1 X85.232 Y96.409 E0.03628

G1 X85.505 Y96.363 E0.00320

G1 X85.777 Y96.317 E0.00169

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.505 Y96.363 E-0.15321

G1 E-0.80679 F4200.00000

G1 Z9.400 F9000.000

G1 X88.710 Y96.317

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X88.813 Y96.338 E0.00060

G1 X88.917 Y96.358 E0.00085

G1 X89.021 Y96.378 E0.00109

G1 X89.184 Y96.393 E0.00200

G1 X89.347 Y96.408 E0.00230

G1 X92.388 Y96.408 E0.04271

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y96.408 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.431 Y103.623

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.589 Y103.729 E0.00495

G1 X92.594 Y104.196 E0.01217

G1 X81.887 Y104.193 E0.27896

G1 X81.884 Y103.743 E0.01172

G1 X82.062 Y103.619 E0.00564

G1 X82.314 Y103.550 E0.00681

G1 X90.949 Y103.538 E0.22499

G1 X92.180 Y103.550 E0.03209

G1 X92.377 Y103.596 E0.00528

M204 S1250

G1 X92.945 Y103.496 F9000.000

M204 S800

G1 F1500.000

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G1 X93.013 Y104.309 E0.01800

G1 X92.984 Y104.414 E0.00285

G1 X92.920 Y104.525 E0.00334

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G1 X92.708 Y104.614 E0.00408

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G1 X81.470 Y104.313 E0.00172

G1 X81.466 Y103.674 E0.01664

G1 X81.481 Y103.586 E0.00233

G1 X81.530 Y103.495 E0.00270

G1 X81.683 Y103.367 E0.00519

G1 X81.888 Y103.234 E0.00638

G1 X82.257 Y103.132 E0.00997

G1 X90.950 Y103.120 E0.22651

G1 X92.229 Y103.133 E0.03331

G1 X92.515 Y103.198 E0.00766

G1 X92.642 Y103.261 E0.00368

G1 X92.905 Y103.452 E0.00847

M204 S1250

G1 X92.890 Y103.620 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.005 Y103.618 E-0.10743

G1 X93.013 Y104.309 E-0.38279

G1 X92.984 Y104.414 E-0.06064

G1 X92.920 Y104.525 E-0.07096

G1 X92.858 Y104.569 E-0.04177

G1 X92.708 Y104.614 E-0.08681

G1 X92.417 Y104.613 E-0.16160

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X82.095 Y103.922

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X82.357 Y103.872 E0.00328

G1 X90.947 Y103.867 E0.10524

G1 X92.142 Y103.873 E0.01464

G1 X92.382 Y103.921 E0.00299

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.142 Y103.873 E-0.13535

G1 X90.947 Y103.867 E-0.66234

G1 X90.741 Y103.867 E-0.11431

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.598 Y109.085

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y109.725 E0.01666

G1 X89.318 Y109.727 E0.08541

G1 X88.938 Y109.657 E0.01006

G1 X88.588 Y109.515 E0.00984

G1 X88.172 Y109.394 E0.01129

G1 X87.815 Y109.321 E0.00950

G1 X87.466 Y109.283 E0.00915

G1 X86.883 Y109.292 E0.01519

G1 X86.259 Y109.414 E0.01657

G1 X86.051 Y109.464 E0.00557

G1 X85.269 Y109.736 E0.02158

G1 X81.887 Y109.727 E0.08811

G1 X81.891 Y109.082 E0.01680

G1 X92.538 Y109.085 E0.27742

M204 S1250

G1 X92.895 Y108.740 F9000.000

M204 S800

G1 F1500.000

G1 X93.002 Y108.907 E0.00516

G1 X93.016 Y108.991 E0.00221

G1 X93.013 Y109.820 E0.02160

G1 X92.969 Y109.966 E0.00397

G1 X92.855 Y110.099 E0.00456

G1 X92.708 Y110.143 E0.00399

G1 X89.280 Y110.145 E0.08933

G1 X88.820 Y110.061 E0.01218

G1 X88.451 Y109.910 E0.01040

G1 X88.072 Y109.800 E0.01026

G1 X87.751 Y109.735 E0.00855

G1 X87.446 Y109.701 E0.00798

G1 X86.927 Y109.709 E0.01354

G1 X86.348 Y109.822 E0.01537

G1 X86.169 Y109.865 E0.00480

G1 X85.356 Y110.149 E0.02243

G1 X85.227 Y110.159 E0.00337

G1 X81.766 Y110.144 E0.09017

G1 X81.648 Y110.118 E0.00314

G1 X81.578 Y110.063 E0.00232

G1 X81.521 Y109.987 E0.00249

G1 X81.469 Y109.809 E0.00483

G1 X81.474 Y108.925 E0.02301

G1 X81.510 Y108.826 E0.00276

G1 X81.658 Y108.687 E0.00530

G1 X81.765 Y108.664 E0.00284

G1 X92.719 Y108.668 E0.28542

G1 X92.848 Y108.703 E0.00348

M204 S1250

G1 X92.866 Y108.936 F9000.000

G1 X92.388 Y109.405

G1 F2400.000

G1 X89.347 Y109.406 E0.04265

G1 X89.183 Y109.391 E0.00230

G1 X89.020 Y109.376 E0.00200

G1 X88.916 Y109.356 E0.00109

G1 X88.812 Y109.335 E0.00085

G1 X88.709 Y109.315 E0.00060

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.812 Y109.335 E-0.05864

G1 E-0.90136 F4200.00000

G1 Z9.400 F9000.000

G1 X85.776 Y109.315

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X85.489 Y109.363 E0.00183

G1 X85.199 Y109.412 E0.00354

G1 X82.098 Y109.405 E0.03740

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.744 Y109.409 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X81.932 Y116.702

G1 Z9.200

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.062 Y116.617 E0.00404

G1 X82.314 Y116.548 E0.00681

G1 X92.180 Y116.548 E0.25707

G1 X92.374 Y116.592 E0.00518

G1 X92.589 Y116.727 E0.00660

G1 X92.594 Y117.193 E0.01216

G1 X88.189 Y117.180 E0.11478

G1 X81.887 Y117.191 E0.16418

G1 X81.886 Y116.740 E0.01174

M204 S1250

G1 X81.530 Y116.493 F9000.000

M204 S800

G1 F1500.000

G1 X81.683 Y116.365 E0.00520

G1 X81.888 Y116.232 E0.00638

G1 X82.257 Y116.130 E0.00997

G1 X90.950 Y116.118 E0.22651

G1 X92.229 Y116.131 E0.03331

G1 X92.515 Y116.196 E0.00766

G1 X92.642 Y116.259 E0.00368

G1 X92.870 Y116.413 E0.00717

G1 X92.945 Y116.494 E0.00289

G1 X93.005 Y116.615 E0.00352

G1 X93.013 Y117.306 E0.01799

G1 X92.984 Y117.411 E0.00284

G1 X92.919 Y117.523 E0.00336

G1 X92.858 Y117.567 E0.00197

G1 X92.709 Y117.611 E0.00406

G1 X88.188 Y117.598 E0.11778

G1 X81.767 Y117.609 E0.16730

G1 X81.638 Y117.578 E0.00346

G1 X81.584 Y117.544 E0.00168

G1 X81.486 Y117.375 E0.00509

G1 X81.470 Y117.311 E0.00171

G1 X81.466 Y116.672 E0.01664

G1 X81.501 Y116.546 E0.00341

M204 S1250

G1 X81.729 Y116.510 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.683 Y116.365 E-0.14203

G1 X81.888 Y116.232 E-0.13579

G1 X82.257 Y116.130 E-0.21201

G1 X83.019 Y116.129 E-0.42216

G1 E-0.04800 F4200.00000

G1 Z9.400 F9000.000

G1 X92.382 Y116.918

G1 Z9.200

G1 E3.20000 F2400.00000

G1 X92.142 Y116.870 E0.00297

G1 X88.189 Y116.860 E0.04809

G1 X82.357 Y116.869 E0.07093

G1 X82.095 Y116.919 E0.00325

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;9.35

G1 Z9.350 F9000.000

;AFTER\_LAYER\_CHANGE

;9.35

G1 X81.884 Y116.738

M204 S800

G1 F1500.000

G1 X82.226 Y116.511 E0.01070

G1 X82.458 Y116.452 E0.00623

G1 X89.304 Y116.428 E0.17838

G1 X92.059 Y116.455 E0.07179

G1 X92.302 Y116.536 E0.00665

G1 X92.588 Y116.727 E0.00896

G1 X92.594 Y117.142 E0.01081

G1 X88.086 Y117.127 E0.11746

G1 X81.884 Y117.142 E0.16159

G1 X81.884 Y116.798 E0.00897

M204 S1250

G1 X81.586 Y117.495 F9000.000

M204 S800

G1 F1500.000

G1 X81.496 Y117.337 E0.00474

G1 X81.466 Y117.216 E0.00324

G1 X81.466 Y116.673 E0.01413

G1 X81.481 Y116.585 E0.00233

G1 X81.541 Y116.479 E0.00317

G1 X81.656 Y116.383 E0.00391

G1 X82.034 Y116.138 E0.01175

G1 X82.408 Y116.035 E0.01009

G1 X89.306 Y116.010 E0.17973

G1 X92.083 Y116.038 E0.07237

G1 X92.150 Y116.042 E0.00174

G1 X92.501 Y116.167 E0.00972

G1 X92.872 Y116.414 E0.01161

G1 X92.956 Y116.508 E0.00329

G1 X93.004 Y116.607 E0.00285

G1 X93.013 Y117.234 E0.01633

G1 X92.981 Y117.344 E0.00301

G1 X92.922 Y117.461 E0.00339

G1 X92.841 Y117.523 E0.00266

G1 X92.710 Y117.560 E0.00355

G1 X88.086 Y117.545 E0.12050

G1 X81.767 Y117.560 E0.16464

G1 X81.636 Y117.528 E0.00350

M204 S1250

G1 X81.619 Y117.316 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.496 Y117.337 E-0.13129

G1 X81.466 Y117.216 E-0.06894

G1 X81.466 Y116.673 E-0.30063

G1 X81.481 Y116.585 E-0.04945

G1 X81.541 Y116.479 E-0.06748

G1 X81.656 Y116.383 E-0.08317

G1 X81.976 Y116.176 E-0.21104

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.381 Y116.848

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X91.993 Y116.797 E0.00506

G1 X89.303 Y116.779 E0.03486

G1 X82.500 Y116.796 E0.08815

G1 X82.096 Y116.845 E0.00526

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.500 Y116.796 E-0.22514

G1 X83.739 Y116.793 E-0.68686

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X82.081 Y109.829

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y109.827 E0.00484

G1 X81.892 Y109.161 E0.01737

G1 X92.598 Y109.135 E0.27895

G1 X92.595 Y109.825 E0.01798

G1 X89.481 Y109.817 E0.08112

G1 X89.137 Y109.740 E0.00919

G1 X88.570 Y109.509 E0.01595

G1 X88.168 Y109.393 E0.01091

G1 X87.790 Y109.318 E0.01005

G1 X87.453 Y109.282 E0.00883

G1 X86.890 Y109.292 E0.01465

G1 X86.315 Y109.401 E0.01525

G1 X86.046 Y109.465 E0.00723

G1 X85.097 Y109.814 E0.02633

G1 X82.141 Y109.828 E0.07703

M204 S1250

G1 X81.507 Y110.042 F9000.000

M204 S800

G1 F1500.000

G1 X81.478 Y109.945 E0.00264

G1 X81.473 Y108.983 E0.02507

G1 X81.510 Y108.880 E0.00284

G1 X81.663 Y108.743 E0.00535

G1 X92.714 Y108.717 E0.28794

G1 X92.830 Y108.746 E0.00311

G1 X92.898 Y108.800 E0.00226

G1 X92.987 Y108.930 E0.00412

G1 X93.016 Y109.069 E0.00368

G1 X93.012 Y109.929 E0.02241

G1 X92.983 Y110.022 E0.00254

G1 X92.901 Y110.154 E0.00405

G1 X92.846 Y110.206 E0.00198

G1 X92.711 Y110.243 E0.00364

G1 X89.449 Y110.235 E0.08499

G1 X89.237 Y110.202 E0.00558

G1 X89.001 Y110.136 E0.00638

G1 X88.433 Y109.904 E0.01599

G1 X88.070 Y109.799 E0.00986

G1 X87.727 Y109.732 E0.00909

G1 X87.434 Y109.701 E0.00768

G1 X86.933 Y109.709 E0.01306

G1 X86.403 Y109.809 E0.01406

G1 X86.167 Y109.866 E0.00633

G1 X85.187 Y110.226 E0.02719

G1 X85.009 Y110.240 E0.00468

G1 X81.796 Y110.247 E0.08370

G1 X81.726 Y110.210 E0.00207

G1 X81.629 Y110.191 E0.00258

G1 X81.540 Y110.093 E0.00346

M204 S1250

G1 X81.560 Y109.956 F9000.000

G1 X82.103 Y109.494

G1 F2400.000

G1 X84.978 Y109.488 E0.03572

G1 X85.312 Y109.434 E0.00421

G1 X85.599 Y109.383 E0.00186

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.312 Y109.434 E-0.16157

G1 E-0.79843 F4200.00000

G1 Z9.550 F9000.000

G1 X88.852 Y109.375

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X88.980 Y109.400 E0.00082

G1 X89.109 Y109.425 E0.00121

G1 X89.237 Y109.450 E0.00159

G1 X89.395 Y109.471 E0.00239

G1 X92.387 Y109.480 E0.05044

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y109.475 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.404 Y104.143

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.086 Y104.129 E0.11253

G1 X81.884 Y104.144 E0.16159

G1 X81.884 Y103.740 E0.01053

G1 X82.226 Y103.513 E0.01070

G1 X82.458 Y103.454 E0.00623

G1 X89.304 Y103.430 E0.17838

G1 X92.059 Y103.457 E0.07178

G1 X92.302 Y103.538 E0.00666

G1 X92.588 Y103.729 E0.00896

G1 X92.594 Y104.144 E0.01081

G1 X92.464 Y104.143 E0.00337

M204 S1250

G1 X92.842 Y104.525 F9000.000

M204 S800

G1 F1500.000

G1 X92.710 Y104.562 E0.00356

G1 X88.086 Y104.547 E0.12050

G1 X81.767 Y104.562 E0.16464

G1 X81.640 Y104.532 E0.00338

G1 X81.586 Y104.497 E0.00169

G1 X81.496 Y104.338 E0.00474

G1 X81.466 Y104.218 E0.00324

G1 X81.466 Y103.675 E0.01413

G1 X81.481 Y103.588 E0.00231

G1 X81.542 Y103.481 E0.00320

G1 X81.656 Y103.385 E0.00390

G1 X82.034 Y103.140 E0.01175

G1 X82.408 Y103.037 E0.01009

G1 X89.306 Y103.012 E0.17973

G1 X92.150 Y103.044 E0.07411

G1 X92.501 Y103.169 E0.00972

G1 X92.872 Y103.416 E0.01161

G1 X92.956 Y103.510 E0.00328

G1 X93.004 Y103.609 E0.00286

G1 X93.013 Y104.236 E0.01634

G1 X92.981 Y104.347 E0.00302

G1 X92.923 Y104.463 E0.00338

G1 X92.889 Y104.488 E0.00108

M204 S1250

G1 X92.726 Y104.452 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.710 Y104.562 E-0.10741

G1 X91.258 Y104.557 E-0.80460

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X82.096 Y103.847

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X82.500 Y103.798 E0.00526

G1 X89.303 Y103.781 E0.08815

G1 X91.993 Y103.799 E0.03486

G1 X92.380 Y103.850 E0.00506

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.993 Y103.799 E-0.21640

G1 X90.738 Y103.791 E-0.69560

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.397 Y96.827

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.482 Y96.820 E0.07595

G1 X89.137 Y96.742 E0.00922

G1 X88.570 Y96.511 E0.01595

G1 X88.168 Y96.395 E0.01091

G1 X87.788 Y96.320 E0.01008

G1 X87.452 Y96.286 E0.00881

G1 X86.891 Y96.294 E0.01463

G1 X86.315 Y96.403 E0.01527

G1 X86.040 Y96.469 E0.00736

G1 X85.110 Y96.815 E0.02586

G1 X81.899 Y96.831 E0.08367

G1 X81.892 Y96.163 E0.01742

G1 X92.598 Y96.138 E0.27895

G1 X92.595 Y96.827 E0.01795

G1 X92.457 Y96.827 E0.00358

M204 S1250

G1 X92.901 Y97.156 F9000.000

M204 S800

G1 F1500.000

G1 X92.846 Y97.209 E0.00199

G1 X92.711 Y97.245 E0.00363

G1 X89.449 Y97.237 E0.08499

G1 X89.238 Y97.204 E0.00558

G1 X89.001 Y97.138 E0.00639

G1 X88.433 Y96.906 E0.01599

G1 X88.070 Y96.801 E0.00986

G1 X87.727 Y96.733 E0.00910

G1 X87.434 Y96.704 E0.00767

G1 X86.933 Y96.711 E0.01305

G1 X86.403 Y96.812 E0.01407

G1 X86.165 Y96.869 E0.00638

G1 X85.192 Y97.228 E0.02702

G1 X85.009 Y97.242 E0.00479

G1 X81.796 Y97.249 E0.08370

G1 X81.726 Y97.212 E0.00207

G1 X81.629 Y97.193 E0.00258

G1 X81.574 Y97.148 E0.00185

G1 X81.507 Y97.045 E0.00320

G1 X81.478 Y96.947 E0.00265

G1 X81.473 Y95.985 E0.02507

G1 X81.510 Y95.883 E0.00282

G1 X81.663 Y95.745 E0.00537

G1 X92.714 Y95.720 E0.28795

G1 X92.830 Y95.748 E0.00310

G1 X92.898 Y95.802 E0.00225

G1 X92.987 Y95.932 E0.00412

G1 X93.016 Y96.071 E0.00368

G1 X93.012 Y96.931 E0.02241

G1 X92.933 Y97.105 E0.00500

M204 S1250

G1 X92.825 Y97.152 F9000.000

G1 X92.387 Y96.483

G1 F2400.000

G1 X89.397 Y96.474 E0.05027

G1 X89.237 Y96.452 E0.00241

G1 X89.109 Y96.427 E0.00158

G1 X88.981 Y96.402 E0.00120

G1 X88.854 Y96.377 E0.00082

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.981 Y96.402 E-0.07207

G1 E-0.88793 F4200.00000

G1 Z9.550 F9000.000

G1 X85.617 Y96.385

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X85.359 Y96.434 E0.00162

G1 X84.978 Y96.490 E0.00451

G1 X82.103 Y96.496 E0.03373

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.748 Y96.493 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X81.884 Y91.146

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y90.742 E0.01052

G1 X82.228 Y90.515 E0.01074

G1 X82.458 Y90.456 E0.00619

G1 X89.304 Y90.432 E0.17838

G1 X92.059 Y90.459 E0.07178

G1 X92.302 Y90.540 E0.00669

G1 X92.588 Y90.731 E0.00894

G1 X92.594 Y91.146 E0.01081

G1 X88.086 Y91.131 E0.11746

G1 X81.944 Y91.146 E0.16002

M204 S1250

G1 X81.586 Y91.499 F9000.000

M204 S800

G1 F1500.000

G1 X81.496 Y91.342 E0.00472

G1 X81.466 Y91.220 E0.00327

G1 X81.466 Y90.677 E0.01414

G1 X81.481 Y90.590 E0.00231

G1 X81.541 Y90.483 E0.00319

G1 X81.656 Y90.388 E0.00389

G1 X82.035 Y90.142 E0.01177

G1 X82.408 Y90.039 E0.01008

G1 X89.306 Y90.014 E0.17973

G1 X92.083 Y90.042 E0.07237

G1 X92.150 Y90.046 E0.00174

G1 X92.502 Y90.171 E0.00973

G1 X92.872 Y90.418 E0.01161

G1 X92.956 Y90.512 E0.00328

G1 X93.004 Y90.611 E0.00286

G1 X93.013 Y91.238 E0.01634

G1 X92.981 Y91.349 E0.00302

G1 X92.923 Y91.465 E0.00338

G1 X92.842 Y91.527 E0.00264

G1 X92.710 Y91.564 E0.00356

G1 X88.086 Y91.549 E0.12050

G1 X81.767 Y91.564 E0.16464

G1 X81.636 Y91.532 E0.00351

M204 S1250

G1 X81.618 Y91.321 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.496 Y91.342 E-0.13081

G1 X81.466 Y91.220 E-0.06945

G1 X81.466 Y90.677 E-0.30066

G1 X81.481 Y90.590 E-0.04907

G1 X81.541 Y90.483 E-0.06789

G1 X81.656 Y90.388 E-0.08276

G1 X81.976 Y90.180 E-0.21137

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.381 Y90.852

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X91.993 Y90.801 E0.00506

G1 X89.303 Y90.784 E0.03479

G1 X82.500 Y90.800 E0.08800

G1 X82.098 Y90.849 E0.00524

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.500 Y90.800 E-0.22442

G1 X83.740 Y90.797 E-0.68758

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X82.082 Y83.833

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y83.831 E0.00485

G1 X81.892 Y83.165 E0.01736

G1 X92.598 Y83.140 E0.27895

G1 X92.595 Y83.829 E0.01795

G1 X89.482 Y83.822 E0.08110

G1 X89.137 Y83.744 E0.00922

G1 X88.570 Y83.513 E0.01595

G1 X88.168 Y83.397 E0.01091

G1 X87.788 Y83.322 E0.01008

G1 X87.452 Y83.288 E0.00881

G1 X86.891 Y83.296 E0.01463

G1 X86.315 Y83.405 E0.01527

G1 X86.045 Y83.470 E0.00722

G1 X85.098 Y83.818 E0.02629

G1 X82.142 Y83.833 E0.07704

M204 S1250

G1 X81.507 Y84.047 F9000.000

M204 S800

G1 F1500.000

G1 X81.478 Y83.949 E0.00266

G1 X81.473 Y82.987 E0.02508

G1 X81.510 Y82.885 E0.00282

G1 X81.663 Y82.747 E0.00537

G1 X92.714 Y82.722 E0.28795

G1 X92.830 Y82.750 E0.00310

G1 X92.898 Y82.804 E0.00225

G1 X92.987 Y82.934 E0.00411

G1 X93.016 Y83.073 E0.00369

G1 X93.012 Y83.933 E0.02241

G1 X92.983 Y84.027 E0.00256

G1 X92.901 Y84.159 E0.00404

G1 X92.846 Y84.211 E0.00199

G1 X92.711 Y84.247 E0.00362

G1 X89.449 Y84.239 E0.08500

G1 X89.238 Y84.206 E0.00558

G1 X89.001 Y84.140 E0.00639

G1 X88.433 Y83.908 E0.01599

G1 X88.070 Y83.803 E0.00986

G1 X87.727 Y83.735 E0.00910

G1 X87.434 Y83.706 E0.00767

G1 X86.933 Y83.713 E0.01305

G1 X86.403 Y83.814 E0.01407

G1 X86.167 Y83.871 E0.00633

G1 X85.188 Y84.231 E0.02717

G1 X85.009 Y84.244 E0.00467

G1 X81.797 Y84.251 E0.08370

G1 X81.726 Y84.214 E0.00208

G1 X81.628 Y84.195 E0.00260

G1 X81.540 Y84.098 E0.00342

M204 S1250

G1 X81.560 Y83.960 F9000.000

G1 X82.103 Y83.498

G1 F2400.000

G1 X84.980 Y83.492 E0.03574

G1 X85.314 Y83.439 E0.00420

G1 X85.601 Y83.387 E0.00186

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.314 Y83.439 E-0.16136

G1 E-0.79864 F4200.00000

G1 Z9.550 F9000.000

G1 X88.854 Y83.379

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X88.981 Y83.404 E0.00082

G1 X89.109 Y83.429 E0.00120

G1 X89.237 Y83.454 E0.00158

G1 X89.397 Y83.476 E0.00241

G1 X92.387 Y83.485 E0.05027

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y83.480 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.404 Y78.147

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.086 Y78.133 E0.11253

G1 X81.884 Y78.148 E0.16159

G1 X81.884 Y77.744 E0.01052

G1 X82.228 Y77.517 E0.01074

G1 X82.458 Y77.459 E0.00618

G1 X89.304 Y77.435 E0.17840

G1 X92.058 Y77.461 E0.07174

G1 X92.302 Y77.542 E0.00672

G1 X92.588 Y77.733 E0.00894

G1 X92.594 Y78.148 E0.01081

G1 X92.464 Y78.147 E0.00337

M204 S1250

G1 X92.842 Y78.529 F9000.000

M204 S800

G1 F1500.000

G1 X92.710 Y78.566 E0.00356

G1 X88.086 Y78.551 E0.12050

G1 X81.767 Y78.566 E0.16464

G1 X81.640 Y78.536 E0.00340

G1 X81.586 Y78.501 E0.00168

G1 X81.496 Y78.344 E0.00472

G1 X81.466 Y78.222 E0.00327

G1 X81.466 Y77.679 E0.01414

G1 X81.481 Y77.592 E0.00230

G1 X81.541 Y77.486 E0.00319

G1 X81.656 Y77.390 E0.00390

G1 X82.035 Y77.144 E0.01176

G1 X82.407 Y77.041 E0.01007

G1 X89.306 Y77.017 E0.17974

G1 X92.082 Y77.044 E0.07235

G1 X92.149 Y77.049 E0.00175

G1 X92.502 Y77.173 E0.00974

G1 X92.872 Y77.420 E0.01160

G1 X92.956 Y77.514 E0.00330

G1 X93.004 Y77.613 E0.00285

G1 X93.013 Y78.240 E0.01633

G1 X92.981 Y78.351 E0.00302

G1 X92.923 Y78.467 E0.00338

G1 X92.889 Y78.492 E0.00108

M204 S1250

G1 X92.726 Y78.456 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.710 Y78.566 E-0.10740

G1 X91.258 Y78.561 E-0.80460

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X82.098 Y77.850

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X82.499 Y77.803 E0.00522

G1 X89.303 Y77.786 E0.08790

G1 X91.992 Y77.803 E0.03474

G1 X92.381 Y77.854 E0.00506

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.992 Y77.803 E-0.21700

G1 X90.738 Y77.795 E-0.69500

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.399 Y70.831

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.482 Y70.824 E0.07601

G1 X89.137 Y70.747 E0.00919

G1 X88.570 Y70.515 E0.01595

G1 X88.168 Y70.399 E0.01092

G1 X87.789 Y70.324 E0.01006

G1 X87.453 Y70.290 E0.00881

G1 X86.891 Y70.298 E0.01464

G1 X86.315 Y70.407 E0.01527

G1 X86.045 Y70.472 E0.00723

G1 X85.098 Y70.820 E0.02629

G1 X81.900 Y70.835 E0.08334

G1 X81.892 Y70.167 E0.01742

G1 X92.598 Y70.142 E0.27895

G1 X92.595 Y70.832 E0.01797

G1 X92.459 Y70.831 E0.00355

M204 S1250

G1 X92.901 Y71.161 F9000.000

M204 S800

G1 F1500.000

G1 X92.846 Y71.213 E0.00198

G1 X92.711 Y71.250 E0.00363

G1 X89.449 Y71.241 E0.08500

G1 X89.237 Y71.209 E0.00558

G1 X89.002 Y71.143 E0.00638

G1 X88.433 Y70.911 E0.01600

G1 X88.069 Y70.805 E0.00986

G1 X87.727 Y70.738 E0.00909

G1 X87.434 Y70.708 E0.00767

G1 X86.933 Y70.715 E0.01305

G1 X86.403 Y70.816 E0.01406

G1 X86.167 Y70.873 E0.00633

G1 X85.188 Y71.233 E0.02717

G1 X81.797 Y71.253 E0.08836

G1 X81.726 Y71.216 E0.00210

G1 X81.628 Y71.197 E0.00258

G1 X81.574 Y71.153 E0.00182

G1 X81.507 Y71.049 E0.00322

G1 X81.478 Y70.951 E0.00266

G1 X81.473 Y69.989 E0.02508

G1 X81.510 Y69.887 E0.00282

G1 X81.663 Y69.749 E0.00537

G1 X92.714 Y69.724 E0.28795

G1 X92.830 Y69.752 E0.00310

G1 X92.898 Y69.806 E0.00225

G1 X92.987 Y69.937 E0.00414

G1 X93.016 Y70.076 E0.00369

G1 X93.012 Y70.935 E0.02239

G1 X92.933 Y71.110 E0.00501

M204 S1250

G1 X92.825 Y71.157 F9000.000

G1 X92.387 Y70.487

G1 F2400.000

G1 X89.396 Y70.478 E0.05039

G1 X89.237 Y70.456 E0.00239

G1 X89.109 Y70.431 E0.00159

G1 X88.981 Y70.406 E0.00121

G1 X88.853 Y70.381 E0.00082

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.981 Y70.406 E-0.07234

G1 E-0.88766 F4200.00000

G1 Z9.550 F9000.000

G1 X85.601 Y70.389

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X85.314 Y70.441 E0.00186

G1 X84.980 Y70.494 E0.00420

G1 X82.103 Y70.500 E0.03574

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.748 Y70.497 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X81.884 Y65.150

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y64.746 E0.01052

G1 X82.228 Y64.519 E0.01074

G1 X82.458 Y64.461 E0.00618

G1 X89.304 Y64.437 E0.17840

G1 X92.057 Y64.463 E0.07173

G1 X92.303 Y64.545 E0.00675

G1 X92.588 Y64.735 E0.00892

G1 X92.594 Y65.150 E0.01081

G1 X88.086 Y65.135 E0.11746

G1 X81.944 Y65.150 E0.16002

M204 S1250

G1 X81.586 Y65.503 F9000.000

M204 S800

G1 F1500.000

G1 X81.496 Y65.346 E0.00472

G1 X81.466 Y65.224 E0.00327

G1 X81.466 Y64.682 E0.01411

G1 X81.481 Y64.594 E0.00233

G1 X81.541 Y64.488 E0.00318

G1 X81.656 Y64.392 E0.00390

G1 X82.035 Y64.146 E0.01176

G1 X82.407 Y64.043 E0.01007

G1 X89.306 Y64.019 E0.17974

G1 X92.082 Y64.046 E0.07235

G1 X92.149 Y64.051 E0.00175

G1 X92.502 Y64.175 E0.00975

G1 X92.872 Y64.422 E0.01159

G1 X92.956 Y64.516 E0.00329

G1 X93.004 Y64.616 E0.00287

G1 X93.013 Y65.242 E0.01633

G1 X92.981 Y65.353 E0.00300

G1 X92.923 Y65.469 E0.00339

G1 X92.842 Y65.531 E0.00264

G1 X92.710 Y65.568 E0.00356

G1 X88.086 Y65.553 E0.12050

G1 X81.767 Y65.568 E0.16464

G1 X81.636 Y65.536 E0.00351

M204 S1250

G1 X81.618 Y65.325 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.496 Y65.346 E-0.13081

G1 X81.466 Y65.224 E-0.06945

G1 X81.466 Y64.682 E-0.30017

G1 X81.481 Y64.594 E-0.04953

G1 X81.541 Y64.488 E-0.06770

G1 X81.656 Y64.392 E-0.08302

G1 X81.976 Y64.184 E-0.21132

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.380 Y64.857

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X91.991 Y64.805 E0.00506

G1 X89.303 Y64.788 E0.03467

G1 X82.499 Y64.805 E0.08775

G1 X82.098 Y64.852 E0.00521

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.499 Y64.805 E-0.22379

G1 X83.741 Y64.802 E-0.68821

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X82.084 Y57.837

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.896 Y57.835 E0.00491

G1 X81.892 Y57.169 E0.01736

G1 X92.598 Y57.144 E0.27895

G1 X92.595 Y57.834 E0.01797

G1 X89.481 Y57.826 E0.08113

G1 X89.137 Y57.749 E0.00918

G1 X88.570 Y57.518 E0.01595

G1 X88.168 Y57.402 E0.01091

G1 X87.790 Y57.327 E0.01005

G1 X87.453 Y57.292 E0.00882

G1 X86.886 Y57.300 E0.01478

G1 X86.055 Y57.470 E0.02210

G1 X85.097 Y57.823 E0.02661

G1 X82.144 Y57.837 E0.07695

M204 S1250

G1 X81.507 Y58.051 F9000.000

M204 S800

G1 F1500.000

G1 X81.478 Y57.953 E0.00266

G1 X81.473 Y56.991 E0.02508

G1 X81.510 Y56.889 E0.00282

G1 X81.663 Y56.751 E0.00537

G1 X92.714 Y56.726 E0.28794

G1 X92.830 Y56.755 E0.00312

G1 X92.898 Y56.808 E0.00225

G1 X92.987 Y56.939 E0.00413

G1 X93.016 Y57.078 E0.00369

G1 X93.012 Y57.937 E0.02240

G1 X92.983 Y58.031 E0.00256

G1 X92.901 Y58.163 E0.00405

G1 X92.846 Y58.215 E0.00198

G1 X92.711 Y58.252 E0.00363

G1 X89.449 Y58.243 E0.08500

G1 X89.237 Y58.211 E0.00558

G1 X89.001 Y58.145 E0.00638

G1 X88.433 Y57.913 E0.01599

G1 X88.070 Y57.808 E0.00986

G1 X87.727 Y57.741 E0.00909

G1 X87.434 Y57.710 E0.00767

G1 X86.932 Y57.717 E0.01310

G1 X86.170 Y57.873 E0.02025

G1 X85.187 Y58.235 E0.02728

G1 X85.009 Y58.249 E0.00467

G1 X81.797 Y58.255 E0.08369

G1 X81.726 Y58.218 E0.00210

G1 X81.628 Y58.199 E0.00258

G1 X81.540 Y58.102 E0.00343

M204 S1250

G1 X81.560 Y57.964 F9000.000

G1 X82.103 Y57.503

G1 F2400.000

G1 X84.978 Y57.496 E0.03581

G1 X85.313 Y57.443 E0.00422

G1 X85.600 Y57.391 E0.00187

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.313 Y57.443 E-0.16195

G1 E-0.79805 F4200.00000

G1 Z9.550 F9000.000

G1 X88.851 Y57.383

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X88.980 Y57.408 E0.00083

G1 X89.108 Y57.433 E0.00121

G1 X89.237 Y57.458 E0.00160

G1 X89.395 Y57.480 E0.00238

G1 X92.387 Y57.489 E0.05039

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.742 Y57.484 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.404 Y52.151

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.086 Y52.138 E0.11250

G1 X81.884 Y52.152 E0.16159

G1 X81.884 Y51.749 E0.01050

G1 X82.228 Y51.521 E0.01075

G1 X82.458 Y51.463 E0.00617

G1 X89.304 Y51.439 E0.17839

G1 X92.059 Y51.466 E0.07179

G1 X92.302 Y51.547 E0.00665

G1 X92.588 Y51.738 E0.00896

G1 X92.594 Y52.152 E0.01079

G1 X92.464 Y52.151 E0.00340

M204 S1250

G1 X92.842 Y52.533 F9000.000

M204 S800

G1 F1500.000

G1 X92.711 Y52.570 E0.00354

G1 X88.086 Y52.556 E0.12051

G1 X81.766 Y52.570 E0.16466

G1 X81.640 Y52.541 E0.00338

G1 X81.586 Y52.506 E0.00168

G1 X81.496 Y52.348 E0.00474

G1 X81.466 Y52.226 E0.00327

G1 X81.466 Y51.684 E0.01411

G1 X81.481 Y51.596 E0.00233

G1 X81.541 Y51.490 E0.00317

G1 X81.656 Y51.394 E0.00391

G1 X82.035 Y51.148 E0.01176

G1 X82.407 Y51.045 E0.01007

G1 X89.306 Y51.021 E0.17973

G1 X92.150 Y51.053 E0.07411

G1 X92.501 Y51.178 E0.00972

G1 X92.872 Y51.425 E0.01161

G1 X92.956 Y51.519 E0.00329

G1 X93.004 Y51.618 E0.00285

G1 X93.013 Y52.244 E0.01633

G1 X92.981 Y52.355 E0.00300

G1 X92.922 Y52.472 E0.00340

G1 X92.889 Y52.497 E0.00108

M204 S1250

G1 X92.727 Y52.461 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.711 Y52.570 E-0.10693

G1 X91.258 Y52.566 E-0.80507

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X82.098 Y51.854

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X82.499 Y51.807 E0.00520

G1 X89.303 Y51.790 E0.08779

G1 X91.994 Y51.808 E0.03471

G1 X92.380 Y51.859 E0.00504

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.994 Y51.808 E-0.21628

G1 X90.738 Y51.800 E-0.69572

G1 E-0.04800 F4200.00000

G1 Z9.550 F9000.000

G1 X92.399 Y44.836

G1 Z9.350

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.481 Y44.828 E0.07604

G1 X89.137 Y44.751 E0.00918

G1 X88.570 Y44.520 E0.01595

G1 X88.168 Y44.404 E0.01091

G1 X87.790 Y44.329 E0.01005

G1 X87.453 Y44.294 E0.00882

G1 X86.891 Y44.302 E0.01466

G1 X86.315 Y44.412 E0.01527

G1 X86.046 Y44.476 E0.00722

G1 X85.097 Y44.825 E0.02633

G1 X81.900 Y44.839 E0.08331

G1 X81.892 Y44.171 E0.01741

G1 X92.598 Y44.146 E0.27895

G1 X92.595 Y44.836 E0.01797

G1 X92.459 Y44.836 E0.00353

M204 S1250

G1 X92.901 Y45.165 F9000.000

M204 S800

G1 F1500.000

G1 X92.846 Y45.217 E0.00198

G1 X92.711 Y45.254 E0.00364

G1 X89.449 Y45.245 E0.08499

G1 X89.237 Y45.213 E0.00558

G1 X89.001 Y45.147 E0.00638

G1 X88.433 Y44.915 E0.01599

G1 X88.070 Y44.810 E0.00986

G1 X87.727 Y44.743 E0.00909

G1 X87.434 Y44.712 E0.00767

G1 X86.933 Y44.719 E0.01306

G1 X86.403 Y44.820 E0.01407

G1 X86.167 Y44.877 E0.00633

G1 X85.187 Y45.237 E0.02719

G1 X85.009 Y45.251 E0.00467

G1 X81.797 Y45.257 E0.08369

G1 X81.726 Y45.220 E0.00210

G1 X81.628 Y45.201 E0.00258

G1 X81.574 Y45.157 E0.00182

G1 X81.507 Y45.053 E0.00322

G1 X81.478 Y44.955 E0.00266

G1 X81.473 Y43.993 E0.02508

G1 X81.509 Y43.891 E0.00282

G1 X81.664 Y43.754 E0.00538

G1 X92.714 Y43.728 E0.28792

G1 X92.830 Y43.757 E0.00311

G1 X92.898 Y43.811 E0.00226

G1 X92.987 Y43.941 E0.00412

G1 X93.016 Y44.080 E0.00368

G1 X93.012 Y44.939 E0.02240

G1 X92.933 Y45.114 E0.00501

M204 S1250

G1 X92.825 Y45.161 F9000.000

G1 X92.387 Y44.491

G1 F2400.000

G1 X89.395 Y44.482 E0.05045

G1 X89.237 Y44.461 E0.00238

G1 X89.108 Y44.436 E0.00159

G1 X88.980 Y44.411 E0.00121

G1 X88.852 Y44.386 E0.00082

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.980 Y44.411 E-0.07246

G1 E-0.88754 F4200.00000

G1 Z9.550 F9000.000

G1 X85.600 Y44.394

G1 Z9.350

G1 E3.20000 F2400.00000

G1 X85.313 Y44.445 E0.00187

G1 X84.978 Y44.499 E0.00421

G1 X82.103 Y44.505 E0.03576

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;9.5

G1 Z9.500 F9000.000

;AFTER\_LAYER\_CHANGE

;9.5

G1 E-3.20000 F4200.00000

G1 Z9.700 F9000.000

G1 X81.884 Y116.734

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.368 Y116.421 E0.01503

G1 X82.639 Y116.344 E0.00732

G1 X87.659 Y116.319 E0.13083

G1 X91.843 Y116.336 E0.10900

G1 X92.144 Y116.435 E0.00825

G1 X92.587 Y116.728 E0.01383

G1 X92.594 Y117.076 E0.00909

G1 X81.885 Y117.073 E0.27902

M73 P82 R12

G1 X81.884 Y116.794 E0.00725

M204 S1250

G1 X81.584 Y117.428 F9000.000

M204 S800

G1 F1500.000

G1 X81.505 Y117.295 E0.00404

G1 X81.468 Y117.146 E0.00399

G1 X81.466 Y116.673 E0.01232

G1 X81.481 Y116.587 E0.00229

G1 X81.553 Y116.465 E0.00368

G1 X82.194 Y116.036 E0.02009

G1 X82.579 Y115.927 E0.01044

G1 X87.661 Y115.901 E0.13239

G1 X91.868 Y115.919 E0.10962

G1 X92.007 Y115.935 E0.00366

G1 X92.336 Y116.062 E0.00918

G1 X92.875 Y116.417 E0.01684

G1 X92.967 Y116.521 E0.00361

G1 X93.002 Y116.598 E0.00219

G1 X93.013 Y117.159 E0.01464

G1 X92.979 Y117.273 E0.00309

G1 X92.900 Y117.411 E0.00414

G1 X92.829 Y117.470 E0.00241

G1 X92.718 Y117.494 E0.00298

G1 X81.764 Y117.490 E0.28540

G1 X81.634 Y117.461 E0.00347

M204 S1250

G1 X81.610 Y117.275 F9000.000

G1 X82.204 Y116.776

G1 F2400.000

G1 X82.447 Y116.742 E0.00437

G1 X82.690 Y116.708 E0.00492

G1 X91.817 Y116.706 E0.18319

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.172 Y116.707 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X92.594 Y109.930

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.654 Y109.920 E0.07661

G1 X89.328 Y109.819 E0.00890

G1 X88.552 Y109.503 E0.02182

G1 X88.164 Y109.392 E0.01053

G1 X87.764 Y109.314 E0.01061

G1 X87.439 Y109.282 E0.00851

G1 X86.891 Y109.291 E0.01428

G1 X86.054 Y109.462 E0.02226

G1 X85.382 Y109.712 E0.01869

G1 X85.100 Y109.848 E0.00816

G1 X84.721 Y109.929 E0.01009

G1 X81.903 Y109.939 E0.07344

G1 X81.892 Y109.239 E0.01826

G1 X92.598 Y109.203 E0.27895

G1 X92.595 Y109.870 E0.01739

M204 S1250

G1 X92.841 Y108.819 F9000.000

M204 S800

G1 F1500.000

G1 X92.905 Y108.864 E0.00205

G1 X92.979 Y108.963 E0.00322

G1 X93.006 Y109.042 E0.00218

G1 X93.012 Y110.040 E0.02600

G1 X92.930 Y110.224 E0.00524

G1 X92.825 Y110.318 E0.00369

G1 X92.711 Y110.348 E0.00306

G1 X89.751 Y110.348 E0.07713

G1 X89.594 Y110.334 E0.00411

G1 X89.455 Y110.306 E0.00368

G1 X89.180 Y110.210 E0.00761

G1 X88.416 Y109.898 E0.02150

G1 X88.067 Y109.798 E0.00946

G1 X87.704 Y109.728 E0.00963

G1 X87.422 Y109.700 E0.00738

G1 X86.937 Y109.708 E0.01263

G1 X86.170 Y109.865 E0.02041

G1 X85.546 Y110.097 E0.01735

G1 X85.249 Y110.239 E0.00857

G1 X85.023 Y110.305 E0.00614

G1 X84.755 Y110.347 E0.00707

G1 X81.774 Y110.358 E0.07767

G1 X81.716 Y110.340 E0.00158

G1 X81.636 Y110.263 E0.00290

G1 X81.578 Y110.251 E0.00155

G1 X81.487 Y110.071 E0.00523

G1 X81.468 Y109.562 E0.01329

G1 X81.478 Y109.031 E0.01384

G1 X81.510 Y108.944 E0.00242

G1 X81.640 Y108.822 E0.00464

G1 X92.710 Y108.785 E0.28845

G1 X92.782 Y108.805 E0.00196

M204 S1250

G1 X92.850 Y108.897 F9000.000

G1 X92.387 Y109.567

G1 F2400.000

G1 X89.658 Y109.563 E0.05249

G1 X89.548 Y109.545 E0.00196

G1 X89.439 Y109.526 E0.00170

G1 X89.335 Y109.506 E0.00137

G1 X89.231 Y109.486 E0.00112

G1 X89.126 Y109.466 E0.00087

G1 X89.022 Y109.445 E0.00061

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.126 Y109.466 E-0.05873

G1 E-0.90127 F4200.00000

G1 Z9.700 F9000.000

G1 X85.373 Y109.492

G1 Z9.500

G1 E3.20000 F2400.00000

G1 X84.693 Y109.579 E0.01098

G1 X82.237 Y109.588 E0.03934

G1 X82.097 Y109.453 E0.00312

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.237 Y109.588 E-0.10805

G1 X83.688 Y109.583 E-0.80395

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X81.885 Y104.075

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X82.368 Y103.423 E0.01503

G1 X82.639 Y103.346 E0.00732

G1 X87.659 Y103.321 E0.13083

G1 X91.905 Y103.346 E0.11062

G1 X92.144 Y103.438 E0.00667

G1 X92.587 Y103.730 E0.01382

G1 X92.594 Y104.078 E0.00909

G1 X81.945 Y104.075 E0.27745

M204 S1250

G1 X81.584 Y104.430 F9000.000

M204 S800

G1 F1500.000

G1 X81.505 Y104.297 E0.00404

G1 X81.468 Y104.148 E0.00399

G1 X81.466 Y103.675 E0.01231

G1 X81.481 Y103.590 E0.00227

G1 X81.553 Y103.467 E0.00370

G1 X82.194 Y103.038 E0.02009

G1 X82.579 Y102.929 E0.01044

G1 X87.661 Y102.903 E0.13239

G1 X91.867 Y102.921 E0.10961

G1 X92.007 Y102.938 E0.00366

G1 X92.336 Y103.064 E0.00919

G1 X92.875 Y103.419 E0.01683

G1 X92.967 Y103.523 E0.00361

G1 X93.002 Y103.600 E0.00219

G1 X93.013 Y104.161 E0.01464

G1 X92.979 Y104.275 E0.00310

G1 X92.900 Y104.413 E0.00414

G1 X92.830 Y104.472 E0.00240

G1 X92.718 Y104.496 E0.00299

G1 X81.764 Y104.492 E0.28540

G1 X81.634 Y104.463 E0.00347

M204 S1250

G1 X81.610 Y104.277 F9000.000

G1 X82.204 Y103.778

G1 F2400.000

G1 X82.447 Y103.744 E0.00437

G1 X82.690 Y103.710 E0.00492

G1 X91.817 Y103.708 E0.18318

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.171 Y103.709 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X92.594 Y96.932

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X89.328 Y96.821 E0.00894

G1 X88.552 Y96.505 E0.02182

G1 X88.164 Y96.394 E0.01053

G1 X87.763 Y96.316 E0.01064

G1 X87.439 Y96.285 E0.00849

G1 X86.892 Y96.293 E0.01425

G1 X86.054 Y96.464 E0.02228

G1 X85.382 Y96.715 E0.01868

G1 X85.101 Y96.850 E0.00813

G1 X84.721 Y96.931 E0.01011

G1 X81.903 Y96.941 E0.07344

G1 X81.892 Y96.241 E0.01826

G1 X92.598 Y96.206 E0.27895

G1 X92.595 Y96.872 E0.01736

M204 S1250

G1 X92.841 Y95.821 F9000.000

M204 S800

G1 F1500.000

G1 X92.905 Y95.866 E0.00204

G1 X92.979 Y95.965 E0.00321

G1 X93.006 Y96.045 E0.00220

G1 X93.012 Y97.042 E0.02598

G1 X92.930 Y97.226 E0.00525

G1 X92.825 Y97.320 E0.00368

G1 X92.712 Y97.350 E0.00304

G1 X89.751 Y97.351 E0.07713

G1 X89.595 Y97.336 E0.00411

G1 X89.456 Y97.309 E0.00369

G1 X89.180 Y97.212 E0.00762

G1 X88.416 Y96.900 E0.02150

G1 X88.067 Y96.800 E0.00946

G1 X87.703 Y96.730 E0.00964

G1 X87.422 Y96.703 E0.00737

G1 X86.937 Y96.710 E0.01262

G1 X86.169 Y96.867 E0.02042

G1 X85.546 Y97.100 E0.01734

G1 X85.250 Y97.242 E0.00856

G1 X85.023 Y97.306 E0.00614

G1 X84.755 Y97.349 E0.00707

G1 X81.774 Y97.360 E0.07767

G1 X81.716 Y97.342 E0.00158

G1 X81.636 Y97.265 E0.00290

G1 X81.578 Y97.253 E0.00155

G1 X81.487 Y97.073 E0.00523

G1 X81.468 Y96.564 E0.01329

G1 X81.478 Y96.033 E0.01383

G1 X81.510 Y95.946 E0.00241

G1 X81.640 Y95.824 E0.00465

G1 X92.711 Y95.788 E0.28846

G1 X92.783 Y95.808 E0.00195

M204 S1250

G1 X92.850 Y95.899 F9000.000

G1 X92.387 Y96.569

G1 F2400.000

G1 X89.659 Y96.566 E0.05233

G1 X89.549 Y96.547 E0.00198

G1 X89.438 Y96.529 E0.00171

G1 X89.335 Y96.508 E0.00136

G1 X89.231 Y96.488 E0.00111

G1 X89.128 Y96.468 E0.00086

G1 X89.024 Y96.448 E0.00061

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.128 Y96.468 E-0.05848

G1 E-0.90152 F4200.00000

G1 Z9.700 F9000.000

G1 X85.373 Y96.495

G1 Z9.500

G1 E3.20000 F2400.00000

G1 X84.693 Y96.582 E0.01096

G1 X82.237 Y96.590 E0.03927

G1 X82.097 Y96.455 E0.00312

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.237 Y96.590 E-0.10803

G1 X83.688 Y96.585 E-0.80397

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X81.885 Y91.077

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y90.739 E0.00880

G1 X82.369 Y90.425 E0.01503

G1 X82.639 Y90.348 E0.00732

G1 X87.660 Y90.324 E0.13082

G1 X91.906 Y90.348 E0.11064

G1 X92.144 Y90.440 E0.00665

G1 X92.587 Y90.732 E0.01382

G1 X92.594 Y91.080 E0.00909

G1 X81.945 Y91.077 E0.27745

M204 S1250

G1 X81.584 Y91.432 F9000.000

M204 S800

G1 F1500.000

G1 X81.505 Y91.300 E0.00402

G1 X81.468 Y91.150 E0.00401

G1 X81.466 Y90.677 E0.01232

G1 X81.481 Y90.592 E0.00227

G1 X81.553 Y90.469 E0.00370

G1 X82.194 Y90.041 E0.02009

G1 X82.580 Y89.931 E0.01045

G1 X87.661 Y89.906 E0.13239

G1 X91.868 Y89.923 E0.10962

G1 X92.007 Y89.940 E0.00366

G1 X92.336 Y90.066 E0.00918

G1 X92.875 Y90.421 E0.01683

G1 X92.967 Y90.525 E0.00361

G1 X93.002 Y90.602 E0.00219

G1 X93.013 Y91.163 E0.01464

G1 X92.979 Y91.277 E0.00310

G1 X92.900 Y91.415 E0.00414

G1 X92.830 Y91.474 E0.00240

G1 X92.718 Y91.498 E0.00299

G1 X81.764 Y91.494 E0.28540

G1 X81.634 Y91.465 E0.00347

M204 S1250

G1 X81.610 Y91.280 F9000.000

G1 X82.205 Y90.780

G1 F2400.000

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G1 X82.691 Y90.712 E0.00492

G1 X91.817 Y90.710 E0.18301

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.172 Y90.711 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X92.594 Y83.934

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X88.552 Y83.507 E0.02182

G1 X88.164 Y83.396 E0.01053

G1 X87.763 Y83.318 E0.01064

G1 X87.439 Y83.287 E0.00849

G1 X86.892 Y83.295 E0.01425

G1 X86.054 Y83.466 E0.02228

G1 X85.382 Y83.717 E0.01869

G1 X85.100 Y83.853 E0.00816

G1 X84.722 Y83.933 E0.01006

G1 X81.904 Y83.944 E0.07343

G1 X81.892 Y83.243 E0.01828

G1 X92.598 Y83.208 E0.27895

G1 X92.595 Y83.874 E0.01736

M204 S1250

G1 X92.841 Y82.823 F9000.000

M204 S800

G1 F1500.000

G1 X92.905 Y82.868 E0.00204

G1 X92.979 Y82.967 E0.00321

G1 X93.006 Y83.047 E0.00220

G1 X93.012 Y84.044 E0.02598

G1 X92.930 Y84.228 E0.00524

G1 X92.825 Y84.322 E0.00369

G1 X92.712 Y84.352 E0.00304

G1 X89.751 Y84.353 E0.07714

G1 X89.595 Y84.338 E0.00411

G1 X89.456 Y84.311 E0.00369

G1 X89.180 Y84.214 E0.00762

G1 X88.416 Y83.902 E0.02150

G1 X88.067 Y83.802 E0.00946

G1 X87.703 Y83.732 E0.00964

G1 X87.422 Y83.705 E0.00737

G1 X86.937 Y83.712 E0.01262

G1 X86.169 Y83.869 E0.02042

G1 X85.546 Y84.102 E0.01735

G1 X85.249 Y84.244 E0.00857

G1 X85.023 Y84.309 E0.00613

G1 X84.755 Y84.351 E0.00706

G1 X81.774 Y84.362 E0.07768

G1 X81.717 Y84.345 E0.00157

G1 X81.637 Y84.267 E0.00292

G1 X81.577 Y84.255 E0.00157

G1 X81.487 Y84.076 E0.00521

G1 X81.468 Y83.566 E0.01330

G1 X81.478 Y83.035 E0.01385

G1 X81.510 Y82.948 E0.00241

G1 X81.640 Y82.826 E0.00465

G1 X92.711 Y82.790 E0.28846

G1 X92.783 Y82.810 E0.00195

M204 S1250

G1 X92.850 Y82.901 F9000.000

G1 X92.387 Y83.571

G1 F2400.000

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G1 X89.549 Y83.549 E0.00198

G1 X89.438 Y83.531 E0.00171

G1 X89.335 Y83.510 E0.00136

G1 X89.231 Y83.490 E0.00111

G1 X89.128 Y83.470 E0.00086

G1 X89.024 Y83.450 E0.00061

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.128 Y83.470 E-0.05848

G1 E-0.90152 F4200.00000

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G1 X85.373 Y83.497

G1 Z9.500

G1 E3.20000 F2400.00000

G1 X84.695 Y83.584 E0.01097

G1 X82.238 Y83.592 E0.03940

G1 X82.097 Y83.457 E0.00313

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.238 Y83.592 E-0.10826

G1 X83.688 Y83.587 E-0.80374

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X81.885 Y78.079

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y77.741 E0.00880

G1 X82.369 Y77.428 E0.01503

G1 X82.639 Y77.351 E0.00733

G1 X87.660 Y77.326 E0.13081

G1 X91.905 Y77.351 E0.11062

G1 X92.144 Y77.442 E0.00667

G1 X92.587 Y77.734 E0.01381

G1 X92.594 Y78.082 E0.00909

G1 X81.945 Y78.079 E0.27745

M204 S1250

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M204 S800

G1 F1500.000

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G1 X81.481 Y77.594 E0.00227

G1 X81.553 Y77.472 E0.00369

G1 X82.194 Y77.043 E0.02008

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G1 X87.661 Y76.908 E0.13239

G1 X91.867 Y76.925 E0.10961

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G1 X92.900 Y78.417 E0.00414

G1 X92.830 Y78.476 E0.00240

G1 X92.718 Y78.500 E0.00299

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G1 X81.634 Y78.467 E0.00347

M204 S1250

G1 X81.610 Y78.282 F9000.000

G1 X82.205 Y77.783

G1 F2400.000

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G1 X82.691 Y77.715 E0.00492

G1 X91.816 Y77.712 E0.18299

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.171 Y77.713 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X92.594 Y70.937

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X89.328 Y70.826 E0.00890

G1 X88.553 Y70.509 E0.02182

G1 X88.164 Y70.398 E0.01054

G1 X87.764 Y70.321 E0.01062

G1 X87.439 Y70.289 E0.00849

G1 X86.892 Y70.298 E0.01427

G1 X86.054 Y70.468 E0.02227

G1 X85.382 Y70.719 E0.01870

G1 X85.100 Y70.855 E0.00816

G1 X84.722 Y70.935 E0.01006

G1 X81.904 Y70.946 E0.07343

G1 X81.892 Y70.245 E0.01828

G1 X92.598 Y70.210 E0.27895

G1 X92.595 Y70.877 E0.01739

M204 S1250

G1 X92.841 Y69.825 F9000.000

M204 S800

G1 F1500.000

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G1 X92.979 Y69.970 E0.00324

G1 X93.006 Y70.049 E0.00219

G1 X93.012 Y71.046 E0.02598

G1 X92.930 Y71.231 E0.00526

G1 X92.825 Y71.325 E0.00368

G1 X92.711 Y71.355 E0.00306

G1 X89.751 Y71.355 E0.07712

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G1 X89.180 Y71.217 E0.00760

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G1 X88.067 Y70.805 E0.00946

G1 X87.703 Y70.735 E0.00964

G1 X87.422 Y70.707 E0.00737

G1 X86.937 Y70.715 E0.01263

G1 X86.170 Y70.871 E0.02042

G1 X85.546 Y71.104 E0.01735

G1 X85.249 Y71.246 E0.00857

G1 X85.023 Y71.311 E0.00613

G1 X84.755 Y71.353 E0.00706

G1 X81.774 Y71.364 E0.07768

G1 X81.717 Y71.347 E0.00157

G1 X81.636 Y71.268 E0.00294

G1 X81.577 Y71.257 E0.00155

G1 X81.487 Y71.078 E0.00521

G1 X81.468 Y70.568 E0.01330

G1 X81.478 Y70.037 E0.01384

G1 X81.510 Y69.950 E0.00240

G1 X81.640 Y69.828 E0.00466

G1 X92.711 Y69.792 E0.28846

G1 X92.783 Y69.812 E0.00195

M204 S1250

G1 X92.850 Y69.902 F9000.000

G1 X92.387 Y70.574

G1 F2400.000

G1 X89.657 Y70.570 E0.05252

G1 X89.548 Y70.551 E0.00195

G1 X89.439 Y70.533 E0.00169

G1 X89.335 Y70.513 E0.00138

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G1 X89.126 Y70.472 E0.00087

G1 X89.022 Y70.452 E0.00061

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.126 Y70.472 E-0.05875

G1 E-0.90125 F4200.00000

G1 Z9.700 F9000.000

G1 X85.373 Y70.499

G1 Z9.500

G1 E3.20000 F2400.00000

G1 X84.695 Y70.586 E0.01097

G1 X82.238 Y70.594 E0.03940

G1 X82.097 Y70.459 E0.00313

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.238 Y70.594 E-0.10826

G1 X83.688 Y70.589 E-0.80374

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X81.885 Y65.081

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y64.743 E0.00881

G1 X82.369 Y64.430 E0.01503

G1 X82.639 Y64.353 E0.00733

G1 X87.660 Y64.328 E0.13081

G1 X91.904 Y64.352 E0.11060

G1 X92.144 Y64.445 E0.00669

G1 X92.587 Y64.736 E0.01381

G1 X92.594 Y65.084 E0.00908

G1 X81.945 Y65.081 E0.27745

M204 S1250

G1 X81.584 Y65.436 F9000.000

M204 S800

G1 F1500.000

G1 X81.505 Y65.304 E0.00402

G1 X81.468 Y65.154 E0.00401

G1 X81.466 Y64.682 E0.01230

G1 X81.481 Y64.596 E0.00230

G1 X81.553 Y64.474 E0.00369

G1 X82.194 Y64.045 E0.02008

G1 X82.580 Y63.935 E0.01045

G1 X87.661 Y63.910 E0.13239

G1 X91.867 Y63.927 E0.10961

G1 X92.007 Y63.944 E0.00366

G1 X92.336 Y64.071 E0.00920

G1 X92.875 Y64.426 E0.01682

G1 X92.967 Y64.530 E0.00361

G1 X93.002 Y64.607 E0.00220

G1 X93.013 Y65.168 E0.01464

G1 X92.979 Y65.281 E0.00308

G1 X92.900 Y65.419 E0.00414

G1 X92.830 Y65.478 E0.00240

G1 X92.718 Y65.502 E0.00299

G1 X81.764 Y65.499 E0.28540

G1 X81.634 Y65.470 E0.00347

M204 S1250

G1 X81.610 Y65.284 F9000.000

G1 X82.204 Y64.785

G1 F2400.000

G1 X82.448 Y64.751 E0.00438

G1 X82.691 Y64.717 E0.00493

G1 X91.816 Y64.714 E0.18298

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.170 Y64.715 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X92.594 Y57.939

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.654 Y57.928 E0.07660

G1 X89.328 Y57.828 E0.00891

G1 X88.552 Y57.512 E0.02181

G1 X88.164 Y57.401 E0.01053

G1 X87.764 Y57.323 E0.01061

G1 X87.440 Y57.291 E0.00850

G1 X86.892 Y57.300 E0.01428

G1 X86.054 Y57.470 E0.02228

G1 X85.382 Y57.721 E0.01870

G1 X85.100 Y57.857 E0.00816

G1 X84.721 Y57.938 E0.01009

G1 X81.904 Y57.948 E0.07340

G1 X81.892 Y57.247 E0.01828

G1 X92.598 Y57.212 E0.27895

G1 X92.595 Y57.879 E0.01739

M204 S1250

G1 X92.842 Y56.828 F9000.000

M204 S800

G1 F1500.000

G1 X92.905 Y56.872 E0.00202

G1 X92.979 Y56.972 E0.00323

G1 X93.006 Y57.051 E0.00219

G1 X93.012 Y58.048 E0.02599

G1 X92.930 Y58.233 E0.00525

G1 X92.825 Y58.327 E0.00368

G1 X92.711 Y58.357 E0.00306

G1 X89.752 Y58.357 E0.07712

G1 X89.594 Y58.342 E0.00412

G1 X89.455 Y58.315 E0.00369

G1 X89.180 Y58.219 E0.00761

G1 X88.416 Y57.907 E0.02150

G1 X88.067 Y57.807 E0.00946

G1 X87.704 Y57.737 E0.00963

G1 X87.422 Y57.709 E0.00737

G1 X86.937 Y57.717 E0.01263

G1 X86.170 Y57.873 E0.02042

G1 X85.546 Y58.106 E0.01735

G1 X85.249 Y58.248 E0.00857

G1 X85.023 Y58.314 E0.00614

G1 X84.755 Y58.356 E0.00707

G1 X81.774 Y58.366 E0.07767

G1 X81.717 Y58.349 E0.00157

G1 X81.636 Y58.270 E0.00294

G1 X81.577 Y58.259 E0.00155

G1 X81.487 Y58.080 E0.00521

G1 X81.468 Y57.570 E0.01330

G1 X81.478 Y57.039 E0.01384

G1 X81.510 Y56.952 E0.00241

G1 X81.640 Y56.830 E0.00466

G1 X92.710 Y56.794 E0.28844

G1 X92.783 Y56.814 E0.00198

M204 S1250

G1 X92.850 Y56.904 F9000.000

G1 X92.387 Y57.576

G1 F2400.000

G1 X89.657 Y57.572 E0.05252

G1 X89.548 Y57.553 E0.00195

G1 X89.438 Y57.535 E0.00170

G1 X89.334 Y57.515 E0.00138

G1 X89.230 Y57.495 E0.00112

G1 X89.126 Y57.474 E0.00087

G1 X89.022 Y57.454 E0.00061

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.126 Y57.474 E-0.05880

G1 E-0.90120 F4200.00000

G1 Z9.700 F9000.000

G1 X85.373 Y57.501

G1 Z9.500

G1 E3.20000 F2400.00000

G1 X84.693 Y57.588 E0.01102

G1 X82.238 Y57.596 E0.03945

G1 X82.097 Y57.461 E0.00314

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.238 Y57.596 E-0.10832

G1 X83.688 Y57.591 E-0.80368

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X81.885 Y52.083

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.884 Y51.745 E0.00879

G1 X82.369 Y51.432 E0.01504

G1 X82.639 Y51.355 E0.00732

G1 X87.659 Y51.330 E0.13081

G1 X91.906 Y51.355 E0.11064

G1 X92.144 Y51.446 E0.00665

G1 X92.587 Y51.739 E0.01383

G1 X92.594 Y52.087 E0.00907

G1 X81.945 Y52.083 E0.27745

M204 S1250

G1 X81.584 Y52.439 F9000.000

M204 S800

G1 F1500.000

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G1 X81.468 Y52.156 E0.00401

G1 X81.466 Y51.684 E0.01230

G1 X81.481 Y51.598 E0.00229

G1 X81.553 Y51.476 E0.00368

G1 X82.194 Y51.047 E0.02010

G1 X82.580 Y50.937 E0.01045

G1 X87.661 Y50.912 E0.13239

G1 X91.868 Y50.930 E0.10962

G1 X92.007 Y50.946 E0.00366

G1 X92.336 Y51.073 E0.00918

G1 X92.875 Y51.428 E0.01684

G1 X92.967 Y51.532 E0.00361

G1 X93.002 Y51.609 E0.00219

G1 X93.013 Y52.170 E0.01463

G1 X92.979 Y52.283 E0.00308

G1 X92.900 Y52.422 E0.00415

G1 X92.830 Y52.481 E0.00240

G1 X92.718 Y52.505 E0.00297

G1 X81.764 Y52.501 E0.28542

G1 X81.634 Y52.472 E0.00346

M204 S1250

G1 X81.610 Y52.286 F9000.000

G1 X82.205 Y51.787

G1 F2400.000

G1 X82.448 Y51.753 E0.00437

G1 X82.691 Y51.719 E0.00492

G1 X91.817 Y51.717 E0.18284

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.172 Y51.717 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.700 F9000.000

G1 X92.594 Y44.941

G1 Z9.500

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.654 Y44.930 E0.07660

G1 X89.328 Y44.830 E0.00891

G1 X88.552 Y44.514 E0.02181

G1 X88.164 Y44.403 E0.01053

G1 X87.764 Y44.325 E0.01061

G1 X87.440 Y44.293 E0.00850

G1 X86.892 Y44.302 E0.01428

G1 X86.054 Y44.473 E0.02227

G1 X85.382 Y44.723 E0.01869

G1 X85.100 Y44.859 E0.00816

G1 X84.721 Y44.940 E0.01009

G1 X81.904 Y44.950 E0.07340

G1 X81.892 Y44.248 E0.01829

G1 X92.598 Y44.214 E0.27895

G1 X92.595 Y44.881 E0.01740

M204 S1250

G1 X92.841 Y43.829 F9000.000

M204 S800

G1 F1500.000

G1 X92.905 Y43.875 E0.00204

G1 X92.979 Y43.974 E0.00322

G1 X93.006 Y44.053 E0.00218

G1 X93.012 Y45.050 E0.02599

G1 X92.930 Y45.235 E0.00525

G1 X92.825 Y45.329 E0.00369

G1 X92.711 Y45.359 E0.00306

G1 X89.752 Y45.359 E0.07712

G1 X89.594 Y45.344 E0.00412

G1 X89.455 Y45.317 E0.00369

G1 X89.180 Y45.221 E0.00761

G1 X88.416 Y44.909 E0.02150

G1 X88.067 Y44.809 E0.00946

G1 X87.704 Y44.739 E0.00963

G1 X87.422 Y44.711 E0.00737

G1 X86.937 Y44.719 E0.01263

G1 X86.170 Y44.876 E0.02042

G1 X85.546 Y45.108 E0.01734

G1 X85.249 Y45.250 E0.00857

G1 X85.023 Y45.316 E0.00614

G1 X84.755 Y45.358 E0.00707

G1 X81.774 Y45.368 E0.07767

G1 X81.717 Y45.351 E0.00157

G1 X81.636 Y45.272 E0.00294

G1 X81.577 Y45.261 E0.00155

G1 X81.487 Y45.082 E0.00521

G1 X81.468 Y44.572 E0.01330

G1 X81.478 Y44.041 E0.01384

G1 X81.510 Y43.955 E0.00240

G1 X81.640 Y43.832 E0.00466

G1 X92.710 Y43.796 E0.28844

G1 X92.783 Y43.816 E0.00197

M204 S1250

G1 X92.850 Y43.907 F9000.000

G1 X92.387 Y44.578

G1 F2400.000

G1 X89.657 Y44.572 E0.05264

G1 X89.548 Y44.553 E0.00198

G1 X89.439 Y44.535 E0.00173

G1 X89.331 Y44.514 E0.00146

G1 X89.224 Y44.493 E0.00119

G1 X89.116 Y44.472 E0.00091

G1 X89.009 Y44.451 E0.00064

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.116 Y44.472 E-0.06078

G1 E-0.89922 F4200.00000

G1 Z9.700 F9000.000

G1 X85.397 Y44.494

G1 Z9.500

G1 E3.20000 F2400.00000

G1 X84.693 Y44.584 E0.01193

G1 X82.239 Y44.597 E0.04120

G1 X82.097 Y44.462 E0.00330

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;9.65

G1 Z9.650 F9000.000

;AFTER\_LAYER\_CHANGE

;9.65

G1 E-3.20000 F4200.00000

G1 Z9.850 F9000.000

G1 X81.885 Y116.735

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.563 Y116.300 E0.02101

G1 X82.850 Y116.216 E0.00779

G1 X91.609 Y116.211 E0.22822

G1 X91.747 Y116.233 E0.00365

G1 X92.004 Y116.340 E0.00725

G1 X92.586 Y116.727 E0.01820

G1 X92.590 Y117.009 E0.00735

G1 X81.886 Y117.002 E0.27889

G1 X81.885 Y116.795 E0.00537

M204 S1250

G1 X81.514 Y117.252 F9000.000

M204 S800

G1 F1500.000

G1 X81.469 Y117.076 E0.00473

G1 X81.466 Y116.673 E0.01050

G1 X81.481 Y116.588 E0.00226

G1 X81.565 Y116.451 E0.00418

G1 X82.388 Y115.916 E0.02556

G1 X82.790 Y115.798 E0.01092

G1 X91.642 Y115.794 E0.23064

G1 X91.862 Y115.829 E0.00581

G1 X92.202 Y115.970 E0.00959

G1 X92.879 Y116.421 E0.02120

G1 X92.947 Y116.496 E0.00263

G1 X93.002 Y116.609 E0.00327

G1 X93.009 Y117.095 E0.01267

G1 X92.976 Y117.203 E0.00296

G1 X92.885 Y117.350 E0.00448

G1 X92.826 Y117.399 E0.00201

G1 X92.714 Y117.427 E0.00302

G1 X81.762 Y117.419 E0.28536

G1 X81.636 Y117.396 E0.00332

G1 X81.582 Y117.360 E0.00171

G1 X81.546 Y117.303 E0.00175

M204 S1250

G1 X81.623 Y117.107 F9000.000

G1 X82.342 Y116.690

G1 F2400.000

G1 X82.624 Y116.650 E0.00607

G1 X82.907 Y116.609 E0.00675

G1 X91.578 Y116.610 E0.20516

G1 X92.094 Y116.651 E0.01225

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.578 Y116.610 E-0.28680

G1 X90.450 Y116.610 E-0.62520

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X86.890 Y109.292

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.054 Y109.462 E0.02223

G1 X85.370 Y109.717 E0.01902

G1 X84.893 Y109.947 E0.01379

G1 X84.537 Y110.037 E0.00956

G1 X81.903 Y110.060 E0.06865

G1 X81.887 Y109.308 E0.01961

G1 X86.830 Y109.293 E0.12880

M204 S1250

G1 X87.524 Y109.290 F9000.000

M204 S800

G1 F1500.000

G1 X92.590 Y109.275 E0.13199

G1 X92.592 Y110.067 E0.02066

G1 X89.943 Y110.048 E0.06903

G1 X89.811 Y110.022 E0.00350

G1 X89.556 Y109.927 E0.00709

G1 X88.538 Y109.498 E0.02879

G1 X88.160 Y109.391 E0.01024

G1 X87.584 Y109.296 E0.01521

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.229 Y109.289 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X81.519 Y109.002

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.639 Y108.891 E0.00425

G1 X92.710 Y108.856 E0.28848

G1 X92.848 Y108.887 E0.00367

G1 X92.900 Y108.920 E0.00160

G1 X92.976 Y109.046 E0.00384

G1 X93.007 Y109.143 E0.00265

G1 X93.011 Y110.152 E0.02630

G1 X92.933 Y110.337 E0.00521

G1 X92.813 Y110.450 E0.00432

G1 X92.705 Y110.486 E0.00295

G1 X89.902 Y110.465 E0.07305

G1 X89.698 Y110.426 E0.00540

G1 X88.399 Y109.893 E0.03659

G1 X88.064 Y109.798 E0.00909

G1 X87.680 Y109.725 E0.01018

G1 X87.410 Y109.699 E0.00708

G1 X86.943 Y109.708 E0.01216

G1 X86.169 Y109.865 E0.02057

G1 X85.534 Y110.102 E0.01767

G1 X85.036 Y110.341 E0.01439

G1 X84.592 Y110.454 E0.01196

G1 X81.778 Y110.479 E0.07331

G1 X81.647 Y110.433 E0.00362

G1 X81.587 Y110.379 E0.00211

G1 X81.487 Y110.177 E0.00587

G1 X81.466 Y109.195 E0.02559

G1 X81.495 Y109.057 E0.00367

M204 S1250

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G1 X82.104 Y109.683

G1 F2400.000

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G1 X85.168 Y109.583 E0.01211

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.490 Y109.669 E-0.37886

G1 X83.528 Y109.674 E-0.53314

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X89.171 Y109.527

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X89.542 Y109.593 E0.00686

G1 X89.981 Y109.665 E0.00964

G1 X92.382 Y109.671 E0.05553

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y109.667 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X92.590 Y104.011

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y104.004 E0.27889

G1 X81.885 Y103.737 E0.00693

G1 X82.563 Y103.302 E0.02101

G1 X82.850 Y103.218 E0.00779

G1 X91.608 Y103.213 E0.22820

G1 X91.747 Y103.236 E0.00366

G1 X92.005 Y103.343 E0.00726

G1 X92.586 Y103.729 E0.01819

G1 X92.589 Y103.951 E0.00579

M204 S1250

G1 X92.885 Y104.352 F9000.000

M204 S800

G1 F1500.000

G1 X92.827 Y104.401 E0.00200

G1 X92.714 Y104.429 E0.00303

G1 X81.762 Y104.421 E0.28536

G1 X81.636 Y104.398 E0.00332

G1 X81.582 Y104.362 E0.00171

G1 X81.514 Y104.254 E0.00331

G1 X81.469 Y104.078 E0.00473

G1 X81.466 Y103.675 E0.01050

G1 X81.481 Y103.591 E0.00225

G1 X81.603 Y103.421 E0.00543

G1 X82.388 Y102.918 E0.02429

G1 X82.790 Y102.800 E0.01092

G1 X91.641 Y102.796 E0.23063

G1 X91.862 Y102.831 E0.00582

G1 X92.202 Y102.972 E0.00960

G1 X92.879 Y103.423 E0.02119

G1 X92.947 Y103.498 E0.00263

G1 X93.002 Y103.611 E0.00327

G1 X93.009 Y104.097 E0.01267

G1 X92.976 Y104.206 E0.00297

G1 X92.917 Y104.301 E0.00291

M204 S1250

G1 X92.810 Y104.336 F9000.000

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G1 F2400.000

G1 X91.576 Y103.612 E0.01231

G1 X82.907 Y103.611 E0.20513

G1 X82.624 Y103.652 E0.00675

G1 X82.342 Y103.692 E0.00607

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.624 Y103.652 E-0.15809

G1 E-0.80191 F4200.00000

G1 Z9.850 F9000.000

G1 X81.903 Y97.062

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y96.310 E0.01961

G1 X86.888 Y96.295 E0.13030

G1 X86.054 Y96.464 E0.02218

G1 X85.370 Y96.720 E0.01902

G1 X84.893 Y96.949 E0.01379

G1 X84.537 Y97.040 E0.00956

G1 X81.963 Y97.062 E0.06708

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X82.777 Y96.307 E-0.49326

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X87.522 Y96.293

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X89.944 Y97.050 E0.06901

G1 X89.812 Y97.024 E0.00351

G1 X89.556 Y96.930 E0.00711

G1 X88.538 Y96.500 E0.02879

G1 X88.160 Y96.393 E0.01025

G1 X87.582 Y96.298 E0.01527

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.227 Y96.292 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X81.519 Y96.004

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

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G1 X92.900 Y95.922 E0.00158

G1 X92.976 Y96.048 E0.00383

G1 X93.007 Y96.145 E0.00267

G1 X93.011 Y97.154 E0.02629

G1 X92.933 Y97.339 E0.00523

G1 X92.813 Y97.453 E0.00430

G1 X92.706 Y97.488 E0.00295

G1 X89.902 Y97.468 E0.07305

G1 X89.699 Y97.428 E0.00540

G1 X88.399 Y96.895 E0.03659

G1 X88.064 Y96.800 E0.00909

G1 X87.680 Y96.727 E0.01019

G1 X87.409 Y96.702 E0.00707

G1 X86.943 Y96.710 E0.01215

G1 X86.169 Y96.867 E0.02058

G1 X85.534 Y97.105 E0.01767

G1 X85.036 Y97.344 E0.01438

G1 X84.591 Y97.457 E0.01196

G1 X81.778 Y97.481 E0.07330

G1 X81.647 Y97.435 E0.00362

G1 X81.587 Y97.381 E0.00211

G1 X81.487 Y97.179 E0.00586

G1 X81.466 Y96.197 E0.02560

G1 X81.495 Y96.059 E0.00367

M204 S1250

G1 X81.682 Y96.009 F9000.000

G1 X82.104 Y96.685

G1 F2400.000

G1 X84.489 Y96.671 E0.04230

G1 X85.169 Y96.585 E0.01215

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.489 Y96.671 E-0.37965

G1 X83.529 Y96.677 E-0.53235

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X89.172 Y96.530

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X89.543 Y96.596 E0.00684

G1 X89.982 Y96.668 E0.00965

G1 X92.382 Y96.673 E0.05538

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y96.670 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X92.590 Y91.013

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y91.006 E0.27889

G1 X81.885 Y90.740 E0.00693

G1 X82.563 Y90.304 E0.02101

G1 X82.850 Y90.220 E0.00779

G1 X91.609 Y90.216 E0.22822

G1 X91.748 Y90.238 E0.00366

G1 X92.005 Y90.345 E0.00724

G1 X92.586 Y90.731 E0.01819

G1 X92.589 Y90.953 E0.00579

M204 S1250

G1 X92.885 Y91.354 F9000.000

M204 S800

G1 F1500.000

G1 X92.827 Y91.403 E0.00200

G1 X92.714 Y91.431 E0.00303

G1 X81.762 Y91.423 E0.28536

G1 X81.636 Y91.400 E0.00332

G1 X81.582 Y91.364 E0.00172

G1 X81.514 Y91.257 E0.00329

G1 X81.469 Y91.081 E0.00474

G1 X81.466 Y90.677 E0.01051

G1 X81.481 Y90.593 E0.00225

G1 X81.603 Y90.424 E0.00542

G1 X82.388 Y89.920 E0.02430

G1 X82.790 Y89.802 E0.01092

G1 X91.642 Y89.798 E0.23064

G1 X91.862 Y89.833 E0.00582

G1 X92.202 Y89.974 E0.00959

G1 X92.879 Y90.425 E0.02119

G1 X92.947 Y90.500 E0.00263

G1 X93.002 Y90.613 E0.00327

G1 X93.009 Y91.099 E0.01267

G1 X92.976 Y91.208 E0.00297

G1 X92.917 Y91.303 E0.00291

M204 S1250

G1 X92.810 Y91.338 F9000.000

G1 X92.094 Y90.655

G1 F2400.000

G1 X91.578 Y90.614 E0.01225

G1 X82.907 Y90.613 E0.20480

G1 X82.624 Y90.654 E0.00673

G1 X82.342 Y90.694 E0.00607

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.624 Y90.654 E-0.15801

G1 E-0.80199 F4200.00000

G1 Z9.850 F9000.000

G1 X81.903 Y84.065

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y83.312 E0.01963

G1 X86.888 Y83.297 E0.13030

G1 X86.054 Y83.466 E0.02218

G1 X85.370 Y83.722 E0.01903

G1 X84.893 Y83.952 E0.01378

G1 X84.538 Y84.042 E0.00955

G1 X81.963 Y84.065 E0.06709

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X82.776 Y83.309 E-0.49284

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X87.522 Y83.295

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y83.280 E0.13204

G1 X92.592 Y84.072 E0.02064

G1 X89.945 Y84.053 E0.06899

G1 X89.812 Y84.027 E0.00351

G1 X89.556 Y83.932 E0.00712

G1 X88.538 Y83.502 E0.02879

G1 X88.160 Y83.395 E0.01025

G1 X87.582 Y83.300 E0.01527

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.227 Y83.294 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X81.519 Y83.006

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.639 Y82.895 E0.00425

G1 X92.711 Y82.861 E0.28849

G1 X92.848 Y82.892 E0.00367

G1 X92.900 Y82.924 E0.00158

G1 X92.976 Y83.050 E0.00384

G1 X93.007 Y83.148 E0.00267

G1 X93.011 Y84.156 E0.02628

G1 X92.933 Y84.341 E0.00523

G1 X92.813 Y84.455 E0.00430

G1 X92.706 Y84.490 E0.00295

G1 X89.902 Y84.470 E0.07305

G1 X89.699 Y84.430 E0.00540

G1 X88.399 Y83.897 E0.03659

G1 X88.064 Y83.802 E0.00909

G1 X87.680 Y83.729 E0.01019

G1 X87.409 Y83.704 E0.00707

G1 X86.943 Y83.712 E0.01215

G1 X86.169 Y83.869 E0.02058

G1 X85.534 Y84.107 E0.01767

G1 X85.036 Y84.346 E0.01438

G1 X84.592 Y84.459 E0.01195

G1 X81.778 Y84.484 E0.07331

G1 X81.647 Y84.438 E0.00361

G1 X81.587 Y84.383 E0.00213

G1 X81.487 Y84.182 E0.00586

G1 X81.466 Y83.200 E0.02559

G1 X81.495 Y83.061 E0.00370

M204 S1250

G1 X81.682 Y83.011 F9000.000

G1 X82.104 Y83.687

G1 F2400.000

G1 X84.490 Y83.673 E0.04235

G1 X85.168 Y83.587 E0.01213

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.490 Y83.673 E-0.37867

G1 X83.528 Y83.679 E-0.53333

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X89.172 Y83.532

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X89.543 Y83.598 E0.00685

G1 X89.983 Y83.670 E0.00966

G1 X92.382 Y83.675 E0.05537

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y83.672 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X92.590 Y78.015

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y78.008 E0.27889

G1 X81.885 Y77.754 E0.00662

G1 X82.546 Y77.316 E0.02067

G1 X82.854 Y77.222 E0.00839

G1 X91.603 Y77.218 E0.22796

G1 X91.714 Y77.238 E0.00294

G1 X92.012 Y77.352 E0.00831

G1 X92.586 Y77.733 E0.01795

G1 X92.589 Y77.955 E0.00579

M204 S1250

G1 X92.975 Y77.538 F9000.000

M204 S800

G1 F1500.000

G1 X93.002 Y77.605 E0.00189

G1 X93.009 Y78.101 E0.01291

G1 X92.973 Y78.220 E0.00324

G1 X92.895 Y78.348 E0.00390

G1 X92.826 Y78.405 E0.00234

G1 X92.714 Y78.433 E0.00302

G1 X81.762 Y78.425 E0.28537

G1 X81.636 Y78.402 E0.00332

G1 X81.582 Y78.366 E0.00172

G1 X81.514 Y78.259 E0.00329

G1 X81.469 Y78.083 E0.00474

G1 X81.466 Y77.679 E0.01051

G1 X81.481 Y77.595 E0.00224

G1 X81.559 Y77.468 E0.00386

G1 X82.366 Y76.934 E0.02522

G1 X82.791 Y76.804 E0.01159

G1 X91.640 Y76.800 E0.23055

G1 X91.826 Y76.833 E0.00494

G1 X92.205 Y76.978 E0.01056

G1 X92.878 Y77.426 E0.02106

G1 X92.936 Y77.493 E0.00231

M204 S1250

G1 X92.941 Y77.602 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.002 Y77.605 E-0.07243

G1 X93.009 Y78.101 E-0.27452

G1 X92.973 Y78.220 E-0.06894

G1 X92.895 Y78.348 E-0.08286

G1 X92.826 Y78.405 E-0.04980

G1 X92.714 Y78.433 E-0.06430

G1 X92.174 Y78.433 E-0.29915

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X82.345 Y77.700

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X82.913 Y77.615 E0.01172

G1 X91.568 Y77.616 E0.17650

G1 X92.204 Y77.730 E0.01318

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.568 Y77.616 E-0.35805

G1 X90.568 Y77.616 E-0.55395

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X86.889 Y70.299

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.054 Y70.468 E0.02220

G1 X85.370 Y70.724 E0.01903

G1 X84.893 Y70.954 E0.01378

G1 X84.538 Y71.044 E0.00955

G1 X81.903 Y71.067 E0.06866

G1 X81.887 Y70.314 E0.01963

G1 X86.829 Y70.299 E0.12877

M204 S1250

G1 X87.520 Y70.297 F9000.000

M204 S800

G1 F1500.000

G1 X92.590 Y70.282 E0.13209

G1 X92.592 Y71.074 E0.02066

G1 X89.944 Y71.055 E0.06900

G1 X89.812 Y71.029 E0.00352

G1 X89.556 Y70.934 E0.00711

G1 X88.538 Y70.505 E0.02877

G1 X88.160 Y70.397 E0.01026

G1 X87.580 Y70.303 E0.01531

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.225 Y70.296 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X81.519 Y70.008

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.639 Y69.897 E0.00427

G1 X92.711 Y69.863 E0.28848

G1 X92.848 Y69.894 E0.00367

G1 X92.899 Y69.926 E0.00157

G1 X92.976 Y70.053 E0.00386

G1 X93.007 Y70.150 E0.00266

G1 X93.011 Y71.158 E0.02628

G1 X92.933 Y71.344 E0.00523

G1 X92.813 Y71.457 E0.00431

G1 X92.705 Y71.493 E0.00296

G1 X89.902 Y71.472 E0.07304

G1 X89.699 Y71.432 E0.00541

G1 X88.399 Y70.900 E0.03658

G1 X88.064 Y70.804 E0.00910

G1 X87.680 Y70.732 E0.01018

G1 X87.410 Y70.706 E0.00707

G1 X86.943 Y70.714 E0.01216

G1 X86.169 Y70.871 E0.02057

G1 X85.534 Y71.109 E0.01768

G1 X85.036 Y71.348 E0.01438

G1 X84.592 Y71.461 E0.01195

G1 X81.778 Y71.486 E0.07331

G1 X81.647 Y71.440 E0.00361

G1 X81.587 Y71.385 E0.00213

G1 X81.487 Y71.184 E0.00586

M73 P83 R11

G1 X81.466 Y70.202 E0.02559

G1 X81.495 Y70.064 E0.00368

M204 S1250

G1 X81.683 Y70.014 F9000.000

G1 X82.104 Y70.689

G1 F2400.000

G1 X84.490 Y70.675 E0.04235

G1 X85.168 Y70.589 E0.01213

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.490 Y70.675 E-0.37866

G1 X83.528 Y70.681 E-0.53334

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X89.171 Y70.534

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X89.542 Y70.600 E0.00686

G1 X89.983 Y70.672 E0.00968

G1 X92.382 Y70.678 E0.05550

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y70.674 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X92.590 Y65.017

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y65.010 E0.27889

G1 X81.885 Y64.756 E0.00663

G1 X82.546 Y64.318 E0.02067

G1 X82.854 Y64.224 E0.00839

G1 X91.603 Y64.220 E0.22797

G1 X91.714 Y64.240 E0.00293

G1 X92.012 Y64.354 E0.00832

G1 X92.586 Y64.736 E0.01796

G1 X92.589 Y64.957 E0.00578

M204 S1250

G1 X92.975 Y64.540 F9000.000

M204 S800

G1 F1500.000

G1 X93.002 Y64.608 E0.00191

G1 X93.009 Y65.095 E0.01269

G1 X92.895 Y65.350 E0.00726

G1 X92.826 Y65.407 E0.00234

G1 X92.714 Y65.435 E0.00302

G1 X81.761 Y65.428 E0.28537

G1 X81.637 Y65.405 E0.00330

G1 X81.582 Y65.368 E0.00172

G1 X81.514 Y65.261 E0.00330

G1 X81.469 Y65.085 E0.00474

G1 X81.466 Y64.682 E0.01049

G1 X81.481 Y64.597 E0.00227

G1 X81.559 Y64.470 E0.00386

G1 X82.366 Y63.936 E0.02522

G1 X82.791 Y63.806 E0.01159

G1 X91.640 Y63.802 E0.23055

G1 X91.826 Y63.835 E0.00494

G1 X92.205 Y63.981 E0.01056

G1 X92.878 Y64.428 E0.02107

G1 X92.936 Y64.495 E0.00229

M204 S1250

G1 X92.941 Y64.605 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.002 Y64.608 E-0.07285

G1 X93.009 Y65.095 E-0.26999

G1 X92.895 Y65.350 E-0.15440

G1 X92.826 Y65.407 E-0.04980

G1 X92.714 Y65.435 E-0.06430

G1 X92.171 Y65.435 E-0.30066

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X82.344 Y64.702

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X82.913 Y64.617 E0.01173

G1 X91.568 Y64.618 E0.17650

G1 X92.204 Y64.733 E0.01317

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.568 Y64.618 E-0.35800

G1 X90.568 Y64.618 E-0.55400

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X92.592 Y58.076

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X89.944 Y58.057 E0.06900

G1 X89.812 Y58.031 E0.00352

G1 X89.556 Y57.936 E0.00711

G1 X88.538 Y57.507 E0.02877

G1 X88.160 Y57.400 E0.01024

G1 X87.739 Y57.320 E0.01116

G1 X87.519 Y57.299 E0.00575

G1 X92.590 Y57.284 E0.13211

G1 X92.592 Y58.016 E0.01910

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.947 Y58.041 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X86.889 Y57.301

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.054 Y57.470 E0.02220

G1 X85.370 Y57.726 E0.01903

G1 X84.893 Y57.956 E0.01379

G1 X84.537 Y58.046 E0.00955

G1 X81.903 Y58.069 E0.06865

G1 X81.887 Y57.316 E0.01963

G1 X86.829 Y57.301 E0.12877

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.054 Y57.470 E-0.43964

G1 X85.370 Y57.726 E-0.40469

G1 X85.260 Y57.779 E-0.06767

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X81.519 Y57.010

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.639 Y56.899 E0.00426

G1 X92.710 Y56.865 E0.28847

G1 X92.848 Y56.896 E0.00369

G1 X92.899 Y56.928 E0.00157

G1 X92.976 Y57.055 E0.00386

G1 X93.007 Y57.152 E0.00266

G1 X93.011 Y58.161 E0.02629

G1 X92.933 Y58.346 E0.00523

G1 X92.813 Y58.459 E0.00431

G1 X92.705 Y58.495 E0.00295

G1 X89.902 Y58.474 E0.07304

G1 X89.699 Y58.434 E0.00541

G1 X88.399 Y57.902 E0.03658

G1 X88.064 Y57.807 E0.00909

G1 X87.680 Y57.734 E0.01018

G1 X87.410 Y57.708 E0.00708

G1 X86.943 Y57.716 E0.01216

G1 X86.169 Y57.873 E0.02057

G1 X85.534 Y58.111 E0.01768

G1 X85.036 Y58.350 E0.01439

G1 X84.592 Y58.463 E0.01195

G1 X81.778 Y58.488 E0.07330

G1 X81.647 Y58.442 E0.00362

G1 X81.587 Y58.387 E0.00213

G1 X81.487 Y58.186 E0.00586

G1 X81.466 Y57.204 E0.02559

G1 X81.495 Y57.065 E0.00368

M204 S1250

G1 X81.682 Y57.016 F9000.000

G1 X82.104 Y57.691

G1 F2400.000

G1 X84.490 Y57.677 E0.04238

G1 X85.168 Y57.591 E0.01215

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.490 Y57.677 E-0.37906

G1 X83.528 Y57.683 E-0.53294

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X89.170 Y57.536

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X89.542 Y57.602 E0.00686

G1 X89.983 Y57.674 E0.00969

G1 X92.382 Y57.680 E0.05550

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.736 Y57.676 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X92.590 Y52.020

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y52.012 E0.27889

G1 X81.885 Y51.746 E0.00692

G1 X82.564 Y51.311 E0.02102

G1 X82.850 Y51.226 E0.00779

G1 X91.609 Y51.222 E0.22821

G1 X91.747 Y51.244 E0.00365

G1 X92.004 Y51.351 E0.00725

G1 X92.586 Y51.738 E0.01820

G1 X92.589 Y51.960 E0.00579

M204 S1250

G1 X92.885 Y52.360 F9000.000

M204 S800

G1 F1500.000

G1 X92.826 Y52.410 E0.00201

G1 X92.714 Y52.438 E0.00302

G1 X81.761 Y52.430 E0.28537

G1 X81.636 Y52.407 E0.00331

G1 X81.582 Y52.371 E0.00170

G1 X81.514 Y52.263 E0.00331

G1 X81.469 Y52.087 E0.00475

G1 X81.466 Y51.684 E0.01049

G1 X81.481 Y51.599 E0.00226

G1 X81.603 Y51.430 E0.00541

G1 X82.388 Y50.927 E0.02429

G1 X82.790 Y50.808 E0.01092

G1 X91.642 Y50.805 E0.23064

G1 X91.862 Y50.840 E0.00581

G1 X92.202 Y50.981 E0.00959

G1 X92.879 Y51.432 E0.02120

G1 X92.947 Y51.507 E0.00263

G1 X93.002 Y51.620 E0.00327

G1 X93.009 Y52.106 E0.01266

G1 X92.976 Y52.214 E0.00295

G1 X92.917 Y52.309 E0.00293

M204 S1250

G1 X92.809 Y52.344 F9000.000

G1 X92.094 Y51.662

G1 F2400.000

G1 X91.578 Y51.621 E0.01224

G1 X82.907 Y51.619 E0.20506

G1 X82.625 Y51.660 E0.00675

G1 X82.342 Y51.701 E0.00608

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.625 Y51.660 E-0.15820

G1 E-0.80180 F4200.00000

G1 Z9.850 F9000.000

G1 X87.524 Y44.301

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y44.286 E0.13198

G1 X92.592 Y45.078 E0.02066

G1 X89.944 Y45.059 E0.06900

G1 X89.812 Y45.033 E0.00352

G1 X89.556 Y44.938 E0.00711

G1 X88.538 Y44.509 E0.02877

G1 X88.160 Y44.402 E0.01024

G1 X87.584 Y44.307 E0.01521

M204 S1250

G1 X86.886 Y44.303 F9000.000

M204 S800

G1 F1500.000

G1 X86.054 Y44.473 E0.02213

G1 X85.370 Y44.728 E0.01902

G1 X84.893 Y44.958 E0.01380

G1 X84.537 Y45.048 E0.00955

G1 X81.903 Y45.071 E0.06865

G1 X81.887 Y44.319 E0.01961

G1 X86.826 Y44.304 E0.12870

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.054 Y44.473 E-0.43811

G1 X85.370 Y44.728 E-0.40444

G1 X85.257 Y44.782 E-0.06945

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X81.519 Y44.013

G1 Z9.650

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.639 Y43.902 E0.00425

G1 X92.710 Y43.867 E0.28848

G1 X92.848 Y43.898 E0.00367

G1 X92.899 Y43.930 E0.00159

G1 X92.976 Y44.057 E0.00385

G1 X93.007 Y44.154 E0.00265

G1 X93.011 Y45.163 E0.02629

G1 X92.933 Y45.348 E0.00522

G1 X92.813 Y45.461 E0.00432

G1 X92.705 Y45.497 E0.00295

G1 X89.902 Y45.476 E0.07304

G1 X89.699 Y45.436 E0.00541

G1 X88.399 Y44.904 E0.03658

G1 X88.064 Y44.809 E0.00909

G1 X87.680 Y44.736 E0.01018

G1 X87.410 Y44.710 E0.00708

G1 X86.943 Y44.718 E0.01217

G1 X86.169 Y44.876 E0.02057

G1 X85.534 Y45.113 E0.01767

G1 X85.036 Y45.352 E0.01439

G1 X84.592 Y45.465 E0.01195

G1 X81.778 Y45.490 E0.07330

G1 X81.647 Y45.444 E0.00362

G1 X81.587 Y45.389 E0.00213

G1 X81.487 Y45.188 E0.00586

G1 X81.466 Y44.206 E0.02559

G1 X81.495 Y44.068 E0.00367

M204 S1250

G1 X81.682 Y44.018 F9000.000

G1 X82.104 Y44.694

G1 F2400.000

G1 X84.490 Y44.680 E0.04227

G1 X85.167 Y44.594 E0.01210

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.490 Y44.680 E-0.37849

G1 X83.527 Y44.685 E-0.53351

G1 E-0.04800 F4200.00000

G1 Z9.850 F9000.000

G1 X89.171 Y44.538

G1 Z9.650

G1 E3.20000 F2400.00000

G1 X89.542 Y44.604 E0.00685

G1 X89.983 Y44.676 E0.00967

G1 X92.382 Y44.682 E0.05549

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;9.8

G1 Z9.800 F9000.000

;AFTER\_LAYER\_CHANGE

;9.8

G1 E-3.20000 F4200.00000

G1 Z10.000 F9000.000

G1 X92.586 Y116.728

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.587 Y116.930 E0.00527

G1 X81.887 Y116.930 E0.27879

G1 X81.885 Y116.742 E0.00491

G1 X82.731 Y116.190 E0.02633

G1 X83.102 Y116.061 E0.01021

G1 X91.379 Y116.084 E0.21566

G1 X91.590 Y116.121 E0.00560

G1 X91.817 Y116.219 E0.00643

G1 X92.536 Y116.695 E0.02247

M204 S1250

G1 X92.990 Y116.550 F9000.000

M204 S800

G1 F1500.000

G1 X93.006 Y117.020 E0.01225

G1 X92.936 Y117.208 E0.00522

G1 X92.877 Y117.283 E0.00248

G1 X92.828 Y117.323 E0.00165

G1 X92.716 Y117.348 E0.00299

G1 X81.764 Y117.348 E0.28538

G1 X81.660 Y117.327 E0.00275

G1 X81.517 Y117.187 E0.00523

G1 X81.470 Y117.007 E0.00484

G1 X81.466 Y116.673 E0.00870

G1 X81.482 Y116.589 E0.00224

G1 X81.571 Y116.448 E0.00433

G1 X82.541 Y115.815 E0.03019

G1 X82.873 Y115.689 E0.00925

G1 X83.049 Y115.643 E0.00475

G1 X91.416 Y115.666 E0.21800

G1 X91.711 Y115.718 E0.00781

G1 X92.016 Y115.850 E0.00867

G1 X92.881 Y116.423 E0.02704

G1 X92.951 Y116.505 E0.00281

M204 S1250

G1 X92.730 Y116.854 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.006 Y117.020 E-0.28731

G1 X92.936 Y117.208 E-0.11102

G1 X92.877 Y117.283 E-0.05278

G1 X92.828 Y117.323 E-0.03500

G1 X92.716 Y117.348 E-0.06365

G1 X92.063 Y117.348 E-0.36224

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X83.304 Y116.805

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.943 Y116.444 E0.01412

G1 X83.141 Y116.374 E0.00580

G1 X83.503 Y116.377 E0.01003

G1 X83.744 Y116.617 E0.00940

G1 X84.371 Y116.617 E0.01736

G1 X84.135 Y116.381 E0.00924

G1 X84.767 Y116.385 E0.01748

G1 X84.999 Y116.617 E0.00908

G1 X85.626 Y116.617 E0.01736

G1 X85.396 Y116.387 E0.00901

G1 X86.025 Y116.388 E0.01739

G1 X86.254 Y116.617 E0.00897

G1 X86.881 Y116.617 E0.01736

G1 X86.653 Y116.389 E0.00893

G1 X87.282 Y116.390 E0.01739

G1 X87.509 Y116.617 E0.00889

G1 X88.136 Y116.617 E0.01736

G1 X87.910 Y116.391 E0.00885

G1 X88.539 Y116.392 E0.01739

G1 X88.764 Y116.617 E0.00880

G1 X89.391 Y116.617 E0.01736

G1 X89.168 Y116.393 E0.00876

G1 X89.796 Y116.394 E0.01739

G1 X90.019 Y116.617 E0.00872

G1 X90.647 Y116.617 E0.01736

G1 X90.425 Y116.395 E0.00868

G1 X91.053 Y116.396 E0.01739

G1 X91.462 Y116.805 E0.01600

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.053 Y116.396 E-0.32035

G1 X90.425 Y116.395 E-0.34834

G1 X90.647 Y116.617 E-0.17383

G1 X90.521 Y116.617 E-0.06947

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X86.469 Y109.364

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.043 Y109.466 E0.01143

G1 X85.358 Y109.723 E0.01905

G1 X84.643 Y110.066 E0.02067

G1 X84.501 Y110.120 E0.00395

G1 X84.226 Y110.182 E0.00735

G1 X81.898 Y110.204 E0.06067

G1 X81.886 Y109.386 E0.02130

G1 X86.409 Y109.365 E0.11786

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.043 Y109.466 E-0.21072

G1 X85.358 Y109.723 E-0.40527

G1 X84.876 Y109.954 E-0.29601

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X87.965 Y109.354

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.583 Y109.352 E0.12032

G1 X92.597 Y109.387 E0.00098

G1 X92.593 Y110.176 E0.02055

G1 X92.581 Y110.206 E0.00085

G1 X90.329 Y110.197 E0.05870

G1 X90.152 Y110.175 E0.00463

G1 X89.989 Y110.097 E0.00471

G1 X89.790 Y110.041 E0.00537

G1 X89.470 Y109.881 E0.00933

G1 X88.517 Y109.491 E0.02683

G1 X88.024 Y109.365 E0.01326

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.669 Y109.361 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X92.842 Y108.954

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.882 Y108.981 E0.00124

G1 X93.015 Y109.306 E0.00915

G1 X93.010 Y110.252 E0.02466

G1 X92.932 Y110.462 E0.00585

G1 X92.812 Y110.582 E0.00441

G1 X92.700 Y110.625 E0.00313

G1 X90.302 Y110.614 E0.06249

G1 X90.078 Y110.587 E0.00589

G1 X89.942 Y110.554 E0.00365

G1 X89.823 Y110.485 E0.00357

G1 X89.639 Y110.432 E0.00500

G1 X89.297 Y110.262 E0.00995

G1 X88.381 Y109.887 E0.02581

G1 X88.061 Y109.797 E0.00865

G1 X87.656 Y109.722 E0.01072

G1 X87.397 Y109.698 E0.00678

G1 X86.953 Y109.707 E0.01158

G1 X86.569 Y109.770 E0.01013

G1 X86.165 Y109.866 E0.01082

G1 X85.522 Y110.107 E0.01789

G1 X84.808 Y110.451 E0.02063

G1 X84.622 Y110.522 E0.00519

G1 X84.276 Y110.599 E0.00923

G1 X81.789 Y110.622 E0.06482

G1 X81.607 Y110.541 E0.00520

G1 X81.489 Y110.336 E0.00615

G1 X81.481 Y110.288 E0.00125

G1 X81.467 Y109.290 E0.02601

G1 X81.523 Y109.067 E0.00599

G1 X81.626 Y108.969 E0.00371

G1 X84.998 Y108.966 E0.08785

G1 X87.176 Y108.937 E0.05677

G1 X92.783 Y108.943 E0.14609

M204 S1250

G1 X92.848 Y109.001 F9000.000

G1 X92.049 Y110.079

M204 S1000

G1 F4800.000

G1 X91.637 Y109.666 E0.01824

G1 X90.928 Y109.666 E0.02216

G1 X91.149 Y109.887 E0.00975

G1 X90.437 Y109.884 E0.02226

G1 X90.220 Y109.668 E0.00956

M204 S1250

G1 X89.434 Y109.641 F9000.000

G1 F2400.000

G1 X90.085 Y109.732 E0.01219

G1 X90.085 Y109.738 F9000.000

G1 F2400.000

G1 X89.467 Y109.607 E0.00534

G1 X89.353 Y109.584 E0.00068

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.467 Y109.607 E-0.06447

G1 E-0.89553 F4200.00000

G1 Z10.000 F9000.000

G1 X87.757 Y109.333

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X87.179 Y109.320 E0.01293

G1 X86.677 Y109.345 E0.01124

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.179 Y109.320 E-0.27835

G1 X87.757 Y109.333 E-0.32036

G1 E-0.36129 F4200.00000

G1 Z10.000 F9000.000

G1 X85.052 Y109.638

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X84.178 Y109.783 E0.01843

G1 X82.101 Y109.795 E0.04320

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y109.786 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.887 Y103.932

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y103.744 E0.00491

G1 X82.731 Y103.192 E0.02633

G1 X83.102 Y103.063 E0.01021

G1 X91.378 Y103.086 E0.21564

G1 X91.590 Y103.124 E0.00562

G1 X91.817 Y103.221 E0.00644

G1 X92.586 Y103.730 E0.02402

G1 X92.587 Y103.932 E0.00527

G1 X81.947 Y103.932 E0.27723

M204 S1250

G1 X81.660 Y104.329 F9000.000

M204 S800

G1 F1500.000

G1 X81.517 Y104.189 E0.00523

G1 X81.470 Y104.009 E0.00484

G1 X81.466 Y103.675 E0.00869

G1 X81.482 Y103.591 E0.00222

G1 X81.571 Y103.450 E0.00435

G1 X82.541 Y102.817 E0.03018

G1 X82.873 Y102.691 E0.00925

G1 X83.049 Y102.645 E0.00475

G1 X91.415 Y102.668 E0.21799

G1 X91.711 Y102.721 E0.00782

G1 X92.017 Y102.852 E0.00867

G1 X92.881 Y103.425 E0.02703

G1 X92.990 Y103.552 E0.00437

G1 X93.003 Y103.604 E0.00138

G1 X93.006 Y104.022 E0.01091

G1 X92.936 Y104.210 E0.00523

G1 X92.829 Y104.325 E0.00409

G1 X92.716 Y104.350 E0.00300

G1 X81.719 Y104.341 E0.28655

M204 S1250

G1 X81.659 Y104.129 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.517 Y104.189 E-0.14025

G1 X81.470 Y104.009 E-0.10296

G1 X81.466 Y103.675 E-0.18485

G1 X81.482 Y103.591 E-0.04722

G1 X81.571 Y103.450 E-0.09260

G1 X82.091 Y103.111 E-0.34412

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X91.462 Y103.807

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.053 Y103.398 E0.01599

G1 X90.425 Y103.397 E0.01739

G1 X90.647 Y103.619 E0.00868

G1 X90.019 Y103.619 E0.01736

G1 X89.796 Y103.396 E0.00872

G1 X89.168 Y103.395 E0.01739

G1 X89.391 Y103.619 E0.00876

G1 X88.764 Y103.619 E0.01736

G1 X88.539 Y103.394 E0.00880

G1 X87.910 Y103.393 E0.01739

G1 X88.136 Y103.619 E0.00884

G1 X87.509 Y103.619 E0.01736

G1 X87.282 Y103.392 E0.00889

G1 X86.653 Y103.391 E0.01739

G1 X86.881 Y103.619 E0.00893

G1 X86.254 Y103.619 E0.01736

G1 X86.025 Y103.390 E0.00897

G1 X85.396 Y103.389 E0.01739

G1 X85.626 Y103.619 E0.00901

G1 X84.999 Y103.619 E0.01736

G1 X84.767 Y103.387 E0.00908

G1 X84.135 Y103.383 E0.01748

G1 X84.371 Y103.619 E0.00924

G1 X83.744 Y103.619 E0.01736

G1 X83.503 Y103.379 E0.00940

G1 X83.141 Y103.376 E0.01003

G1 X82.943 Y103.446 E0.00580

G1 X83.304 Y103.807 E0.01412

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.943 Y103.446 E-0.28277

G1 X83.141 Y103.376 E-0.11618

G1 X83.503 Y103.379 E-0.20081

G1 X83.744 Y103.619 E-0.18831

G1 X83.967 Y103.619 E-0.12392

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.898 Y97.204

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y96.388 E0.02127

G1 X85.001 Y96.386 E0.08115

G1 X86.469 Y96.366 E0.03827

G1 X86.042 Y96.468 E0.01144

G1 X85.358 Y96.725 E0.01905

G1 X84.643 Y97.068 E0.02065

G1 X84.501 Y97.123 E0.00396

G1 X84.229 Y97.184 E0.00726

G1 X81.958 Y97.204 E0.05919

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.886 Y96.388 E-0.45368

G1 X82.713 Y96.388 E-0.45832

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X87.965 Y96.356

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.583 Y96.355 E0.12031

G1 X92.597 Y96.389 E0.00096

G1 X92.593 Y97.178 E0.02055

G1 X92.582 Y97.208 E0.00084

G1 X90.328 Y97.199 E0.05871

G1 X90.152 Y97.177 E0.00462

G1 X89.988 Y97.099 E0.00476

G1 X89.790 Y97.043 E0.00535

G1 X89.470 Y96.884 E0.00931

G1 X88.517 Y96.493 E0.02685

G1 X88.024 Y96.367 E0.01324

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.670 Y96.363 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X92.843 Y95.956

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.882 Y95.983 E0.00123

G1 X93.015 Y96.308 E0.00915

G1 X93.010 Y97.254 E0.02466

G1 X92.932 Y97.465 E0.00586

G1 X92.813 Y97.584 E0.00439

G1 X92.700 Y97.627 E0.00313

G1 X90.302 Y97.616 E0.06249

G1 X90.078 Y97.589 E0.00588

G1 X89.942 Y97.556 E0.00364

G1 X89.823 Y97.487 E0.00358

G1 X89.639 Y97.435 E0.00499

G1 X89.297 Y97.264 E0.00994

G1 X88.381 Y96.889 E0.02581

G1 X88.061 Y96.799 E0.00865

G1 X87.656 Y96.724 E0.01073

G1 X87.397 Y96.701 E0.00678

G1 X86.953 Y96.709 E0.01157

G1 X86.569 Y96.772 E0.01014

G1 X86.165 Y96.869 E0.01082

G1 X85.522 Y97.110 E0.01789

G1 X84.808 Y97.453 E0.02063

G1 X84.622 Y97.524 E0.00520

G1 X84.278 Y97.601 E0.00920

G1 X81.788 Y97.623 E0.06487

G1 X81.607 Y97.543 E0.00517

G1 X81.489 Y97.338 E0.00615

G1 X81.481 Y97.291 E0.00124

G1 X81.467 Y96.292 E0.02602

G1 X81.523 Y96.069 E0.00599

G1 X81.626 Y95.971 E0.00372

G1 X84.998 Y95.968 E0.08785

G1 X87.176 Y95.939 E0.05677

G1 X92.784 Y95.945 E0.14610

M204 S1250

G1 X92.848 Y96.003 F9000.000

G1 X92.049 Y97.081

M204 S1000

G1 F4800.000

G1 X91.637 Y96.669 E0.01821

G1 X90.928 Y96.669 E0.02216

G1 X91.148 Y96.889 E0.00972

G1 X90.436 Y96.886 E0.02226

G1 X90.222 Y96.673 E0.00943

M204 S1250

G1 X89.440 Y96.645 F9000.000

G1 F2400.000

G1 X90.088 Y96.734 E0.01215

G1 X90.087 Y96.741 F9000.000

G1 F2400.000

G1 X89.468 Y96.609 E0.00536

G1 X89.354 Y96.587 E0.00068

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.468 Y96.609 E-0.06445

G1 E-0.89555 F4200.00000

G1 Z10.000 F9000.000

G1 X87.758 Y96.335

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X87.179 Y96.322 E0.01296

G1 X86.678 Y96.347 E0.01124

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.179 Y96.322 E-0.27825

G1 X87.758 Y96.335 E-0.32072

G1 E-0.36104 F4200.00000

G1 Z10.000 F9000.000

G1 X85.053 Y96.640

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X84.183 Y96.785 E0.01832

G1 X82.101 Y96.795 E0.04328

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y96.787 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.887 Y90.934

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y90.746 E0.00491

G1 X82.731 Y90.194 E0.02633

G1 X83.102 Y90.065 E0.01021

G1 X91.379 Y90.089 E0.21566

G1 X91.591 Y90.126 E0.00562

G1 X91.817 Y90.223 E0.00642

G1 X92.586 Y90.732 E0.02402

G1 X92.587 Y90.934 E0.00527

G1 X81.947 Y90.934 E0.27723

M204 S1250

G1 X81.660 Y91.331 F9000.000

M204 S800

G1 F1500.000

G1 X81.517 Y91.191 E0.00521

G1 X81.470 Y91.012 E0.00484

G1 X81.466 Y90.677 E0.00871

G1 X81.482 Y90.593 E0.00222

G1 X81.571 Y90.452 E0.00435

G1 X82.541 Y89.819 E0.03018

G1 X82.873 Y89.693 E0.00925

G1 X83.049 Y89.647 E0.00475

G1 X91.416 Y89.671 E0.21800

G1 X91.711 Y89.723 E0.00781

G1 X92.017 Y89.854 E0.00866

G1 X92.881 Y90.427 E0.02703

G1 X92.990 Y90.554 E0.00437

G1 X93.003 Y90.606 E0.00138

G1 X93.006 Y91.024 E0.01091

G1 X92.936 Y91.212 E0.00523

G1 X92.829 Y91.327 E0.00409

G1 X92.716 Y91.352 E0.00300

G1 X81.719 Y91.343 E0.28655

M204 S1250

G1 X81.658 Y91.131 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.517 Y91.191 E-0.13987

G1 X81.470 Y91.012 E-0.10299

G1 X81.466 Y90.677 E-0.18524

G1 X81.482 Y90.593 E-0.04722

G1 X81.571 Y90.452 E-0.09260

G1 X82.091 Y90.113 E-0.34407

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X91.462 Y90.809

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.054 Y90.401 E0.01596

G1 X90.426 Y90.400 E0.01740

G1 X90.647 Y90.621 E0.00865

G1 X90.019 Y90.621 E0.01736

G1 X89.797 Y90.399 E0.00869

G1 X89.168 Y90.398 E0.01740

G1 X89.391 Y90.621 E0.00874

G1 X88.764 Y90.621 E0.01736

G1 X88.540 Y90.397 E0.00878

G1 X87.911 Y90.396 E0.01740

G1 X88.136 Y90.621 E0.00883

G1 X87.509 Y90.621 E0.01736

G1 X87.282 Y90.394 E0.00887

G1 X86.653 Y90.393 E0.01740

G1 X86.881 Y90.621 E0.00892

G1 X86.254 Y90.621 E0.01736

G1 X86.025 Y90.392 E0.00896

G1 X85.396 Y90.391 E0.01740

G1 X85.626 Y90.621 E0.00901

G1 X84.999 Y90.621 E0.01736

G1 X84.767 Y90.389 E0.00908

G1 X84.135 Y90.385 E0.01748

G1 X84.371 Y90.621 E0.00924

G1 X83.744 Y90.621 E0.01736

G1 X83.503 Y90.381 E0.00940

G1 X83.141 Y90.378 E0.01003

G1 X82.943 Y90.448 E0.00580

G1 X83.304 Y90.809 E0.01412

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.943 Y90.448 E-0.28277

G1 X83.141 Y90.378 E-0.11619

G1 X83.503 Y90.381 E-0.20081

G1 X83.744 Y90.621 E-0.18831

G1 X83.967 Y90.621 E-0.12392

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.898 Y84.208

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y83.390 E0.02131

G1 X86.467 Y83.369 E0.11937

G1 X86.042 Y83.470 E0.01138

G1 X85.358 Y83.728 E0.01906

G1 X84.644 Y84.071 E0.02063

G1 X84.502 Y84.124 E0.00395

G1 X84.226 Y84.186 E0.00739

G1 X81.958 Y84.208 E0.05910

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.886 Y83.390 E-0.45495

G1 X82.711 Y83.386 E-0.45705

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X87.969 Y83.359

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.583 Y83.357 E0.12022

G1 X92.597 Y83.392 E0.00098

G1 X92.593 Y84.180 E0.02054

G1 X92.582 Y84.210 E0.00083

G1 X90.327 Y84.201 E0.05873

G1 X90.153 Y84.180 E0.00459

G1 X89.988 Y84.101 E0.00477

G1 X89.789 Y84.045 E0.00536

G1 X89.470 Y83.886 E0.00930

G1 X88.517 Y83.495 E0.02684

G1 X88.028 Y83.370 E0.01315

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.674 Y83.365 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X92.843 Y82.958

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.882 Y82.985 E0.00123

G1 X93.015 Y83.311 E0.00917

G1 X93.010 Y84.256 E0.02464

G1 X92.932 Y84.467 E0.00586

G1 X92.813 Y84.586 E0.00439

G1 X92.700 Y84.629 E0.00313

G1 X90.301 Y84.618 E0.06250

G1 X90.078 Y84.591 E0.00587

G1 X89.942 Y84.558 E0.00364

G1 X89.823 Y84.489 E0.00360

G1 X89.639 Y84.437 E0.00499

G1 X89.297 Y84.267 E0.00994

G1 X88.381 Y83.891 E0.02581

G1 X88.061 Y83.801 E0.00866

G1 X87.656 Y83.726 E0.01073

G1 X87.397 Y83.703 E0.00678

G1 X86.953 Y83.711 E0.01157

G1 X86.569 Y83.774 E0.01014

G1 X86.165 Y83.871 E0.01082

G1 X85.522 Y84.112 E0.01790

G1 X84.809 Y84.455 E0.02063

G1 X84.622 Y84.525 E0.00519

G1 X84.276 Y84.603 E0.00924

G1 X81.789 Y84.626 E0.06482

G1 X81.607 Y84.545 E0.00519

G1 X81.489 Y84.340 E0.00615

G1 X81.481 Y84.293 E0.00124

G1 X81.467 Y83.295 E0.02601

G1 X81.523 Y83.072 E0.00600

G1 X81.626 Y82.973 E0.00372

G1 X84.998 Y82.970 E0.08785

G1 X87.176 Y82.941 E0.05677

G1 X92.784 Y82.947 E0.14610

M204 S1250

G1 X92.848 Y83.005 F9000.000

G1 X92.049 Y84.083

M204 S1000

G1 F4800.000

G1 X91.637 Y83.671 E0.01821

G1 X90.928 Y83.671 E0.02216

G1 X91.148 Y83.891 E0.00971

G1 X90.436 Y83.888 E0.02226

G1 X90.223 Y83.675 E0.00943

M204 S1250

G1 X89.439 Y83.648 F9000.000

G1 F2400.000

G1 X90.088 Y83.736 E0.01215

G1 X90.087 Y83.743 F9000.000

G1 F2400.000

G1 X89.468 Y83.612 E0.00535

G1 X89.354 Y83.589 E0.00068

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.468 Y83.612 E-0.06429

G1 E-0.89571 F4200.00000

G1 Z10.000 F9000.000

G1 X87.761 Y83.337

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X87.179 Y83.324 E0.01303

G1 X86.675 Y83.350 E0.01128

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.179 Y83.324 E-0.27946

G1 X87.761 Y83.337 E-0.32270

G1 E-0.35784 F4200.00000

G1 Z10.000 F9000.000

G1 X85.048 Y83.644

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X84.178 Y83.788 E0.01832

G1 X82.101 Y83.799 E0.04310

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y83.790 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.887 Y77.936

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y77.748 E0.00491

G1 X82.732 Y77.196 E0.02633

G1 X83.101 Y77.067 E0.01021

G1 X91.379 Y77.091 E0.21567

G1 X91.591 Y77.128 E0.00562

G1 X91.818 Y77.225 E0.00642

G1 X92.586 Y77.734 E0.02402

G1 X92.587 Y77.937 E0.00528

G1 X81.947 Y77.936 E0.27723

M204 S1250

G1 X81.660 Y78.334 F9000.000

M204 S800

G1 F1500.000

G1 X81.517 Y78.194 E0.00521

G1 X81.470 Y78.014 E0.00485

G1 X81.466 Y77.679 E0.00871

G1 X81.482 Y77.596 E0.00222

G1 X81.571 Y77.454 E0.00435

G1 X82.541 Y76.822 E0.03018

G1 X82.873 Y76.695 E0.00926

G1 X83.049 Y76.649 E0.00474

G1 X91.416 Y76.673 E0.21800

G1 X91.711 Y76.725 E0.00781

G1 X92.017 Y76.856 E0.00866

G1 X92.881 Y77.429 E0.02702

G1 X92.990 Y77.557 E0.00439

G1 X93.003 Y77.608 E0.00136

G1 X93.006 Y78.026 E0.01090

G1 X92.936 Y78.214 E0.00523

G1 X92.828 Y78.330 E0.00411

G1 X92.717 Y78.354 E0.00298

G1 X81.719 Y78.345 E0.28656

M204 S1250

G1 X81.658 Y78.134 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.517 Y78.194 E-0.13985

G1 X81.470 Y78.014 E-0.10306

G1 X81.466 Y77.679 E-0.18524

G1 X81.482 Y77.596 E-0.04720

G1 X81.571 Y77.454 E-0.09250

G1 X82.091 Y77.115 E-0.34415

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X91.462 Y77.811

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.054 Y77.403 E0.01596

G1 X90.426 Y77.402 E0.01739

G1 X90.647 Y77.623 E0.00865

G1 X90.019 Y77.623 E0.01736

G1 X89.797 Y77.401 E0.00869

G1 X89.169 Y77.400 E0.01739

G1 X89.392 Y77.623 E0.00873

G1 X88.765 Y77.623 E0.01736

G1 X88.540 Y77.399 E0.00877

G1 X87.912 Y77.398 E0.01739

G1 X88.137 Y77.623 E0.00881

G1 X87.510 Y77.623 E0.01736

G1 X87.283 Y77.397 E0.00886

G1 X86.655 Y77.396 E0.01739

G1 X86.882 Y77.623 E0.00890

G1 X86.255 Y77.623 E0.01736

G1 X86.026 Y77.395 E0.00894

G1 X85.398 Y77.394 E0.01739

G1 X85.627 Y77.623 E0.00898

G1 X85.000 Y77.623 E0.01736

G1 X84.768 Y77.392 E0.00906

G1 X84.136 Y77.387 E0.01748

G1 X84.372 Y77.623 E0.00923

G1 X83.745 Y77.623 E0.01736

G1 X83.505 Y77.383 E0.00940

G1 X83.141 Y77.381 E0.01006

G1 X82.945 Y77.450 E0.00577

G1 X83.305 Y77.811 E0.01411

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.945 Y77.450 E-0.28270

G1 X83.141 Y77.381 E-0.11552

G1 X83.505 Y77.383 E-0.20155

G1 X83.745 Y77.623 E-0.18818

G1 X83.969 Y77.623 E-0.12406

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.898 Y71.210

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y70.392 E0.02131

G1 X86.467 Y70.371 E0.11937

G1 X86.042 Y70.472 E0.01138

G1 X85.358 Y70.730 E0.01906

G1 X84.643 Y71.073 E0.02066

G1 X84.502 Y71.127 E0.00394

G1 X84.227 Y71.188 E0.00735

G1 X81.958 Y71.210 E0.05912

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.886 Y70.392 E-0.45495

G1 X82.711 Y70.388 E-0.45705

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X87.966 Y70.361

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.583 Y70.359 E0.12029

G1 X92.597 Y70.394 E0.00098

G1 X92.593 Y71.182 E0.02054

G1 X92.581 Y71.213 E0.00086

G1 X90.328 Y71.203 E0.05872

G1 X90.153 Y71.182 E0.00459

G1 X89.987 Y71.103 E0.00478

G1 X89.789 Y71.047 E0.00536

G1 X89.470 Y70.889 E0.00929

G1 X88.517 Y70.498 E0.02682

G1 X88.025 Y70.372 E0.01323

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.671 Y70.367 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X92.843 Y69.960

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.881 Y69.987 E0.00123

G1 X93.015 Y70.313 E0.00917

G1 X93.010 Y71.258 E0.02464

G1 X92.932 Y71.469 E0.00586

G1 X92.812 Y71.588 E0.00440

G1 X92.700 Y71.632 E0.00314

G1 X90.302 Y71.620 E0.06249

G1 X90.078 Y71.593 E0.00587

G1 X89.942 Y71.560 E0.00364

G1 X89.823 Y71.491 E0.00360

G1 X89.638 Y71.439 E0.00499

G1 X89.297 Y71.269 E0.00993

G1 X88.381 Y70.894 E0.02581

G1 X88.061 Y70.803 E0.00866

G1 X87.656 Y70.729 E0.01072

G1 X87.397 Y70.705 E0.00677

G1 X86.953 Y70.714 E0.01158

G1 X86.569 Y70.776 E0.01014

G1 X86.165 Y70.873 E0.01082

G1 X85.522 Y71.114 E0.01790

G1 X84.808 Y71.458 E0.02064

G1 X84.622 Y71.528 E0.00519

G1 X84.277 Y71.605 E0.00923

G1 X81.789 Y71.628 E0.06482

G1 X81.607 Y71.547 E0.00519

G1 X81.489 Y71.342 E0.00615

G1 X81.481 Y71.295 E0.00124

G1 X81.467 Y70.297 E0.02601

G1 X81.523 Y70.074 E0.00600

G1 X81.626 Y69.975 E0.00372

G1 X84.998 Y69.972 E0.08785

G1 X87.176 Y69.943 E0.05677

G1 X92.784 Y69.949 E0.14610

M204 S1250

G1 X92.848 Y70.007 F9000.000

G1 X92.049 Y71.085

M204 S1000

G1 F4800.000

G1 X91.637 Y70.673 E0.01824

G1 X90.928 Y70.673 E0.02216

G1 X91.148 Y70.893 E0.00973

G1 X90.436 Y70.890 E0.02227

G1 X90.222 Y70.677 E0.00943

M204 S1250

G1 X89.437 Y70.649 F9000.000

G1 F2400.000

G1 X90.088 Y70.738 E0.01219

G1 X90.087 Y70.745 F9000.000

G1 F2400.000

G1 X89.467 Y70.614 E0.00538

G1 X89.353 Y70.591 E0.00068

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.467 Y70.614 E-0.06462

G1 E-0.89538 F4200.00000

G1 Z10.000 F9000.000

G1 X87.758 Y70.340

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X87.179 Y70.326 E0.01298

G1 X86.675 Y70.352 E0.01129

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.179 Y70.326 E-0.27946

G1 X87.758 Y70.340 E-0.32122

G1 E-0.35933 F4200.00000

G1 Z10.000 F9000.000

G1 X85.052 Y70.645

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X84.179 Y70.790 E0.01842

G1 X82.101 Y70.801 E0.04325

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y70.792 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.887 Y64.939

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y64.750 E0.00493

G1 X82.732 Y64.198 E0.02633

G1 X83.101 Y64.069 E0.01019

G1 X91.379 Y64.093 E0.21568

G1 X91.590 Y64.130 E0.00561

G1 X91.817 Y64.227 E0.00643

G1 X92.586 Y64.737 E0.02403

G1 X92.587 Y64.939 E0.00527

G1 X81.947 Y64.939 E0.27723

M204 S1250

G1 X81.660 Y65.336 F9000.000

M204 S800

G1 F1500.000

G1 X81.517 Y65.196 E0.00523

G1 X81.470 Y65.016 E0.00485

G1 X81.466 Y64.682 E0.00869

G1 X81.482 Y64.597 E0.00224

G1 X81.571 Y64.456 E0.00435

G1 X82.541 Y63.824 E0.03018

G1 X82.873 Y63.697 E0.00926

G1 X83.049 Y63.651 E0.00474

G1 X91.416 Y63.675 E0.21801

G1 X91.711 Y63.727 E0.00781

G1 X92.017 Y63.858 E0.00867

G1 X92.881 Y64.431 E0.02703

G1 X92.990 Y64.559 E0.00438

G1 X93.003 Y64.611 E0.00139

G1 X93.006 Y65.029 E0.01090

G1 X92.936 Y65.216 E0.00521

G1 X92.828 Y65.332 E0.00411

G1 X92.717 Y65.356 E0.00298

G1 X81.719 Y65.348 E0.28656

M204 S1250

G1 X81.659 Y65.136 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.517 Y65.196 E-0.14018

G1 X81.470 Y65.016 E-0.10314

G1 X81.466 Y64.682 E-0.18476

G1 X81.482 Y64.597 E-0.04774

G1 X81.571 Y64.456 E-0.09243

G1 X82.090 Y64.118 E-0.34375

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X91.462 Y64.813

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.054 Y64.405 E0.01597

G1 X90.425 Y64.404 E0.01740

G1 X90.646 Y64.625 E0.00865

G1 X90.019 Y64.625 E0.01736

G1 X89.796 Y64.403 E0.00870

G1 X89.168 Y64.402 E0.01740

G1 X89.391 Y64.626 E0.00874

G1 X88.764 Y64.626 E0.01736

G1 X88.539 Y64.401 E0.00878

G1 X87.911 Y64.400 E0.01740

G1 X88.136 Y64.626 E0.00883

G1 X87.509 Y64.626 E0.01736

G1 X87.282 Y64.399 E0.00887

G1 X86.653 Y64.398 E0.01740

G1 X86.881 Y64.626 E0.00891

G1 X86.254 Y64.626 E0.01736

G1 X86.025 Y64.397 E0.00895

G1 X85.396 Y64.396 E0.01740

G1 X85.626 Y64.626 E0.00900

G1 X84.999 Y64.626 E0.01736

G1 X84.767 Y64.394 E0.00907

G1 X84.135 Y64.390 E0.01748

G1 X84.371 Y64.626 E0.00924

G1 X83.744 Y64.626 E0.01736

G1 X83.503 Y64.385 E0.00941

G1 X83.140 Y64.383 E0.01005

G1 X82.943 Y64.453 E0.00578

G1 X83.304 Y64.814 E0.01413

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.943 Y64.453 E-0.28287

G1 X83.140 Y64.383 E-0.11585

G1 X83.503 Y64.385 E-0.20116

G1 X83.744 Y64.626 E-0.18847

G1 X83.967 Y64.626 E-0.12365

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.898 Y58.213

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y57.394 E0.02133

G1 X86.471 Y57.373 E0.11946

G1 X86.043 Y57.474 E0.01145

G1 X85.358 Y57.732 E0.01908

G1 X84.643 Y58.075 E0.02067

G1 X84.501 Y58.129 E0.00394

G1 X84.226 Y58.191 E0.00735

G1 X81.958 Y58.213 E0.05911

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.886 Y57.394 E-0.45530

G1 X82.710 Y57.390 E-0.45670

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X87.964 Y57.363

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.583 Y57.361 E0.12036

G1 X92.597 Y57.396 E0.00098

G1 X92.593 Y58.185 E0.02055

G1 X92.581 Y58.215 E0.00085

G1 X90.329 Y58.206 E0.05870

G1 X90.154 Y58.184 E0.00459

G1 X89.987 Y58.105 E0.00480

G1 X89.789 Y58.049 E0.00537

G1 X89.470 Y57.890 E0.00929

G1 X88.517 Y57.500 E0.02683

G1 X88.023 Y57.374 E0.01329

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.668 Y57.369 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X92.843 Y56.962

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.882 Y56.989 E0.00122

G1 X93.015 Y57.315 E0.00917

G1 X93.010 Y58.261 E0.02465

G1 X92.932 Y58.471 E0.00585

G1 X92.812 Y58.591 E0.00441

G1 X92.700 Y58.634 E0.00313

G1 X90.302 Y58.623 E0.06249

G1 X90.078 Y58.596 E0.00587

G1 X89.942 Y58.562 E0.00365

G1 X89.823 Y58.493 E0.00360

G1 X89.638 Y58.441 E0.00499

G1 X89.297 Y58.271 E0.00993

G1 X88.381 Y57.896 E0.02581

G1 X88.061 Y57.806 E0.00865

G1 X87.656 Y57.731 E0.01072

G1 X87.397 Y57.707 E0.00678

G1 X86.953 Y57.716 E0.01159

G1 X86.569 Y57.779 E0.01013

G1 X86.165 Y57.875 E0.01081

G1 X85.522 Y58.116 E0.01790

G1 X84.808 Y58.460 E0.02064

G1 X84.622 Y58.531 E0.00519

G1 X84.276 Y58.608 E0.00923

G1 X81.789 Y58.631 E0.06481

G1 X81.607 Y58.549 E0.00520

G1 X81.489 Y58.344 E0.00616

G1 X81.481 Y58.297 E0.00124

G1 X81.467 Y57.299 E0.02601

G1 X81.523 Y57.076 E0.00600

G1 X81.626 Y56.977 E0.00372

G1 X84.998 Y56.974 E0.08785

G1 X87.176 Y56.945 E0.05677

G1 X92.784 Y56.951 E0.14611

M204 S1250

G1 X92.849 Y57.009 F9000.000

G1 X92.049 Y58.088

M204 S1000

G1 F4800.000

G1 X91.637 Y57.675 E0.01824

G1 X90.928 Y57.675 E0.02216

G1 X91.149 Y57.896 E0.00975

G1 X90.436 Y57.893 E0.02227

G1 X90.220 Y57.676 E0.00957

M204 S1250

G1 X89.437 Y57.651 F9000.000

G1 F2400.000

G1 X90.085 Y57.740 E0.01210

G1 X90.084 Y57.747 F9000.000

G1 F2400.000

G1 X89.467 Y57.616 E0.00535

G1 X89.353 Y57.593 E0.00068

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.467 Y57.616 E-0.06458

G1 E-0.89542 F4200.00000

G1 Z10.000 F9000.000

G1 X87.756 Y57.342

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X87.179 Y57.328 E0.01291

G1 X86.679 Y57.354 E0.01121

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.179 Y57.328 E-0.27755

G1 X87.756 Y57.342 E-0.31976

G1 E-0.36269 F4200.00000

G1 Z10.000 F9000.000

G1 X85.052 Y57.647

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X84.178 Y57.792 E0.01845

G1 X82.101 Y57.803 E0.04327

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.747 Y57.795 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.887 Y51.941

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.885 Y51.753 E0.00491

G1 X82.732 Y51.200 E0.02635

G1 X83.101 Y51.071 E0.01018

G1 X91.379 Y51.095 E0.21568

G1 X91.590 Y51.132 E0.00560

G1 X91.817 Y51.230 E0.00643

G1 X92.586 Y51.739 E0.02404

G1 X92.587 Y51.941 E0.00527

G1 X81.947 Y51.941 E0.27723

M204 S1250

G1 X81.660 Y52.338 F9000.000

M204 S800

G1 F1500.000

G1 X81.517 Y52.198 E0.00523

G1 X81.470 Y52.018 E0.00485

G1 X81.466 Y51.684 E0.00869

G1 X81.482 Y51.600 E0.00224

G1 X81.571 Y51.459 E0.00433

G1 X82.541 Y50.826 E0.03019

G1 X82.873 Y50.699 E0.00926

G1 X83.049 Y50.653 E0.00474

G1 X91.416 Y50.677 E0.21801

G1 X91.711 Y50.729 E0.00781

G1 X92.016 Y50.861 E0.00867

G1 X92.881 Y51.434 E0.02704

G1 X92.990 Y51.561 E0.00437

G1 X93.003 Y51.613 E0.00138

G1 X93.006 Y52.031 E0.01090

G1 X92.936 Y52.218 E0.00521

G1 X92.828 Y52.334 E0.00413

G1 X92.716 Y52.359 E0.00298

G1 X81.719 Y52.350 E0.28655

M204 S1250

G1 X81.659 Y52.138 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.517 Y52.198 E-0.14018

G1 X81.470 Y52.018 E-0.10314

G1 X81.466 Y51.684 E-0.18476

G1 X81.482 Y51.600 E-0.04763

G1 X81.571 Y51.459 E-0.09206

G1 X82.091 Y51.120 E-0.34424

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X91.462 Y51.816

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.053 Y51.407 E0.01600

G1 X90.425 Y51.406 E0.01739

G1 X90.647 Y51.628 E0.00868

G1 X90.019 Y51.628 E0.01736

G1 X89.796 Y51.405 E0.00872

G1 X89.168 Y51.404 E0.01739

G1 X89.392 Y51.628 E0.00876

G1 X88.764 Y51.628 E0.01736

G1 X88.539 Y51.403 E0.00880

G1 X87.910 Y51.402 E0.01739

G1 X88.136 Y51.628 E0.00884

G1 X87.509 Y51.628 E0.01736

G1 X87.282 Y51.401 E0.00889

G1 X86.653 Y51.400 E0.01739

G1 X86.881 Y51.628 E0.00893

G1 X86.254 Y51.628 E0.01736

G1 X86.025 Y51.399 E0.00897

G1 X85.396 Y51.398 E0.01739

G1 X85.626 Y51.628 E0.00901

G1 X84.999 Y51.628 E0.01736

G1 X84.767 Y51.396 E0.00908

G1 X84.135 Y51.392 E0.01748

G1 X84.371 Y51.628 E0.00925

G1 X83.744 Y51.628 E0.01736

G1 X83.503 Y51.387 E0.00942

G1 X83.140 Y51.385 E0.01005

G1 X82.943 Y51.455 E0.00578

G1 X83.304 Y51.816 E0.01413

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.943 Y51.455 E-0.28300

G1 X83.140 Y51.385 E-0.11577

G1 X83.503 Y51.387 E-0.20124

G1 X83.744 Y51.628 E-0.18859

G1 X83.967 Y51.628 E-0.12340

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X81.898 Y45.215

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.886 Y44.397 E0.02130

G1 X86.471 Y44.375 E0.11945

G1 X86.043 Y44.477 E0.01146

G1 X85.358 Y44.733 E0.01905

G1 X84.643 Y45.077 E0.02068

G1 X84.501 Y45.131 E0.00394

G1 X84.226 Y45.193 E0.00735

G1 X81.958 Y45.215 E0.05911

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.886 Y44.397 E-0.45480

G1 X82.711 Y44.393 E-0.45720

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X87.964 Y44.365

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.583 Y44.363 E0.12035

M73 P85 R10

G1 X92.597 Y44.398 E0.00099

G1 X92.593 Y45.187 E0.02054

G1 X92.581 Y45.217 E0.00085

G1 X90.329 Y45.208 E0.05870

G1 X90.154 Y45.186 E0.00459

G1 X89.987 Y45.107 E0.00480

G1 X89.789 Y45.051 E0.00537

G1 X89.470 Y44.892 E0.00929

G1 X88.517 Y44.502 E0.02683

G1 X88.023 Y44.376 E0.01329

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.668 Y44.371 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.000 F9000.000

G1 X92.842 Y43.964

G1 Z9.800

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.881 Y43.992 E0.00124

G1 X93.015 Y44.317 E0.00917

G1 X93.010 Y45.263 E0.02465

G1 X92.932 Y45.473 E0.00585

G1 X92.812 Y45.593 E0.00441

G1 X92.700 Y45.636 E0.00313

G1 X90.302 Y45.625 E0.06249

G1 X90.078 Y45.598 E0.00587

G1 X89.942 Y45.564 E0.00365

G1 X89.823 Y45.495 E0.00360

G1 X89.638 Y45.443 E0.00499

G1 X89.297 Y45.273 E0.00993

G1 X88.381 Y44.898 E0.02581

G1 X88.061 Y44.808 E0.00865

G1 X87.656 Y44.733 E0.01072

G1 X87.397 Y44.709 E0.00678

G1 X86.953 Y44.718 E0.01159

G1 X86.569 Y44.781 E0.01014

G1 X86.165 Y44.877 E0.01081

G1 X85.522 Y45.118 E0.01789

G1 X84.808 Y45.462 E0.02064

G1 X84.622 Y45.533 E0.00519

G1 X84.276 Y45.610 E0.00923

G1 X81.789 Y45.633 E0.06481

G1 X81.607 Y45.551 E0.00520

G1 X81.489 Y45.346 E0.00616

G1 X81.481 Y45.299 E0.00124

G1 X81.467 Y44.301 E0.02601

G1 X81.523 Y44.078 E0.00599

G1 X81.626 Y43.980 E0.00371

G1 X84.998 Y43.976 E0.08785

G1 X87.176 Y43.947 E0.05677

G1 X92.783 Y43.953 E0.14609

M204 S1250

G1 X92.848 Y44.012 F9000.000

G1 X92.049 Y45.090

M204 S1000

G1 F4800.000

G1 X91.637 Y44.677 E0.01825

G1 X90.928 Y44.677 E0.02216

G1 X91.149 Y44.898 E0.00975

G1 X90.437 Y44.895 E0.02226

G1 X90.219 Y44.678 E0.00960

M204 S1250

G1 X89.437 Y44.653 F9000.000

G1 F2400.000

G1 X90.084 Y44.742 E0.01209

G1 X90.084 Y44.749 F9000.000

G1 F2400.000

G1 X89.467 Y44.618 E0.00534

G1 X89.353 Y44.595 E0.00068

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.467 Y44.618 E-0.06458

G1 E-0.89542 F4200.00000

G1 Z10.000 F9000.000

G1 X87.756 Y44.344

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X87.179 Y44.330 E0.01291

G1 X86.679 Y44.356 E0.01121

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.179 Y44.330 E-0.27758

G1 X87.756 Y44.344 E-0.31976

G1 E-0.36266 F4200.00000

G1 Z10.000 F9000.000

G1 X85.052 Y44.649

G1 Z9.800

G1 E3.20000 F2400.00000

G1 X84.178 Y44.794 E0.01844

G1 X82.101 Y44.806 E0.04325

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;9.95

G1 Z9.950 F9000.000

;AFTER\_LAYER\_CHANGE

;9.95

G1 X81.894 Y44.479

M204 S800

G1 F1500.000

G1 X86.088 Y44.466 E0.10928

G1 X85.344 Y44.739 E0.02065

G1 X84.268 Y45.265 E0.03121

G1 X84.143 Y45.307 E0.00343

G1 X83.820 Y45.365 E0.00855

G1 X81.909 Y45.367 E0.04980

G1 X81.892 Y45.340 E0.00083

G1 X81.894 Y44.539 E0.02087

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y44.510 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X88.287 Y44.437

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y44.441 E0.11233

G1 X92.592 Y45.324 E0.02301

G1 X92.581 Y45.365 E0.00111

G1 X92.551 Y45.377 E0.00083

G1 X90.570 Y45.365 E0.05161

G1 X90.299 Y45.298 E0.00728

G1 X89.913 Y45.071 E0.01167

G1 X89.794 Y45.053 E0.00314

G1 X89.503 Y44.908 E0.00847

G1 X88.499 Y44.496 E0.02828

G1 X88.344 Y44.453 E0.00417

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.990 Y44.449 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X92.842 Y44.052

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.925 Y44.121 E0.00280

G1 X93.005 Y44.292 E0.00494

G1 X93.009 Y45.383 E0.02841

G1 X92.951 Y45.591 E0.00564

G1 X92.832 Y45.715 E0.00447

G1 X92.673 Y45.796 E0.00464

G1 X90.518 Y45.782 E0.05615

G1 X90.140 Y45.689 E0.01014

G1 X89.771 Y45.472 E0.01116

G1 X89.666 Y45.457 E0.00276

G1 X89.330 Y45.289 E0.00979

G1 X88.363 Y44.892 E0.02723

G1 X88.058 Y44.807 E0.00825

G1 X87.633 Y44.730 E0.01126

G1 X87.385 Y44.709 E0.00648

G1 X86.960 Y44.717 E0.01108

G1 X86.625 Y44.767 E0.00883

G1 X86.165 Y44.877 E0.01232

G1 X85.510 Y45.124 E0.01823

G1 X84.426 Y45.653 E0.03143

G1 X84.246 Y45.713 E0.00494

G1 X83.857 Y45.782 E0.01028

G1 X81.791 Y45.785 E0.05384

G1 X81.624 Y45.706 E0.00481

G1 X81.493 Y45.485 E0.00672

G1 X81.474 Y45.379 E0.00280

G1 X81.476 Y44.327 E0.02741

G1 X81.518 Y44.177 E0.00405

G1 X81.623 Y44.061 E0.00407

G1 X85.817 Y44.052 E0.10927

G1 X88.544 Y44.016 E0.07105

G1 X92.716 Y44.024 E0.10872

G1 X92.783 Y44.039 E0.00179

M204 S1250

G1 X92.848 Y44.159 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y44.121 E-0.09046

G1 X93.005 Y44.292 E-0.10515

G1 X93.009 Y45.383 E-0.60414

G1 X92.955 Y45.578 E-0.11225

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.452 Y45.245

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.942 Y44.754 E0.02171

G1 X91.234 Y44.753 E0.02215

G1 X90.934 Y45.054 E0.01328

G1 X90.610 Y45.052 E0.01014

G1 X90.436 Y45.009 E0.00558

G1 X90.499 Y44.780 E0.00743

G1 X90.714 Y44.565 E0.00950

M204 S1250

G1 X89.611 Y44.729 F9000.000

G1 F2400.000

G1 X90.001 Y44.759 E0.00554

G1 X90.168 Y44.800 E0.00263

G1 X90.167 Y44.805 F9000.000

G1 F2400.000

G1 X89.520 Y44.666 E0.00319

G1 X88.079 Y44.413 F9000.000

G1 F2400.000

G1 X87.687 Y44.380 E0.00817

G1 X87.403 Y44.370 E0.00511

G1 X86.923 Y44.378 E0.00778

G1 X86.295 Y44.440 E0.01022

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.923 Y44.378 E-0.34935

G1 X87.403 Y44.370 E-0.26608

G1 E-0.34458 F4200.00000

G1 Z10.150 F9000.000

G1 X83.541 Y45.240

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.995 Y44.786 E0.01780

G1 X83.365 Y44.788 E0.01748

G1 X83.100 Y45.052 E0.01037

G1 X82.471 Y45.053 E0.01745

G1 X82.923 Y44.601 E0.01772

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.471 Y45.053 E-0.35427

G1 X83.100 Y45.052 E-0.34880

G1 X83.365 Y44.788 E-0.20735

G1 X83.368 Y44.788 E-0.00159

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.886 Y51.746

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.922 Y51.070 E0.03222

G1 X83.153 Y50.969 E0.00657

G1 X83.362 Y50.916 E0.00562

G1 X91.112 Y50.936 E0.20194

G1 X91.385 Y50.997 E0.00728

G1 X91.612 Y51.096 E0.00645

G1 X92.586 Y51.740 E0.03042

G1 X92.585 Y51.857 E0.00306

G1 X81.888 Y51.859 E0.27872

G1 X81.887 Y51.806 E0.00139

M204 S1250

G1 X81.482 Y51.601 F9000.000

M204 S800

G1 F1500.000

G1 X81.584 Y51.444 E0.00488

G1 X82.723 Y50.701 E0.03541

G1 X83.017 Y50.573 E0.00837

G1 X83.311 Y50.498 E0.00790

G1 X91.164 Y50.519 E0.20463

G1 X91.479 Y50.583 E0.00836

G1 X91.812 Y50.728 E0.00946

G1 X92.884 Y51.436 E0.03350

G1 X92.988 Y51.560 E0.00419

G1 X93.004 Y51.631 E0.00191

G1 X93.002 Y51.965 E0.00870

G1 X92.946 Y52.123 E0.00439

G1 X92.858 Y52.235 E0.00370

G1 X92.718 Y52.275 E0.00380

G1 X81.763 Y52.277 E0.28545

G1 X81.660 Y52.257 E0.00272

G1 X81.517 Y52.116 E0.00522

G1 X81.472 Y51.947 E0.00456

G1 X81.471 Y51.660 E0.00748

M204 S1250

G1 X81.667 Y51.571 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.584 Y51.444 E-0.13515

G1 X82.723 Y50.701 E-0.75319

G1 X82.762 Y50.684 E-0.02366

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.089 Y51.732

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.452 Y51.369 E0.01387

G1 X91.287 Y51.297 E0.00486

G1 X91.077 Y51.250 E0.00581

G1 X90.959 Y51.249 E0.00318

G1 X90.665 Y51.544 E0.01125

G1 X90.053 Y51.544 E0.01652

G1 X90.349 Y51.248 E0.01130

G1 X89.738 Y51.247 E0.01649

G1 X89.440 Y51.544 E0.01135

G1 X88.828 Y51.544 E0.01652

G1 X89.127 Y51.246 E0.01140

G1 X88.516 Y51.244 E0.01649

G1 X88.216 Y51.544 E0.01145

G1 X87.604 Y51.545 E0.01652

G1 X87.905 Y51.243 E0.01150

G1 X87.294 Y51.242 E0.01649

G1 X86.992 Y51.545 E0.01156

G1 X86.379 Y51.545 E0.01652

G1 X86.684 Y51.241 E0.01161

G1 X86.073 Y51.239 E0.01649

G1 X85.767 Y51.545 E0.01166

G1 X85.155 Y51.545 E0.01652

G1 X85.462 Y51.238 E0.01171

G1 X84.851 Y51.237 E0.01649

G1 X84.543 Y51.545 E0.01176

G1 X83.931 Y51.545 E0.01652

G1 X84.240 Y51.235 E0.01182

G1 X83.632 Y51.231 E0.01641

G1 X83.130 Y51.733 E0.01916

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X84.240 Y51.235 E-0.33693

G1 X84.008 Y51.467 E-0.18167

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.894 Y57.476

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.085 Y57.464 E0.10919

G1 X85.344 Y57.738 E0.02057

G1 X84.269 Y58.263 E0.03117

G1 X84.143 Y58.304 E0.00344

G1 X83.819 Y58.363 E0.00858

G1 X81.909 Y58.365 E0.04979

G1 X81.892 Y58.338 E0.00083

G1 X81.894 Y57.536 E0.02090

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y57.508 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X88.287 Y57.435

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y57.439 E0.11233

G1 X92.592 Y58.322 E0.02300

G1 X92.581 Y58.363 E0.00112

G1 X92.551 Y58.375 E0.00082

G1 X90.570 Y58.363 E0.05161

G1 X90.299 Y58.296 E0.00728

G1 X89.913 Y58.069 E0.01167

G1 X89.794 Y58.051 E0.00314

G1 X89.503 Y57.906 E0.00847

G1 X88.499 Y57.494 E0.02828

G1 X88.344 Y57.451 E0.00417

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.990 Y57.447 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X92.843 Y57.050

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.925 Y57.118 E0.00277

G1 X93.005 Y57.290 E0.00497

G1 X93.009 Y58.381 E0.02841

G1 X92.951 Y58.590 E0.00566

G1 X92.832 Y58.713 E0.00446

G1 X92.673 Y58.794 E0.00464

G1 X90.518 Y58.780 E0.05615

G1 X90.140 Y58.687 E0.01014

G1 X89.771 Y58.470 E0.01116

G1 X89.666 Y58.455 E0.00276

G1 X89.330 Y58.287 E0.00979

G1 X88.363 Y57.890 E0.02723

G1 X88.058 Y57.805 E0.00825

G1 X87.633 Y57.728 E0.01126

G1 X87.385 Y57.707 E0.00648

G1 X86.960 Y57.715 E0.01108

G1 X86.625 Y57.765 E0.00883

G1 X86.165 Y57.875 E0.01232

G1 X85.510 Y58.122 E0.01825

G1 X84.426 Y58.651 E0.03142

G1 X84.246 Y58.710 E0.00494

G1 X83.857 Y58.780 E0.01029

G1 X81.791 Y58.783 E0.05383

G1 X81.624 Y58.704 E0.00481

G1 X81.493 Y58.483 E0.00672

G1 X81.474 Y58.377 E0.00280

G1 X81.476 Y57.325 E0.02741

G1 X81.518 Y57.174 E0.00407

G1 X81.623 Y57.058 E0.00407

G1 X85.817 Y57.050 E0.10927

G1 X88.544 Y57.014 E0.07105

G1 X92.716 Y57.022 E0.10872

G1 X92.784 Y57.037 E0.00181

M204 S1250

G1 X92.849 Y57.156 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y57.118 E-0.08981

G1 X93.005 Y57.290 E-0.10561

G1 X93.009 Y58.381 E-0.60417

G1 X92.955 Y58.576 E-0.11241

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.452 Y58.243

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.942 Y57.752 E0.02171

G1 X91.234 Y57.751 E0.02215

G1 X90.934 Y58.052 E0.01328

G1 X90.610 Y58.050 E0.01014

G1 X90.436 Y58.007 E0.00558

G1 X90.499 Y57.778 E0.00743

G1 X90.714 Y57.563 E0.00950

M204 S1250

G1 X89.611 Y57.727 F9000.000

G1 F2400.000

G1 X90.001 Y57.757 E0.00554

G1 X90.168 Y57.798 E0.00263

G1 X90.167 Y57.803 F9000.000

G1 F2400.000

G1 X89.521 Y57.664 E0.00319

G1 X88.079 Y57.411 F9000.000

G1 F2400.000

G1 X87.687 Y57.378 E0.00817

G1 X87.403 Y57.368 E0.00511

G1 X86.923 Y57.376 E0.00778

G1 X86.292 Y57.439 E0.01027

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.923 Y57.376 E-0.35122

G1 X87.403 Y57.368 E-0.26607

G1 E-0.34270 F4200.00000

G1 Z10.150 F9000.000

G1 X83.541 Y58.238

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.996 Y57.783 E0.01782

G1 X83.365 Y57.785 E0.01749

G1 X83.100 Y58.050 E0.01040

G1 X82.470 Y58.051 E0.01746

G1 X82.923 Y57.598 E0.01776

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.470 Y58.051 E-0.35481

G1 X83.100 Y58.050 E-0.34893

G1 X83.365 Y57.785 E-0.20781

G1 X83.366 Y57.785 E-0.00046

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.887 Y64.743

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.921 Y64.068 E0.03219

G1 X83.153 Y63.967 E0.00657

G1 X83.362 Y63.914 E0.00562

G1 X91.112 Y63.934 E0.20194

G1 X91.385 Y63.995 E0.00728

G1 X91.612 Y64.094 E0.00645

G1 X92.586 Y64.737 E0.03041

G1 X92.585 Y64.855 E0.00305

G1 X81.888 Y64.857 E0.27872

G1 X81.887 Y64.802 E0.00142

M204 S1250

G1 X81.482 Y64.598 F9000.000

M204 S800

G1 F1500.000

G1 X81.585 Y64.441 E0.00490

G1 X82.723 Y63.699 E0.03539

G1 X83.017 Y63.571 E0.00837

G1 X83.311 Y63.496 E0.00790

G1 X91.164 Y63.517 E0.20463

G1 X91.479 Y63.581 E0.00836

G1 X91.812 Y63.726 E0.00946

G1 X92.884 Y64.434 E0.03349

G1 X92.988 Y64.557 E0.00419

G1 X93.004 Y64.629 E0.00191

G1 X93.002 Y64.962 E0.00868

G1 X92.946 Y65.121 E0.00440

G1 X92.858 Y65.233 E0.00370

G1 X92.718 Y65.272 E0.00379

G1 X81.763 Y65.275 E0.28546

G1 X81.660 Y65.255 E0.00273

G1 X81.517 Y65.114 E0.00522

G1 X81.472 Y64.945 E0.00456

G1 X81.471 Y64.657 E0.00749

M204 S1250

G1 X81.668 Y64.568 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.585 Y64.441 E-0.13558

G1 X82.723 Y63.699 E-0.75278

G1 X82.762 Y63.682 E-0.02364

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.088 Y64.730

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.452 Y64.366 E0.01386

G1 X91.287 Y64.295 E0.00484

G1 X91.077 Y64.248 E0.00581

G1 X90.958 Y64.247 E0.00320

G1 X90.664 Y64.542 E0.01123

G1 X90.052 Y64.542 E0.01652

G1 X90.348 Y64.246 E0.01128

G1 X89.737 Y64.245 E0.01649

G1 X89.440 Y64.542 E0.01134

G1 X88.828 Y64.542 E0.01652

G1 X89.126 Y64.244 E0.01139

G1 X88.515 Y64.242 E0.01649

G1 X88.215 Y64.542 E0.01144

G1 X87.603 Y64.542 E0.01652

G1 X87.904 Y64.241 E0.01149

G1 X87.294 Y64.240 E0.01649

G1 X86.991 Y64.542 E0.01155

G1 X86.379 Y64.543 E0.01652

G1 X86.683 Y64.239 E0.01160

G1 X86.072 Y64.237 E0.01649

G1 X85.767 Y64.543 E0.01165

G1 X85.154 Y64.543 E0.01652

G1 X85.461 Y64.236 E0.01170

G1 X84.850 Y64.235 E0.01649

G1 X84.542 Y64.543 E0.01176

G1 X83.930 Y64.543 E0.01652

G1 X84.240 Y64.233 E0.01182

G1 X83.632 Y64.229 E0.01641

G1 X83.130 Y64.731 E0.01916

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.632 Y64.229 E-0.39335

G1 X84.240 Y64.233 E-0.33692

G1 X84.008 Y64.465 E-0.18174

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.894 Y70.474

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.085 Y70.462 E0.10919

G1 X85.344 Y70.736 E0.02057

G1 X84.269 Y71.261 E0.03117

G1 X84.144 Y71.302 E0.00342

G1 X83.820 Y71.360 E0.00858

G1 X81.908 Y71.362 E0.04982

G1 X81.892 Y71.336 E0.00080

G1 X81.894 Y70.534 E0.02090

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y70.506 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X88.289 Y70.433

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y70.437 E0.11228

G1 X92.592 Y71.320 E0.02299

G1 X92.580 Y71.361 E0.00113

G1 X92.551 Y71.373 E0.00081

G1 X90.570 Y71.360 E0.05162

G1 X90.299 Y71.294 E0.00728

G1 X89.913 Y71.067 E0.01166

G1 X89.794 Y71.049 E0.00314

G1 X89.503 Y70.904 E0.00847

G1 X88.499 Y70.492 E0.02826

G1 X88.347 Y70.449 E0.00414

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.992 Y70.445 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X92.843 Y70.048

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.925 Y70.116 E0.00277

G1 X93.005 Y70.288 E0.00497

G1 X93.009 Y71.378 E0.02838

G1 X92.951 Y71.587 E0.00567

G1 X92.832 Y71.711 E0.00447

G1 X92.673 Y71.792 E0.00463

G1 X90.518 Y71.778 E0.05615

G1 X90.140 Y71.685 E0.01015

G1 X89.771 Y71.468 E0.01116

G1 X89.666 Y71.453 E0.00276

G1 X89.330 Y71.285 E0.00979

G1 X88.363 Y70.888 E0.02723

G1 X88.058 Y70.803 E0.00826

G1 X87.633 Y70.725 E0.01127

G1 X87.385 Y70.705 E0.00648

G1 X86.960 Y70.713 E0.01107

G1 X86.625 Y70.762 E0.00883

G1 X86.165 Y70.873 E0.01233

G1 X85.510 Y71.120 E0.01824

G1 X84.426 Y71.649 E0.03142

G1 X84.246 Y71.708 E0.00493

G1 X83.857 Y71.778 E0.01029

G1 X81.791 Y71.780 E0.05385

G1 X81.624 Y71.702 E0.00480

G1 X81.493 Y71.481 E0.00671

G1 X81.474 Y71.375 E0.00280

G1 X81.476 Y70.323 E0.02741

G1 X81.518 Y70.172 E0.00407

G1 X81.623 Y70.056 E0.00407

G1 X85.817 Y70.048 E0.10927

G1 X88.544 Y70.012 E0.07105

G1 X92.716 Y70.020 E0.10872

G1 X92.784 Y70.035 E0.00181

M204 S1250

G1 X92.849 Y70.154 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y70.116 E-0.08985

G1 X93.005 Y70.288 E-0.10560

G1 X93.009 Y71.378 E-0.60370

G1 X92.955 Y71.574 E-0.11285

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.452 Y71.241

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.942 Y70.750 E0.02170

G1 X91.234 Y70.749 E0.02215

G1 X90.934 Y71.049 E0.01326

G1 X90.609 Y71.047 E0.01016

G1 X90.436 Y71.005 E0.00557

G1 X90.499 Y70.776 E0.00742

G1 X90.714 Y70.561 E0.00950

M204 S1250

G1 X89.611 Y70.725 F9000.000

G1 F2400.000

G1 X90.001 Y70.755 E0.00553

G1 X90.168 Y70.796 E0.00264

G1 X90.167 Y70.801 F9000.000

G1 F2400.000

G1 X89.520 Y70.662 E0.00319

G1 X88.081 Y70.409 F9000.000

G1 F2400.000

G1 X87.686 Y70.376 E0.00823

G1 X87.403 Y70.366 E0.00509

G1 X86.924 Y70.374 E0.00777

G1 X86.292 Y70.436 E0.01029

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.924 Y70.374 E-0.35178

G1 X87.403 Y70.366 E-0.26548

G1 E-0.34275 F4200.00000

G1 Z10.150 F9000.000

G1 X83.542 Y71.235

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.996 Y70.781 E0.01779

G1 X83.365 Y70.783 E0.01749

G1 X83.101 Y71.047 E0.01037

G1 X82.471 Y71.048 E0.01746

G1 X82.923 Y70.596 E0.01772

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.471 Y71.048 E-0.35412

G1 X83.101 Y71.047 E-0.34892

G1 X83.365 Y70.783 E-0.20714

G1 X83.368 Y70.783 E-0.00183

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.887 Y77.741

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.921 Y77.066 E0.03219

G1 X83.153 Y76.965 E0.00659

G1 X83.362 Y76.911 E0.00562

G1 X91.112 Y76.932 E0.20192

G1 X91.386 Y76.994 E0.00730

G1 X91.612 Y77.092 E0.00644

G1 X92.586 Y77.735 E0.03040

G1 X92.585 Y77.853 E0.00307

G1 X81.888 Y77.854 E0.27873

G1 X81.887 Y77.800 E0.00139

M204 S1250

G1 X81.482 Y77.597 F9000.000

M204 S800

G1 F1500.000

G1 X81.585 Y77.439 E0.00491

G1 X82.723 Y76.697 E0.03539

G1 X83.017 Y76.569 E0.00837

G1 X83.311 Y76.493 E0.00791

G1 X91.164 Y76.515 E0.20462

G1 X91.479 Y76.579 E0.00837

G1 X91.812 Y76.723 E0.00945

G1 X92.884 Y77.431 E0.03348

G1 X92.988 Y77.555 E0.00421

G1 X93.004 Y77.626 E0.00189

G1 X93.002 Y77.960 E0.00870

G1 X92.946 Y78.120 E0.00441

G1 X92.858 Y78.231 E0.00369

G1 X92.718 Y78.270 E0.00379

G1 X81.762 Y78.272 E0.28547

G1 X81.660 Y78.252 E0.00272

G1 X81.517 Y78.111 E0.00522

G1 X81.472 Y77.943 E0.00455

G1 X81.471 Y77.656 E0.00748

M204 S1250

G1 X81.668 Y77.566 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.585 Y77.439 E-0.13567

G1 X82.723 Y76.697 E-0.75278

G1 X82.762 Y76.680 E-0.02355

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.090 Y77.727

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.453 Y77.364 E0.01386

G1 X91.288 Y77.293 E0.00484

G1 X91.077 Y77.246 E0.00583

G1 X90.960 Y77.245 E0.00318

G1 X90.665 Y77.539 E0.01122

G1 X90.053 Y77.540 E0.01652

G1 X90.349 Y77.244 E0.01128

G1 X89.738 Y77.243 E0.01649

G1 X89.441 Y77.540 E0.01133

G1 X88.829 Y77.540 E0.01652

G1 X89.127 Y77.242 E0.01138

G1 X88.516 Y77.240 E0.01649

G1 X88.217 Y77.540 E0.01143

G1 X87.605 Y77.540 E0.01652

G1 X87.905 Y77.239 E0.01149

G1 X87.295 Y77.238 E0.01649

G1 X86.992 Y77.540 E0.01154

G1 X86.380 Y77.540 E0.01652

G1 X86.684 Y77.236 E0.01159

G1 X86.073 Y77.235 E0.01649

G1 X85.768 Y77.540 E0.01165

G1 X85.156 Y77.540 E0.01652

G1 X85.462 Y77.234 E0.01170

G1 X84.851 Y77.232 E0.01649

G1 X84.544 Y77.540 E0.01175

G1 X83.931 Y77.540 E0.01652

G1 X84.241 Y77.231 E0.01181

G1 X83.633 Y77.227 E0.01641

G1 X83.131 Y77.728 E0.01915

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.633 Y77.227 E-0.39317

G1 X84.241 Y77.231 E-0.33690

G1 X84.009 Y77.463 E-0.18193

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.894 Y83.472

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.085 Y83.460 E0.10919

G1 X85.344 Y83.733 E0.02057

G1 X84.268 Y84.259 E0.03120

G1 X84.143 Y84.300 E0.00344

G1 X83.820 Y84.358 E0.00854

G1 X81.908 Y84.360 E0.04982

G1 X81.892 Y84.334 E0.00080

G1 X81.894 Y83.532 E0.02090

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y83.504 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X88.290 Y83.431

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y83.435 E0.11224

G1 X92.592 Y84.318 E0.02299

G1 X92.581 Y84.359 E0.00111

G1 X92.551 Y84.370 E0.00083

G1 X90.570 Y84.358 E0.05162

G1 X90.299 Y84.291 E0.00727

G1 X89.913 Y84.065 E0.01166

G1 X89.794 Y84.047 E0.00313

G1 X89.503 Y83.902 E0.00847

G1 X88.499 Y83.489 E0.02829

G1 X88.348 Y83.447 E0.00409

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.994 Y83.443 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X92.843 Y83.046

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.925 Y83.114 E0.00278

G1 X93.005 Y83.285 E0.00494

G1 X93.009 Y84.376 E0.02841

G1 X92.951 Y84.585 E0.00567

G1 X92.832 Y84.708 E0.00446

G1 X92.674 Y84.789 E0.00463

G1 X90.518 Y84.775 E0.05616

G1 X90.140 Y84.683 E0.01014

G1 X89.771 Y84.466 E0.01116

G1 X89.666 Y84.450 E0.00276

G1 X89.330 Y84.283 E0.00979

G1 X88.363 Y83.885 E0.02724

G1 X88.058 Y83.800 E0.00825

G1 X87.632 Y83.722 E0.01128

G1 X87.384 Y83.703 E0.00648

G1 X86.960 Y83.711 E0.01106

G1 X86.625 Y83.760 E0.00883

G1 X86.165 Y83.871 E0.01233

G1 X85.510 Y84.118 E0.01824

G1 X84.426 Y84.646 E0.03142

G1 X84.246 Y84.706 E0.00494

G1 X83.857 Y84.776 E0.01027

G1 X81.791 Y84.778 E0.05385

G1 X81.624 Y84.700 E0.00480

G1 X81.493 Y84.479 E0.00671

G1 X81.474 Y84.373 E0.00280

G1 X81.476 Y83.320 E0.02742

G1 X81.518 Y83.170 E0.00406

G1 X81.623 Y83.054 E0.00407

G1 X85.817 Y83.046 E0.10927

G1 X88.544 Y83.010 E0.07105

G1 X92.716 Y83.018 E0.10872

G1 X92.784 Y83.033 E0.00181

M204 S1250

G1 X92.849 Y83.152 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y83.114 E-0.08995

G1 X93.005 Y83.285 E-0.10506

G1 X93.009 Y84.376 E-0.60419

G1 X92.955 Y84.572 E-0.11280

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.452 Y84.238

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.942 Y83.748 E0.02167

G1 X91.233 Y83.747 E0.02215

G1 X90.934 Y84.047 E0.01324

G1 X90.609 Y84.045 E0.01017

G1 X90.437 Y84.003 E0.00554

G1 X90.499 Y83.772 E0.00746

G1 X90.713 Y83.559 E0.00944

M204 S1250

G1 X89.612 Y83.723 F9000.000

G1 F2400.000

G1 X90.001 Y83.753 E0.00551

G1 X90.169 Y83.794 E0.00264

G1 X90.167 Y83.799 F9000.000

G1 F2400.000

G1 X89.521 Y83.660 E0.00318

G1 X88.082 Y83.407 F9000.000

G1 F2400.000

G1 X87.685 Y83.374 E0.00825

G1 X87.401 Y83.364 E0.00510

G1 X86.924 Y83.372 E0.00774

G1 X86.292 Y83.434 E0.01029

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.924 Y83.372 E-0.35176

G1 X87.401 Y83.364 E-0.26472

G1 E-0.34352 F4200.00000

G1 Z10.150 F9000.000

G1 X83.541 Y84.233

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.995 Y83.779 E0.01778

G1 X83.365 Y83.781 E0.01748

G1 X83.100 Y84.045 E0.01036

G1 X82.471 Y84.046 E0.01745

G1 X82.923 Y83.594 E0.01772

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.471 Y84.046 E-0.35412

G1 X83.100 Y84.045 E-0.34880

G1 X83.365 Y83.781 E-0.20714

G1 X83.368 Y83.781 E-0.00194

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.887 Y90.738

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.921 Y90.063 E0.03218

G1 X83.153 Y89.963 E0.00658

G1 X83.363 Y89.909 E0.00565

G1 X91.090 Y89.926 E0.20135

G1 X91.386 Y89.991 E0.00790

G1 X91.612 Y90.089 E0.00641

G1 X92.586 Y90.733 E0.03042

G1 X92.585 Y90.850 E0.00306

G1 X81.888 Y90.852 E0.27873

G1 X81.887 Y90.798 E0.00140

M204 S1250

G1 X81.482 Y90.595 F9000.000

M204 S800

G1 F1500.000

G1 X81.585 Y90.437 E0.00491

G1 X82.722 Y89.694 E0.03540

G1 X83.017 Y89.567 E0.00836

G1 X83.311 Y89.491 E0.00791

G1 X91.140 Y89.509 E0.20399

G1 X91.479 Y89.576 E0.00901

G1 X91.812 Y89.721 E0.00945

G1 X92.884 Y90.429 E0.03350

G1 X92.988 Y90.553 E0.00419

G1 X93.004 Y90.624 E0.00191

G1 X93.002 Y90.958 E0.00870

G1 X92.946 Y91.118 E0.00441

G1 X92.859 Y91.228 E0.00367

G1 X92.718 Y91.268 E0.00380

G1 X81.763 Y91.270 E0.28545

G1 X81.660 Y91.250 E0.00273

G1 X81.517 Y91.109 E0.00522

G1 X81.472 Y90.941 E0.00454

G1 X81.471 Y90.654 E0.00748

M204 S1250

G1 X81.668 Y90.564 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.585 Y90.437 E-0.13572

G1 X82.722 Y89.694 E-0.75292

G1 X82.761 Y89.677 E-0.02337

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.089 Y90.725

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.452 Y90.362 E0.01387

G1 X91.289 Y90.291 E0.00479

G1 X91.056 Y90.240 E0.00644

G1 X90.962 Y90.240 E0.00254

G1 X90.665 Y90.537 E0.01135

G1 X90.053 Y90.537 E0.01652

G1 X90.351 Y90.239 E0.01140

G1 X89.740 Y90.238 E0.01649

G1 X89.440 Y90.537 E0.01144

G1 X88.828 Y90.537 E0.01652

G1 X89.129 Y90.237 E0.01148

G1 X88.518 Y90.236 E0.01649

G1 X88.216 Y90.537 E0.01152

G1 X87.604 Y90.538 E0.01652

G1 X87.907 Y90.235 E0.01156

G1 X87.296 Y90.234 E0.01649

G1 X86.992 Y90.538 E0.01161

G1 X86.379 Y90.538 E0.01652

G1 X86.685 Y90.233 E0.01165

G1 X86.073 Y90.232 E0.01649

G1 X85.767 Y90.538 E0.01169

G1 X85.155 Y90.538 E0.01652

G1 X85.462 Y90.231 E0.01173

G1 X84.851 Y90.230 E0.01649

G1 X84.543 Y90.538 E0.01177

G1 X83.931 Y90.538 E0.01652

G1 X84.240 Y90.228 E0.01182

G1 X83.632 Y90.225 E0.01642

G1 X83.130 Y90.726 E0.01915

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.632 Y90.225 E-0.39324

G1 X84.240 Y90.228 E-0.33703

G1 X84.008 Y90.460 E-0.18173

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.894 Y96.470

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.085 Y96.458 E0.10920

G1 X85.344 Y96.731 E0.02058

G1 X84.268 Y97.257 E0.03120

G1 X84.143 Y97.298 E0.00344

G1 X83.820 Y97.356 E0.00854

G1 X81.908 Y97.358 E0.04982

G1 X81.892 Y97.331 E0.00080

G1 X81.894 Y96.530 E0.02089

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y96.502 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X88.287 Y96.428

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y96.433 E0.11232

G1 X92.592 Y97.316 E0.02299

G1 X92.581 Y97.357 E0.00111

G1 X92.551 Y97.368 E0.00083

G1 X90.570 Y97.356 E0.05162

G1 X90.299 Y97.289 E0.00727

G1 X89.913 Y97.063 E0.01166

G1 X89.794 Y97.045 E0.00312

G1 X89.503 Y96.900 E0.00848

G1 X88.499 Y96.487 E0.02829

G1 X88.345 Y96.444 E0.00416

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.991 Y96.440 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X92.843 Y96.044

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.925 Y96.112 E0.00278

G1 X93.005 Y96.283 E0.00494

G1 X93.009 Y97.374 E0.02841

G1 X92.951 Y97.583 E0.00565

G1 X92.831 Y97.707 E0.00449

G1 X92.674 Y97.787 E0.00462

G1 X90.518 Y97.773 E0.05616

G1 X90.140 Y97.681 E0.01014

G1 X89.771 Y97.464 E0.01116

G1 X89.666 Y97.448 E0.00275

G1 X89.330 Y97.280 E0.00979

G1 X88.363 Y96.883 E0.02724

G1 X88.058 Y96.798 E0.00825

G1 X87.632 Y96.720 E0.01128

G1 X87.384 Y96.701 E0.00648

G1 X86.960 Y96.709 E0.01106

G1 X86.625 Y96.758 E0.00883

G1 X86.165 Y96.869 E0.01233

G1 X85.510 Y97.116 E0.01824

G1 X84.426 Y97.644 E0.03142

G1 X84.246 Y97.704 E0.00494

G1 X83.857 Y97.774 E0.01027

G1 X81.791 Y97.776 E0.05385

G1 X81.624 Y97.698 E0.00480

G1 X81.493 Y97.476 E0.00671

G1 X81.474 Y97.371 E0.00279

G1 X81.476 Y96.318 E0.02743

G1 X81.518 Y96.168 E0.00405

G1 X81.623 Y96.052 E0.00407

G1 X85.817 Y96.044 E0.10928

G1 X88.544 Y96.007 E0.07105

G1 X92.716 Y96.016 E0.10872

G1 X92.784 Y96.031 E0.00181

M204 S1250

G1 X92.849 Y96.150 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y96.112 E-0.08995

G1 X93.005 Y96.283 E-0.10509

G1 X93.009 Y97.374 E-0.60416

G1 X92.955 Y97.570 E-0.11281

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.452 Y97.236

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.942 Y96.746 E0.02168

G1 X91.234 Y96.745 E0.02214

G1 X90.934 Y97.045 E0.01325

G1 X90.609 Y97.043 E0.01017

G1 X90.436 Y97.000 E0.00557

G1 X90.498 Y96.772 E0.00741

G1 X90.713 Y96.556 E0.00952

M204 S1250

G1 X89.612 Y96.721 F9000.000

G1 F2400.000

G1 X90.001 Y96.750 E0.00551

G1 X90.168 Y96.792 E0.00263

G1 X90.166 Y96.797 F9000.000

G1 F2400.000

G1 X89.521 Y96.658 E0.00319

G1 X88.080 Y96.405 F9000.000

G1 F2400.000

G1 X87.686 Y96.372 E0.00819

G1 X87.401 Y96.362 E0.00511

G1 X86.923 Y96.370 E0.00776

G1 X86.292 Y96.432 E0.01030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.923 Y96.370 E-0.35153

G1 X87.401 Y96.362 E-0.26475

G1 E-0.34372 F4200.00000

G1 Z10.150 F9000.000

G1 X83.541 Y97.231

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.995 Y96.777 E0.01778

G1 X83.365 Y96.779 E0.01748

G1 X83.100 Y97.043 E0.01036

G1 X82.471 Y97.044 E0.01745

G1 X82.923 Y96.592 E0.01772

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.471 Y97.044 E-0.35414

G1 X83.100 Y97.043 E-0.34881

G1 X83.365 Y96.779 E-0.20717

G1 X83.368 Y96.779 E-0.00189

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.887 Y103.736

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.921 Y103.061 E0.03218

G1 X83.153 Y102.961 E0.00658

G1 X83.363 Y102.907 E0.00565

G1 X91.091 Y102.924 E0.20137

G1 X91.385 Y102.988 E0.00783

G1 X91.612 Y103.087 E0.00645

G1 X92.586 Y103.731 E0.03042

G1 X92.585 Y103.848 E0.00306

G1 X81.888 Y103.850 E0.27872

G1 X81.887 Y103.796 E0.00140

M204 S1250

G1 X81.482 Y103.593 F9000.000

M204 S800

G1 F1500.000

G1 X81.585 Y103.435 E0.00491

G1 X82.722 Y102.692 E0.03540

G1 X83.017 Y102.565 E0.00836

G1 X83.311 Y102.489 E0.00791

G1 X91.141 Y102.507 E0.20400

G1 X91.479 Y102.574 E0.00899

G1 X91.812 Y102.719 E0.00946

G1 X92.884 Y103.427 E0.03350

G1 X92.988 Y103.551 E0.00419

G1 X93.004 Y103.622 E0.00191

G1 X93.002 Y103.956 E0.00870

G1 X92.946 Y104.116 E0.00441

G1 X92.859 Y104.226 E0.00367

G1 X92.718 Y104.266 E0.00380

G1 X81.763 Y104.268 E0.28545

G1 X81.660 Y104.248 E0.00272

G1 X81.517 Y104.107 E0.00522

G1 X81.472 Y103.938 E0.00456

G1 X81.471 Y103.652 E0.00746

M204 S1250

G1 X81.668 Y103.562 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.585 Y103.435 E-0.13572

G1 X82.722 Y102.692 E-0.75292

G1 X82.761 Y102.675 E-0.02337

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.089 Y103.723

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.452 Y103.360 E0.01387

G1 X91.288 Y103.288 E0.00484

G1 X91.057 Y103.238 E0.00638

G1 X90.962 Y103.238 E0.00256

G1 X90.665 Y103.535 E0.01135

G1 X90.053 Y103.535 E0.01652

G1 X90.351 Y103.237 E0.01140

G1 X89.740 Y103.236 E0.01649

G1 X89.440 Y103.535 E0.01144

G1 X88.828 Y103.535 E0.01652

G1 X89.129 Y103.235 E0.01148

G1 X88.518 Y103.234 E0.01649

G1 X88.216 Y103.535 E0.01152

G1 X87.604 Y103.536 E0.01652

G1 X87.907 Y103.233 E0.01156

G1 X87.296 Y103.232 E0.01649

G1 X86.992 Y103.536 E0.01161

G1 X86.379 Y103.536 E0.01652

G1 X86.685 Y103.231 E0.01165

G1 X86.073 Y103.230 E0.01649

G1 X85.767 Y103.536 E0.01169

G1 X85.155 Y103.536 E0.01652

G1 X85.462 Y103.229 E0.01173

G1 X84.851 Y103.228 E0.01649

G1 X84.543 Y103.536 E0.01177

G1 X83.931 Y103.536 E0.01652

G1 X84.240 Y103.226 E0.01182

G1 X83.632 Y103.223 E0.01642

G1 X83.130 Y103.724 E0.01915

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.632 Y103.223 E-0.39324

G1 X84.240 Y103.226 E-0.33703

G1 X84.008 Y103.458 E-0.18173

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.894 Y109.468

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X86.087 Y109.456 E0.10925

G1 X85.344 Y109.729 E0.02062

G1 X84.268 Y110.254 E0.03119

G1 X84.143 Y110.296 E0.00344

G1 X83.820 Y110.354 E0.00855

G1 X81.908 Y110.356 E0.04981

G1 X81.892 Y110.329 E0.00081

G1 X81.894 Y109.528 E0.02089

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y109.499 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X88.287 Y109.426

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y109.430 E0.11233

G1 X92.592 Y110.314 E0.02301

G1 X92.581 Y110.354 E0.00110

G1 X92.551 Y110.366 E0.00083

G1 X90.570 Y110.354 E0.05163

G1 X90.299 Y110.287 E0.00727

G1 X89.915 Y110.063 E0.01158

G1 X89.796 Y110.044 E0.00314

G1 X89.503 Y109.897 E0.00854

G1 X88.499 Y109.485 E0.02828

G1 X88.345 Y109.442 E0.00417

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.990 Y109.438 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X92.842 Y109.042

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.925 Y109.110 E0.00279

G1 X93.005 Y109.281 E0.00494

G1 X93.009 Y110.372 E0.02841

G1 X92.951 Y110.580 E0.00564

G1 X92.832 Y110.704 E0.00447

G1 X92.673 Y110.785 E0.00464

G1 X90.518 Y110.771 E0.05616

G1 X90.140 Y110.679 E0.01014

G1 X89.772 Y110.463 E0.01113

G1 X89.667 Y110.446 E0.00276

G1 X89.330 Y110.278 E0.00981

G1 X88.363 Y109.881 E0.02723

G1 X88.058 Y109.796 E0.00825

G1 X87.633 Y109.719 E0.01126

G1 X87.385 Y109.698 E0.00649

G1 X86.960 Y109.707 E0.01107

G1 X86.625 Y109.756 E0.00882

G1 X86.165 Y109.867 E0.01233

G1 X85.510 Y110.113 E0.01824

G1 X84.426 Y110.642 E0.03143

G1 X84.246 Y110.702 E0.00494

G1 X83.857 Y110.772 E0.01028

G1 X81.791 Y110.774 E0.05384

G1 X81.624 Y110.696 E0.00481

G1 X81.493 Y110.474 E0.00670

G1 X81.474 Y110.368 E0.00282

G1 X81.476 Y109.316 E0.02741

G1 X81.518 Y109.166 E0.00405

G1 X81.623 Y109.050 E0.00407

G1 X85.817 Y109.041 E0.10927

G1 X88.544 Y109.005 E0.07105

G1 X92.716 Y109.013 E0.10870

G1 X92.784 Y109.028 E0.00182

M204 S1250

G1 X92.849 Y109.148 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.925 Y109.110 E-0.09028

G1 X93.005 Y109.281 E-0.10509

G1 X93.009 Y110.372 E-0.60416

G1 X92.955 Y110.567 E-0.11247

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.452 Y110.234

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.942 Y109.743 E0.02171

G1 X91.234 Y109.742 E0.02215

G1 X90.934 Y110.043 E0.01328

G1 X90.609 Y110.041 E0.01016

G1 X90.434 Y109.998 E0.00564

G1 X90.498 Y109.769 E0.00743

G1 X90.714 Y109.554 E0.00951

M204 S1250

G1 X89.610 Y109.717 F9000.000

G1 F2400.000

G1 X90.005 Y109.749 E0.00606

G1 X90.167 Y109.790 E0.00254

G1 X90.166 Y109.794 F9000.000

G1 F2400.000

G1 X89.521 Y109.655 E0.00318

G1 X88.079 Y109.403 F9000.000

G1 F2400.000

G1 X87.687 Y109.370 E0.00817

G1 X87.402 Y109.359 E0.00512

G1 X86.923 Y109.368 E0.00776

G1 X86.294 Y109.430 E0.01024

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.923 Y109.368 E-0.35030

G1 X87.402 Y109.359 E-0.26553

G1 E-0.34417 F4200.00000

G1 Z10.150 F9000.000

G1 X83.541 Y110.229

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.995 Y109.775 E0.01780

G1 X83.365 Y109.777 E0.01748

G1 X83.100 Y110.041 E0.01037

G1 X82.471 Y110.042 E0.01745

G1 X82.923 Y109.590 E0.01772

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.471 Y110.042 E-0.35424

G1 X83.100 Y110.041 E-0.34880

G1 X83.365 Y109.777 E-0.20734

G1 X83.368 Y109.777 E-0.00163

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X81.886 Y116.735

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.921 Y116.059 E0.03220

G1 X83.153 Y115.959 E0.00658

G1 X83.363 Y115.905 E0.00565

G1 X91.112 Y115.925 E0.20192

G1 X91.385 Y115.986 E0.00728

G1 X91.612 Y116.085 E0.00645

G1 X92.586 Y116.729 E0.03042

G1 X92.585 Y116.846 E0.00306

G1 X81.888 Y116.848 E0.27872

G1 X81.887 Y116.795 E0.00139

M204 S1250

G1 X81.482 Y116.590 F9000.000

M204 S800

G1 F1500.000

G1 X81.584 Y116.433 E0.00488

G1 X82.722 Y115.690 E0.03541

G1 X83.017 Y115.563 E0.00836

G1 X83.311 Y115.487 E0.00791

G1 X91.164 Y115.508 E0.20462

G1 X91.479 Y115.572 E0.00836

G1 X91.812 Y115.717 E0.00946

G1 X92.884 Y116.425 E0.03350

G1 X92.988 Y116.549 E0.00419

G1 X93.004 Y116.620 E0.00191

G1 X93.002 Y116.954 E0.00870

G1 X92.946 Y117.113 E0.00441

G1 X92.858 Y117.224 E0.00368

G1 X92.718 Y117.264 E0.00380

G1 X81.763 Y117.266 E0.28545

G1 X81.660 Y117.246 E0.00272

G1 X81.517 Y117.105 E0.00522

G1 X81.472 Y116.936 E0.00456

G1 X81.471 Y116.649 E0.00749

M204 S1250

G1 X81.667 Y116.560 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.584 Y116.433 E-0.13515

G1 X82.722 Y115.690 E-0.75304

G1 X82.762 Y115.673 E-0.02381

G1 E-0.04800 F4200.00000

G1 Z10.150 F9000.000

G1 X91.089 Y116.721

G1 Z9.950

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.452 Y116.358 E0.01387

G1 X91.287 Y116.286 E0.00486

G1 X91.077 Y116.239 E0.00580

G1 X90.959 Y116.238 E0.00318

G1 X90.665 Y116.533 E0.01125

G1 X90.053 Y116.533 E0.01652

G1 X90.349 Y116.237 E0.01130

G1 X89.738 Y116.236 E0.01649

G1 X89.440 Y116.533 E0.01135

G1 X88.828 Y116.533 E0.01652

G1 X89.127 Y116.235 E0.01140

G1 X88.516 Y116.233 E0.01649

G1 X88.216 Y116.533 E0.01145

G1 X87.604 Y116.534 E0.01652

G1 X87.905 Y116.232 E0.01150

G1 X87.294 Y116.231 E0.01649

G1 X86.992 Y116.534 E0.01156

G1 X86.379 Y116.534 E0.01652

G1 X86.684 Y116.230 E0.01161

G1 X86.073 Y116.228 E0.01649

G1 X85.767 Y116.534 E0.01166

G1 X85.155 Y116.534 E0.01652

G1 X85.462 Y116.227 E0.01171

G1 X84.851 Y116.226 E0.01649

G1 X84.543 Y116.534 E0.01176

G1 X83.931 Y116.534 E0.01652

G1 X84.240 Y116.224 E0.01182

G1 X83.632 Y116.221 E0.01642

G1 X83.130 Y116.722 E0.01915

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;10.1

G1 Z10.100 F9000.000

;AFTER\_LAYER\_CHANGE

;10.1

G1 X81.887 Y116.757

M204 S800

G1 F1500.000

G1 X81.887 Y116.735 E0.00058

G1 X83.120 Y115.925 E0.03844

G1 X83.378 Y115.806 E0.00740

G1 X83.621 Y115.749 E0.00650

G1 X90.782 Y115.733 E0.18659

G1 X91.217 Y115.857 E0.01178

G1 X91.410 Y115.953 E0.00561

G1 X92.591 Y116.733 E0.03687

G1 X92.591 Y116.760 E0.00072

G1 X88.007 Y116.763 E0.11944

G1 X85.075 Y116.741 E0.07640

G1 X81.947 Y116.757 E0.08151

M204 S1250

G1 X81.660 Y117.158 F9000.000

M204 S800

G1 F1500.000

G1 X81.518 Y117.013 E0.00527

G1 X81.471 Y116.834 E0.00483

G1 X81.482 Y116.589 E0.00639

G1 X81.585 Y116.433 E0.00488

G1 X82.917 Y115.559 E0.04150

G1 X83.242 Y115.409 E0.00933

G1 X83.573 Y115.332 E0.00885

G1 X90.813 Y115.315 E0.18867

G1 X91.072 Y115.369 E0.00687

G1 X91.176 Y115.421 E0.00303

G1 X91.356 Y115.459 E0.00480

G1 X91.619 Y115.590 E0.00765

G1 X92.884 Y116.426 E0.03951

G1 X92.994 Y116.568 E0.00468

G1 X93.006 Y116.638 E0.00183

G1 X93.010 Y116.806 E0.00439

G1 X92.962 Y117.004 E0.00530

G1 X92.867 Y117.130 E0.00412

G1 X92.707 Y117.179 E0.00436

G1 X88.006 Y117.181 E0.12250

G1 X85.074 Y117.159 E0.07638

G1 X81.719 Y117.168 E0.08742

M204 S1250

G1 X81.662 Y116.955 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.518 Y117.013 E-0.14060

G1 X81.471 Y116.834 E-0.10273

G1 X81.482 Y116.589 E-0.13583

G1 X81.585 Y116.433 E-0.10381

G1 X82.233 Y116.008 E-0.42903

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X91.253 Y116.637

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.672 Y116.056 E0.02154

G1 X90.078 Y116.056 E0.01557

G1 X90.471 Y116.449 E0.01456

G1 X89.876 Y116.449 E0.01558

G1 X89.484 Y116.057 E0.01454

G1 X88.890 Y116.058 E0.01557

G1 X89.282 Y116.449 E0.01453

G1 X88.688 Y116.450 E0.01558

G1 X88.296 Y116.058 E0.01451

G1 X87.702 Y116.059 E0.01557

G1 X88.093 Y116.450 E0.01450

G1 X87.495 Y116.446 E0.01569

G1 X87.108 Y116.059 E0.01433

G1 X86.514 Y116.060 E0.01557

G1 X86.896 Y116.441 E0.01414

G1 X86.297 Y116.437 E0.01571

G1 X85.920 Y116.060 E0.01395

G1 X85.326 Y116.061 E0.01557

G1 X85.697 Y116.432 E0.01376

G1 X85.098 Y116.428 E0.01571

G1 X84.732 Y116.062 E0.01357

G1 X84.138 Y116.062 E0.01557

G1 X84.506 Y116.430 E0.01365

G1 X83.915 Y116.433 E0.01551

G1 X83.566 Y116.084 E0.01295

G1 X83.480 Y116.104 E0.00230

G1 X83.273 Y116.200 E0.00599

G1 X83.160 Y116.273 E0.00352

G1 X83.511 Y116.623 E0.01298

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.160 Y116.273 E-0.27439

G1 X83.273 Y116.200 E-0.07436

G1 X83.480 Y116.104 E-0.12671

G1 X83.566 Y116.084 E-0.04861

G1 X83.915 Y116.433 E-0.27382

G1 X84.121 Y116.432 E-0.11412

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.920 Y110.549

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y110.499 E0.00149

G1 X81.884 Y109.545 E0.02485

G1 X85.873 Y109.530 E0.10394

G1 X85.334 Y109.734 E0.01503

G1 X84.593 Y110.090 E0.02141

G1 X84.046 Y110.386 E0.01621

G1 X83.858 Y110.457 E0.00522

G1 X83.523 Y110.532 E0.00895

G1 X81.980 Y110.548 E0.04021

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.893 Y110.499 E-0.05549

G1 X81.884 Y109.545 E-0.52850

G1 X82.476 Y109.543 E-0.32801

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X88.580 Y109.520

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y109.529 E0.10455

G1 X92.585 Y110.491 E0.02508

G1 X92.556 Y110.554 E0.00179

G1 X91.012 Y110.539 E0.04024

G1 X90.847 Y110.521 E0.00431

G1 X90.511 Y110.420 E0.00914

G1 X89.875 Y110.047 E0.01922

G1 X89.771 Y110.031 E0.00274

G1 X89.536 Y109.913 E0.00687

G1 X88.635 Y109.543 E0.02536

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.281 Y109.537 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X92.846 Y109.135

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.965 Y109.265 E0.00460

G1 X93.010 Y109.442 E0.00474

G1 X93.000 Y110.561 E0.02917

G1 X92.957 Y110.711 E0.00406

G1 X92.878 Y110.846 E0.00407

G1 X92.714 Y110.973 E0.00541

G1 X90.988 Y110.957 E0.04499

G1 X90.764 Y110.933 E0.00586

G1 X90.343 Y110.806 E0.01145

G1 X89.731 Y110.448 E0.01848

G1 X89.642 Y110.433 E0.00236

G1 X89.363 Y110.294 E0.00814

G1 X88.346 Y109.875 E0.02866

G1 X88.057 Y109.796 E0.00781

G1 X87.619 Y109.711 E0.01163

G1 X87.355 Y109.685 E0.00689

G1 X86.957 Y109.694 E0.01039

G1 X86.167 Y109.866 E0.02107

G1 X85.498 Y110.118 E0.01861

G1 X84.783 Y110.462 E0.02068

G1 X84.220 Y110.767 E0.01668

G1 X83.979 Y110.858 E0.00673

G1 X83.571 Y110.949 E0.01087

G1 X81.785 Y110.968 E0.04654

G1 X81.701 Y110.933 E0.00238

G1 X81.547 Y110.757 E0.00610

G1 X81.476 Y110.545 E0.00582

G1 X81.466 Y109.512 E0.02690

G1 X81.482 Y109.362 E0.00395

G1 X81.535 Y109.235 E0.00358

G1 X81.646 Y109.128 E0.00401

G1 X89.552 Y109.098 E0.20601

G1 X92.787 Y109.124 E0.08430

M204 S1250

G1 X92.840 Y109.311 F9000.000

G1 X92.267 Y110.426

M204 S1000

G1 F4800.000

G1 X91.681 Y109.840 E0.02470

G1 X91.003 Y109.839 E0.02020

G1 X91.394 Y110.229 E0.01647

G1 X90.910 Y110.213 E0.01445

G1 X90.638 Y110.131 E0.00847

G1 X90.433 Y109.944 E0.00828

M204 S1250

G1 X90.321 Y109.852 F9000.000

G1 F2400.000

G1 X89.957 Y109.787 E0.00299

G1 X89.711 Y109.767 E0.00199

G1 X88.374 Y109.486 F9000.000

G1 F2400.000

G1 X88.142 Y109.455 E0.00448

G1 X87.899 Y109.432 E0.00433

G1 X87.667 Y109.410 E0.00345

G1 X87.372 Y109.396 E0.00354

G1 X86.930 Y109.401 E0.00442

G1 X86.636 Y109.433 E0.00296

G1 X86.079 Y109.494 E0.00929

G1 X84.740 Y109.761 F9000.000

G1 F2400.000

G1 X84.166 Y109.900 E0.00626

G1 X83.674 Y110.370 F9000.000

M204 S1000

G1 F4800.000

G1 X83.158 Y109.853 E0.02253

G1 X82.460 Y109.856 E0.02153

G1 X83.016 Y110.412 E0.02426

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.460 Y109.856 E-0.43541

G1 X83.158 Y109.853 E-0.38650

G1 X83.273 Y109.968 E-0.09009

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.887 Y103.759

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y103.737 E0.00059

G1 X83.120 Y102.927 E0.03843

G1 X83.378 Y102.808 E0.00740

G1 X83.621 Y102.751 E0.00650

G1 X90.783 Y102.735 E0.18660

G1 X90.924 Y102.765 E0.00376

G1 X91.038 Y102.822 E0.00332

G1 X91.219 Y102.859 E0.00482

G1 X91.410 Y102.955 E0.00557

G1 X92.591 Y103.735 E0.03687

G1 X92.591 Y103.763 E0.00073

G1 X88.007 Y103.765 E0.11944

G1 X85.075 Y103.743 E0.07640

M73 P86 R9

G1 X81.947 Y103.759 E0.08151

M204 S1250

G1 X81.660 Y104.160 F9000.000

M204 S800

G1 F1500.000

G1 X81.518 Y104.015 E0.00527

G1 X81.471 Y103.836 E0.00483

G1 X81.482 Y103.592 E0.00636

G1 X81.586 Y103.435 E0.00491

G1 X82.917 Y102.561 E0.04149

G1 X83.242 Y102.411 E0.00933

G1 X83.573 Y102.334 E0.00885

G1 X90.814 Y102.317 E0.18867

G1 X91.071 Y102.371 E0.00685

G1 X91.176 Y102.424 E0.00306

G1 X91.357 Y102.461 E0.00481

G1 X91.619 Y102.592 E0.00763

G1 X92.884 Y103.428 E0.03951

G1 X92.994 Y103.570 E0.00468

G1 X93.006 Y103.640 E0.00183

G1 X93.010 Y103.808 E0.00439

G1 X92.962 Y104.006 E0.00530

G1 X92.867 Y104.132 E0.00412

G1 X92.707 Y104.181 E0.00436

G1 X88.006 Y104.183 E0.12250

G1 X85.074 Y104.161 E0.07637

G1 X81.719 Y104.170 E0.08742

M204 S1250

G1 X81.662 Y103.957 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.518 Y104.015 E-0.14060

G1 X81.471 Y103.836 E-0.10273

G1 X81.482 Y103.592 E-0.13534

G1 X81.586 Y103.435 E-0.10435

G1 X82.233 Y103.010 E-0.42899

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X91.253 Y103.639

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.672 Y103.058 E0.02154

G1 X90.078 Y103.059 E0.01557

G1 X90.471 Y103.451 E0.01455

G1 X89.876 Y103.451 E0.01558

G1 X89.484 Y103.059 E0.01454

G1 X88.890 Y103.060 E0.01557

G1 X89.282 Y103.451 E0.01452

G1 X88.687 Y103.452 E0.01558

G1 X88.296 Y103.060 E0.01451

G1 X87.702 Y103.061 E0.01557

G1 X88.093 Y103.452 E0.01450

G1 X87.495 Y103.448 E0.01569

G1 X87.108 Y103.061 E0.01433

G1 X86.514 Y103.062 E0.01557

G1 X86.896 Y103.443 E0.01414

G1 X86.297 Y103.439 E0.01571

G1 X85.920 Y103.063 E0.01396

G1 X85.326 Y103.063 E0.01557

G1 X85.697 Y103.434 E0.01377

G1 X85.098 Y103.430 E0.01571

G1 X84.732 Y103.064 E0.01358

G1 X84.138 Y103.064 E0.01557

G1 X84.507 Y103.433 E0.01366

G1 X83.915 Y103.436 E0.01551

G1 X83.565 Y103.086 E0.01296

G1 X83.480 Y103.106 E0.00229

G1 X83.273 Y103.202 E0.00599

G1 X83.160 Y103.275 E0.00352

G1 X83.510 Y103.626 E0.01299

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.160 Y103.275 E-0.27446

G1 X83.273 Y103.202 E-0.07448

G1 X83.480 Y103.106 E-0.12671

G1 X83.565 Y103.086 E-0.04847

G1 X83.915 Y103.436 E-0.27398

G1 X84.120 Y103.435 E-0.11390

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.920 Y97.551

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y97.501 E0.00149

G1 X81.884 Y96.547 E0.02486

G1 X85.874 Y96.532 E0.10395

G1 X85.334 Y96.736 E0.01504

G1 X84.593 Y97.092 E0.02140

G1 X84.046 Y97.388 E0.01622

G1 X83.858 Y97.459 E0.00522

G1 X83.523 Y97.534 E0.00896

G1 X81.980 Y97.551 E0.04020

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.893 Y97.501 E-0.05560

G1 X81.884 Y96.547 E-0.52869

G1 X82.476 Y96.545 E-0.32771

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X88.580 Y96.522

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y96.531 E0.10455

G1 X92.585 Y97.493 E0.02507

G1 X92.556 Y97.556 E0.00181

G1 X91.012 Y97.541 E0.04023

G1 X90.847 Y97.523 E0.00432

G1 X90.511 Y97.422 E0.00914

G1 X89.872 Y97.048 E0.01930

G1 X89.769 Y97.032 E0.00272

G1 X89.536 Y96.916 E0.00680

G1 X88.635 Y96.545 E0.02538

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.281 Y96.539 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X92.847 Y96.137

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.965 Y96.267 E0.00459

G1 X93.010 Y96.444 E0.00474

G1 X93.000 Y97.563 E0.02917

G1 X92.957 Y97.713 E0.00406

G1 X92.878 Y97.849 E0.00410

G1 X92.713 Y97.976 E0.00542

G1 X90.988 Y97.959 E0.04497

G1 X90.764 Y97.935 E0.00586

G1 X90.343 Y97.808 E0.01145

G1 X89.731 Y97.449 E0.01851

G1 X89.641 Y97.436 E0.00235

G1 X89.363 Y97.296 E0.00812

G1 X88.346 Y96.877 E0.02866

G1 X88.057 Y96.798 E0.00781

G1 X87.618 Y96.713 E0.01163

G1 X87.355 Y96.687 E0.00689

G1 X86.957 Y96.696 E0.01038

G1 X86.166 Y96.868 E0.02108

G1 X85.498 Y97.121 E0.01861

G1 X84.783 Y97.464 E0.02068

G1 X84.220 Y97.769 E0.01668

G1 X83.979 Y97.860 E0.00673

G1 X83.571 Y97.951 E0.01088

G1 X81.785 Y97.971 E0.04655

G1 X81.701 Y97.936 E0.00237

G1 X81.547 Y97.759 E0.00612

G1 X81.476 Y97.547 E0.00581

G1 X81.466 Y96.514 E0.02691

G1 X81.482 Y96.364 E0.00395

G1 X81.535 Y96.237 E0.00358

G1 X81.646 Y96.130 E0.00401

G1 X89.552 Y96.100 E0.20601

G1 X92.788 Y96.126 E0.08431

M204 S1250

G1 X92.841 Y96.313 F9000.000

G1 X92.267 Y97.428

M204 S1000

G1 F4800.000

G1 X91.681 Y96.843 E0.02468

G1 X91.004 Y96.841 E0.02018

G1 X91.394 Y97.231 E0.01646

G1 X90.910 Y97.215 E0.01445

G1 X90.638 Y97.133 E0.00846

G1 X90.433 Y96.946 E0.00826

M204 S1250

G1 X90.322 Y96.853 F9000.000

G1 F2400.000

G1 X89.952 Y96.788 E0.00298

G1 X89.711 Y96.770 E0.00192

G1 X88.374 Y96.488 F9000.000

G1 F2400.000

G1 X88.142 Y96.457 E0.00448

G1 X87.899 Y96.434 E0.00434

G1 X87.667 Y96.412 E0.00345

G1 X87.371 Y96.398 E0.00354

G1 X86.930 Y96.403 E0.00443

G1 X86.636 Y96.435 E0.00298

G1 X86.080 Y96.496 E0.00929

G1 X84.740 Y96.763 F9000.000

G1 F2400.000

G1 X84.166 Y96.902 E0.00626

G1 X83.674 Y97.372 F9000.000

M204 S1000

G1 F4800.000

G1 X83.157 Y96.855 E0.02254

G1 X82.460 Y96.858 E0.02154

G1 X83.016 Y97.414 E0.02427

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.460 Y96.858 E-0.43555

G1 X83.157 Y96.855 E-0.38658

G1 X83.272 Y96.970 E-0.08986

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.887 Y90.761

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y90.739 E0.00059

G1 X83.120 Y89.929 E0.03843

G1 X83.378 Y89.810 E0.00740

G1 X83.621 Y89.753 E0.00650

G1 X90.781 Y89.737 E0.18655

G1 X90.926 Y89.768 E0.00386

G1 X91.039 Y89.824 E0.00330

G1 X91.219 Y89.861 E0.00477

G1 X91.410 Y89.957 E0.00557

G1 X92.591 Y90.737 E0.03687

G1 X92.591 Y90.765 E0.00073

G1 X88.007 Y90.767 E0.11945

G1 X85.075 Y90.746 E0.07640

G1 X81.947 Y90.761 E0.08151

M204 S1250

G1 X81.660 Y91.162 F9000.000

M204 S800

G1 F1500.000

G1 X81.518 Y91.017 E0.00527

G1 X81.471 Y90.839 E0.00481

G1 X81.482 Y90.594 E0.00638

G1 X81.586 Y90.437 E0.00491

G1 X82.917 Y89.563 E0.04149

G1 X83.242 Y89.413 E0.00933

G1 X83.573 Y89.336 E0.00885

G1 X90.813 Y89.319 E0.18865

G1 X91.072 Y89.374 E0.00689

G1 X91.177 Y89.426 E0.00305

G1 X91.357 Y89.463 E0.00480

G1 X91.619 Y89.594 E0.00763

G1 X92.884 Y90.430 E0.03951

G1 X92.994 Y90.572 E0.00468

G1 X93.006 Y90.642 E0.00183

G1 X93.010 Y90.810 E0.00439

G1 X92.962 Y91.008 E0.00530

G1 X92.867 Y91.134 E0.00412

G1 X92.707 Y91.183 E0.00436

G1 X81.719 Y91.172 E0.28629

M204 S1250

G1 X81.661 Y90.959 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.518 Y91.017 E-0.14065

G1 X81.471 Y90.839 E-0.10231

G1 X81.482 Y90.594 E-0.13572

G1 X81.586 Y90.437 E-0.10435

G1 X82.233 Y90.012 E-0.42897

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X91.253 Y90.641

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.672 Y90.060 E0.02152

G1 X90.078 Y90.061 E0.01558

G1 X90.471 Y90.453 E0.01454

G1 X89.876 Y90.453 E0.01558

G1 X89.484 Y90.061 E0.01453

G1 X88.890 Y90.062 E0.01558

G1 X89.282 Y90.454 E0.01452

G1 X88.688 Y90.454 E0.01558

G1 X88.296 Y90.063 E0.01451

G1 X87.702 Y90.063 E0.01558

G1 X88.093 Y90.454 E0.01450

G1 X87.495 Y90.450 E0.01569

G1 X87.108 Y90.064 E0.01434

G1 X86.514 Y90.064 E0.01558

G1 X86.896 Y90.446 E0.01415

G1 X86.297 Y90.441 E0.01571

G1 X85.920 Y90.065 E0.01397

G1 X85.326 Y90.065 E0.01558

G1 X85.698 Y90.437 E0.01378

G1 X85.099 Y90.433 E0.01571

G1 X84.732 Y90.066 E0.01360

G1 X84.138 Y90.066 E0.01558

G1 X84.507 Y90.435 E0.01368

G1 X83.915 Y90.438 E0.01551

G1 X83.565 Y90.088 E0.01298

G1 X83.480 Y90.108 E0.00228

G1 X83.273 Y90.204 E0.00600

G1 X83.160 Y90.278 E0.00353

G1 X83.510 Y90.628 E0.01299

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.160 Y90.278 E-0.27455

G1 X83.273 Y90.204 E-0.07462

G1 X83.480 Y90.108 E-0.12676

G1 X83.565 Y90.088 E-0.04824

G1 X83.915 Y90.438 E-0.27425

G1 X84.120 Y90.437 E-0.11358

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.920 Y84.553

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y84.503 E0.00149

G1 X81.884 Y83.549 E0.02486

G1 X85.873 Y83.534 E0.10392

G1 X85.334 Y83.738 E0.01502

G1 X84.593 Y84.095 E0.02140

G1 X84.046 Y84.390 E0.01620

G1 X83.858 Y84.461 E0.00523

G1 X83.523 Y84.536 E0.00896

G1 X81.980 Y84.553 E0.04020

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.893 Y84.503 E-0.05560

G1 X81.884 Y83.549 E-0.52867

G1 X82.476 Y83.547 E-0.32773

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X88.582 Y83.524

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y83.533 E0.10451

G1 X92.585 Y84.496 E0.02507

G1 X92.557 Y84.558 E0.00180

G1 X91.012 Y84.543 E0.04025

G1 X90.847 Y84.525 E0.00432

G1 X90.511 Y84.424 E0.00914

G1 X89.872 Y84.050 E0.01930

G1 X89.769 Y84.034 E0.00274

G1 X89.536 Y83.918 E0.00678

G1 X88.637 Y83.547 E0.02533

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.283 Y83.542 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X92.847 Y83.139

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.965 Y83.269 E0.00459

G1 X93.010 Y83.446 E0.00474

G1 X93.000 Y84.565 E0.02917

G1 X92.957 Y84.716 E0.00408

G1 X92.878 Y84.850 E0.00407

G1 X92.713 Y84.978 E0.00543

G1 X90.988 Y84.961 E0.04497

G1 X90.764 Y84.937 E0.00586

G1 X90.343 Y84.810 E0.01145

G1 X89.731 Y84.451 E0.01851

G1 X89.641 Y84.437 E0.00235

G1 X89.363 Y84.299 E0.00811

G1 X88.346 Y83.879 E0.02866

G1 X88.057 Y83.800 E0.00781

G1 X87.618 Y83.715 E0.01163

G1 X87.355 Y83.689 E0.00689

G1 X86.957 Y83.698 E0.01038

G1 X86.166 Y83.870 E0.02108

G1 X85.498 Y84.123 E0.01861

G1 X84.783 Y84.467 E0.02068

G1 X84.220 Y84.770 E0.01667

G1 X83.979 Y84.862 E0.00673

G1 X83.571 Y84.953 E0.01087

G1 X81.785 Y84.973 E0.04655

G1 X81.701 Y84.938 E0.00237

G1 X81.547 Y84.761 E0.00612

G1 X81.476 Y84.549 E0.00581

G1 X81.466 Y83.517 E0.02690

G1 X81.482 Y83.366 E0.00396

G1 X81.535 Y83.239 E0.00358

G1 X81.646 Y83.132 E0.00401

G1 X89.552 Y83.103 E0.20601

G1 X92.788 Y83.128 E0.08431

M204 S1250

G1 X92.841 Y83.315 F9000.000

G1 X92.267 Y84.430

M204 S1000

G1 F4800.000

G1 X91.682 Y83.845 E0.02467

G1 X91.004 Y83.843 E0.02017

G1 X91.395 Y84.233 E0.01644

G1 X90.910 Y84.217 E0.01446

G1 X90.638 Y84.135 E0.00846

G1 X90.434 Y83.949 E0.00822

M204 S1250

G1 X90.323 Y83.856 F9000.000

G1 F2400.000

G1 X89.952 Y83.791 E0.00297

G1 X89.711 Y83.772 E0.00191

G1 X88.375 Y83.490 F9000.000

G1 F2400.000

G1 X88.141 Y83.459 E0.00451

G1 X87.899 Y83.436 E0.00433

G1 X87.667 Y83.414 E0.00344

G1 X87.371 Y83.400 E0.00353

G1 X86.930 Y83.406 E0.00441

G1 X86.636 Y83.437 E0.00297

G1 X86.078 Y83.498 E0.00929

G1 X84.740 Y83.765 F9000.000

G1 F2400.000

G1 X84.166 Y83.904 E0.00628

G1 X83.673 Y84.374 F9000.000

M204 S1000

G1 F4800.000

G1 X83.157 Y83.858 E0.02253

G1 X82.460 Y83.860 E0.02154

G1 X83.016 Y84.416 E0.02426

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.460 Y83.860 E-0.43548

G1 X83.157 Y83.858 E-0.38659

G1 X83.272 Y83.972 E-0.08993

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.887 Y77.763

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y77.741 E0.00058

G1 X83.121 Y76.932 E0.03844

G1 X83.379 Y76.812 E0.00742

G1 X83.621 Y76.755 E0.00648

G1 X90.781 Y76.739 E0.18655

G1 X91.218 Y76.864 E0.01184

G1 X91.410 Y76.959 E0.00560

G1 X92.591 Y77.739 E0.03685

G1 X92.591 Y77.767 E0.00073

G1 X88.007 Y77.769 E0.11944

G1 X85.075 Y77.748 E0.07640

G1 X81.947 Y77.763 E0.08151

M204 S1250

G1 X81.660 Y78.164 F9000.000

M204 S800

G1 F1500.000

G1 X81.518 Y78.019 E0.00527

G1 X81.471 Y77.841 E0.00481

G1 X81.482 Y77.596 E0.00638

G1 X81.586 Y77.439 E0.00490

G1 X82.917 Y76.566 E0.04149

G1 X83.242 Y76.415 E0.00934

G1 X83.573 Y76.338 E0.00885

G1 X90.813 Y76.321 E0.18865

G1 X91.072 Y76.376 E0.00689

G1 X91.176 Y76.428 E0.00303

G1 X91.357 Y76.466 E0.00481

G1 X91.619 Y76.596 E0.00764

G1 X92.884 Y77.432 E0.03950

G1 X92.994 Y77.575 E0.00469

G1 X93.006 Y77.644 E0.00182

G1 X93.010 Y77.812 E0.00439

G1 X92.962 Y78.010 E0.00530

G1 X92.866 Y78.136 E0.00413

G1 X92.707 Y78.186 E0.00436

G1 X81.719 Y78.174 E0.28628

M204 S1250

G1 X81.661 Y77.961 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.518 Y78.019 E-0.14064

G1 X81.471 Y77.841 E-0.10233

G1 X81.482 Y77.596 E-0.13568

G1 X81.586 Y77.439 E-0.10416

G1 X82.233 Y77.014 E-0.42919

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X91.254 Y77.643

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.673 Y77.062 E0.02154

G1 X90.079 Y77.063 E0.01557

G1 X90.471 Y77.456 E0.01456

G1 X89.877 Y77.456 E0.01558

G1 X89.485 Y77.063 E0.01454

G1 X88.891 Y77.064 E0.01557

G1 X89.283 Y77.456 E0.01453

G1 X88.688 Y77.456 E0.01558

G1 X88.297 Y77.065 E0.01451

G1 X87.703 Y77.065 E0.01557

G1 X88.094 Y77.456 E0.01450

G1 X87.495 Y77.452 E0.01569

G1 X87.109 Y77.066 E0.01434

G1 X86.515 Y77.066 E0.01557

G1 X86.897 Y77.448 E0.01415

G1 X86.298 Y77.443 E0.01570

G1 X85.921 Y77.067 E0.01397

G1 X85.327 Y77.067 E0.01557

G1 X85.699 Y77.439 E0.01378

G1 X85.100 Y77.435 E0.01570

G1 X84.733 Y77.068 E0.01360

G1 X84.139 Y77.068 E0.01557

G1 X84.508 Y77.437 E0.01368

G1 X83.916 Y77.440 E0.01551

G1 X83.566 Y77.090 E0.01298

G1 X83.481 Y77.110 E0.00228

G1 X83.273 Y77.206 E0.00601

G1 X83.161 Y77.280 E0.00352

G1 X83.511 Y77.630 E0.01299

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.161 Y77.280 E-0.27448

G1 X83.273 Y77.206 E-0.07434

G1 X83.481 Y77.110 E-0.12702

G1 X83.566 Y77.090 E-0.04816

G1 X83.916 Y77.440 E-0.27438

G1 X84.121 Y77.439 E-0.11361

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.920 Y71.555

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y71.505 E0.00148

G1 X81.884 Y70.551 E0.02486

G1 X85.872 Y70.536 E0.10391

G1 X85.334 Y70.740 E0.01501

G1 X84.593 Y71.097 E0.02141

G1 X84.047 Y71.392 E0.01618

G1 X83.859 Y71.463 E0.00521

G1 X83.523 Y71.538 E0.00898

G1 X81.980 Y71.555 E0.04022

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X81.884 Y70.551 E-0.52866

G1 X82.476 Y70.549 E-0.32805

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X88.580 Y70.527

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y70.535 E0.10456

G1 X92.585 Y71.498 E0.02509

G1 X92.556 Y71.561 E0.00179

G1 X91.011 Y71.545 E0.04027

G1 X90.847 Y71.528 E0.00430

G1 X90.521 Y71.429 E0.00887

G1 X90.213 Y71.236 E0.00948

G1 X89.857 Y71.050 E0.01045

G1 X89.769 Y71.037 E0.00233

G1 X89.536 Y70.920 E0.00679

G1 X88.635 Y70.549 E0.02537

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.281 Y70.544 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X92.847 Y70.141

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.965 Y70.271 E0.00459

G1 X93.010 Y70.448 E0.00475

G1 X93.000 Y71.568 E0.02918

G1 X92.957 Y71.718 E0.00406

G1 X92.878 Y71.852 E0.00407

G1 X92.713 Y71.980 E0.00543

G1 X90.987 Y71.963 E0.04497

G1 X90.764 Y71.939 E0.00585

G1 X90.347 Y71.813 E0.01136

G1 X90.005 Y71.599 E0.01052

G1 X89.725 Y71.453 E0.00822

G1 X89.641 Y71.440 E0.00221

G1 X89.363 Y71.301 E0.00811

G1 X88.346 Y70.882 E0.02865

G1 X88.057 Y70.802 E0.00782

G1 X87.618 Y70.718 E0.01163

G1 X87.356 Y70.691 E0.00688

G1 X86.957 Y70.700 E0.01039

G1 X86.166 Y70.872 E0.02108

G1 X85.498 Y71.125 E0.01861

G1 X84.783 Y71.469 E0.02068

G1 X84.220 Y71.773 E0.01667

G1 X83.979 Y71.864 E0.00672

G1 X83.571 Y71.955 E0.01088

G1 X81.785 Y71.975 E0.04655

G1 X81.701 Y71.940 E0.00238

G1 X81.547 Y71.764 E0.00609

G1 X81.476 Y71.551 E0.00583

G1 X81.466 Y70.519 E0.02690

G1 X81.482 Y70.369 E0.00394

G1 X81.535 Y70.241 E0.00361

G1 X81.645 Y70.134 E0.00399

G1 X89.552 Y70.105 E0.20602

G1 X92.788 Y70.130 E0.08431

M204 S1250

G1 X92.841 Y70.317 F9000.000

G1 X92.275 Y71.433

M204 S1000

G1 F4800.000

G1 X91.689 Y70.847 E0.02450

G1 X91.017 Y70.845 E0.01989

G1 X91.407 Y71.236 E0.01633

G1 X90.909 Y71.219 E0.01474

G1 X90.652 Y71.142 E0.00795

G1 X90.453 Y70.953 E0.00810

M204 S1250

G1 X90.342 Y70.858 F9000.000

G1 F2400.000

G1 X89.711 Y70.774 E0.00486

G1 X88.373 Y70.492 F9000.000

G1 F2400.000

G1 X88.142 Y70.462 E0.00446

G1 X87.899 Y70.439 E0.00434

G1 X87.667 Y70.417 E0.00344

G1 X87.372 Y70.402 E0.00353

G1 X86.930 Y70.408 E0.00442

G1 X86.636 Y70.439 E0.00297

G1 X86.078 Y70.500 E0.00929

G1 X84.740 Y70.767 F9000.000

G1 F2400.000

G1 X84.167 Y70.906 E0.00627

G1 X83.674 Y71.376 F9000.000

M204 S1000

G1 F4800.000

G1 X83.158 Y70.860 E0.02252

G1 X82.460 Y70.862 E0.02155

G1 X83.016 Y71.418 E0.02426

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.460 Y70.862 E-0.43532

G1 X83.158 Y70.860 E-0.38667

G1 X83.273 Y70.975 E-0.09002

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.887 Y64.766

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y64.743 E0.00060

G1 X83.121 Y63.934 E0.03844

G1 X83.378 Y63.814 E0.00739

G1 X83.620 Y63.758 E0.00648

G1 X90.782 Y63.742 E0.18661

G1 X91.217 Y63.866 E0.01178

G1 X91.410 Y63.962 E0.00561

G1 X92.591 Y64.741 E0.03687

G1 X92.591 Y64.769 E0.00072

G1 X88.007 Y64.772 E0.11944

G1 X85.075 Y64.750 E0.07640

G1 X81.947 Y64.766 E0.08151

M204 S1250

G1 X81.661 Y65.166 F9000.000

M204 S800

G1 F1500.000

G1 X81.518 Y65.022 E0.00528

G1 X81.471 Y64.843 E0.00482

G1 X81.482 Y64.598 E0.00639

G1 X81.586 Y64.441 E0.00489

G1 X82.917 Y63.568 E0.04149

G1 X83.242 Y63.417 E0.00933

G1 X83.572 Y63.341 E0.00884

G1 X90.813 Y63.324 E0.18867

G1 X91.072 Y63.378 E0.00687

G1 X91.176 Y63.430 E0.00303

G1 X91.356 Y63.468 E0.00480

G1 X91.619 Y63.599 E0.00765

G1 X92.884 Y64.435 E0.03951

G1 X92.994 Y64.577 E0.00467

G1 X93.006 Y64.646 E0.00184

G1 X93.010 Y64.815 E0.00439

G1 X92.962 Y65.012 E0.00527

G1 X92.866 Y65.138 E0.00413

G1 X92.707 Y65.188 E0.00436

G1 X88.006 Y65.190 E0.12249

G1 X85.074 Y65.168 E0.07638

G1 X81.720 Y65.177 E0.08741

M204 S1250

G1 X81.662 Y64.963 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.518 Y65.022 E-0.14082

G1 X81.471 Y64.843 E-0.10245

G1 X81.482 Y64.598 E-0.13589

G1 X81.586 Y64.441 E-0.10408

G1 X82.232 Y64.017 E-0.42876

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X91.253 Y64.646

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.672 Y64.065 E0.02154

G1 X90.078 Y64.065 E0.01557

G1 X90.470 Y64.458 E0.01456

G1 X89.876 Y64.458 E0.01558

G1 X89.484 Y64.066 E0.01454

G1 X88.890 Y64.066 E0.01557

G1 X89.282 Y64.458 E0.01453

G1 X88.687 Y64.459 E0.01558

G1 X88.296 Y64.067 E0.01451

G1 X87.702 Y64.068 E0.01557

G1 X88.093 Y64.459 E0.01450

G1 X87.495 Y64.455 E0.01569

G1 X87.108 Y64.068 E0.01433

G1 X86.514 Y64.069 E0.01557

G1 X86.895 Y64.450 E0.01414

G1 X86.296 Y64.446 E0.01571

G1 X85.920 Y64.069 E0.01395

G1 X85.326 Y64.070 E0.01557

G1 X85.697 Y64.441 E0.01376

G1 X85.098 Y64.437 E0.01571

G1 X84.732 Y64.071 E0.01357

G1 X84.138 Y64.071 E0.01557

G1 X84.506 Y64.439 E0.01365

G1 X83.915 Y64.442 E0.01551

G1 X83.565 Y64.093 E0.01297

G1 X83.480 Y64.112 E0.00228

G1 X83.273 Y64.208 E0.00598

G1 X83.160 Y64.282 E0.00355

G1 X83.510 Y64.632 E0.01298

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.160 Y64.282 E-0.27434

G1 X83.273 Y64.208 E-0.07499

G1 X83.480 Y64.112 E-0.12637

G1 X83.565 Y64.093 E-0.04822

G1 X83.915 Y64.442 E-0.27413

G1 X84.120 Y64.441 E-0.11395

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.920 Y58.558

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y58.507 E0.00149

G1 X81.884 Y57.553 E0.02486

G1 X85.872 Y57.539 E0.10391

G1 X85.333 Y57.742 E0.01500

G1 X84.593 Y58.099 E0.02141

G1 X84.047 Y58.394 E0.01618

G1 X83.859 Y58.465 E0.00521

G1 X83.523 Y58.540 E0.00899

G1 X81.980 Y58.557 E0.04021

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X81.884 Y57.553 E-0.52866

G1 X82.476 Y57.551 E-0.32780

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X88.580 Y57.529

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y57.538 E0.10456

G1 X92.585 Y58.500 E0.02508

G1 X92.557 Y58.563 E0.00179

G1 X91.011 Y58.547 E0.04028

G1 X90.846 Y58.530 E0.00431

G1 X90.521 Y58.432 E0.00886

G1 X90.213 Y58.239 E0.00947

G1 X89.858 Y58.052 E0.01046

G1 X89.769 Y58.039 E0.00233

G1 X89.536 Y57.922 E0.00680

G1 X88.635 Y57.552 E0.02537

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X92.847 Y57.143

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.965 Y57.274 E0.00459

G1 X93.010 Y57.450 E0.00474

G1 X93.000 Y58.570 E0.02919

G1 X92.957 Y58.720 E0.00406

G1 X92.878 Y58.854 E0.00406

G1 X92.713 Y58.982 E0.00543

G1 X90.987 Y58.965 E0.04498

G1 X90.764 Y58.942 E0.00585

G1 X90.347 Y58.816 E0.01136

G1 X90.005 Y58.601 E0.01052

G1 X89.725 Y58.455 E0.00822

G1 X89.641 Y58.442 E0.00221

G1 X89.363 Y58.303 E0.00811

G1 X88.346 Y57.884 E0.02866

G1 X88.057 Y57.805 E0.00781

G1 X87.619 Y57.720 E0.01162

G1 X87.356 Y57.693 E0.00689

G1 X86.957 Y57.702 E0.01039

G1 X86.166 Y57.874 E0.02108

G1 X85.498 Y58.127 E0.01861

G1 X84.783 Y58.471 E0.02069

G1 X84.220 Y58.775 E0.01667

G1 X83.979 Y58.866 E0.00672

G1 X83.571 Y58.957 E0.01089

G1 X81.785 Y58.977 E0.04654

G1 X81.701 Y58.942 E0.00238

G1 X81.547 Y58.766 E0.00610

G1 X81.476 Y58.553 E0.00583

G1 X81.466 Y57.521 E0.02690

G1 X81.482 Y57.371 E0.00394

G1 X81.535 Y57.243 E0.00361

G1 X81.645 Y57.136 E0.00399

G1 X89.552 Y57.107 E0.20602

G1 X92.788 Y57.132 E0.08431

M204 S1250

G1 X92.841 Y57.319 F9000.000

G1 X92.274 Y58.435

M204 S1000

G1 F4800.000

G1 X91.689 Y57.849 E0.02449

G1 X91.017 Y57.848 E0.01989

G1 X91.407 Y58.238 E0.01632

G1 X90.908 Y58.221 E0.01475

G1 X90.652 Y58.144 E0.00793

G1 X90.453 Y57.955 E0.00810

M204 S1250

G1 X90.342 Y57.860 F9000.000

G1 F2400.000

G1 X89.711 Y57.776 E0.00485

G1 X88.373 Y57.495 F9000.000

G1 F2400.000

G1 X88.142 Y57.464 E0.00448

G1 X87.899 Y57.441 E0.00433

G1 X87.668 Y57.419 E0.00345

G1 X87.372 Y57.404 E0.00354

G1 X86.930 Y57.410 E0.00442

G1 X86.635 Y57.441 E0.00297

G1 X86.078 Y57.502 E0.00929

G1 X84.740 Y57.769 F9000.000

G1 F2400.000

G1 X84.167 Y57.908 E0.00628

G1 X83.674 Y58.378 F9000.000

M204 S1000

G1 F4800.000

G1 X83.158 Y57.862 E0.02253

G1 X82.460 Y57.864 E0.02155

G1 X83.016 Y58.420 E0.02427

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.460 Y57.864 E-0.43544

G1 X83.158 Y57.862 E-0.38673

G1 X83.273 Y57.976 E-0.08983

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.887 Y51.768

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.887 Y51.746 E0.00058

G1 X83.120 Y50.936 E0.03845

G1 X83.378 Y50.816 E0.00740

G1 X83.621 Y50.760 E0.00649

G1 X90.782 Y50.744 E0.18660

G1 X91.217 Y50.868 E0.01178

G1 X91.410 Y50.964 E0.00561

G1 X92.591 Y51.744 E0.03687

G1 X92.591 Y51.771 E0.00072

G1 X88.007 Y51.774 E0.11944

G1 X85.075 Y51.752 E0.07640

G1 X81.947 Y51.768 E0.08151

M204 S1250

G1 X81.660 Y52.169 F9000.000

M204 S800

G1 F1500.000

G1 X81.518 Y52.024 E0.00528

G1 X81.471 Y51.845 E0.00482

G1 X81.482 Y51.600 E0.00639

G1 X81.585 Y51.444 E0.00488

G1 X82.917 Y50.570 E0.04150

G1 X83.242 Y50.419 E0.00933

G1 X83.572 Y50.343 E0.00885

G1 X90.813 Y50.326 E0.18867

G1 X91.072 Y50.380 E0.00687

G1 X91.176 Y50.432 E0.00303

G1 X91.356 Y50.470 E0.00480

G1 X91.619 Y50.601 E0.00765

G1 X92.884 Y51.437 E0.03952

G1 X92.994 Y51.579 E0.00467

G1 X93.006 Y51.648 E0.00184

G1 X93.010 Y51.817 E0.00439

G1 X92.962 Y52.014 E0.00527

G1 X92.866 Y52.140 E0.00413

G1 X92.706 Y52.190 E0.00436

G1 X88.006 Y52.192 E0.12249

G1 X85.074 Y52.170 E0.07638

G1 X81.719 Y52.179 E0.08742

M204 S1250

G1 X81.662 Y51.966 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.518 Y52.024 E-0.14076

G1 X81.471 Y51.845 E-0.10257

G1 X81.482 Y51.600 E-0.13581

G1 X81.585 Y51.444 E-0.10381

G1 X82.233 Y51.019 E-0.42905

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X91.253 Y51.648

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.672 Y51.067 E0.02154

G1 X90.078 Y51.067 E0.01557

G1 X90.471 Y51.460 E0.01456

G1 X89.876 Y51.460 E0.01558

G1 X89.484 Y51.068 E0.01454

G1 X88.890 Y51.069 E0.01557

G1 X89.282 Y51.460 E0.01453

G1 X88.688 Y51.461 E0.01558

G1 X88.296 Y51.069 E0.01452

G1 X87.702 Y51.070 E0.01557

G1 X88.093 Y51.461 E0.01450

G1 X87.495 Y51.457 E0.01569

G1 X87.108 Y51.070 E0.01433

G1 X86.514 Y51.071 E0.01557

G1 X86.896 Y51.452 E0.01414

G1 X86.297 Y51.448 E0.01571

G1 X85.920 Y51.071 E0.01395

G1 X85.326 Y51.072 E0.01557

G1 X85.697 Y51.443 E0.01376

G1 X85.098 Y51.439 E0.01571

G1 X84.732 Y51.073 E0.01357

G1 X84.138 Y51.073 E0.01557

G1 X84.506 Y51.441 E0.01365

G1 X83.915 Y51.444 E0.01551

G1 X83.565 Y51.095 E0.01296

G1 X83.480 Y51.114 E0.00229

G1 X83.273 Y51.210 E0.00598

G1 X83.160 Y51.284 E0.00353

G1 X83.511 Y51.634 E0.01298

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.160 Y51.284 E-0.27439

G1 X83.273 Y51.210 E-0.07470

G1 X83.480 Y51.114 E-0.12647

G1 X83.565 Y51.095 E-0.04844

G1 X83.915 Y51.444 E-0.27402

G1 X84.121 Y51.443 E-0.11398

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X81.920 Y45.560

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.893 Y45.509 E0.00149

G1 X81.884 Y44.556 E0.02484

G1 X85.873 Y44.541 E0.10393

G1 X85.334 Y44.744 E0.01501

G1 X84.593 Y45.101 E0.02142

G1 X84.046 Y45.397 E0.01621

G1 X83.859 Y45.468 E0.00521

G1 X83.523 Y45.542 E0.00895

G1 X81.980 Y45.559 E0.04022

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.893 Y45.509 E-0.05554

G1 X81.884 Y44.556 E-0.52825

G1 X82.477 Y44.554 E-0.32821

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X88.580 Y44.531

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.592 Y44.540 E0.10455

G1 X92.585 Y45.502 E0.02508

G1 X92.557 Y45.565 E0.00179

G1 X91.011 Y45.549 E0.04026

G1 X90.847 Y45.532 E0.00431

G1 X90.521 Y45.434 E0.00887

G1 X90.213 Y45.241 E0.00947

G1 X89.858 Y45.054 E0.01046

G1 X89.769 Y45.041 E0.00233

G1 X89.536 Y44.924 E0.00680

G1 X88.635 Y44.554 E0.02536

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.281 Y44.548 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.300 F9000.000

G1 X92.846 Y44.145

G1 Z10.100

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.965 Y44.276 E0.00461

G1 X93.010 Y44.453 E0.00475

G1 X93.000 Y45.572 E0.02917

G1 X92.957 Y45.722 E0.00406

G1 X92.878 Y45.857 E0.00407

G1 X92.713 Y45.984 E0.00543

G1 X90.988 Y45.967 E0.04497

G1 X90.764 Y45.944 E0.00585

G1 X90.347 Y45.818 E0.01136

G1 X90.005 Y45.603 E0.01052

G1 X89.725 Y45.457 E0.00822

G1 X89.641 Y45.444 E0.00221

G1 X89.363 Y45.305 E0.00811

G1 X88.346 Y44.886 E0.02866

G1 X88.057 Y44.807 E0.00781

G1 X87.619 Y44.722 E0.01163

G1 X87.356 Y44.696 E0.00689

G1 X86.957 Y44.704 E0.01039

G1 X86.166 Y44.877 E0.02108

G1 X85.498 Y45.129 E0.01860

G1 X84.783 Y45.473 E0.02069

G1 X84.220 Y45.778 E0.01668

G1 X83.979 Y45.869 E0.00672

G1 X83.571 Y45.959 E0.01087

G1 X81.785 Y45.979 E0.04655

G1 X81.701 Y45.944 E0.00238

G1 X81.547 Y45.768 E0.00610

G1 X81.476 Y45.555 E0.00583

G1 X81.466 Y44.523 E0.02690

G1 X81.482 Y44.373 E0.00394

G1 X81.535 Y44.246 E0.00359

G1 X81.645 Y44.139 E0.00399

G1 X89.552 Y44.109 E0.20602

G1 X92.787 Y44.134 E0.08430

M204 S1250

G1 X92.840 Y44.322 F9000.000

G1 X92.274 Y45.437

M204 S1000

G1 F4800.000

G1 X91.689 Y44.851 E0.02450

G1 X91.017 Y44.850 E0.01989

G1 X91.407 Y45.240 E0.01633

G1 X90.909 Y45.224 E0.01473

G1 X90.652 Y45.146 E0.00795

G1 X90.453 Y44.957 E0.00810

M204 S1250

G1 X90.342 Y44.862 F9000.000

G1 F2400.000

G1 X89.711 Y44.778 E0.00485

G1 X88.374 Y44.497 F9000.000

G1 F2400.000

G1 X88.142 Y44.466 E0.00448

G1 X87.899 Y44.443 E0.00433

G1 X87.667 Y44.421 E0.00345

G1 X87.372 Y44.407 E0.00354

G1 X86.930 Y44.412 E0.00442

G1 X86.636 Y44.444 E0.00297

G1 X86.079 Y44.505 E0.00928

G1 X84.739 Y44.772 F9000.000

G1 F2400.000

G1 X84.166 Y44.911 E0.00626

G1 X83.673 Y45.380 F9000.000

M204 S1000

G1 F4800.000

G1 X83.158 Y44.864 E0.02251

G1 X82.460 Y44.867 E0.02153

G1 X83.015 Y45.422 E0.02423

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;10.25

G1 Z10.250 F9000.000

;AFTER\_LAYER\_CHANGE

;10.25

G1 X81.945 Y45.766

M204 S800

G1 F1500.000

G1 X81.896 Y45.659 E0.00307

G1 X81.894 Y44.630 E0.02681

G1 X85.663 Y44.621 E0.09820

G1 X85.322 Y44.749 E0.00950

G1 X84.600 Y45.098 E0.02089

G1 X83.875 Y45.505 E0.02167

G1 X83.416 Y45.694 E0.01293

G1 X83.064 Y45.764 E0.00934

G1 X82.005 Y45.766 E0.02760

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.896 Y45.659 E-0.08456

G1 X81.894 Y44.630 E-0.57011

G1 X82.358 Y44.629 E-0.25733

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X88.792 Y44.620

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y44.638 E0.09896

G1 X92.587 Y45.622 E0.02562

G1 X92.566 Y45.713 E0.00245

G1 X92.528 Y45.764 E0.00165

G1 X91.434 Y45.769 E0.02850

G1 X91.165 Y45.727 E0.00709

G1 X90.736 Y45.569 E0.01193

G1 X90.268 Y45.275 E0.01439

G1 X89.817 Y45.039 E0.01325

G1 X89.744 Y45.028 E0.00192

G1 X88.848 Y44.643 E0.02542

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.494 Y44.641 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.576 Y44.285

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y44.227 E0.00244

G1 X81.710 Y44.213 E0.00160

G1 X87.955 Y44.197 E0.16272

G1 X92.828 Y44.232 E0.12697

G1 X92.968 Y44.387 E0.00545

G1 X93.009 Y44.542 E0.00418

G1 X93.004 Y45.669 E0.02936

G1 X92.954 Y45.893 E0.00599

G1 X92.730 Y46.181 E0.00948

G1 X91.403 Y46.187 E0.03458

G1 X91.060 Y46.134 E0.00905

G1 X90.550 Y45.946 E0.01414

G1 X90.059 Y45.638 E0.01510

G1 X89.685 Y45.441 E0.01101

G1 X89.617 Y45.431 E0.00181

G1 X89.385 Y45.316 E0.00673

G1 X88.328 Y44.880 E0.02979

G1 X87.639 Y44.693 E0.01861

G1 X87.311 Y44.651 E0.00861

G1 X86.953 Y44.656 E0.00933

G1 X86.160 Y44.879 E0.02148

G1 X85.487 Y45.134 E0.01875

G1 X84.793 Y45.469 E0.02007

G1 X84.065 Y45.878 E0.02176

G1 X83.530 Y46.097 E0.01506

G1 X83.106 Y46.181 E0.01127

G1 X81.812 Y46.184 E0.03370

G1 X81.576 Y46.011 E0.00765

G1 X81.478 Y45.730 E0.00774

G1 X81.476 Y44.501 E0.03203

G1 X81.546 Y44.337 E0.00465

M204 S1250

G1 X81.669 Y44.294 F9000.000

G1 X82.063 Y45.640

M204 S1000

G1 F4800.000

G1 X82.762 Y44.941 E0.02822

G1 X83.411 Y44.940 E0.01853

G1 X82.712 Y45.639 E0.02824

M204 S1250

G1 X84.045 Y44.983 F9000.000

G1 F2400.000

G1 X84.577 Y44.852 E0.00293

G1 X85.868 Y44.583 F9000.000

G1 F2400.000

G1 X86.224 Y44.525 E0.00619

G1 X86.558 Y44.478 E0.00393

G1 X86.892 Y44.432 E0.00207

G1 X87.446 Y44.432 F9000.000

G1 F2400.000

G1 X87.691 Y44.448 E0.00126

G1 X87.823 Y44.465 E0.00098

G1 X87.955 Y44.483 E0.00128

G1 X88.114 Y44.504 E0.00196

G1 X88.273 Y44.526 E0.00237

G1 X88.449 Y44.551 E0.00314

G1 X88.554 Y44.746 E0.00393

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.449 Y44.551 E-0.12323

G1 X88.273 Y44.526 E-0.09822

G1 E-0.73855 F4200.00000

G1 Z10.450 F9000.000

G1 X90.268 Y45.039

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X90.535 Y44.839 E0.00341

G1 X90.961 Y45.518 F9000.000

M204 S1000

G1 F4800.000

G1 X91.531 Y44.947 E0.02368

G1 X92.194 Y44.950 E0.01943

G1 X91.500 Y45.643 E0.02876

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.194 Y44.950 E-0.54339

G1 X91.531 Y44.947 E-0.36713

G1 X91.529 Y44.949 E-0.00148

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X92.501 Y51.685

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.444 Y51.682 E0.10570

G1 X85.074 Y51.656 E0.08780

G1 X81.994 Y51.677 E0.08027

G1 X83.383 Y50.769 E0.04325

G1 X83.610 Y50.660 E0.00657

G1 X84.197 Y50.518 E0.01572

G1 X90.358 Y50.533 E0.16053

G1 X90.570 Y50.574 E0.00564

G1 X90.643 Y50.625 E0.00231

G1 X90.977 Y50.707 E0.00896

G1 X91.304 Y50.895 E0.00983

G1 X92.450 Y51.652 E0.03579

M204 S1250

G1 X92.995 Y51.575 F9000.000

M204 S800

G1 F1500.000

G1 X93.009 Y51.746 E0.00447

G1 X92.967 Y51.923 E0.00474

G1 X92.834 Y52.066 E0.00508

G1 X92.709 Y52.103 E0.00341

G1 X88.442 Y52.099 E0.11117

G1 X85.074 Y52.074 E0.08775

G1 X81.764 Y52.097 E0.08624

G1 X81.664 Y52.075 E0.00268

G1 X81.528 Y51.936 E0.00507

G1 X81.471 Y51.663 E0.00725

G1 X81.483 Y51.601 E0.00167

G1 X81.588 Y51.443 E0.00494

G1 X83.177 Y50.405 E0.04946

G1 X83.469 Y50.264 E0.00843

G1 X84.148 Y50.100 E0.01819

G1 X90.399 Y50.116 E0.16288

G1 X90.738 Y50.181 E0.00900

G1 X90.812 Y50.233 E0.00236

G1 X91.005 Y50.272 E0.00513

G1 X91.154 Y50.327 E0.00415

G1 X91.523 Y50.539 E0.01108

G1 X92.892 Y51.443 E0.04274

G1 X92.961 Y51.526 E0.00282

M204 S1250

G1 X92.888 Y51.708 F9000.000

G1 X92.765 Y51.616

G1 F2400.000

G1 X92.709 Y51.885 E0.00161

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.765 Y51.616 E-0.15211

G1 E-0.80789 F4200.00000

G1 Z10.450 F9000.000

G1 X90.818 Y51.558

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.185 Y51.191 E0.01411

G1 X90.785 Y50.974 E0.01238

G1 X90.390 Y51.370 E0.01522

G1 X89.773 Y51.369 E0.01677

G1 X90.296 Y50.846 E0.02012

G1 X89.682 Y50.844 E0.01671

G1 X89.157 Y51.369 E0.02020

G1 X88.540 Y51.368 E0.01677

G1 X89.068 Y50.841 E0.02029

G1 X89.046 Y50.841 E0.00058

G1 X88.452 Y50.840 E0.01617

G1 X87.927 Y51.364 E0.02018

G1 X87.315 Y51.360 E0.01666

G1 X87.836 Y50.838 E0.02005

G1 X87.221 Y50.837 E0.01675

G1 X86.703 Y51.355 E0.01992

G1 X86.091 Y51.350 E0.01666

G1 X86.605 Y50.836 E0.01979

G1 X85.989 Y50.835 E0.01675

G1 X85.478 Y51.346 E0.01965

G1 X84.863 Y51.344 E0.01674

G1 X85.373 Y50.833 E0.01964

G1 X84.758 Y50.832 E0.01675

G1 X84.242 Y51.348 E0.01985

G1 X83.621 Y51.353 E0.01690

G1 X84.330 Y50.643 E0.02729

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.621 Y51.353 E-0.55582

G1 X84.242 Y51.348 E-0.34429

G1 X84.257 Y51.333 E-0.01189

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.718 Y51.625

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X81.764 Y51.809 E0.00089

G1 X81.829 Y51.887 E0.00047

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.764 Y51.809 E-0.05606

G1 X81.718 Y51.625 E-0.10522

G1 E-0.79872 F4200.00000

G1 Z10.450 F9000.000

G1 X81.894 Y57.628

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.662 Y57.618 E0.09818

G1 X85.321 Y57.748 E0.00949

G1 X84.600 Y58.096 E0.02088

G1 X83.875 Y58.503 E0.02166

G1 X83.676 Y58.595 E0.00571

G1 X83.416 Y58.691 E0.00723

G1 X83.064 Y58.762 E0.00936

G1 X81.929 Y58.753 E0.02956

G1 X81.896 Y58.657 E0.00265

G1 X81.894 Y57.688 E0.02525

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y57.658 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X88.792 Y57.618

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y57.636 E0.09896

G1 X92.587 Y58.620 E0.02562

G1 X92.566 Y58.711 E0.00245

G1 X92.528 Y58.762 E0.00165

G1 X91.434 Y58.767 E0.02850

G1 X91.165 Y58.725 E0.00710

G1 X90.736 Y58.567 E0.01193

G1 X90.268 Y58.273 E0.01439

G1 X89.817 Y58.037 E0.01325

G1 X89.744 Y58.026 E0.00192

G1 X88.848 Y57.641 E0.02542

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.494 Y57.639 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.576 Y57.283

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y57.225 E0.00244

G1 X81.710 Y57.211 E0.00160

G1 X87.955 Y57.195 E0.16272

G1 X92.828 Y57.230 E0.12697

G1 X92.968 Y57.385 E0.00544

G1 X93.009 Y57.540 E0.00417

G1 X93.004 Y58.667 E0.02937

G1 X92.954 Y58.891 E0.00599

G1 X92.730 Y59.179 E0.00948

G1 X91.403 Y59.185 E0.03458

G1 X91.060 Y59.132 E0.00905

G1 X90.550 Y58.944 E0.01414

G1 X90.059 Y58.636 E0.01510

G1 X89.685 Y58.439 E0.01101

G1 X89.617 Y58.429 E0.00181

G1 X89.385 Y58.314 E0.00673

G1 X88.328 Y57.878 E0.02979

G1 X87.639 Y57.691 E0.01860

G1 X87.311 Y57.648 E0.00862

G1 X86.953 Y57.653 E0.00933

G1 X86.160 Y57.876 E0.02148

G1 X85.487 Y58.132 E0.01876

G1 X84.793 Y58.467 E0.02006

G1 X84.065 Y58.876 E0.02176

G1 X83.530 Y59.094 E0.01506

G1 X83.106 Y59.179 E0.01128

G1 X81.812 Y59.182 E0.03369

G1 X81.576 Y59.009 E0.00765

G1 X81.478 Y58.728 E0.00774

G1 X81.476 Y57.499 E0.03203

G1 X81.546 Y57.335 E0.00466

M204 S1250

G1 X81.670 Y57.292 F9000.000

G1 X82.063 Y58.638

M204 S1000

G1 F4800.000

G1 X82.763 Y57.939 E0.02824

G1 X83.412 Y57.938 E0.01854

G1 X82.712 Y58.637 E0.02825

M204 S1250

G1 X84.045 Y57.981 F9000.000

G1 F2400.000

G1 X84.578 Y57.850 E0.00293

G1 X85.867 Y57.581 F9000.000

G1 F2400.000

G1 X86.224 Y57.523 E0.00618

G1 X86.557 Y57.476 E0.00391

G1 X86.890 Y57.430 E0.00206

G1 X87.450 Y57.430 F9000.000

G1 F2400.000

G1 X87.691 Y57.446 E0.00125

G1 X87.823 Y57.463 E0.00098

G1 X87.955 Y57.481 E0.00127

G1 X88.114 Y57.502 E0.00196

G1 X88.273 Y57.524 E0.00237

G1 X88.449 Y57.549 E0.00314

G1 X88.554 Y57.745 E0.00394

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.449 Y57.549 E-0.12328

G1 X88.273 Y57.524 E-0.09822

G1 E-0.73850 F4200.00000

G1 Z10.450 F9000.000

G1 X90.268 Y58.037

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X90.535 Y57.837 E0.00341

G1 X90.961 Y58.516 F9000.000

M204 S1000

G1 F4800.000

G1 X91.531 Y57.945 E0.02368

G1 X92.194 Y57.948 E0.01943

G1 X91.500 Y58.641 E0.02877

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.194 Y57.948 E-0.54340

G1 X91.531 Y57.945 E-0.36713

G1 X91.529 Y57.947 E-0.00147

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X92.501 Y64.683

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.444 Y64.680 E0.10570

G1 X85.074 Y64.654 E0.08780

G1 X81.993 Y64.675 E0.08028

G1 X83.384 Y63.767 E0.04328

G1 X83.611 Y63.657 E0.00657

G1 X84.197 Y63.516 E0.01570

G1 X90.358 Y63.531 E0.16054

G1 X90.570 Y63.572 E0.00564

G1 X90.643 Y63.623 E0.00231

G1 X90.977 Y63.705 E0.00896

G1 X91.304 Y63.893 E0.00983

G1 X92.451 Y64.650 E0.03579

M204 S1250

G1 X92.986 Y64.553 F9000.000

M204 S800

G1 F1500.000

G1 X93.008 Y64.732 E0.00469

G1 X92.961 Y64.927 E0.00523

G1 X92.834 Y65.064 E0.00487

G1 X92.709 Y65.101 E0.00341

G1 X88.442 Y65.097 E0.11118

G1 X85.074 Y65.072 E0.08775

G1 X81.765 Y65.095 E0.08624

G1 X81.664 Y65.073 E0.00269

G1 X81.528 Y64.934 E0.00507

G1 X81.471 Y64.661 E0.00725

G1 X81.483 Y64.599 E0.00167

G1 X81.588 Y64.441 E0.00495

G1 X83.178 Y63.403 E0.04946

G1 X83.469 Y63.261 E0.00844

G1 X84.147 Y63.098 E0.01818

G1 X90.399 Y63.114 E0.16289

G1 X90.738 Y63.179 E0.00900

G1 X90.812 Y63.231 E0.00236

G1 X91.005 Y63.270 E0.00513

G1 X91.154 Y63.325 E0.00415

G1 X91.523 Y63.537 E0.01108

G1 X92.892 Y64.441 E0.04274

G1 X92.947 Y64.507 E0.00226

M204 S1250

G1 X92.878 Y64.697 F9000.000

G1 X92.765 Y64.614

G1 F2400.000

G1 X92.708 Y64.883 E0.00145

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.765 Y64.614 E-0.15239

G1 E-0.80761 F4200.00000

G1 Z10.450 F9000.000

G1 X90.818 Y64.556

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.185 Y64.189 E0.01411

G1 X90.785 Y63.972 E0.01238

G1 X90.389 Y64.368 E0.01522

G1 X89.773 Y64.367 E0.01677

G1 X90.296 Y63.844 E0.02012

G1 X89.682 Y63.842 E0.01671

G1 X89.157 Y64.367 E0.02020

G1 X88.540 Y64.366 E0.01677

G1 X89.067 Y63.839 E0.02029

G1 X89.046 Y63.839 E0.00058

G1 X88.452 Y63.838 E0.01617

G1 X87.927 Y64.362 E0.02018

G1 X87.315 Y64.358 E0.01666

G1 X87.836 Y63.836 E0.02005

G1 X87.220 Y63.835 E0.01675

G1 X86.703 Y64.353 E0.01992

G1 X86.090 Y64.348 E0.01666

G1 X86.605 Y63.834 E0.01979

G1 X85.989 Y63.833 E0.01675

G1 X85.478 Y64.344 E0.01965

G1 X84.863 Y64.342 E0.01674

G1 X85.373 Y63.831 E0.01964

G1 X84.758 Y63.830 E0.01675

G1 X84.242 Y64.346 E0.01985

G1 X83.620 Y64.351 E0.01690

G1 X84.330 Y63.641 E0.02729

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.620 Y64.351 E-0.55582

G1 X84.242 Y64.346 E-0.34429

G1 X84.257 Y64.331 E-0.01188

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.717 Y64.624

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X81.764 Y64.807 E0.00088

G1 X81.829 Y64.885 E0.00047

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.764 Y64.807 E-0.05608

G1 X81.717 Y64.624 E-0.10509

G1 E-0.79883 F4200.00000

G1 Z10.450 F9000.000

G1 X81.894 Y70.626

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.662 Y70.616 E0.09818

G1 X85.321 Y70.746 E0.00948

G1 X84.600 Y71.094 E0.02088

G1 X83.875 Y71.501 E0.02167

G1 X83.676 Y71.593 E0.00571

G1 X83.416 Y71.689 E0.00723

G1 X83.064 Y71.760 E0.00936

G1 X81.929 Y71.751 E0.02956

G1 X81.896 Y71.655 E0.00265

G1 X81.894 Y70.686 E0.02525

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y70.656 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X88.792 Y70.616

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y70.634 E0.09897

G1 X92.587 Y71.618 E0.02563

G1 X92.566 Y71.709 E0.00245

G1 X92.528 Y71.760 E0.00165

G1 X91.434 Y71.765 E0.02851

G1 X91.165 Y71.723 E0.00709

G1 X90.736 Y71.564 E0.01193

G1 X90.267 Y71.271 E0.01440

G1 X89.817 Y71.035 E0.01324

G1 X89.744 Y71.024 E0.00192

G1 X88.848 Y70.638 E0.02543

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.493 Y70.636 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.576 Y70.281

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y70.223 E0.00244

G1 X81.710 Y70.209 E0.00160

G1 X87.955 Y70.193 E0.16272

G1 X92.828 Y70.228 E0.12697

G1 X92.968 Y70.382 E0.00543

G1 X93.009 Y70.538 E0.00418

G1 X93.004 Y71.665 E0.02937

G1 X92.954 Y71.889 E0.00599

G1 X92.730 Y72.177 E0.00948

G1 X91.403 Y72.183 E0.03459

G1 X91.060 Y72.130 E0.00905

G1 X90.551 Y71.941 E0.01415

G1 X90.059 Y71.634 E0.01510

G1 X89.685 Y71.437 E0.01101

G1 X89.617 Y71.427 E0.00180

G1 X89.385 Y71.312 E0.00673

G1 X88.328 Y70.876 E0.02978

G1 X87.639 Y70.688 E0.01862

G1 X87.311 Y70.646 E0.00862

G1 X86.953 Y70.651 E0.00933

G1 X86.160 Y70.874 E0.02148

G1 X85.487 Y71.130 E0.01876

G1 X84.793 Y71.464 E0.02006

G1 X84.065 Y71.874 E0.02177

G1 X83.530 Y72.092 E0.01506

G1 X83.106 Y72.177 E0.01128

G1 X81.812 Y72.180 E0.03369

G1 X81.576 Y72.007 E0.00765

G1 X81.478 Y71.726 E0.00774

G1 X81.476 Y70.497 E0.03203

G1 X81.546 Y70.333 E0.00465

M204 S1250

G1 X81.670 Y70.290 F9000.000

G1 X82.063 Y71.636

M204 S1000

G1 F4800.000

G1 X82.762 Y70.937 E0.02824

G1 X83.412 Y70.936 E0.01853

G1 X82.712 Y71.635 E0.02825

M204 S1250

G1 X84.045 Y70.979 F9000.000

G1 F2400.000

G1 X84.577 Y70.848 E0.00292

G1 X85.867 Y70.579 F9000.000

G1 F2400.000

G1 X86.224 Y70.521 E0.00618

G1 X86.557 Y70.474 E0.00391

G1 X86.890 Y70.428 E0.00206

G1 X87.453 Y70.428 F9000.000

G1 F2400.000

G1 X87.691 Y70.443 E0.00122

G1 X87.823 Y70.461 E0.00097

G1 X87.955 Y70.478 E0.00127

G1 X88.114 Y70.500 E0.00196

G1 X88.273 Y70.522 E0.00238

G1 X88.448 Y70.546 E0.00313

G1 X88.554 Y70.742 E0.00393

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.448 Y70.546 E-0.12312

G1 X88.273 Y70.522 E-0.09791

G1 E-0.73896 F4200.00000

G1 Z10.450 F9000.000

G1 X90.267 Y71.035

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X90.535 Y70.834 E0.00341

G1 X90.960 Y71.514 F9000.000

M204 S1000

G1 F4800.000

G1 X91.531 Y70.943 E0.02369

G1 X92.194 Y70.946 E0.01945

G1 X91.500 Y71.639 E0.02878

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.194 Y70.946 E-0.54343

G1 X91.531 Y70.943 E-0.36727

G1 X91.529 Y70.945 E-0.00130

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X92.501 Y77.680

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y77.652 E0.19354

G1 X81.995 Y77.672 E0.08021

G1 X83.384 Y76.765 E0.04323

G1 X83.611 Y76.655 E0.00657

G1 X84.197 Y76.514 E0.01570

G1 X90.357 Y76.528 E0.16052

G1 X90.570 Y76.570 E0.00564

G1 X90.643 Y76.621 E0.00233

G1 X90.977 Y76.704 E0.00897

G1 X91.305 Y76.890 E0.00981

G1 X92.451 Y77.647 E0.03579

M204 S1250

G1 X92.986 Y77.551 F9000.000

M204 S800

G1 F1500.000

G1 X93.008 Y77.729 E0.00467

G1 X92.961 Y77.925 E0.00525

G1 X92.834 Y78.061 E0.00486

G1 X92.709 Y78.099 E0.00341

G1 X85.074 Y78.070 E0.19894

G1 X81.764 Y78.092 E0.08623

G1 X81.663 Y78.070 E0.00269

G1 X81.528 Y77.932 E0.00505

G1 X81.471 Y77.659 E0.00727

G1 X81.483 Y77.597 E0.00164

G1 X81.588 Y77.439 E0.00495

G1 X83.178 Y76.401 E0.04946

G1 X83.469 Y76.259 E0.00844

G1 X84.147 Y76.096 E0.01818

G1 X90.399 Y76.111 E0.16288

G1 X90.738 Y76.177 E0.00900

G1 X90.812 Y76.229 E0.00236

G1 X91.005 Y76.268 E0.00513

G1 X91.154 Y76.323 E0.00416

G1 X91.523 Y76.534 E0.01107

G1 X92.892 Y77.437 E0.04272

G1 X92.947 Y77.505 E0.00227

M204 S1250

G1 X92.878 Y77.694 F9000.000

G1 X92.765 Y77.612

G1 F2400.000

G1 X92.708 Y77.881 E0.00145

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.765 Y77.612 E-0.15244

G1 E-0.80756 F4200.00000

G1 Z10.450 F9000.000

G1 X90.817 Y77.548

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.181 Y77.184 E0.01401

G1 X90.780 Y76.969 E0.01238

G1 X90.390 Y77.359 E0.01499

G1 X89.776 Y77.356 E0.01669

G1 X90.291 Y76.841 E0.01980

G1 X89.677 Y76.839 E0.01668

G1 X89.162 Y77.354 E0.01981

G1 X88.548 Y77.352 E0.01669

G1 X89.063 Y76.836 E0.01981

G1 X88.448 Y76.835 E0.01672

G1 X87.934 Y77.349 E0.01977

G1 X87.320 Y77.347 E0.01669

G1 X87.833 Y76.834 E0.01972

G1 X87.218 Y76.833 E0.01672

G1 X86.706 Y77.345 E0.01968

M73 P88 R8

G1 X86.092 Y77.342 E0.01669

G1 X86.602 Y76.832 E0.01963

G1 X85.987 Y76.830 E0.01672

G1 X85.478 Y77.340 E0.01959

G1 X84.861 Y77.340 E0.01675

G1 X85.372 Y76.829 E0.01963

G1 X84.757 Y76.828 E0.01672

G1 X84.241 Y77.344 E0.01983

G1 X83.620 Y77.348 E0.01687

G1 X84.329 Y76.639 E0.02725

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.620 Y77.348 E-0.55551

G1 X84.241 Y77.344 E-0.34388

G1 X84.257 Y77.328 E-0.01261

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.718 Y77.621

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X81.765 Y77.805 E0.00091

G1 X81.830 Y77.882 E0.00049

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.765 Y77.805 E-0.05607

G1 X81.718 Y77.621 E-0.10533

G1 E-0.79861 F4200.00000

G1 Z10.450 F9000.000

G1 X81.894 Y83.623

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.662 Y83.614 E0.09820

G1 X85.321 Y83.744 E0.00950

G1 X84.600 Y84.091 E0.02087

G1 X83.874 Y84.499 E0.02168

G1 X83.675 Y84.591 E0.00572

G1 X83.416 Y84.687 E0.00720

G1 X83.063 Y84.758 E0.00936

G1 X81.929 Y84.749 E0.02955

G1 X81.896 Y84.653 E0.00267

G1 X81.894 Y83.683 E0.02525

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y83.653 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X88.794 Y83.614

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y83.632 E0.09892

G1 X92.587 Y84.615 E0.02562

G1 X92.566 Y84.707 E0.00245

G1 X92.528 Y84.758 E0.00166

G1 X91.435 Y84.763 E0.02848

G1 X91.165 Y84.721 E0.00710

G1 X90.735 Y84.562 E0.01194

G1 X90.268 Y84.269 E0.01438

G1 X89.817 Y84.032 E0.01326

G1 X89.744 Y84.021 E0.00194

G1 X88.849 Y83.636 E0.02537

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.495 Y83.634 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.576 Y83.279

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y83.220 E0.00246

G1 X81.710 Y83.206 E0.00161

G1 X87.955 Y83.191 E0.16271

G1 X92.828 Y83.226 E0.12697

G1 X92.968 Y83.380 E0.00543

G1 X93.009 Y83.535 E0.00417

G1 X93.004 Y84.662 E0.02937

G1 X92.954 Y84.887 E0.00599

G1 X92.730 Y85.175 E0.00949

G1 X91.403 Y85.181 E0.03458

G1 X91.060 Y85.127 E0.00905

G1 X90.550 Y84.939 E0.01414

G1 X90.059 Y84.632 E0.01510

G1 X89.685 Y84.435 E0.01102

G1 X89.616 Y84.425 E0.00181

G1 X89.385 Y84.310 E0.00672

G1 X88.328 Y83.873 E0.02979

G1 X87.639 Y83.686 E0.01862

G1 X87.311 Y83.644 E0.00861

G1 X86.953 Y83.649 E0.00933

G1 X86.160 Y83.872 E0.02148

G1 X85.487 Y84.128 E0.01876

G1 X84.793 Y84.462 E0.02006

G1 X84.065 Y84.871 E0.02176

G1 X83.530 Y85.090 E0.01506

G1 X83.105 Y85.175 E0.01128

G1 X81.812 Y85.178 E0.03369

G1 X81.576 Y85.005 E0.00765

G1 X81.478 Y84.724 E0.00775

G1 X81.476 Y83.495 E0.03202

G1 X81.546 Y83.331 E0.00465

M204 S1250

G1 X81.670 Y83.288 F9000.000

G1 X82.062 Y84.634

M204 S1000

G1 F4800.000

G1 X82.762 Y83.935 E0.02826

G1 X83.411 Y83.933 E0.01853

G1 X82.711 Y84.633 E0.02826

M204 S1250

G1 X84.044 Y83.976 F9000.000

G1 F2400.000

G1 X84.578 Y83.845 E0.00293

G1 X85.868 Y83.576 F9000.000

G1 F2400.000

G1 X86.224 Y83.518 E0.00617

G1 X86.557 Y83.472 E0.00391

G1 X86.890 Y83.426 E0.00206

G1 X87.453 Y83.426 F9000.000

G1 F2400.000

G1 X87.691 Y83.441 E0.00121

G1 X87.823 Y83.459 E0.00097

G1 X87.955 Y83.476 E0.00127

G1 X88.114 Y83.498 E0.00195

G1 X88.273 Y83.520 E0.00237

G1 X88.589 Y83.573 E0.00566

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.273 Y83.520 E-0.17753

G1 E-0.78247 F4200.00000

G1 Z10.450 F9000.000

G1 X90.268 Y84.033

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X90.534 Y83.832 E0.00340

G1 X90.961 Y84.512 F9000.000

M204 S1000

G1 F4800.000

G1 X91.532 Y83.941 E0.02367

G1 X92.194 Y83.944 E0.01943

G1 X91.501 Y84.637 E0.02876

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.194 Y83.944 E-0.54343

G1 X91.532 Y83.941 E-0.36711

G1 X91.530 Y83.943 E-0.00146

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X92.499 Y90.677

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y90.650 E0.19350

G1 X81.994 Y90.670 E0.08024

G1 X83.384 Y89.763 E0.04325

G1 X83.611 Y89.653 E0.00657

G1 X84.197 Y89.511 E0.01571

G1 X90.358 Y89.526 E0.16052

G1 X90.568 Y89.567 E0.00560

G1 X90.641 Y89.619 E0.00233

G1 X90.977 Y89.702 E0.00902

G1 X91.305 Y89.888 E0.00981

G1 X92.449 Y90.644 E0.03575

M204 S1250

G1 X92.985 Y90.548 F9000.000

M204 S800

G1 F1500.000

G1 X93.008 Y90.727 E0.00470

G1 X92.961 Y90.923 E0.00525

G1 X92.835 Y91.059 E0.00485

G1 X92.709 Y91.096 E0.00340

G1 X85.074 Y91.068 E0.19895

G1 X81.764 Y91.090 E0.08623

G1 X81.663 Y91.068 E0.00269

G1 X81.528 Y90.930 E0.00505

G1 X81.471 Y90.657 E0.00727

G1 X81.483 Y90.595 E0.00165

G1 X81.588 Y90.436 E0.00497

G1 X83.177 Y89.398 E0.04945

G1 X83.469 Y89.257 E0.00844

G1 X84.147 Y89.093 E0.01819

G1 X90.399 Y89.109 E0.16288

G1 X90.737 Y89.174 E0.00898

G1 X90.811 Y89.227 E0.00237

G1 X91.005 Y89.266 E0.00514

G1 X91.154 Y89.321 E0.00416

G1 X91.523 Y89.532 E0.01107

G1 X92.892 Y90.436 E0.04273

G1 X92.947 Y90.502 E0.00224

M204 S1250

G1 X92.877 Y90.692 F9000.000

G1 X92.764 Y90.609

G1 F2400.000

G1 X92.729 Y90.799 E0.00103

G1 X92.678 Y90.887 E0.00055

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.729 Y90.799 E-0.05667

G1 X92.764 Y90.609 E-0.10700

G1 E-0.79633 F4200.00000

G1 Z10.450 F9000.000

G1 X90.815 Y90.546

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.180 Y90.181 E0.01401

G1 X90.778 Y89.966 E0.01238

G1 X90.389 Y90.356 E0.01497

G1 X89.775 Y90.354 E0.01669

G1 X90.289 Y89.839 E0.01977

G1 X89.676 Y89.837 E0.01668

G1 X89.161 Y90.352 E0.01979

G1 X88.547 Y90.349 E0.01669

G1 X89.062 Y89.834 E0.01981

G1 X88.447 Y89.833 E0.01672

G1 X87.933 Y90.347 E0.01976

G1 X87.319 Y90.345 E0.01669

G1 X87.832 Y89.832 E0.01972

G1 X87.217 Y89.830 E0.01672

G1 X86.705 Y90.342 E0.01968

G1 X86.091 Y90.340 E0.01669

G1 X86.602 Y89.829 E0.01964

G1 X85.986 Y89.828 E0.01672

G1 X85.477 Y90.338 E0.01960

G1 X84.860 Y90.338 E0.01675

G1 X85.371 Y89.827 E0.01964

G1 X84.756 Y89.826 E0.01672

G1 X84.240 Y90.342 E0.01984

G1 X83.619 Y90.346 E0.01686

G1 X84.329 Y89.637 E0.02726

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.619 Y90.346 E-0.55582

G1 X84.240 Y90.342 E-0.34383

G1 X84.256 Y90.326 E-0.01236

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.718 Y90.619

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X81.764 Y90.803 E0.00090

G1 X81.829 Y90.880 E0.00048

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.764 Y90.803 E-0.05583

G1 X81.718 Y90.619 E-0.10532

G1 E-0.79885 F4200.00000

G1 Z10.450 F9000.000

G1 X81.894 Y96.621

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.663 Y96.612 E0.09820

G1 X85.322 Y96.741 E0.00950

G1 X84.600 Y97.089 E0.02087

G1 X83.874 Y97.497 E0.02170

G1 X83.675 Y97.589 E0.00572

G1 X83.416 Y97.685 E0.00720

G1 X83.064 Y97.755 E0.00936

G1 X81.929 Y97.747 E0.02956

G1 X81.896 Y97.651 E0.00266

G1 X81.894 Y96.681 E0.02525

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.539 Y96.651 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X88.794 Y96.611

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y96.630 E0.09892

G1 X92.587 Y97.613 E0.02562

G1 X92.566 Y97.705 E0.00244

G1 X92.528 Y97.756 E0.00167

G1 X91.435 Y97.761 E0.02848

G1 X91.165 Y97.719 E0.00710

G1 X90.735 Y97.560 E0.01194

G1 X90.268 Y97.267 E0.01438

G1 X89.817 Y97.030 E0.01326

G1 X89.745 Y97.019 E0.00191

G1 X88.849 Y96.634 E0.02540

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.495 Y96.632 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.576 Y96.277

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y96.218 E0.00246

G1 X81.710 Y96.204 E0.00161

G1 X87.955 Y96.189 E0.16271

G1 X92.828 Y96.224 E0.12697

G1 X92.968 Y96.378 E0.00543

G1 X93.009 Y96.533 E0.00417

G1 X93.004 Y97.660 E0.02937

G1 X92.954 Y97.884 E0.00598

G1 X92.730 Y98.172 E0.00950

G1 X91.403 Y98.179 E0.03458

G1 X91.060 Y98.125 E0.00905

G1 X90.550 Y97.937 E0.01414

G1 X90.059 Y97.630 E0.01510

G1 X89.685 Y97.433 E0.01102

G1 X89.617 Y97.423 E0.00180

G1 X89.386 Y97.307 E0.00674

G1 X88.328 Y96.871 E0.02979

G1 X87.639 Y96.684 E0.01861

G1 X87.311 Y96.642 E0.00861

G1 X86.953 Y96.647 E0.00933

G1 X86.160 Y96.870 E0.02148

G1 X85.487 Y97.126 E0.01876

G1 X84.793 Y97.459 E0.02005

G1 X84.065 Y97.869 E0.02177

G1 X83.530 Y98.088 E0.01505

G1 X83.106 Y98.173 E0.01128

G1 X81.812 Y98.176 E0.03370

G1 X81.576 Y98.003 E0.00764

G1 X81.478 Y97.722 E0.00775

G1 X81.476 Y96.493 E0.03202

G1 X81.546 Y96.329 E0.00465

M204 S1250

G1 X81.670 Y96.286 F9000.000

G1 X82.063 Y97.632

M204 S1000

G1 F4800.000

G1 X82.762 Y96.933 E0.02825

G1 X83.411 Y96.931 E0.01852

G1 X82.711 Y97.631 E0.02825

M204 S1250

G1 X84.044 Y96.974 F9000.000

G1 F2400.000

G1 X84.577 Y96.843 E0.00290

G1 X85.868 Y96.574 F9000.000

G1 F2400.000

G1 X86.224 Y96.516 E0.00617

G1 X86.557 Y96.470 E0.00391

G1 X86.891 Y96.424 E0.00206

G1 X87.452 Y96.424 F9000.000

G1 F2400.000

G1 X87.691 Y96.439 E0.00122

G1 X87.823 Y96.457 E0.00098

G1 X87.955 Y96.474 E0.00127

G1 X88.114 Y96.496 E0.00195

G1 X88.273 Y96.517 E0.00237

G1 X88.589 Y96.570 E0.00567

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.273 Y96.517 E-0.17753

G1 E-0.78247 F4200.00000

G1 Z10.450 F9000.000

G1 X90.326 Y96.829

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X90.448 Y97.129 E0.00286

G1 X90.266 Y97.031 F9000.000

G1 F2400.000

G1 X90.534 Y96.830 E0.00338

G1 X90.960 Y97.509 F9000.000

M204 S1000

G1 F4800.000

G1 X91.531 Y96.939 E0.02369

G1 X92.194 Y96.941 E0.01945

G1 X91.500 Y97.635 E0.02879

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.194 Y96.941 E-0.54354

G1 X91.531 Y96.939 E-0.36728

G1 X91.529 Y96.940 E-0.00118

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X92.501 Y103.676

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.074 Y103.647 E0.19350

G1 X81.994 Y103.668 E0.08027

G1 X83.383 Y102.760 E0.04325

G1 X83.610 Y102.651 E0.00657

G1 X84.197 Y102.509 E0.01573

G1 X90.358 Y102.524 E0.16053

G1 X90.570 Y102.565 E0.00562

G1 X90.642 Y102.617 E0.00232

G1 X90.976 Y102.699 E0.00896

G1 X91.305 Y102.886 E0.00985

G1 X92.450 Y103.643 E0.03578

M204 S1250

G1 X92.985 Y103.546 F9000.000

M204 S800

G1 F1500.000

G1 X93.008 Y103.725 E0.00470

G1 X92.961 Y103.921 E0.00525

G1 X92.835 Y104.057 E0.00485

G1 X92.709 Y104.094 E0.00341

G1 X88.442 Y104.090 E0.11118

G1 X85.074 Y104.065 E0.08775

G1 X81.764 Y104.088 E0.08624

G1 X81.663 Y104.066 E0.00269

G1 X81.528 Y103.928 E0.00505

G1 X81.471 Y103.655 E0.00727

G1 X81.483 Y103.593 E0.00165

G1 X81.588 Y103.434 E0.00497

G1 X83.177 Y102.396 E0.04945

G1 X83.469 Y102.255 E0.00843

G1 X84.148 Y102.091 E0.01820

G1 X90.399 Y102.107 E0.16288

G1 X90.738 Y102.172 E0.00899

G1 X90.811 Y102.225 E0.00236

G1 X91.004 Y102.263 E0.00512

G1 X91.154 Y102.319 E0.00416

G1 X91.523 Y102.530 E0.01108

G1 X92.892 Y103.434 E0.04273

G1 X92.947 Y103.500 E0.00224

M204 S1250

G1 X92.877 Y103.690 F9000.000

G1 X92.765 Y103.607

G1 F2400.000

G1 X92.708 Y103.876 E0.00145

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.765 Y103.607 E-0.15247

G1 E-0.80753 F4200.00000

G1 Z10.450 F9000.000

G1 X90.816 Y103.544

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.181 Y103.180 E0.01401

G1 X90.780 Y102.964 E0.01237

G1 X90.389 Y103.354 E0.01501

G1 X89.775 Y103.352 E0.01669

G1 X90.290 Y102.837 E0.01979

G1 X89.676 Y102.835 E0.01668

G1 X89.161 Y103.350 E0.01980

G1 X88.547 Y103.347 E0.01669

G1 X89.063 Y102.832 E0.01981

G1 X88.447 Y102.831 E0.01672

G1 X87.933 Y103.345 E0.01977

G1 X87.319 Y103.343 E0.01669

G1 X87.832 Y102.829 E0.01973

G1 X87.217 Y102.828 E0.01672

G1 X86.705 Y103.340 E0.01969

G1 X86.091 Y103.338 E0.01669

G1 X86.602 Y102.827 E0.01964

G1 X85.987 Y102.826 E0.01672

G1 X85.477 Y103.336 E0.01960

G1 X84.861 Y103.335 E0.01675

G1 X85.372 Y102.824 E0.01964

G1 X84.756 Y102.823 E0.01672

G1 X84.240 Y103.340 E0.01985

G1 X83.619 Y103.344 E0.01687

G1 X84.329 Y102.634 E0.02728

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.619 Y103.344 E-0.55608

G1 X84.240 Y103.340 E-0.34394

G1 X84.255 Y103.324 E-0.01197

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.718 Y103.617

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X81.764 Y103.801 E0.00090

G1 X81.829 Y103.878 E0.00048

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.764 Y103.801 E-0.05582

G1 X81.718 Y103.617 E-0.10530

G1 E-0.79889 F4200.00000

G1 Z10.450 F9000.000

G1 X88.792 Y109.609

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.590 Y109.627 E0.09896

G1 X92.587 Y110.611 E0.02562

G1 X92.566 Y110.703 E0.00246

G1 X92.528 Y110.753 E0.00164

G1 X91.434 Y110.759 E0.02850

G1 X91.165 Y110.717 E0.00710

G1 X90.735 Y110.558 E0.01194

G1 X90.268 Y110.265 E0.01438

G1 X89.820 Y110.030 E0.01318

G1 X89.747 Y110.018 E0.00193

G1 X88.848 Y109.632 E0.02549

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.494 Y109.630 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X85.664 Y109.610

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.322 Y109.739 E0.00953

G1 X84.600 Y110.087 E0.02087

G1 X83.875 Y110.494 E0.02167

G1 X83.415 Y110.683 E0.01294

G1 X83.064 Y110.753 E0.00934

G1 X81.945 Y110.755 E0.02916

G1 X81.896 Y110.648 E0.00307

G1 X81.894 Y109.619 E0.02681

G1 X85.604 Y109.610 E0.09667

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.322 Y109.739 E-0.17193

G1 X84.600 Y110.087 E-0.44389

G1 X84.134 Y110.349 E-0.29618

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.650 Y109.216

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.710 Y109.202 E0.00161

G1 X87.955 Y109.186 E0.16271

G1 X92.828 Y109.222 E0.12697

G1 X92.968 Y109.376 E0.00544

G1 X93.009 Y109.531 E0.00417

G1 X93.004 Y110.658 E0.02936

G1 X92.954 Y110.882 E0.00600

G1 X92.731 Y111.170 E0.00947

G1 X91.403 Y111.177 E0.03461

G1 X91.060 Y111.123 E0.00905

G1 X90.550 Y110.935 E0.01414

G1 X90.059 Y110.628 E0.01510

G1 X89.686 Y110.431 E0.01099

G1 X89.617 Y110.420 E0.00181

G1 X89.385 Y110.305 E0.00676

G1 X88.328 Y109.869 E0.02979

G1 X87.639 Y109.682 E0.01861

G1 X87.311 Y109.640 E0.00861

G1 X86.953 Y109.645 E0.00933

G1 X86.160 Y109.868 E0.02148

G1 X85.487 Y110.123 E0.01875

G1 X84.793 Y110.457 E0.02006

G1 X84.065 Y110.867 E0.02177

G1 X83.530 Y111.086 E0.01507

G1 X83.106 Y111.171 E0.01127

G1 X81.812 Y111.173 E0.03370

G1 X81.576 Y111.000 E0.00765

G1 X81.478 Y110.719 E0.00774

G1 X81.476 Y109.490 E0.03203

G1 X81.494 Y109.417 E0.00195

G1 X81.603 Y109.253 E0.00514

M204 S1250

G1 X81.703 Y109.249 F9000.000

G1 X82.063 Y110.630

M204 S1000

G1 F4800.000

G1 X82.762 Y109.930 E0.02823

G1 X83.411 Y109.929 E0.01853

G1 X82.712 Y110.628 E0.02825

M204 S1250

G1 X84.045 Y109.972 F9000.000

G1 F2400.000

G1 X84.577 Y109.841 E0.00292

G1 X85.869 Y109.572 F9000.000

G1 F2400.000

G1 X86.224 Y109.514 E0.00618

G1 X86.559 Y109.467 E0.00393

G1 X86.893 Y109.421 E0.00207

G1 X87.446 Y109.421 F9000.000

G1 F2400.000

G1 X87.691 Y109.437 E0.00126

G1 X87.823 Y109.454 E0.00098

G1 X87.955 Y109.472 E0.00128

G1 X88.114 Y109.493 E0.00196

G1 X88.273 Y109.515 E0.00237

G1 X88.449 Y109.540 E0.00314

G1 X88.554 Y109.735 E0.00394

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.449 Y109.540 E-0.12327

G1 X88.273 Y109.515 E-0.09822

G1 E-0.73851 F4200.00000

G1 Z10.450 F9000.000

G1 X90.326 Y109.827

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X90.448 Y110.127 E0.00286

G1 X90.266 Y110.028 F9000.000

G1 F2400.000

G1 X90.534 Y109.828 E0.00338

G1 X90.960 Y110.507 F9000.000

M204 S1000

G1 F4800.000

G1 X91.531 Y109.936 E0.02369

G1 X92.193 Y109.939 E0.01945

G1 X91.500 Y110.633 E0.02880

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.193 Y109.939 E-0.54379

G1 X91.531 Y109.936 E-0.36731

G1 X91.529 Y109.937 E-0.00091

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X92.501 Y116.674

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.444 Y116.671 E0.10570

G1 X85.074 Y116.645 E0.08780

G1 X81.994 Y116.666 E0.08027

G1 X83.383 Y115.758 E0.04325

G1 X83.610 Y115.649 E0.00657

G1 X84.197 Y115.507 E0.01573

G1 X90.358 Y115.522 E0.16053

G1 X90.570 Y115.563 E0.00564

G1 X90.643 Y115.614 E0.00231

G1 X90.977 Y115.696 E0.00896

G1 X91.304 Y115.884 E0.00983

G1 X92.450 Y116.641 E0.03579

M204 S1250

G1 X92.985 Y116.544 F9000.000

M204 S800

G1 F1500.000

G1 X93.008 Y116.723 E0.00470

G1 X92.961 Y116.919 E0.00525

G1 X92.835 Y117.055 E0.00485

G1 X92.709 Y117.092 E0.00341

G1 X88.442 Y117.088 E0.11118

G1 X85.074 Y117.063 E0.08775

G1 X81.764 Y117.086 E0.08624

G1 X81.663 Y117.064 E0.00269

G1 X81.528 Y116.926 E0.00505

G1 X81.471 Y116.652 E0.00727

G1 X81.483 Y116.590 E0.00167

G1 X81.588 Y116.432 E0.00494

G1 X83.177 Y115.394 E0.04946

G1 X83.469 Y115.253 E0.00843

G1 X84.148 Y115.089 E0.01820

G1 X90.399 Y115.105 E0.16288

G1 X90.738 Y115.170 E0.00900

G1 X90.812 Y115.222 E0.00236

G1 X91.005 Y115.261 E0.00513

G1 X91.154 Y115.316 E0.00415

G1 X91.523 Y115.528 E0.01108

G1 X92.892 Y116.432 E0.04274

G1 X92.947 Y116.498 E0.00224

M204 S1250

G1 X92.877 Y116.688 F9000.000

G1 X92.765 Y116.605

G1 F2400.000

G1 X92.708 Y116.874 E0.00145

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.765 Y116.605 E-0.15247

G1 E-0.80753 F4200.00000

G1 Z10.450 F9000.000

G1 X90.818 Y116.547

G1 Z10.250

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.185 Y116.180 E0.01411

G1 X90.785 Y115.963 E0.01238

G1 X90.390 Y116.359 E0.01522

G1 X89.773 Y116.358 E0.01677

G1 X90.296 Y115.835 E0.02012

G1 X89.682 Y115.833 E0.01671

G1 X89.157 Y116.358 E0.02020

G1 X88.540 Y116.357 E0.01677

G1 X89.068 Y115.830 E0.02029

G1 X89.046 Y115.830 E0.00058

G1 X88.452 Y115.829 E0.01617

G1 X87.927 Y116.353 E0.02018

G1 X87.315 Y116.349 E0.01666

G1 X87.836 Y115.827 E0.02005

G1 X87.221 Y115.826 E0.01675

G1 X86.703 Y116.344 E0.01992

G1 X86.091 Y116.339 E0.01666

G1 X86.605 Y115.825 E0.01979

G1 X85.989 Y115.824 E0.01675

G1 X85.478 Y116.335 E0.01965

G1 X84.863 Y116.333 E0.01674

G1 X85.373 Y115.822 E0.01964

G1 X84.758 Y115.821 E0.01675

G1 X84.242 Y116.337 E0.01985

G1 X83.621 Y116.342 E0.01690

G1 X84.330 Y115.632 E0.02729

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.621 Y116.342 E-0.55582

G1 X84.242 Y116.337 E-0.34429

G1 X84.257 Y116.322 E-0.01189

G1 E-0.04800 F4200.00000

G1 Z10.450 F9000.000

G1 X81.718 Y116.614

G1 Z10.250

G1 E3.20000 F2400.00000

G1 X81.764 Y116.799 E0.00090

G1 X81.829 Y116.876 E0.00048

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;10.4

G1 Z10.400 F9000.000

;AFTER\_LAYER\_CHANGE

;10.4

G1 E-3.20000 F4200.00000

G1 Z10.600 F9000.000

G1 X81.981 Y46.022

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.937 Y45.990 E0.00144

G1 X81.897 Y45.860 E0.00354

G1 X81.891 Y44.719 E0.02972

G1 X85.401 Y44.720 E0.09146

G1 X84.611 Y45.093 E0.02276

G1 X83.510 Y45.714 E0.03294

G1 X83.231 Y45.845 E0.00802

G1 X82.827 Y45.982 E0.01112

G1 X82.614 Y46.026 E0.00566

G1 X82.041 Y46.023 E0.01493

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.937 Y45.990 E-0.06083

G1 X81.897 Y45.860 E-0.07527

G1 X81.891 Y44.719 E-0.63210

G1 X82.150 Y44.719 E-0.14380

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X89.066 Y44.725

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y44.737 E0.09186

G1 X92.589 Y45.832 E0.02852

G1 X92.557 Y45.976 E0.00385

G1 X92.543 Y46.002 E0.00076

G1 X91.900 Y46.024 E0.01676

G1 X91.524 Y45.949 E0.00999

G1 X90.948 Y45.702 E0.01634

G1 X90.322 Y45.310 E0.01923

G1 X89.777 Y45.024 E0.01604

G1 X89.721 Y45.015 E0.00149

G1 X89.121 Y44.748 E0.01710

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.767 Y44.743 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X81.668 Y44.324

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.767 Y44.301 E0.00265

G1 X92.725 Y44.320 E0.28551

G1 X92.822 Y44.334 E0.00256

G1 X92.961 Y44.480 E0.00527

G1 X93.014 Y44.713 E0.00622

G1 X93.007 Y45.880 E0.03040

G1 X92.953 Y46.119 E0.00640

G1 X92.836 Y46.346 E0.00664

G1 X92.764 Y46.412 E0.00255

G1 X91.850 Y46.443 E0.02384

G1 X91.407 Y46.353 E0.01178

G1 X90.753 Y46.073 E0.01852

G1 X90.114 Y45.673 E0.01966

G1 X89.645 Y45.426 E0.01380

G1 X89.592 Y45.418 E0.00139

G1 X89.312 Y45.277 E0.00817

G1 X88.532 Y44.958 E0.02196

G1 X88.377 Y44.867 E0.00469

G1 X88.009 Y44.738 E0.01015

G1 X87.957 Y44.691 E0.00183

G1 X87.638 Y44.595 E0.00867

G1 X87.184 Y44.525 E0.01198

G1 X86.821 Y44.596 E0.00962

G1 X86.448 Y44.752 E0.01054

G1 X86.219 Y44.824 E0.00626

G1 X86.184 Y44.816 E0.00094

G1 X85.907 Y44.975 E0.00832

G1 X85.475 Y45.139 E0.01204

G1 X84.804 Y45.463 E0.01940

G1 X83.702 Y46.086 E0.03300

G1 X83.388 Y46.233 E0.00904

G1 X82.937 Y46.386 E0.01240

G1 X82.656 Y46.444 E0.00748

G1 X81.844 Y46.439 E0.02116

G1 X81.573 Y46.231 E0.00889

G1 X81.480 Y45.922 E0.00841

G1 X81.473 Y44.667 E0.03270

G1 X81.518 Y44.485 E0.00490

G1 X81.627 Y44.368 E0.00416

M204 S1250

G1 X81.755 Y44.377 F9000.000

G1 X82.017 Y44.902

M204 S1000

G1 F4800.000

G1 X82.782 Y45.667 E0.03276

G1 X83.114 Y45.554 E0.01063

G1 X83.279 Y45.477 E0.00551

G1 X82.835 Y45.033 E0.01903

G1 X83.522 Y45.033 E0.02083

G1 X83.861 Y45.372 E0.01453

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.522 Y45.033 E-0.26569

G1 X82.835 Y45.033 E-0.38093

G1 X83.173 Y45.371 E-0.26538

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.606 Y44.683

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X86.368 Y44.544 E0.01402

G1 X86.367 Y44.535 F9000.000

G1 F2400.000

G1 X85.590 Y44.596 E0.00457

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.367 Y44.535 E-0.43157

G1 E-0.52843 F4200.00000

G1 Z10.600 F9000.000

G1 X88.862 Y44.680

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X88.372 Y44.577 E0.00545

G1 X88.251 Y44.556 E0.00099

G1 X88.131 Y44.536 E0.00070

G1 X88.130 Y44.539 F9000.000

G1 F2400.000

G1 X88.861 Y44.684 E0.01317

G1 X90.147 Y44.952 F9000.000

G1 F2400.000

G1 X90.652 Y45.088 E0.00671

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.147 Y44.952 E-0.28976

G1 E-0.67024 F4200.00000

G1 Z10.600 F9000.000

G1 X92.052 Y45.893

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.205 Y45.046 E0.03142

G1 X91.801 Y45.048 E0.01564

G1 X92.464 Y45.711 E0.02458

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y45.048 E-0.51952

G1 X91.205 Y45.046 E-0.33064

G1 X91.283 Y45.125 E-0.06184

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X92.332 Y51.576

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y51.560 E0.18914

G1 X82.136 Y51.577 E0.07653

G1 X83.574 Y50.643 E0.04468

G1 X83.924 Y50.466 E0.01023

G1 X84.686 Y50.270 E0.02050

G1 X89.884 Y50.274 E0.13545

G1 X90.008 Y50.323 E0.00348

G1 X90.379 Y50.396 E0.00984

G1 X90.600 Y50.533 E0.00677

G1 X90.826 Y50.599 E0.00616

G1 X92.282 Y51.543 E0.04520

M204 S1250

G1 X92.992 Y51.591 F9000.000

M204 S800

G1 F1500.000

G1 X93.004 Y51.663 E0.00190

G1 X92.968 Y51.814 E0.00404

G1 X92.837 Y51.963 E0.00520

G1 X92.718 Y51.995 E0.00319

G1 X85.074 Y51.978 E0.19919

G1 X81.770 Y51.998 E0.08607

G1 X81.651 Y51.965 E0.00321

G1 X81.544 Y51.857 E0.00397

G1 X81.501 Y51.715 E0.00386

G1 X81.499 Y51.583 E0.00346

G1 X81.588 Y51.452 E0.00411

G1 X81.710 Y51.356 E0.00404

G1 X83.365 Y50.281 E0.05144

G1 X83.776 Y50.072 E0.01200

G1 X84.634 Y49.852 E0.02308

G1 X89.923 Y49.856 E0.13780

G1 X90.035 Y49.877 E0.00299

G1 X90.136 Y49.923 E0.00289

G1 X90.510 Y49.996 E0.00992

G1 X90.669 Y50.071 E0.00458

G1 X90.783 Y50.151 E0.00363

G1 X90.985 Y50.210 E0.00548

G1 X91.086 Y50.264 E0.00299

G1 X92.816 Y51.393 E0.05383

G1 X92.961 Y51.540 E0.00537

M204 S1250

G1 X92.950 Y51.650 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.004 Y51.663 E-0.07199

G1 X92.968 Y51.814 E-0.08596

G1 X92.837 Y51.963 E-0.11049

G1 X92.718 Y51.995 E-0.06793

G1 X91.680 Y51.992 E-0.57563

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X83.319 Y50.958

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.616 Y51.255 E0.01100

G1 X84.207 Y51.252 E0.01545

G1 X83.823 Y50.868 E0.01420

G1 X84.035 Y50.761 E0.00622

G1 X84.253 Y50.705 E0.00590

G1 X84.797 Y51.248 E0.02012

G1 X85.390 Y51.247 E0.01552

G1 X84.726 Y50.584 E0.02457

G1 X85.321 Y50.585 E0.01557

G1 X85.985 Y51.249 E0.02459

G1 X86.580 Y51.250 E0.01558

G1 X85.915 Y50.585 E0.02462

G1 X86.509 Y50.585 E0.01556

G1 X87.175 Y51.251 E0.02466

G1 X87.770 Y51.253 E0.01558

G1 X87.103 Y50.586 E0.02469

G1 X87.697 Y50.586 E0.01556

G1 X88.365 Y51.254 E0.02473

G1 X88.960 Y51.255 E0.01558

G1 X88.291 Y50.586 E0.02476

G1 X88.885 Y50.587 E0.01556

G1 X89.555 Y51.257 E0.02480

G1 X90.150 Y51.258 E0.01558

G1 X89.480 Y50.587 E0.02483

G1 X89.824 Y50.587 E0.00903

G1 X89.920 Y50.625 E0.00268

G1 X90.158 Y50.672 E0.00637

G1 X90.934 Y51.448 E0.02872

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.158 Y50.672 E-0.60777

G1 X89.920 Y50.625 E-0.13477

G1 X89.824 Y50.587 E-0.05682

G1 X89.621 Y50.587 E-0.11264

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.401 Y57.718

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.611 Y58.091 E0.02275

G1 X83.509 Y58.712 E0.03295

G1 X83.231 Y58.843 E0.00803

G1 X82.827 Y58.980 E0.01110

G1 X82.614 Y59.024 E0.00566

G1 X81.981 Y59.020 E0.01650

G1 X81.937 Y58.988 E0.00144

G1 X81.897 Y58.858 E0.00354

G1 X81.891 Y57.717 E0.02972

G1 X85.341 Y57.718 E0.08989

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.611 Y58.091 E-0.45399

G1 X83.891 Y58.496 E-0.45801

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X89.066 Y57.723

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y57.735 E0.09186

G1 X92.589 Y58.830 E0.02852

G1 X92.557 Y58.974 E0.00385

G1 X92.543 Y59.000 E0.00076

G1 X91.900 Y59.022 E0.01676

G1 X91.524 Y58.947 E0.00999

G1 X90.948 Y58.700 E0.01634

G1 X90.322 Y58.308 E0.01923

G1 X89.777 Y58.022 E0.01604

G1 X89.721 Y58.013 E0.00149

G1 X89.121 Y57.746 E0.01710

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.767 Y57.741 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X81.668 Y57.322

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.767 Y57.299 E0.00265

G1 X92.725 Y57.318 E0.28551

G1 X92.822 Y57.332 E0.00256

G1 X92.961 Y57.478 E0.00527

G1 X93.014 Y57.711 E0.00622

G1 X93.007 Y58.878 E0.03040

G1 X92.953 Y59.117 E0.00640

G1 X92.836 Y59.344 E0.00664

G1 X92.764 Y59.410 E0.00255

G1 X91.850 Y59.441 E0.02384

G1 X91.407 Y59.351 E0.01178

G1 X90.753 Y59.071 E0.01852

G1 X90.114 Y58.671 E0.01966

G1 X89.645 Y58.424 E0.01380

G1 X89.592 Y58.416 E0.00139

G1 X89.312 Y58.275 E0.00817

G1 X88.532 Y57.956 E0.02196

G1 X88.377 Y57.865 E0.00469

G1 X88.009 Y57.736 E0.01015

G1 X87.957 Y57.688 E0.00185

G1 X87.638 Y57.593 E0.00866

G1 X87.184 Y57.522 E0.01198

G1 X86.821 Y57.593 E0.00963

G1 X86.448 Y57.749 E0.01054

G1 X86.220 Y57.821 E0.00623

G1 X86.185 Y57.812 E0.00094

G1 X85.907 Y57.973 E0.00836

G1 X85.475 Y58.137 E0.01205

G1 X84.804 Y58.461 E0.01940

G1 X83.702 Y59.083 E0.03299

G1 X83.388 Y59.231 E0.00905

G1 X82.937 Y59.384 E0.01239

G1 X82.656 Y59.442 E0.00748

G1 X81.844 Y59.437 E0.02116

G1 X81.573 Y59.229 E0.00889

G1 X81.480 Y58.920 E0.00841

G1 X81.473 Y57.665 E0.03270

G1 X81.518 Y57.483 E0.00490

G1 X81.627 Y57.366 E0.00416

M204 S1250

G1 X81.755 Y57.375 F9000.000

G1 X82.017 Y57.900

M204 S1000

G1 F4800.000

G1 X82.782 Y58.665 E0.03275

G1 X83.113 Y58.552 E0.01060

G1 X83.278 Y58.474 E0.00553

G1 X82.834 Y58.031 E0.01901

G1 X83.522 Y58.031 E0.02082

G1 X83.861 Y58.370 E0.01452

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.522 Y58.031 E-0.26552

G1 X82.834 Y58.031 E-0.38088

G1 X83.173 Y58.370 E-0.26561

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.606 Y57.681

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X86.366 Y57.541 E0.01397

G1 X86.364 Y57.533 F9000.000

G1 F2400.000

G1 X85.590 Y57.592 E0.00449

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.364 Y57.533 E-0.43057

G1 E-0.52943 F4200.00000

G1 Z10.600 F9000.000

G1 X88.862 Y57.678

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X88.373 Y57.575 E0.00544

G1 X88.252 Y57.554 E0.00099

G1 X88.132 Y57.533 E0.00070

G1 X88.131 Y57.538 F9000.000

G1 F2400.000

G1 X88.861 Y57.682 E0.01315

G1 X90.147 Y57.950 F9000.000

G1 F2400.000

G1 X90.652 Y58.086 E0.00671

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.147 Y57.950 E-0.28976

G1 E-0.67024 F4200.00000

G1 Z10.600 F9000.000

G1 X92.052 Y58.891

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.205 Y58.044 E0.03142

G1 X91.801 Y58.046 E0.01564

G1 X92.464 Y58.709 E0.02458

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y58.046 E-0.51952

G1 X91.205 Y58.044 E-0.33065

G1 X91.283 Y58.123 E-0.06184

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X92.331 Y64.574

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y64.558 E0.18912

G1 X82.136 Y64.575 E0.07652

G1 X83.574 Y63.641 E0.04468

G1 X83.924 Y63.463 E0.01023

G1 X84.687 Y63.268 E0.02051

G1 X89.884 Y63.272 E0.13543

G1 X90.008 Y63.321 E0.00348

G1 X90.379 Y63.394 E0.00984

G1 X90.600 Y63.531 E0.00677

G1 X90.826 Y63.597 E0.00616

G1 X92.281 Y64.541 E0.04518

M204 S1250

G1 X92.992 Y64.589 F9000.000

M204 S800

G1 F1500.000

G1 X93.004 Y64.660 E0.00189

G1 X92.968 Y64.811 E0.00403

G1 X92.837 Y64.961 E0.00521

G1 X92.719 Y64.992 E0.00318

G1 X85.074 Y64.976 E0.19919

G1 X81.770 Y64.995 E0.08608

G1 X81.651 Y64.963 E0.00321

G1 X81.544 Y64.855 E0.00396

G1 X81.501 Y64.713 E0.00386

G1 X81.499 Y64.581 E0.00346

G1 X81.588 Y64.450 E0.00412

G1 X81.710 Y64.354 E0.00404

G1 X83.365 Y63.279 E0.05144

G1 X83.776 Y63.070 E0.01201

G1 X84.635 Y62.850 E0.02309

G1 X89.923 Y62.854 E0.13778

G1 X90.035 Y62.875 E0.00299

G1 X90.136 Y62.921 E0.00289

G1 X90.510 Y62.994 E0.00992

G1 X90.669 Y63.069 E0.00458

G1 X90.783 Y63.149 E0.00363

G1 X90.985 Y63.208 E0.00548

G1 X91.086 Y63.262 E0.00299

G1 X92.816 Y64.391 E0.05383

G1 X92.961 Y64.538 E0.00537

M204 S1250

G1 X92.950 Y64.648 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.004 Y64.660 E-0.07192

G1 X92.968 Y64.811 E-0.08568

G1 X92.837 Y64.961 E-0.11088

G1 X92.719 Y64.992 E-0.06758

G1 X91.679 Y64.990 E-0.57594

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X83.319 Y63.956

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.616 Y64.253 E0.01100

G1 X84.207 Y64.250 E0.01545

G1 X83.823 Y63.866 E0.01421

G1 X84.035 Y63.758 E0.00623

G1 X84.253 Y63.702 E0.00589

G1 X84.797 Y64.246 E0.02014

G1 X85.390 Y64.245 E0.01552

G1 X84.726 Y63.582 E0.02457

G1 X85.321 Y63.583 E0.01557

G1 X85.985 Y64.247 E0.02458

G1 X86.580 Y64.248 E0.01558

G1 X85.915 Y63.583 E0.02462

G1 X86.509 Y63.583 E0.01555

G1 X87.175 Y64.249 E0.02465

G1 X87.770 Y64.250 E0.01558

G1 X87.103 Y63.584 E0.02468

G1 X87.697 Y63.584 E0.01555

G1 X88.365 Y64.252 E0.02472

G1 X88.960 Y64.253 E0.01558

G1 X88.291 Y63.584 E0.02475

G1 X88.885 Y63.585 E0.01555

G1 X89.555 Y64.254 E0.02479

G1 X90.150 Y64.256 E0.01558

G1 X89.479 Y63.585 E0.02482

G1 X89.824 Y63.585 E0.00903

G1 X89.920 Y63.623 E0.00268

G1 X90.158 Y63.670 E0.00636

G1 X90.933 Y64.445 E0.02870

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.158 Y63.670 E-0.60754

G1 X89.920 Y63.623 E-0.13468

G1 X89.824 Y63.585 E-0.05682

G1 X89.620 Y63.585 E-0.11297

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.401 Y70.716

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.611 Y71.088 E0.02274

G1 X83.509 Y71.710 E0.03296

G1 X83.231 Y71.841 E0.00803

G1 X82.827 Y71.978 E0.01110

G1 X82.614 Y72.022 E0.00566

G1 X81.982 Y72.018 E0.01649

G1 X81.937 Y71.985 E0.00145

G1 X81.897 Y71.855 E0.00354

G1 X81.891 Y70.715 E0.02972

G1 X85.341 Y70.716 E0.08989

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.611 Y71.088 E-0.45381

G1 X83.891 Y71.494 E-0.45819

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X89.065 Y70.721

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y70.732 E0.09187

G1 X92.589 Y71.828 E0.02854

G1 X92.557 Y71.972 E0.00385

G1 X92.543 Y71.998 E0.00075

G1 X91.900 Y72.019 E0.01677

G1 X91.524 Y71.945 E0.00999

G1 X90.948 Y71.697 E0.01634

G1 X90.315 Y71.301 E0.01946

G1 X89.483 Y70.892 E0.02417

G1 X89.121 Y70.744 E0.01019

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.766 Y70.738 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X81.668 Y70.320

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.767 Y70.297 E0.00265

G1 X92.724 Y70.315 E0.28550

G1 X92.822 Y70.330 E0.00257

G1 X92.961 Y70.476 E0.00526

G1 X93.014 Y70.709 E0.00624

G1 X93.007 Y71.876 E0.03040

G1 X92.953 Y72.115 E0.00640

G1 X92.836 Y72.342 E0.00664

G1 X92.764 Y72.408 E0.00255

G1 X91.850 Y72.438 E0.02385

G1 X91.407 Y72.349 E0.01177

G1 X90.753 Y72.068 E0.01852

G1 X90.111 Y71.667 E0.01974

G1 X89.311 Y71.273 E0.02324

G1 X88.532 Y70.954 E0.02193

G1 X88.377 Y70.863 E0.00469

G1 X88.009 Y70.734 E0.01015

G1 X87.957 Y70.686 E0.00184

G1 X87.638 Y70.591 E0.00867

G1 X87.184 Y70.520 E0.01198

G1 X86.821 Y70.591 E0.00963

G1 X86.448 Y70.747 E0.01054

G1 X86.219 Y70.819 E0.00625

G1 X86.185 Y70.810 E0.00092

G1 X85.907 Y70.971 E0.00836

G1 X85.475 Y71.135 E0.01204

G1 X84.805 Y71.458 E0.01939

G1 X83.702 Y72.081 E0.03300

G1 X83.388 Y72.229 E0.00905

G1 X82.937 Y72.382 E0.01239

G1 X82.656 Y72.440 E0.00748

G1 X81.844 Y72.435 E0.02115

G1 X81.573 Y72.227 E0.00891

G1 X81.480 Y71.918 E0.00839

G1 X81.473 Y70.663 E0.03270

G1 X81.518 Y70.480 E0.00492

G1 X81.627 Y70.364 E0.00414

M204 S1250

G1 X81.755 Y70.373 F9000.000

G1 X82.017 Y70.899

M204 S1000

G1 F4800.000

G1 X82.781 Y71.663 E0.03274

G1 X83.113 Y71.550 E0.01061

G1 X83.278 Y71.472 E0.00553

G1 X82.834 Y71.029 E0.01901

G1 X83.521 Y71.029 E0.02082

G1 X83.860 Y71.368 E0.01451

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.521 Y71.029 E-0.26554

G1 X82.834 Y71.029 E-0.38081

G1 X83.173 Y71.368 E-0.26565

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.606 Y70.679

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X86.365 Y70.539 E0.01395

G1 X86.364 Y70.531 F9000.000

G1 F2400.000

G1 X85.590 Y70.590 E0.00448

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.364 Y70.531 E-0.43011

G1 E-0.52989 F4200.00000

G1 Z10.600 F9000.000

G1 X88.861 Y70.676

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X88.373 Y70.573 E0.00544

G1 X88.252 Y70.552 E0.00099

G1 X88.132 Y70.531 E0.00070

G1 X88.131 Y70.536 F9000.000

G1 F2400.000

G1 X88.860 Y70.680 E0.01315

G1 X90.132 Y70.946 F9000.000

G1 F2400.000

G1 X90.653 Y71.082 E0.00668

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.132 Y70.946 E-0.29823

G1 E-0.66177 F4200.00000

G1 Z10.600 F9000.000

G1 X92.052 Y71.888

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.205 Y71.041 E0.03140

G1 X91.801 Y71.043 E0.01563

G1 X92.464 Y71.706 E0.02456

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y71.043 E-0.51925

G1 X91.205 Y71.041 E-0.33049

G1 X91.285 Y71.121 E-0.06225

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X92.333 Y77.572

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y77.556 E0.18916

G1 X82.137 Y77.573 E0.07649

G1 X83.574 Y76.639 E0.04465

G1 X83.924 Y76.461 E0.01023

G1 X84.687 Y76.266 E0.02051

G1 X89.884 Y76.269 E0.13541

G1 X90.008 Y76.319 E0.00350

G1 X90.378 Y76.392 E0.00983

G1 X90.600 Y76.529 E0.00678

G1 X90.827 Y76.595 E0.00618

G1 X92.282 Y77.539 E0.04519

M204 S1250

G1 X92.993 Y77.587 F9000.000

M204 S800

G1 F1500.000

G1 X93.004 Y77.658 E0.00187

G1 X92.968 Y77.809 E0.00404

G1 X92.837 Y77.958 E0.00519

G1 X92.718 Y77.990 E0.00321

G1 X85.074 Y77.974 E0.19918

G1 X81.770 Y77.993 E0.08608

G1 X81.651 Y77.960 E0.00322

G1 X81.544 Y77.853 E0.00394

G1 X81.501 Y77.711 E0.00388

G1 X81.499 Y77.579 E0.00344

G1 X81.588 Y77.448 E0.00412

G1 X81.710 Y77.352 E0.00404

G1 X83.365 Y76.277 E0.05144

G1 X83.776 Y76.068 E0.01201

G1 X84.635 Y75.848 E0.02309

G1 X89.922 Y75.851 E0.13777

G1 X90.035 Y75.872 E0.00300

G1 X90.136 Y75.918 E0.00289

G1 X90.510 Y75.992 E0.00992

G1 X90.669 Y76.067 E0.00459

G1 X90.783 Y76.147 E0.00363

G1 X90.985 Y76.206 E0.00549

G1 X91.086 Y76.260 E0.00298

G1 X92.816 Y77.388 E0.05381

G1 X92.961 Y77.536 E0.00539

M204 S1250

G1 X92.951 Y77.645 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.004 Y77.658 E-0.07150

G1 X92.968 Y77.809 E-0.08592

G1 X92.837 Y77.958 E-0.11046

G1 X92.718 Y77.990 E-0.06822

G1 X91.679 Y77.988 E-0.57590

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X83.320 Y76.954

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.617 Y77.251 E0.01100

G1 X84.208 Y77.247 E0.01546

G1 X83.824 Y76.864 E0.01421

G1 X84.035 Y76.756 E0.00621

G1 X84.254 Y76.700 E0.00591

G1 X84.798 Y77.244 E0.02014

G1 X85.391 Y77.243 E0.01552

G1 X84.727 Y76.580 E0.02457

G1 X85.322 Y76.580 E0.01556

G1 X85.986 Y77.245 E0.02459

G1 X86.581 Y77.246 E0.01558

G1 X85.916 Y76.581 E0.02462

G1 X86.510 Y76.581 E0.01555

G1 X87.176 Y77.247 E0.02466

G1 X87.771 Y77.248 E0.01558

G1 X87.104 Y76.581 E0.02470

G1 X87.698 Y76.582 E0.01555

G1 X88.366 Y77.250 E0.02474

G1 X88.961 Y77.251 E0.01558

G1 X88.292 Y76.582 E0.02478

G1 X88.886 Y76.582 E0.01555

G1 X89.556 Y77.252 E0.02482

G1 X90.151 Y77.254 E0.01558

G1 X89.480 Y76.582 E0.02485

G1 X89.824 Y76.582 E0.00901

G1 X89.920 Y76.620 E0.00270

G1 X90.159 Y76.668 E0.00638

G1 X90.934 Y77.443 E0.02871

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.159 Y76.668 E-0.60777

G1 X89.920 Y76.620 E-0.13507

G1 X89.824 Y76.582 E-0.05717

G1 X89.622 Y76.582 E-0.11199

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.401 Y83.714

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.611 Y84.086 E0.02277

G1 X83.510 Y84.707 E0.03294

G1 X83.231 Y84.839 E0.00803

G1 X82.827 Y84.976 E0.01112

G1 X82.614 Y85.020 E0.00565

G1 X81.982 Y85.016 E0.01648

G1 X81.937 Y84.983 E0.00146

G1 X81.897 Y84.853 E0.00355

G1 X81.891 Y83.712 E0.02972

G1 X85.341 Y83.714 E0.08991

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.611 Y84.086 E-0.45436

G1 X83.892 Y84.492 E-0.45764

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X89.066 Y83.719

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y83.730 E0.09185

G1 X92.589 Y84.826 E0.02854

G1 X92.557 Y84.970 E0.00384

G1 X92.543 Y84.996 E0.00076

G1 X91.900 Y85.017 E0.01677

G1 X91.524 Y84.942 E0.00999

G1 X90.948 Y84.695 E0.01634

G1 X90.322 Y84.304 E0.01923

G1 X89.777 Y84.017 E0.01605

G1 X89.720 Y84.009 E0.00150

G1 X89.122 Y83.742 E0.01707

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.767 Y83.736 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X81.668 Y83.318

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.767 Y83.294 E0.00266

G1 X92.724 Y83.313 E0.28549

G1 X92.822 Y83.328 E0.00257

G1 X92.961 Y83.474 E0.00526

G1 X93.014 Y83.707 E0.00624

G1 X93.007 Y84.874 E0.03040

G1 X92.953 Y85.113 E0.00639

G1 X92.836 Y85.340 E0.00664

G1 X92.764 Y85.406 E0.00256

G1 X91.850 Y85.436 E0.02384

G1 X91.407 Y85.347 E0.01177

G1 X90.753 Y85.066 E0.01852

G1 X90.114 Y84.666 E0.01966

G1 X89.645 Y84.420 E0.01381

G1 X89.592 Y84.412 E0.00140

G1 X89.312 Y84.271 E0.00816

G1 X88.532 Y83.951 E0.02196

G1 X88.377 Y83.860 E0.00470

G1 X88.009 Y83.731 E0.01014

G1 X87.957 Y83.685 E0.00183

G1 X87.638 Y83.588 E0.00868

G1 X87.184 Y83.518 E0.01198

G1 X86.821 Y83.589 E0.00962

G1 X86.448 Y83.745 E0.01054

G1 X86.219 Y83.817 E0.00625

G1 X86.185 Y83.808 E0.00092

G1 X85.907 Y83.969 E0.00836

G1 X85.475 Y84.133 E0.01204

G1 X84.805 Y84.456 E0.01939

G1 X83.702 Y85.079 E0.03300

G1 X83.388 Y85.227 E0.00904

G1 X82.937 Y85.380 E0.01240

G1 X82.656 Y85.438 E0.00748

G1 X81.844 Y85.433 E0.02116

G1 X81.573 Y85.224 E0.00891

G1 X81.480 Y84.916 E0.00841

G1 X81.473 Y83.661 E0.03268

G1 X81.518 Y83.478 E0.00492

G1 X81.627 Y83.362 E0.00416

M204 S1250

G1 X81.756 Y83.370 F9000.000

G1 X82.017 Y83.896

M204 S1000

G1 F4800.000

G1 X82.782 Y84.661 E0.03276

G1 X83.113 Y84.548 E0.01061

G1 X83.278 Y84.470 E0.00553

G1 X82.834 Y84.026 E0.01903

G1 X83.522 Y84.026 E0.02084

G1 X83.861 Y84.365 E0.01453

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.522 Y84.026 E-0.26573

G1 X82.834 Y84.026 E-0.38102

G1 X83.173 Y84.364 E-0.26525

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.607 Y83.676

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X86.366 Y83.537 E0.01394

G1 X86.364 Y83.528 F9000.000

G1 F2400.000

G1 X85.591 Y83.588 E0.00449

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.364 Y83.528 E-0.42997

G1 E-0.53003 F4200.00000

G1 Z10.600 F9000.000

G1 X88.862 Y83.674

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X88.372 Y83.571 E0.00542

G1 X88.252 Y83.550 E0.00098

G1 X88.133 Y83.529 E0.00069

G1 X88.132 Y83.533 F9000.000

G1 F2400.000

G1 X88.861 Y83.678 E0.01314

G1 X90.148 Y83.946 F9000.000

G1 F2400.000

G1 X90.653 Y84.081 E0.00671

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.148 Y83.946 E-0.28969

G1 E-0.67031 F4200.00000

G1 Z10.600 F9000.000

G1 X92.052 Y84.886

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.205 Y84.039 E0.03141

G1 X91.801 Y84.041 E0.01564

G1 X92.464 Y84.704 E0.02458

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y84.041 E-0.51946

G1 X91.205 Y84.039 E-0.33058

G1 X91.284 Y84.118 E-0.06196

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X92.332 Y90.569

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y90.554 E0.18913

G1 X82.136 Y90.571 E0.07653

G1 X83.574 Y89.637 E0.04468

G1 X83.924 Y89.459 E0.01022

G1 X84.690 Y89.263 E0.02062

G1 X89.885 Y89.267 E0.13534

G1 X90.007 Y89.316 E0.00345

G1 X90.379 Y89.390 E0.00987

G1 X90.598 Y89.527 E0.00673

G1 X90.827 Y89.593 E0.00622

G1 X92.282 Y90.536 E0.04517

M204 S1250

G1 X92.992 Y90.584 F9000.000

M204 S800

G1 F1500.000

G1 X93.004 Y90.656 E0.00188

G1 X92.968 Y90.807 E0.00404

G1 X92.837 Y90.956 E0.00519

G1 X92.718 Y90.988 E0.00319

G1 X85.074 Y90.972 E0.19918

G1 X81.770 Y90.991 E0.08608

G1 X81.651 Y90.958 E0.00322

G1 X81.544 Y90.851 E0.00394

G1 X81.501 Y90.709 E0.00388

G1 X81.499 Y90.576 E0.00344

G1 X81.588 Y90.445 E0.00414

G1 X81.710 Y90.349 E0.00404

G1 X83.365 Y89.274 E0.05143

G1 X83.776 Y89.066 E0.01200

G1 X84.638 Y88.845 E0.02320

G1 X89.923 Y88.849 E0.13769

G1 X90.035 Y88.870 E0.00298

G1 X90.136 Y88.916 E0.00289

G1 X90.510 Y88.990 E0.00993

G1 X90.669 Y89.064 E0.00457

G1 X90.782 Y89.145 E0.00364

G1 X90.985 Y89.204 E0.00551

G1 X91.086 Y89.258 E0.00298

G1 X92.816 Y90.386 E0.05382

G1 X92.962 Y90.533 E0.00538

M204 S1250

G1 X92.950 Y90.643 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.004 Y90.656 E-0.07179

G1 X92.968 Y90.807 E-0.08592

G1 X92.837 Y90.956 E-0.11046

G1 X92.718 Y90.988 E-0.06794

G1 X91.679 Y90.986 E-0.57589

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X83.319 Y89.952

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.616 Y90.249 E0.01101

G1 X84.206 Y90.245 E0.01546

G1 X83.823 Y89.862 E0.01421

G1 X84.035 Y89.754 E0.00622

G1 X84.253 Y89.698 E0.00591

G1 X84.797 Y90.242 E0.02013

G1 X85.390 Y90.241 E0.01552

G1 X84.726 Y89.578 E0.02457

M73 P89 R7

G1 X85.320 Y89.578 E0.01555

G1 X85.985 Y90.242 E0.02462

G1 X86.580 Y90.244 E0.01558

G1 X85.914 Y89.578 E0.02465

G1 X86.508 Y89.578 E0.01556

G1 X87.175 Y90.245 E0.02468

G1 X87.770 Y90.246 E0.01558

G1 X87.102 Y89.579 E0.02472

G1 X87.697 Y89.579 E0.01556

G1 X88.365 Y90.247 E0.02475

G1 X88.960 Y90.249 E0.01558

G1 X88.291 Y89.579 E0.02478

G1 X88.885 Y89.580 E0.01556

G1 X89.555 Y90.250 E0.02481

G1 X90.150 Y90.251 E0.01558

G1 X89.479 Y89.580 E0.02485

G1 X89.824 Y89.580 E0.00903

G1 X89.918 Y89.618 E0.00266

G1 X90.158 Y89.665 E0.00641

G1 X90.933 Y90.441 E0.02871

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.158 Y89.665 E-0.60766

G1 X89.918 Y89.618 E-0.13558

G1 X89.824 Y89.580 E-0.05622

G1 X89.621 Y89.580 E-0.11254

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.402 Y96.712

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.611 Y97.083 E0.02278

G1 X83.510 Y97.705 E0.03295

G1 X83.231 Y97.836 E0.00803

G1 X82.827 Y97.974 E0.01113

G1 X82.615 Y98.018 E0.00564

G1 X81.982 Y98.013 E0.01649

G1 X81.937 Y97.981 E0.00146

G1 X81.897 Y97.851 E0.00353

G1 X81.891 Y96.710 E0.02973

G1 X85.342 Y96.712 E0.08993

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.611 Y97.083 E-0.45468

G1 X83.892 Y97.489 E-0.45732

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X89.067 Y96.717

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y96.728 E0.09183

G1 X92.589 Y97.824 E0.02854

G1 X92.557 Y97.968 E0.00384

G1 X92.544 Y97.993 E0.00074

G1 X91.900 Y98.015 E0.01678

G1 X91.524 Y97.940 E0.00998

G1 X90.948 Y97.693 E0.01634

G1 X90.315 Y97.297 E0.01944

G1 X89.483 Y96.887 E0.02418

G1 X89.122 Y96.739 E0.01015

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.768 Y96.734 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X81.668 Y96.316

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.767 Y96.292 E0.00265

G1 X92.724 Y96.311 E0.28549

G1 X92.822 Y96.326 E0.00257

G1 X92.961 Y96.472 E0.00526

G1 X93.014 Y96.704 E0.00622

G1 X93.007 Y97.872 E0.03042

G1 X92.953 Y98.111 E0.00639

G1 X92.837 Y98.338 E0.00663

G1 X92.764 Y98.404 E0.00255

G1 X91.850 Y98.434 E0.02385

G1 X91.407 Y98.345 E0.01177

G1 X90.753 Y98.064 E0.01852

G1 X90.111 Y97.663 E0.01973

G1 X89.311 Y97.268 E0.02325

G1 X88.532 Y96.949 E0.02194

G1 X88.377 Y96.858 E0.00469

G1 X88.009 Y96.729 E0.01016

G1 X87.956 Y96.682 E0.00182

G1 X87.638 Y96.586 E0.00866

G1 X87.184 Y96.516 E0.01198

G1 X86.821 Y96.587 E0.00962

G1 X86.448 Y96.743 E0.01054

G1 X86.217 Y96.815 E0.00630

G1 X86.183 Y96.807 E0.00092

G1 X85.907 Y96.967 E0.00830

G1 X85.475 Y97.131 E0.01204

G1 X84.805 Y97.454 E0.01939

G1 X83.702 Y98.077 E0.03300

G1 X83.388 Y98.224 E0.00904

G1 X82.937 Y98.378 E0.01241

G1 X82.656 Y98.436 E0.00748

G1 X81.844 Y98.430 E0.02116

G1 X81.573 Y98.222 E0.00890

G1 X81.480 Y97.914 E0.00841

G1 X81.473 Y96.659 E0.03268

G1 X81.518 Y96.476 E0.00492

G1 X81.627 Y96.359 E0.00416

M204 S1250

G1 X81.755 Y96.368 F9000.000

G1 X82.017 Y96.894

M204 S1000

G1 F4800.000

G1 X82.782 Y97.658 E0.03277

G1 X83.113 Y97.545 E0.01061

G1 X83.278 Y97.468 E0.00552

G1 X82.834 Y97.024 E0.01903

G1 X83.522 Y97.024 E0.02083

G1 X83.861 Y97.363 E0.01453

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.522 Y97.024 E-0.26572

G1 X82.834 Y97.024 E-0.38094

G1 X83.173 Y97.362 E-0.26534

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.608 Y96.674

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X86.367 Y96.535 E0.01395

G1 X86.366 Y96.526 F9000.000

G1 F2400.000

G1 X85.592 Y96.589 E0.00457

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.366 Y96.526 E-0.42996

G1 E-0.53004 F4200.00000

G1 Z10.600 F9000.000

G1 X88.863 Y96.672

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X88.372 Y96.568 E0.00544

G1 X88.252 Y96.548 E0.00098

G1 X88.132 Y96.527 E0.00070

G1 X88.132 Y96.531 F9000.000

G1 F2400.000

G1 X88.862 Y96.676 E0.01317

G1 X90.132 Y96.942 F9000.000

G1 F2400.000

G1 X90.653 Y97.078 E0.00669

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.132 Y96.942 E-0.29802

G1 E-0.66198 F4200.00000

G1 Z10.600 F9000.000

G1 X92.052 Y97.884

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.205 Y97.037 E0.03140

G1 X91.801 Y97.039 E0.01564

G1 X92.464 Y97.702 E0.02457

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y97.039 E-0.51930

G1 X91.205 Y97.037 E-0.33056

G1 X91.284 Y97.116 E-0.06214

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X92.332 Y103.567

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y103.552 E0.18913

G1 X82.136 Y103.569 E0.07653

G1 X83.574 Y102.634 E0.04468

G1 X83.923 Y102.457 E0.01021

G1 X84.691 Y102.261 E0.02063

G1 X89.885 Y102.265 E0.13533

G1 X90.007 Y102.314 E0.00345

G1 X90.379 Y102.388 E0.00987

G1 X90.598 Y102.524 E0.00673

G1 X90.827 Y102.591 E0.00620

G1 X92.281 Y103.534 E0.04518

M204 S1250

G1 X92.992 Y103.582 F9000.000

M204 S800

G1 F1500.000

G1 X93.004 Y103.654 E0.00188

G1 X92.968 Y103.805 E0.00404

G1 X92.837 Y103.954 E0.00519

G1 X92.718 Y103.986 E0.00319

G1 X85.074 Y103.969 E0.19919

G1 X81.770 Y103.989 E0.08608

G1 X81.651 Y103.956 E0.00322

G1 X81.544 Y103.849 E0.00394

G1 X81.501 Y103.707 E0.00388

G1 X81.499 Y103.574 E0.00344

G1 X81.588 Y103.443 E0.00414

G1 X81.710 Y103.347 E0.00404

G1 X83.365 Y102.272 E0.05143

G1 X83.776 Y102.064 E0.01199

G1 X84.638 Y101.843 E0.02320

G1 X89.923 Y101.847 E0.13768

G1 X90.035 Y101.868 E0.00298

G1 X90.136 Y101.914 E0.00289

G1 X90.510 Y101.988 E0.00993

G1 X90.669 Y102.062 E0.00458

G1 X90.783 Y102.143 E0.00362

G1 X90.985 Y102.202 E0.00550

G1 X91.086 Y102.256 E0.00299

G1 X92.816 Y103.384 E0.05382

G1 X92.962 Y103.531 E0.00538

M204 S1250

G1 X92.950 Y103.641 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.004 Y103.654 E-0.07179

G1 X92.968 Y103.805 E-0.08592

G1 X92.837 Y103.954 E-0.11046

G1 X92.718 Y103.986 E-0.06794

G1 X91.679 Y103.984 E-0.57589

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X83.319 Y102.950

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.616 Y103.247 E0.01100

G1 X84.206 Y103.243 E0.01546

G1 X83.823 Y102.860 E0.01421

G1 X84.034 Y102.752 E0.00622

G1 X84.253 Y102.696 E0.00591

G1 X84.797 Y103.240 E0.02013

G1 X85.390 Y103.239 E0.01552

G1 X84.726 Y102.576 E0.02456

G1 X85.320 Y102.576 E0.01555

G1 X85.985 Y103.240 E0.02461

G1 X86.580 Y103.242 E0.01558

G1 X85.914 Y102.576 E0.02464

G1 X86.508 Y102.576 E0.01556

G1 X87.175 Y103.243 E0.02468

G1 X87.770 Y103.244 E0.01558

G1 X87.102 Y102.577 E0.02471

G1 X87.697 Y102.577 E0.01556

G1 X88.365 Y103.245 E0.02474

G1 X88.960 Y103.247 E0.01558

G1 X88.291 Y102.577 E0.02478

G1 X88.885 Y102.578 E0.01556

G1 X89.555 Y103.248 E0.02481

G1 X90.150 Y103.249 E0.01558

G1 X89.479 Y102.578 E0.02484

G1 X89.824 Y102.578 E0.00903

G1 X89.918 Y102.616 E0.00266

G1 X90.158 Y102.663 E0.00640

G1 X90.933 Y103.439 E0.02871

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.158 Y102.663 E-0.60763

G1 X89.918 Y102.616 E-0.13553

G1 X89.824 Y102.578 E-0.05622

G1 X89.621 Y102.578 E-0.11261

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.403 Y109.709

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.611 Y110.081 E0.02280

G1 X83.510 Y110.703 E0.03295

G1 X83.231 Y110.834 E0.00802

G1 X82.826 Y110.972 E0.01114

G1 X82.614 Y111.016 E0.00566

G1 X81.982 Y111.011 E0.01647

G1 X81.937 Y110.979 E0.00145

G1 X81.897 Y110.849 E0.00354

G1 X81.891 Y109.708 E0.02972

G1 X85.343 Y109.709 E0.08995

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.611 Y110.081 E-0.45504

G1 X83.893 Y110.487 E-0.45696

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X89.066 Y109.714

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.591 Y109.726 E0.09186

G1 X92.589 Y110.821 E0.02853

G1 X92.557 Y110.966 E0.00386

G1 X92.544 Y110.991 E0.00073

G1 X91.900 Y111.013 E0.01679

G1 X91.524 Y110.938 E0.00998

G1 X90.948 Y110.691 E0.01634

G1 X90.315 Y110.295 E0.01944

G1 X89.483 Y109.885 E0.02418

G1 X89.121 Y109.737 E0.01018

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.767 Y109.732 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X81.668 Y109.314

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.767 Y109.290 E0.00265

G1 X92.724 Y109.309 E0.28549

G1 X92.822 Y109.323 E0.00257

G1 X92.961 Y109.470 E0.00527

G1 X93.014 Y109.702 E0.00622

G1 X93.007 Y110.869 E0.03041

G1 X92.953 Y111.109 E0.00641

G1 X92.837 Y111.335 E0.00662

G1 X92.764 Y111.401 E0.00255

G1 X91.849 Y111.432 E0.02385

G1 X91.407 Y111.343 E0.01177

G1 X90.753 Y111.062 E0.01852

G1 X90.111 Y110.661 E0.01973

G1 X89.311 Y110.266 E0.02325

G1 X88.532 Y109.947 E0.02194

G1 X88.377 Y109.856 E0.00469

G1 X88.009 Y109.727 E0.01015

G1 X87.957 Y109.680 E0.00183

G1 X87.638 Y109.584 E0.00867

G1 X87.184 Y109.514 E0.01198

G1 X86.821 Y109.585 E0.00962

G1 X86.448 Y109.741 E0.01054

G1 X86.217 Y109.813 E0.00630

G1 X86.183 Y109.805 E0.00092

G1 X85.907 Y109.965 E0.00830

G1 X85.475 Y110.129 E0.01204

G1 X84.805 Y110.452 E0.01939

G1 X83.702 Y111.075 E0.03300

G1 X83.388 Y111.222 E0.00904

G1 X82.937 Y111.375 E0.01241

G1 X82.656 Y111.434 E0.00749

G1 X81.844 Y111.428 E0.02115

G1 X81.573 Y111.220 E0.00890

G1 X81.480 Y110.911 E0.00841

G1 X81.473 Y109.657 E0.03269

G1 X81.518 Y109.474 E0.00490

G1 X81.627 Y109.357 E0.00416

M204 S1250

G1 X81.755 Y109.366 F9000.000

G1 X82.017 Y109.891

M204 S1000

G1 F4800.000

G1 X82.782 Y110.656 E0.03276

G1 X83.114 Y110.543 E0.01064

G1 X83.279 Y110.466 E0.00551

G1 X82.835 Y110.022 E0.01903

G1 X83.522 Y110.022 E0.02083

G1 X83.861 Y110.361 E0.01453

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.522 Y110.022 E-0.26571

G1 X82.835 Y110.022 E-0.38097

G1 X83.173 Y110.360 E-0.26532

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X85.608 Y109.672

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X86.368 Y109.533 E0.01397

G1 X86.367 Y109.524 F9000.000

G1 F2400.000

G1 X85.593 Y109.586 E0.00459

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.367 Y109.524 E-0.43041

G1 E-0.52959 F4200.00000

G1 Z10.600 F9000.000

G1 X88.862 Y109.669

G1 Z10.400

G1 E3.20000 F2400.00000

G1 X88.372 Y109.566 E0.00545

G1 X88.251 Y109.545 E0.00099

G1 X88.131 Y109.525 E0.00070

G1 X88.130 Y109.528 F9000.000

G1 F2400.000

G1 X88.861 Y109.673 E0.01317

G1 X90.131 Y109.939 F9000.000

G1 F2400.000

G1 X90.652 Y110.075 E0.00671

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.131 Y109.939 E-0.29816

G1 E-0.66184 F4200.00000

G1 Z10.600 F9000.000

G1 X92.052 Y110.882

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.205 Y110.035 E0.03142

G1 X91.801 Y110.037 E0.01565

G1 X92.464 Y110.700 E0.02458

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y110.037 E-0.51952

G1 X91.205 Y110.035 E-0.33065

G1 X91.283 Y110.114 E-0.06183

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X92.332 Y116.565

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y116.549 E0.18914

G1 X82.136 Y116.566 E0.07653

G1 X83.574 Y115.632 E0.04468

G1 X83.924 Y115.455 E0.01022

G1 X84.687 Y115.259 E0.02052

G1 X89.884 Y115.263 E0.13543

G1 X90.007 Y115.312 E0.00345

G1 X90.379 Y115.386 E0.00988

G1 X90.600 Y115.522 E0.00675

G1 X90.826 Y115.588 E0.00616

G1 X92.282 Y116.532 E0.04520

M204 S1250

G1 X92.992 Y116.580 F9000.000

M204 S800

G1 F1500.000

G1 X93.004 Y116.652 E0.00190

G1 X92.968 Y116.803 E0.00404

G1 X92.837 Y116.952 E0.00519

G1 X92.718 Y116.984 E0.00319

G1 X85.074 Y116.967 E0.19919

G1 X81.770 Y116.987 E0.08608

G1 X81.651 Y116.954 E0.00322

G1 X81.544 Y116.847 E0.00394

G1 X81.501 Y116.705 E0.00388

G1 X81.499 Y116.572 E0.00346

G1 X81.588 Y116.441 E0.00412

G1 X81.710 Y116.345 E0.00404

G1 X83.365 Y115.270 E0.05143

G1 X83.776 Y115.062 E0.01200

G1 X84.634 Y114.841 E0.02310

G1 X89.923 Y114.845 E0.13779

G1 X90.035 Y114.866 E0.00298

G1 X90.136 Y114.912 E0.00289

G1 X90.510 Y114.986 E0.00994

G1 X90.669 Y115.060 E0.00458

G1 X90.783 Y115.140 E0.00362

G1 X90.985 Y115.199 E0.00548

G1 X91.086 Y115.253 E0.00299

G1 X92.816 Y116.382 E0.05383

G1 X92.961 Y116.529 E0.00537

M204 S1250

G1 X92.950 Y116.639 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X93.004 Y116.652 E-0.07199

G1 X92.968 Y116.803 E-0.08599

G1 X92.837 Y116.952 E-0.11046

G1 X92.718 Y116.984 E-0.06793

G1 X91.680 Y116.981 E-0.57562

G1 E-0.04800 F4200.00000

G1 Z10.600 F9000.000

G1 X83.319 Y115.947

G1 Z10.400

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.616 Y116.244 E0.01100

G1 X84.207 Y116.241 E0.01545

G1 X83.823 Y115.857 E0.01420

G1 X84.035 Y115.750 E0.00621

G1 X84.253 Y115.694 E0.00591

G1 X84.797 Y116.237 E0.02012

G1 X85.390 Y116.236 E0.01552

G1 X84.726 Y115.573 E0.02457

G1 X85.321 Y115.574 E0.01557

G1 X85.985 Y116.238 E0.02459

G1 X86.580 Y116.239 E0.01558

G1 X85.915 Y115.574 E0.02462

G1 X86.509 Y115.574 E0.01556

G1 X87.175 Y116.240 E0.02466

G1 X87.770 Y116.242 E0.01558

G1 X87.103 Y115.575 E0.02469

G1 X87.697 Y115.575 E0.01556

G1 X88.365 Y116.243 E0.02473

G1 X88.960 Y116.244 E0.01558

G1 X88.291 Y115.575 E0.02476

G1 X88.885 Y115.576 E0.01556

G1 X89.555 Y116.246 E0.02480

G1 X90.150 Y116.247 E0.01558

G1 X89.480 Y115.576 E0.02483

G1 X89.824 Y115.576 E0.00901

G1 X89.918 Y115.614 E0.00266

G1 X90.159 Y115.662 E0.00642

G1 X90.934 Y116.437 E0.02870

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;10.55

G1 Z10.550 F9000.000

;AFTER\_LAYER\_CHANGE

;10.55

G1 E-3.20000 F4200.00000

G1 Z10.750 F9000.000

G1 X92.493 Y46.347

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.386 Y46.344 E0.00278

G1 X91.890 Y46.188 E0.01354

G1 X91.566 Y46.055 E0.00912

G1 X91.147 Y45.828 E0.01241

G1 X90.372 Y45.342 E0.02384

G1 X89.357 Y44.836 E0.02955

G1 X92.567 Y44.836 E0.08364

G1 X92.589 Y44.883 E0.00135

G1 X92.588 Y46.047 E0.03035

G1 X92.518 Y46.294 E0.00668

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.386 Y46.344 E-0.07803

G1 X91.890 Y46.188 E-0.28799

G1 X91.566 Y46.055 E-0.19401

G1 X91.147 Y45.828 E-0.26387

G1 X91.013 Y45.744 E-0.08810

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X92.821 Y44.442

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.904 Y44.521 E0.00298

G1 X92.920 Y44.602 E0.00215

G1 X93.007 Y44.792 E0.00545

G1 X93.006 Y46.106 E0.03424

G1 X92.882 Y46.539 E0.01175

G1 X92.753 Y46.748 E0.00638

G1 X92.716 Y46.771 E0.00114

G1 X92.316 Y46.760 E0.01043

G1 X91.748 Y46.582 E0.01552

G1 X91.387 Y46.433 E0.01017

G1 X90.937 Y46.189 E0.01333

G1 X90.167 Y45.706 E0.02368

G1 X89.238 Y45.239 E0.02709

G1 X88.788 Y45.055 E0.01267

G1 X88.647 Y44.954 E0.00452

G1 X88.291 Y44.790 E0.01022

G1 X87.912 Y44.512 E0.01224

G1 X87.875 Y44.465 E0.00157

G1 X88.202 Y44.419 E0.00860

G1 X92.763 Y44.429 E0.11884

M204 S1250

G1 X92.823 Y44.556 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.904 Y44.521 E-0.09348

G1 X92.920 Y44.602 E-0.04564

G1 X93.007 Y44.792 E-0.11582

G1 X93.006 Y45.977 E-0.65706

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X91.673 Y45.963

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.275 Y45.361 E0.02562

G1 X92.275 Y45.149 E0.00638

G1 X91.805 Y45.149 E0.01415

G1 X91.226 Y45.728 E0.02464

M204 S1250

G1 X90.817 Y45.188 F9000.000

G1 F2400.000

G1 X90.334 Y45.061 E0.00390

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.817 Y45.188 E-0.27699

G1 E-0.68301 F4200.00000

G1 Z10.750 F9000.000

G1 X88.542 Y44.676

G1 Z10.550

G1 E3.20000 F2400.00000

G1 X89.152 Y44.796 E0.01095

G1 X89.151 Y44.802 F9000.000

G1 F2400.000

G1 X88.537 Y44.638 E0.00634

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.151 Y44.802 E-0.35238

G1 E-0.60762 F4200.00000

G1 Z10.750 F9000.000

G1 X85.158 Y44.832

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.625 Y45.085 E0.01537

G1 X83.708 Y45.598 E0.02738

G1 X83.169 Y45.927 E0.01645

G1 X82.848 Y46.081 E0.00928

G1 X82.329 Y46.283 E0.01452

G1 X82.115 Y46.340 E0.00578

G1 X81.965 Y46.332 E0.00392

G1 X81.955 Y46.317 E0.00047

G1 X81.898 Y46.089 E0.00610

G1 X81.898 Y44.834 E0.03272

G1 X85.098 Y44.832 E0.08338

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.625 Y45.085 E-0.29718

G1 X83.708 Y45.598 E-0.58227

G1 X83.658 Y45.628 E-0.03255

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X81.669 Y44.437

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.765 Y44.416 E0.00256

G1 X86.303 Y44.414 E0.11822

G1 X86.527 Y44.476 E0.00605

G1 X86.432 Y44.621 E0.00452

G1 X86.209 Y44.769 E0.00698

G1 X86.109 Y44.793 E0.00266

G1 X85.885 Y44.949 E0.00714

G1 X84.817 Y45.457 E0.03079

G1 X83.919 Y45.959 E0.02681

G1 X83.369 Y46.294 E0.01678

G1 X83.015 Y46.465 E0.01024

G1 X82.459 Y46.680 E0.01553

G1 X82.159 Y46.761 E0.00811

G1 X81.734 Y46.740 E0.01109

G1 X81.559 Y46.458 E0.00865

G1 X81.481 Y46.142 E0.00847

G1 X81.470 Y44.832 E0.03413

G1 X81.523 Y44.602 E0.00616

G1 X81.630 Y44.482 E0.00419

M204 S1250

G1 X81.754 Y44.487 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.765 Y44.416 E-0.08361

G1 X83.260 Y44.415 E-0.82839

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.337 Y46.145

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.336 Y45.146 E0.03840

G1 X82.719 Y45.147 E0.01677

G1 X82.024 Y45.842 E0.02673

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.719 Y45.147 E-0.54481

G1 X83.336 Y45.146 E-0.34185

G1 X83.303 Y45.179 E-0.02534

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.313 Y51.470

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.881 Y50.454 E0.04869

G1 X84.463 Y50.167 E0.01689

G1 X85.084 Y50.010 E0.01669

G1 X85.159 Y50.009 E0.00196

G1 X85.242 Y49.970 E0.00238

G1 X85.472 Y49.912 E0.00618

G1 X89.146 Y49.915 E0.09575

G1 X89.513 Y50.005 E0.00984

G1 X89.753 Y50.132 E0.00707

G1 X89.877 Y50.122 E0.00326

G1 X90.037 Y50.174 E0.00439

G1 X90.595 Y50.449 E0.01619

G1 X92.169 Y51.469 E0.04887

G1 X82.373 Y51.470 E0.25523

M204 S1250

G1 X81.664 Y51.870 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y51.759 E0.00384

G1 X81.544 Y51.622 E0.00362

G1 X81.600 Y51.502 E0.00347

G1 X81.803 Y51.302 E0.00741

G1 X83.675 Y50.090 E0.05811

G1 X84.318 Y49.773 E0.01868

G1 X85.063 Y49.593 E0.01997

G1 X85.200 Y49.529 E0.00394

G1 X85.383 Y49.494 E0.00487

G1 X89.196 Y49.497 E0.09935

G1 X89.663 Y49.611 E0.01252

G1 X89.840 Y49.705 E0.00521

G1 X89.926 Y49.698 E0.00227

G1 X90.196 Y49.786 E0.00739

G1 X90.802 Y50.085 E0.01760

G1 X92.575 Y51.234 E0.05506

G1 X92.852 Y51.469 E0.00946

G1 X92.936 Y51.674 E0.00576

G1 X92.915 Y51.775 E0.00271

G1 X92.890 Y51.809 E0.00109

G1 X92.775 Y51.879 E0.00350

G1 X92.724 Y51.887 E0.00134

G1 X81.723 Y51.881 E0.28665

M204 S1250

G1 X81.670 Y51.723 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.567 Y51.759 E-0.10956

G1 X81.544 Y51.622 E-0.07692

G1 X81.600 Y51.502 E-0.07375

G1 X81.803 Y51.302 E-0.15770

G1 X82.552 Y50.818 E-0.49407

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X90.477 Y51.344

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.839 Y50.981 E0.01386

G1 X90.468 Y50.740 E0.01197

G1 X90.052 Y51.156 E0.01588

G1 X89.439 Y51.156 E0.01655

G1 X90.060 Y50.535 E0.02373

G1 X89.840 Y50.439 E0.00648

G1 X89.687 Y50.452 E0.00416

G1 X89.585 Y50.398 E0.00314

G1 X88.826 Y51.156 E0.02897

G1 X88.214 Y51.156 E0.01655

G1 X89.135 Y50.235 E0.03519

G1 X89.109 Y50.229 E0.00072

G1 X88.528 Y50.229 E0.01571

G1 X87.601 Y51.156 E0.03540

G1 X86.988 Y51.156 E0.01655

G1 X87.914 Y50.230 E0.03537

G1 X87.301 Y50.231 E0.01658

G1 X86.376 Y51.156 E0.03534

G1 X85.763 Y51.156 E0.01655

G1 X86.687 Y50.232 E0.03531

G1 X86.076 Y50.230 E0.01650

G1 X85.150 Y51.156 E0.03538

G1 X84.537 Y51.156 E0.01655

G1 X85.454 Y50.240 E0.03501

G1 X85.231 Y50.322 E0.00641

G1 X85.125 Y50.323 E0.00286

G1 X84.634 Y50.448 E0.01370

G1 X83.737 Y51.344 E0.03427

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.634 Y50.448 E-0.70290

G1 X84.999 Y50.355 E-0.20910

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X89.357 Y57.834

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.567 Y57.834 E0.08364

G1 X92.589 Y57.880 E0.00134

G1 X92.588 Y59.045 E0.03036

G1 X92.507 Y59.329 E0.00769

G1 X92.493 Y59.344 E0.00054

G1 X92.385 Y59.341 E0.00281

G1 X91.890 Y59.186 E0.01353

G1 X91.566 Y59.053 E0.00912

G1 X91.147 Y58.826 E0.01241

G1 X90.372 Y58.340 E0.02384

G1 X89.413 Y57.857 E0.02799

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.058 Y57.845 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X92.821 Y57.440

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.904 Y57.518 E0.00297

G1 X92.920 Y57.599 E0.00214

G1 X93.007 Y57.790 E0.00546

G1 X93.006 Y59.104 E0.03425

G1 X92.882 Y59.537 E0.01175

G1 X92.754 Y59.745 E0.00637

G1 X92.717 Y59.768 E0.00113

G1 X92.316 Y59.757 E0.01044

G1 X91.748 Y59.580 E0.01551

G1 X91.387 Y59.431 E0.01017

G1 X90.937 Y59.187 E0.01333

G1 X90.167 Y58.704 E0.02368

G1 X89.238 Y58.237 E0.02709

G1 X88.788 Y58.053 E0.01267

G1 X88.647 Y57.952 E0.00452

G1 X88.291 Y57.788 E0.01021

G1 X87.912 Y57.510 E0.01226

G1 X87.875 Y57.463 E0.00156

G1 X88.202 Y57.417 E0.00860

G1 X92.763 Y57.427 E0.11884

M204 S1250

G1 X92.823 Y57.554 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.904 Y57.518 E-0.09331

G1 X92.920 Y57.599 E-0.04543

G1 X93.007 Y57.790 E-0.11612

G1 X93.006 Y58.975 E-0.65715

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X91.673 Y58.961

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.275 Y58.359 E0.02562

G1 X92.275 Y58.147 E0.00638

G1 X91.805 Y58.147 E0.01415

G1 X91.226 Y58.726 E0.02464

M204 S1250

G1 X90.817 Y58.186 F9000.000

G1 F2400.000

G1 X90.334 Y58.059 E0.00390

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.817 Y58.186 E-0.27699

G1 E-0.68301 F4200.00000

G1 Z10.750 F9000.000

G1 X88.542 Y57.674

G1 Z10.550

G1 E3.20000 F2400.00000

G1 X89.152 Y57.794 E0.01095

G1 X89.151 Y57.800 F9000.000

G1 F2400.000

G1 X88.537 Y57.636 E0.00633

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.151 Y57.800 E-0.35237

G1 E-0.60763 F4200.00000

G1 Z10.750 F9000.000

G1 X85.158 Y57.830

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.625 Y58.083 E0.01537

G1 X83.708 Y58.596 E0.02737

G1 X83.169 Y58.924 E0.01645

G1 X82.848 Y59.079 E0.00929

G1 X82.329 Y59.281 E0.01451

G1 X82.115 Y59.338 E0.00578

G1 X81.965 Y59.330 E0.00391

G1 X81.954 Y59.314 E0.00049

G1 X81.898 Y59.087 E0.00610

G1 X81.898 Y57.832 E0.03271

G1 X85.098 Y57.830 E0.08338

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.625 Y58.083 E-0.29715

G1 X83.708 Y58.596 E-0.58213

G1 X83.658 Y58.626 E-0.03272

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X81.669 Y57.435

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.765 Y57.414 E0.00256

G1 X86.303 Y57.412 E0.11823

G1 X86.527 Y57.473 E0.00604

G1 X86.432 Y57.619 E0.00452

G1 X86.207 Y57.769 E0.00705

G1 X86.158 Y57.757 E0.00130

G1 X85.885 Y57.947 E0.00869

G1 X84.817 Y58.455 E0.03079

G1 X83.919 Y58.957 E0.02681

G1 X83.369 Y59.292 E0.01678

G1 X83.015 Y59.463 E0.01025

G1 X82.459 Y59.678 E0.01553

G1 X82.159 Y59.759 E0.00811

G1 X81.734 Y59.738 E0.01109

G1 X81.559 Y59.456 E0.00865

G1 X81.481 Y59.140 E0.00847

G1 X81.470 Y57.830 E0.03412

G1 X81.523 Y57.600 E0.00616

G1 X81.630 Y57.480 E0.00419

M204 S1250

G1 X81.754 Y57.485 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.765 Y57.414 E-0.08361

G1 X83.260 Y57.413 E-0.82839

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.337 Y59.143

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.336 Y58.144 E0.03840

G1 X82.719 Y58.145 E0.01677

G1 X82.024 Y58.840 E0.02673

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.719 Y58.145 E-0.54481

G1 X83.336 Y58.144 E-0.34185

G1 X83.303 Y58.177 E-0.02534

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.314 Y64.467

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.881 Y63.452 E0.04866

G1 X84.463 Y63.165 E0.01689

G1 X85.084 Y63.008 E0.01669

G1 X85.159 Y63.007 E0.00196

G1 X85.242 Y62.968 E0.00238

G1 X85.473 Y62.910 E0.00621

G1 X89.146 Y62.913 E0.09572

G1 X89.513 Y63.003 E0.00984

G1 X89.753 Y63.130 E0.00707

G1 X89.877 Y63.120 E0.00326

G1 X90.037 Y63.172 E0.00439

G1 X90.595 Y63.447 E0.01619

G1 X92.168 Y64.466 E0.04883

G1 X82.374 Y64.467 E0.25518

M204 S1250

G1 X81.663 Y64.868 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y64.757 E0.00382

G1 X81.544 Y64.620 E0.00362

G1 X81.600 Y64.500 E0.00347

G1 X81.803 Y64.300 E0.00742

G1 X83.675 Y63.088 E0.05810

G1 X84.318 Y62.771 E0.01868

G1 X85.063 Y62.591 E0.01997

G1 X85.200 Y62.526 E0.00394

G1 X85.384 Y62.492 E0.00487

G1 X89.196 Y62.495 E0.09934

G1 X89.663 Y62.609 E0.01252

G1 X89.840 Y62.703 E0.00521

G1 X89.926 Y62.696 E0.00227

G1 X90.196 Y62.784 E0.00739

G1 X90.802 Y63.083 E0.01760

G1 X92.575 Y64.232 E0.05506

G1 X92.852 Y64.467 E0.00946

G1 X92.936 Y64.671 E0.00575

G1 X92.915 Y64.773 E0.00271

G1 X92.891 Y64.805 E0.00105

G1 X92.771 Y64.877 E0.00365

G1 X92.725 Y64.884 E0.00120

G1 X81.722 Y64.878 E0.28668

M204 S1250

G1 X81.670 Y64.721 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.567 Y64.757 E-0.10919

G1 X81.544 Y64.620 E-0.07692

G1 X81.600 Y64.500 E-0.07380

G1 X81.803 Y64.300 E-0.15783

G1 X82.552 Y63.815 E-0.49425

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X90.476 Y64.341

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.838 Y63.978 E0.01385

G1 X90.467 Y63.737 E0.01196

G1 X90.051 Y64.153 E0.01587

G1 X89.439 Y64.153 E0.01655

G1 X90.059 Y63.532 E0.02371

G1 X89.840 Y63.437 E0.00645

G1 X89.687 Y63.450 E0.00415

G1 X89.584 Y63.395 E0.00316

G1 X88.826 Y64.153 E0.02895

G1 X88.213 Y64.153 E0.01655

G1 X89.134 Y63.233 E0.03516

G1 X89.109 Y63.227 E0.00069

G1 X88.527 Y63.227 E0.01573

G1 X87.601 Y64.153 E0.03537

G1 X86.988 Y64.153 E0.01655

G1 X87.913 Y63.228 E0.03534

G1 X87.300 Y63.229 E0.01657

G1 X86.376 Y64.153 E0.03531

G1 X85.763 Y64.153 E0.01655

G1 X86.687 Y63.230 E0.03528

G1 X86.076 Y63.228 E0.01650

G1 X85.150 Y64.153 E0.03536

G1 X84.538 Y64.154 E0.01655

G1 X85.453 Y63.238 E0.03497

G1 X85.231 Y63.320 E0.00639

G1 X85.125 Y63.321 E0.00286

G1 X84.633 Y63.446 E0.01370

G1 X83.737 Y64.342 E0.03423

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.633 Y63.446 E-0.70229

G1 X85.000 Y63.353 E-0.20971

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X89.357 Y70.832

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.567 Y70.831 E0.08365

G1 X92.589 Y70.878 E0.00136

G1 X92.588 Y72.043 E0.03036

G1 X92.507 Y72.327 E0.00769

G1 X92.494 Y72.342 E0.00052

G1 X92.386 Y72.339 E0.00281

G1 X91.890 Y72.184 E0.01352

G1 X91.567 Y72.050 E0.00912

G1 X91.147 Y71.824 E0.01242

G1 X90.372 Y71.337 E0.02384

G1 X89.412 Y70.855 E0.02800

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.058 Y70.842 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X92.821 Y70.438

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.904 Y70.516 E0.00298

G1 X92.920 Y70.597 E0.00215

G1 X93.007 Y70.787 E0.00545

G1 X93.006 Y72.102 E0.03426

G1 X92.882 Y72.535 E0.01175

G1 X92.754 Y72.743 E0.00637

G1 X92.717 Y72.766 E0.00113

G1 X92.316 Y72.755 E0.01045

G1 X91.748 Y72.577 E0.01551

G1 X91.387 Y72.428 E0.01018

G1 X90.937 Y72.185 E0.01333

G1 X90.167 Y71.702 E0.02368

G1 X89.238 Y71.235 E0.02708

G1 X88.788 Y71.051 E0.01267

G1 X88.647 Y70.950 E0.00452

G1 X88.291 Y70.786 E0.01021

G1 X87.912 Y70.508 E0.01225

G1 X87.875 Y70.461 E0.00156

G1 X88.202 Y70.415 E0.00858

G1 X92.763 Y70.424 E0.11883

M204 S1250

G1 X92.823 Y70.552 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.904 Y70.516 E-0.09344

G1 X92.920 Y70.597 E-0.04565

G1 X93.007 Y70.787 E-0.11586

G1 X93.006 Y71.973 E-0.65705

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X91.673 Y71.959

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.275 Y71.357 E0.02561

G1 X92.275 Y71.144 E0.00640

G1 X91.805 Y71.144 E0.01414

G1 X91.226 Y71.724 E0.02465

M204 S1250

G1 X90.817 Y71.183 F9000.000

G1 F2400.000

G1 X90.334 Y71.057 E0.00390

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.817 Y71.183 E-0.27697

G1 E-0.68303 F4200.00000

G1 Z10.750 F9000.000

G1 X88.542 Y70.672

G1 Z10.550

G1 E3.20000 F2400.00000

G1 X89.152 Y70.792 E0.01093

G1 X89.150 Y70.798 F9000.000

G1 F2400.000

G1 X88.537 Y70.633 E0.00634

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.150 Y70.798 E-0.35212

G1 E-0.60788 F4200.00000

G1 Z10.750 F9000.000

G1 X85.156 Y70.828

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.625 Y71.081 E0.01533

G1 X83.708 Y71.594 E0.02738

G1 X83.169 Y71.922 E0.01645

G1 X82.848 Y72.077 E0.00928

G1 X82.328 Y72.278 E0.01453

G1 X82.114 Y72.336 E0.00579

G1 X81.965 Y72.328 E0.00388

G1 X81.955 Y72.312 E0.00050

G1 X81.898 Y72.085 E0.00609

G1 X81.898 Y70.830 E0.03271

G1 X85.096 Y70.828 E0.08334

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.625 Y71.081 E-0.29631

G1 X83.708 Y71.594 E-0.58229

G1 X83.657 Y71.625 E-0.03341

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X81.669 Y70.433

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.765 Y70.412 E0.00256

G1 X86.303 Y70.410 E0.11823

G1 X86.527 Y70.471 E0.00604

G1 X86.432 Y70.617 E0.00452

G1 X86.206 Y70.766 E0.00706

G1 X86.159 Y70.755 E0.00127

G1 X85.885 Y70.944 E0.00868

G1 X84.817 Y71.452 E0.03081

G1 X83.919 Y71.955 E0.02682

G1 X83.369 Y72.290 E0.01678

G1 X83.015 Y72.461 E0.01025

G1 X82.459 Y72.675 E0.01553

G1 X82.158 Y72.757 E0.00812

G1 X81.734 Y72.736 E0.01108

G1 X81.559 Y72.453 E0.00867

G1 X81.481 Y72.138 E0.00845

G1 X81.470 Y70.828 E0.03412

G1 X81.523 Y70.597 E0.00618

G1 X81.629 Y70.478 E0.00417

M204 S1250

G1 X81.754 Y70.483 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.765 Y70.412 E-0.08376

G1 X83.260 Y70.411 E-0.82824

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.337 Y72.140

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.335 Y71.142 E0.03836

G1 X82.718 Y71.143 E0.01677

G1 X82.024 Y71.838 E0.02671

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.718 Y71.143 E-0.54462

G1 X83.335 Y71.142 E-0.34179

G1 X83.303 Y71.175 E-0.02560

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.314 Y77.465

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.882 Y76.449 E0.04866

G1 X84.463 Y76.163 E0.01688

G1 X85.089 Y76.006 E0.01681

G1 X85.159 Y76.005 E0.00184

G1 X85.481 Y75.908 E0.00877

G1 X89.146 Y75.911 E0.09549

G1 X89.514 Y76.001 E0.00985

G1 X89.751 Y76.126 E0.00699

G1 X89.875 Y76.117 E0.00324

G1 X90.037 Y76.170 E0.00446

G1 X90.595 Y76.445 E0.01620

G1 X92.169 Y77.464 E0.04886

G1 X82.374 Y77.465 E0.25521

M204 S1250

G1 X81.663 Y77.866 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y77.755 E0.00383

G1 X81.544 Y77.618 E0.00360

G1 X81.600 Y77.497 E0.00348

G1 X81.803 Y77.298 E0.00740

G1 X83.675 Y76.085 E0.05811

G1 X84.318 Y75.768 E0.01868

G1 X85.063 Y75.589 E0.01997

G1 X85.200 Y75.524 E0.00394

G1 X85.384 Y75.490 E0.00487

G1 X89.196 Y75.493 E0.09934

G1 X89.663 Y75.607 E0.01253

G1 X89.839 Y75.700 E0.00518

G1 X89.926 Y75.694 E0.00226

G1 X90.196 Y75.782 E0.00741

G1 X90.802 Y76.081 E0.01760

G1 X92.575 Y77.229 E0.05504

G1 X92.852 Y77.465 E0.00948

G1 X92.936 Y77.669 E0.00575

G1 X92.915 Y77.770 E0.00269

G1 X92.890 Y77.804 E0.00109

G1 X92.775 Y77.874 E0.00351

G1 X92.724 Y77.882 E0.00134

G1 X81.722 Y77.876 E0.28666

M204 S1250

G1 X81.670 Y77.719 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.567 Y77.755 E-0.10931

G1 X81.544 Y77.618 E-0.07667

G1 X81.600 Y77.497 E-0.07405

G1 X81.803 Y77.298 E-0.15742

G1 X82.552 Y76.813 E-0.49456

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X90.476 Y77.339

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.839 Y76.976 E0.01385

G1 X90.467 Y76.736 E0.01196

G1 X90.052 Y77.151 E0.01587

G1 X89.439 Y77.151 E0.01655

G1 X90.060 Y76.530 E0.02371

G1 X89.836 Y76.434 E0.00657

G1 X89.684 Y76.446 E0.00412

G1 X89.585 Y76.393 E0.00305

G1 X88.826 Y77.151 E0.02896

G1 X88.214 Y77.151 E0.01655

G1 X89.134 Y76.231 E0.03516

G1 X89.109 Y76.224 E0.00071

G1 X88.527 Y76.225 E0.01571

G1 X87.601 Y77.151 E0.03537

G1 X86.989 Y77.151 E0.01655

G1 X87.914 Y76.226 E0.03534

G1 X87.300 Y76.227 E0.01657

G1 X86.376 Y77.151 E0.03531

G1 X85.764 Y77.151 E0.01655

G1 X86.687 Y76.228 E0.03528

G1 X86.076 Y76.226 E0.01650

G1 X85.151 Y77.151 E0.03535

G1 X84.538 Y77.151 E0.01655

G1 X85.443 Y76.247 E0.03454

G1 X85.207 Y76.318 E0.00664

G1 X85.129 Y76.319 E0.00211

G1 X84.634 Y76.443 E0.01378

G1 X83.738 Y77.339 E0.03425

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.634 Y76.443 E-0.70264

G1 X85.001 Y76.351 E-0.20936

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X89.356 Y83.830

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.567 Y83.829 E0.08365

G1 X92.589 Y83.876 E0.00136

G1 X92.588 Y85.041 E0.03036

G1 X92.507 Y85.325 E0.00769

G1 X92.494 Y85.340 E0.00052

G1 X92.386 Y85.337 E0.00281

G1 X91.890 Y85.182 E0.01352

G1 X91.567 Y85.048 E0.00912

G1 X91.147 Y84.821 E0.01242

G1 X90.372 Y84.335 E0.02384

G1 X89.412 Y83.853 E0.02800

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.058 Y83.840 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X92.821 Y83.436

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.904 Y83.514 E0.00298

G1 X92.920 Y83.595 E0.00215

G1 X93.007 Y83.785 E0.00545

G1 X93.006 Y85.100 E0.03426

G1 X92.882 Y85.533 E0.01175

G1 X92.754 Y85.741 E0.00637

G1 X92.717 Y85.764 E0.00113

G1 X92.316 Y85.753 E0.01045

G1 X91.748 Y85.575 E0.01551

G1 X91.387 Y85.426 E0.01017

G1 X90.937 Y85.182 E0.01334

G1 X90.167 Y84.700 E0.02367

G1 X89.238 Y84.233 E0.02708

G1 X88.788 Y84.048 E0.01267

G1 X88.647 Y83.948 E0.00453

G1 X88.291 Y83.784 E0.01022

G1 X87.912 Y83.506 E0.01223

G1 X87.875 Y83.459 E0.00156

G1 X88.202 Y83.413 E0.00859

G1 X92.763 Y83.422 E0.11883

M204 S1250

G1 X92.823 Y83.550 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.904 Y83.514 E-0.09344

G1 X92.920 Y83.595 E-0.04565

G1 X93.007 Y83.785 E-0.11586

G1 X93.006 Y84.971 E-0.65705

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X91.673 Y84.957

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.275 Y84.355 E0.02561

G1 X92.275 Y84.142 E0.00640

G1 X91.805 Y84.142 E0.01414

G1 X91.226 Y84.721 E0.02464

M204 S1250

G1 X90.818 Y84.181 F9000.000

G1 F2400.000

G1 X90.334 Y84.055 E0.00390

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.818 Y84.181 E-0.27715

G1 E-0.68285 F4200.00000

G1 Z10.750 F9000.000

G1 X88.543 Y83.670

G1 Z10.550

G1 E3.20000 F2400.00000

G1 X89.151 Y83.790 E0.01091

G1 X89.150 Y83.796 F9000.000

G1 F2400.000

G1 X88.538 Y83.631 E0.00631

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.150 Y83.796 E-0.35148

G1 E-0.60852 F4200.00000

G1 Z10.750 F9000.000

G1 X85.157 Y83.826

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.625 Y84.079 E0.01533

G1 X83.708 Y84.591 E0.02737

G1 X83.169 Y84.920 E0.01647

G1 X82.848 Y85.075 E0.00928

G1 X82.328 Y85.276 E0.01452

G1 X82.114 Y85.334 E0.00579

G1 X81.965 Y85.326 E0.00388

G1 X81.955 Y85.310 E0.00050

G1 X81.898 Y85.082 E0.00611

G1 X81.898 Y83.827 E0.03271

G1 X85.097 Y83.826 E0.08334

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.625 Y84.079 E-0.29635

G1 X83.708 Y84.591 E-0.58214

G1 X83.657 Y84.622 E-0.03351

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X81.669 Y83.431

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.766 Y83.410 E0.00257

G1 X86.303 Y83.408 E0.11822

G1 X86.527 Y83.469 E0.00605

G1 X86.432 Y83.615 E0.00452

G1 X86.206 Y83.764 E0.00706

G1 X86.159 Y83.753 E0.00127

G1 X85.885 Y83.942 E0.00868

G1 X84.817 Y84.450 E0.03081

G1 X83.919 Y84.952 E0.02681

G1 X83.369 Y85.287 E0.01679

G1 X83.015 Y85.459 E0.01025

G1 X82.459 Y85.673 E0.01553

G1 X82.158 Y85.755 E0.00812

G1 X81.734 Y85.734 E0.01107

G1 X81.559 Y85.451 E0.00867

G1 X81.481 Y85.135 E0.00847

G1 X81.470 Y83.826 E0.03411

G1 X81.523 Y83.595 E0.00618

G1 X81.629 Y83.475 E0.00418

M204 S1250

G1 X81.754 Y83.481 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.766 Y83.410 E-0.08386

G1 X83.260 Y83.409 E-0.82814

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.337 Y85.138

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.335 Y84.140 E0.03838

G1 X82.718 Y84.140 E0.01676

G1 X82.024 Y84.835 E0.02671

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.718 Y84.140 E-0.54456

G1 X83.335 Y84.140 E-0.34173

G1 X83.302 Y84.173 E-0.02571

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.313 Y90.463

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.881 Y89.447 E0.04869

G1 X84.463 Y89.161 E0.01688

G1 X85.082 Y89.005 E0.01663

G1 X85.157 Y89.004 E0.00197

G1 X85.242 Y88.965 E0.00243

G1 X85.474 Y88.906 E0.00625

G1 X89.147 Y88.909 E0.09570

G1 X89.513 Y88.998 E0.00981

G1 X89.752 Y89.126 E0.00709

G1 X89.877 Y89.115 E0.00327

G1 X90.037 Y89.168 E0.00438

G1 X90.595 Y89.443 E0.01621

G1 X92.169 Y90.462 E0.04885

G1 X82.373 Y90.463 E0.25523

M204 S1250

G1 X81.663 Y90.863 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y90.753 E0.00381

G1 X81.544 Y90.616 E0.00360

G1 X81.600 Y90.495 E0.00349

G1 X81.803 Y90.295 E0.00741

G1 X83.675 Y89.083 E0.05811

G1 X84.318 Y88.766 E0.01867

G1 X85.062 Y88.587 E0.01995

G1 X85.200 Y88.522 E0.00396

G1 X85.384 Y88.488 E0.00487

G1 X89.196 Y88.491 E0.09935

G1 X89.663 Y88.604 E0.01251

G1 X89.840 Y88.699 E0.00522

G1 X89.927 Y88.691 E0.00227

G1 X90.196 Y88.780 E0.00738

G1 X90.802 Y89.079 E0.01761

G1 X92.575 Y90.227 E0.05505

G1 X92.852 Y90.462 E0.00946

G1 X92.936 Y90.667 E0.00576

G1 X92.915 Y90.768 E0.00270

G1 X92.890 Y90.802 E0.00109

G1 X92.775 Y90.872 E0.00350

G1 X92.724 Y90.880 E0.00134

G1 X81.722 Y90.874 E0.28668

M204 S1250

G1 X81.670 Y90.717 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.567 Y90.753 E-0.10901

G1 X81.544 Y90.616 E-0.07667

G1 X81.600 Y90.495 E-0.07413

G1 X81.803 Y90.295 E-0.15767

G1 X82.552 Y89.810 E-0.49452

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X90.476 Y90.337

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.839 Y89.974 E0.01386

G1 X90.467 Y89.733 E0.01197

G1 X90.051 Y90.149 E0.01587

G1 X89.439 Y90.149 E0.01655

G1 X90.059 Y89.528 E0.02371

G1 X89.841 Y89.433 E0.00644

G1 X89.687 Y89.447 E0.00417

G1 X89.584 Y89.391 E0.00317

G1 X88.826 Y90.149 E0.02895

G1 X88.213 Y90.149 E0.01655

G1 X89.134 Y89.228 E0.03517

G1 X89.110 Y89.222 E0.00068

G1 X88.526 Y89.223 E0.01575

G1 X87.601 Y90.149 E0.03537

G1 X86.988 Y90.149 E0.01655

G1 X87.913 Y89.224 E0.03534

G1 X87.300 Y89.225 E0.01657

G1 X86.375 Y90.149 E0.03531

G1 X85.763 Y90.149 E0.01655

G1 X86.686 Y89.226 E0.03528

G1 X86.075 Y89.224 E0.01650

G1 X85.150 Y90.149 E0.03535

G1 X84.537 Y90.149 E0.01655

G1 X85.452 Y89.235 E0.03494

G1 X85.228 Y89.317 E0.00643

G1 X85.122 Y89.318 E0.00288

G1 X84.633 Y89.441 E0.01362

G1 X83.737 Y90.337 E0.03425

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.633 Y89.441 E-0.70267

G1 X84.999 Y89.349 E-0.20933

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X89.357 Y96.827

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.567 Y96.827 E0.08364

G1 X92.589 Y96.874 E0.00135

G1 X92.588 Y98.039 E0.03037

G1 X92.507 Y98.321 E0.00764

G1 X92.492 Y98.338 E0.00058

G1 X92.386 Y98.335 E0.00278

G1 X91.890 Y98.180 E0.01352

G1 X91.567 Y98.046 E0.00912

G1 X91.147 Y97.819 E0.01242

G1 X90.372 Y97.334 E0.02383

G1 X89.413 Y96.850 E0.02800

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.058 Y96.838 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X92.821 Y96.434

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.904 Y96.512 E0.00298

G1 X92.920 Y96.593 E0.00214

G1 X93.007 Y96.783 E0.00545

G1 X93.006 Y98.098 E0.03427

G1 X92.882 Y98.531 E0.01172

G1 X92.837 Y98.580 E0.00175

G1 X92.753 Y98.739 E0.00468

G1 X92.717 Y98.762 E0.00112

G1 X92.316 Y98.751 E0.01045

G1 X91.748 Y98.573 E0.01551

G1 X91.387 Y98.424 E0.01017

G1 X90.937 Y98.180 E0.01334

G1 X90.167 Y97.698 E0.02367

G1 X89.238 Y97.230 E0.02709

G1 X88.788 Y97.046 E0.01267

G1 X88.647 Y96.945 E0.00452

G1 X88.291 Y96.781 E0.01022

G1 X87.912 Y96.504 E0.01223

G1 X87.875 Y96.456 E0.00158

G1 X88.202 Y96.410 E0.00860

G1 X92.763 Y96.420 E0.11883

M204 S1250

G1 X92.823 Y96.548 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.904 Y96.512 E-0.09348

G1 X92.920 Y96.593 E-0.04543

G1 X93.007 Y96.783 E-0.11582

G1 X93.006 Y97.969 E-0.65726

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X91.672 Y97.954

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.275 Y97.352 E0.02564

G1 X92.275 Y97.140 E0.00637

G1 X91.804 Y97.140 E0.01416

G1 X91.226 Y97.719 E0.02463

M204 S1250

G1 X90.817 Y97.179 F9000.000

G1 F2400.000

G1 X90.333 Y97.052 E0.00392

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.817 Y97.179 E-0.27726

G1 E-0.68274 F4200.00000

G1 Z10.750 F9000.000

G1 X88.542 Y96.667

G1 Z10.550

G1 E3.20000 F2400.00000

G1 X89.152 Y96.787 E0.01095

G1 X89.151 Y96.793 F9000.000

G1 F2400.000

G1 X88.537 Y96.629 E0.00633

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.151 Y96.793 E-0.35237

G1 E-0.60763 F4200.00000

G1 Z10.750 F9000.000

G1 X85.158 Y96.823

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.625 Y97.076 E0.01537

G1 X83.708 Y97.589 E0.02738

G1 X83.169 Y97.918 E0.01645

G1 X82.848 Y98.072 E0.00928

G1 X82.328 Y98.274 E0.01455

G1 X82.114 Y98.332 E0.00577

G1 X81.965 Y98.324 E0.00390

G1 X81.955 Y98.308 E0.00049

G1 X81.898 Y98.080 E0.00610

G1 X81.898 Y96.825 E0.03272

G1 X85.098 Y96.823 E0.08338

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.625 Y97.076 E-0.29722

G1 X83.708 Y97.589 E-0.58228

G1 X83.658 Y97.620 E-0.03250

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X81.669 Y96.428

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.765 Y96.407 E0.00256

G1 X86.303 Y96.405 E0.11822

G1 X86.527 Y96.467 E0.00606

G1 X86.432 Y96.612 E0.00452

G1 X86.208 Y96.761 E0.00699

G1 X86.109 Y96.785 E0.00265

G1 X85.885 Y96.940 E0.00711

G1 X84.817 Y97.448 E0.03080

G1 X83.919 Y97.950 E0.02681

G1 X83.369 Y98.285 E0.01678

G1 X83.015 Y98.456 E0.01024

G1 X82.459 Y98.671 E0.01554

G1 X82.159 Y98.753 E0.00811

G1 X81.734 Y98.731 E0.01108

G1 X81.559 Y98.449 E0.00866

G1 X81.481 Y98.133 E0.00847

G1 X81.470 Y96.824 E0.03411

G1 X81.523 Y96.593 E0.00619

G1 X81.630 Y96.473 E0.00419

M204 S1250

G1 X81.754 Y96.478 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.765 Y96.407 E-0.08361

G1 X83.260 Y96.406 E-0.82839

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.337 Y98.136

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.336 Y97.137 E0.03840

G1 X82.719 Y97.138 E0.01677

G1 X82.024 Y97.833 E0.02674

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.719 Y97.138 E-0.54491

G1 X83.336 Y97.137 E-0.34186

G1 X83.304 Y97.170 E-0.02523

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.313 Y103.461

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.881 Y102.445 E0.04869

G1 X84.463 Y102.159 E0.01688

G1 X85.086 Y102.002 E0.01676

G1 X85.158 Y102.001 E0.00186

G1 X85.477 Y101.903 E0.00869

G1 X89.147 Y101.907 E0.09562

G1 X89.513 Y101.996 E0.00981

G1 X89.752 Y102.124 E0.00709

G1 X89.877 Y102.113 E0.00327

G1 X90.037 Y102.166 E0.00438

G1 X90.595 Y102.441 E0.01621

G1 X92.169 Y103.460 E0.04885

G1 X82.373 Y103.461 E0.25523

M204 S1250

G1 X81.663 Y103.861 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y103.751 E0.00381

G1 X81.544 Y103.614 E0.00360

G1 X81.600 Y103.493 E0.00349

G1 X81.803 Y103.293 E0.00741

G1 X83.675 Y102.081 E0.05811

G1 X84.318 Y101.764 E0.01867

G1 X85.063 Y101.584 E0.01996

G1 X85.200 Y101.520 E0.00395

G1 X85.384 Y101.485 E0.00487

G1 X89.196 Y101.489 E0.09935

G1 X89.663 Y101.602 E0.01251

G1 X89.840 Y101.697 E0.00522

G1 X89.927 Y101.689 E0.00227

G1 X90.196 Y101.778 E0.00738

G1 X90.802 Y102.077 E0.01761

G1 X92.575 Y103.225 E0.05505

G1 X92.852 Y103.460 E0.00946

G1 X92.936 Y103.665 E0.00576

G1 X92.915 Y103.766 E0.00271

G1 X92.890 Y103.800 E0.00109

G1 X92.775 Y103.870 E0.00350

G1 X92.724 Y103.878 E0.00134

G1 X81.722 Y103.872 E0.28668

M73 P90 R6

M204 S1250

G1 X81.670 Y103.715 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.567 Y103.751 E-0.10901

G1 X81.544 Y103.614 E-0.07667

G1 X81.600 Y103.493 E-0.07420

G1 X81.803 Y103.293 E-0.15760

G1 X82.552 Y102.808 E-0.49452

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X90.476 Y103.335

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.839 Y102.972 E0.01386

G1 X90.467 Y102.731 E0.01197

G1 X90.051 Y103.147 E0.01587

G1 X89.439 Y103.147 E0.01655

G1 X90.059 Y102.526 E0.02371

G1 X89.841 Y102.431 E0.00644

G1 X89.687 Y102.445 E0.00417

G1 X89.584 Y102.389 E0.00317

G1 X88.826 Y103.147 E0.02895

G1 X88.213 Y103.147 E0.01655

G1 X89.134 Y102.226 E0.03517

G1 X89.109 Y102.220 E0.00068

G1 X88.527 Y102.221 E0.01574

G1 X87.601 Y103.147 E0.03538

G1 X86.988 Y103.147 E0.01655

G1 X87.913 Y102.222 E0.03535

G1 X87.300 Y102.222 E0.01657

G1 X86.375 Y103.147 E0.03533

G1 X85.763 Y103.147 E0.01655

G1 X86.687 Y102.223 E0.03530

G1 X86.076 Y102.221 E0.01650

G1 X85.150 Y103.147 E0.03538

G1 X84.537 Y103.147 E0.01655

G1 X85.443 Y102.241 E0.03462

G1 X85.207 Y102.313 E0.00668

G1 X85.127 Y102.314 E0.00215

G1 X84.633 Y102.439 E0.01376

G1 X83.737 Y103.335 E0.03425

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.633 Y102.439 E-0.70267

G1 X84.999 Y102.347 E-0.20933

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X89.357 Y109.825

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.567 Y109.825 E0.08364

G1 X92.589 Y109.872 E0.00135

G1 X92.588 Y111.037 E0.03036

G1 X92.507 Y111.319 E0.00766

G1 X92.492 Y111.336 E0.00058

G1 X92.386 Y111.333 E0.00278

G1 X91.890 Y111.178 E0.01352

G1 X91.567 Y111.044 E0.00912

G1 X91.147 Y110.817 E0.01242

G1 X90.372 Y110.332 E0.02383

G1 X89.413 Y109.848 E0.02800

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.058 Y109.836 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X92.821 Y109.431

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.904 Y109.510 E0.00298

G1 X92.920 Y109.591 E0.00214

G1 X93.007 Y109.781 E0.00545

G1 X93.006 Y111.095 E0.03425

G1 X92.882 Y111.529 E0.01174

G1 X92.753 Y111.737 E0.00638

G1 X92.716 Y111.760 E0.00114

G1 X92.316 Y111.749 E0.01043

G1 X91.748 Y111.571 E0.01551

G1 X91.387 Y111.422 E0.01017

G1 X90.937 Y111.178 E0.01334

G1 X90.167 Y110.696 E0.02367

G1 X89.238 Y110.228 E0.02709

G1 X88.788 Y110.044 E0.01267

G1 X88.647 Y109.943 E0.00452

G1 X88.291 Y109.779 E0.01022

G1 X87.911 Y109.501 E0.01226

G1 X87.875 Y109.454 E0.00155

G1 X88.202 Y109.408 E0.00860

G1 X92.763 Y109.418 E0.11883

M204 S1250

G1 X92.823 Y109.545 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.904 Y109.510 E-0.09350

G1 X92.920 Y109.591 E-0.04558

G1 X93.007 Y109.781 E-0.11582

G1 X93.006 Y110.966 E-0.65710

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X91.672 Y110.952

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.275 Y110.350 E0.02564

G1 X92.275 Y110.138 E0.00637

G1 X91.804 Y110.138 E0.01416

G1 X91.226 Y110.717 E0.02463

M204 S1250

G1 X90.817 Y110.177 F9000.000

G1 F2400.000

G1 X90.333 Y110.050 E0.00392

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.817 Y110.177 E-0.27726

G1 E-0.68274 F4200.00000

G1 Z10.750 F9000.000

G1 X88.542 Y109.665

G1 Z10.550

G1 E3.20000 F2400.00000

G1 X89.152 Y109.785 E0.01095

G1 X89.151 Y109.791 F9000.000

G1 F2400.000

G1 X88.537 Y109.627 E0.00634

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.151 Y109.791 E-0.35237

G1 E-0.60763 F4200.00000

G1 Z10.750 F9000.000

G1 X85.158 Y109.821

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.625 Y110.074 E0.01537

G1 X83.708 Y110.587 E0.02738

G1 X83.169 Y110.916 E0.01645

G1 X82.848 Y111.070 E0.00928

G1 X82.328 Y111.272 E0.01455

G1 X82.114 Y111.330 E0.00577

G1 X81.965 Y111.322 E0.00390

G1 X81.955 Y111.306 E0.00049

G1 X81.898 Y111.078 E0.00610

G1 X81.898 Y109.823 E0.03272

G1 X85.098 Y109.821 E0.08338

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.625 Y110.074 E-0.29719

G1 X83.708 Y110.587 E-0.58227

G1 X83.658 Y110.617 E-0.03254

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X81.669 Y109.426

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.765 Y109.405 E0.00256

G1 X86.303 Y109.403 E0.11822

G1 X86.527 Y109.465 E0.00606

G1 X86.432 Y109.610 E0.00453

G1 X86.208 Y109.759 E0.00699

G1 X86.109 Y109.783 E0.00265

G1 X85.885 Y109.938 E0.00711

G1 X84.817 Y110.446 E0.03080

G1 X83.919 Y110.948 E0.02681

G1 X83.369 Y111.283 E0.01678

G1 X83.015 Y111.454 E0.01024

G1 X82.459 Y111.669 E0.01554

G1 X82.159 Y111.751 E0.00811

G1 X81.734 Y111.729 E0.01108

G1 X81.559 Y111.447 E0.00866

G1 X81.481 Y111.131 E0.00847

G1 X81.470 Y109.822 E0.03412

G1 X81.523 Y109.591 E0.00618

G1 X81.630 Y109.471 E0.00419

M204 S1250

G1 X81.754 Y109.476 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.765 Y109.405 E-0.08361

G1 X83.260 Y109.404 E-0.82839

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.337 Y111.134

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X83.336 Y110.135 E0.03840

G1 X82.719 Y110.136 E0.01677

G1 X82.024 Y110.831 E0.02673

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.719 Y110.136 E-0.54484

G1 X83.336 Y110.135 E-0.34184

G1 X83.303 Y110.168 E-0.02532

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X82.313 Y116.459

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.881 Y115.443 E0.04869

G1 X84.463 Y115.156 E0.01689

G1 X85.084 Y114.999 E0.01669

G1 X85.159 Y114.998 E0.00196

G1 X85.242 Y114.959 E0.00238

G1 X85.472 Y114.901 E0.00618

G1 X89.146 Y114.904 E0.09575

G1 X89.512 Y114.994 E0.00982

G1 X89.752 Y115.122 E0.00710

G1 X89.877 Y115.111 E0.00327

G1 X90.037 Y115.164 E0.00439

G1 X90.595 Y115.438 E0.01620

G1 X92.169 Y116.458 E0.04886

G1 X82.373 Y116.459 E0.25523

M204 S1250

G1 X81.663 Y116.859 F9000.000

M204 S800

G1 F1500.000

G1 X81.567 Y116.749 E0.00381

G1 X81.544 Y116.612 E0.00360

G1 X81.600 Y116.491 E0.00349

G1 X81.803 Y116.291 E0.00741

G1 X83.675 Y115.079 E0.05811

G1 X84.318 Y114.762 E0.01868

G1 X85.063 Y114.582 E0.01997

G1 X85.200 Y114.518 E0.00394

G1 X85.383 Y114.483 E0.00487

G1 X89.196 Y114.486 E0.09935

G1 X89.663 Y114.600 E0.01251

G1 X89.840 Y114.695 E0.00523

G1 X89.927 Y114.687 E0.00227

G1 X90.196 Y114.776 E0.00739

G1 X90.802 Y115.074 E0.01759

G1 X92.575 Y116.223 E0.05506

G1 X92.852 Y116.458 E0.00946

G1 X92.936 Y116.663 E0.00576

G1 X92.915 Y116.764 E0.00271

G1 X92.890 Y116.798 E0.00109

G1 X92.775 Y116.868 E0.00350

G1 X92.724 Y116.876 E0.00134

G1 X81.722 Y116.870 E0.28668

M204 S1250

G1 X81.670 Y116.713 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.567 Y116.749 E-0.10901

G1 X81.544 Y116.612 E-0.07667

G1 X81.600 Y116.491 E-0.07420

G1 X81.803 Y116.291 E-0.15760

G1 X82.552 Y115.806 E-0.49452

G1 E-0.04800 F4200.00000

G1 Z10.750 F9000.000

G1 X90.477 Y116.333

G1 Z10.550

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X90.839 Y115.970 E0.01386

G1 X90.468 Y115.729 E0.01197

G1 X90.052 Y116.145 E0.01588

G1 X89.439 Y116.145 E0.01655

G1 X90.060 Y115.524 E0.02371

G1 X89.841 Y115.429 E0.00646

G1 X89.687 Y115.443 E0.00417

G1 X89.584 Y115.387 E0.00315

G1 X88.826 Y116.145 E0.02894

G1 X88.214 Y116.145 E0.01655

G1 X89.135 Y115.224 E0.03519

G1 X89.109 Y115.218 E0.00072

G1 X88.528 Y115.218 E0.01571

G1 X87.601 Y116.145 E0.03540

G1 X86.988 Y116.145 E0.01655

G1 X87.914 Y115.219 E0.03537

G1 X87.301 Y115.220 E0.01658

G1 X86.376 Y116.145 E0.03534

G1 X85.763 Y116.145 E0.01655

G1 X86.687 Y115.221 E0.03531

G1 X86.076 Y115.219 E0.01650

G1 X85.150 Y116.145 E0.03538

G1 X84.537 Y116.145 E0.01655

G1 X85.454 Y115.229 E0.03501

G1 X85.231 Y115.311 E0.00641

G1 X85.125 Y115.312 E0.00286

G1 X84.634 Y115.437 E0.01370

G1 X83.737 Y116.333 E0.03427

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;10.7

G1 Z10.700 F9000.000

;AFTER\_LAYER\_CHANGE

;10.7

G1 X82.495 Y116.337

M204 S800

G1 F1500.000

G1 X83.541 Y115.651 E0.03260

G1 X84.279 Y115.202 E0.02250

G1 X84.975 Y114.862 E0.02017

G1 X85.137 Y114.862 E0.00424

G1 X85.331 Y114.737 E0.00601

G1 X85.919 Y114.555 E0.01605

G1 X86.404 Y114.460 E0.01288

G1 X87.016 Y114.408 E0.01600

G1 X87.501 Y114.406 E0.01262

G1 X88.504 Y114.535 E0.02636

G1 X88.911 Y114.649 E0.01100

G1 X89.633 Y114.915 E0.02006

G1 X90.199 Y115.198 E0.01648

G1 X91.274 Y115.864 E0.03295

G1 X91.992 Y116.339 E0.02242

G1 X85.073 Y116.323 E0.18027

G1 X82.555 Y116.337 E0.06561

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.541 Y115.651 E-0.66575

G1 X83.921 Y115.420 E-0.24625

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.821 Y116.623

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.819 Y116.687 E0.00167

G1 X92.767 Y116.729 E0.00175

G1 X92.634 Y116.758 E0.00355

G1 X85.074 Y116.741 E0.19698

G1 X81.851 Y116.758 E0.08397

G1 X81.707 Y116.723 E0.00385

G1 X81.672 Y116.594 E0.00348

G1 X81.782 Y116.375 E0.00639

G1 X82.005 Y116.159 E0.00810

G1 X83.318 Y115.297 E0.04091

G1 X84.079 Y114.835 E0.02319

G1 X84.814 Y114.475 E0.02132

G1 X84.954 Y114.427 E0.00387

G1 X85.031 Y114.433 E0.00203

G1 X85.153 Y114.355 E0.00377

G1 X85.817 Y114.150 E0.01811

G1 X86.346 Y114.045 E0.01406

G1 X86.998 Y113.990 E0.01704

G1 X87.515 Y113.988 E0.01347

G1 X87.750 Y114.005 E0.00613

G1 X88.590 Y114.126 E0.02213

G1 X89.039 Y114.251 E0.01214

G1 X89.799 Y114.531 E0.02110

G1 X90.403 Y114.832 E0.01759

G1 X91.499 Y115.513 E0.03361

G1 X92.326 Y116.059 E0.02583

G1 X92.667 Y116.336 E0.01144

G1 X92.780 Y116.494 E0.00505

G1 X92.803 Y116.566 E0.00197

M204 S1250

G1 X92.771 Y116.662 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.819 Y116.687 E-0.06772

G1 X92.767 Y116.729 E-0.03727

G1 X92.634 Y116.758 E-0.07541

G1 X91.313 Y116.755 E-0.73160

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X83.706 Y115.697

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.024 Y116.015 E0.01254

G1 X84.653 Y116.012 E0.01755

G1 X84.236 Y115.595 E0.01644

G1 X84.646 Y115.372 E0.01300

G1 X85.284 Y116.010 E0.02517

G1 X85.918 Y116.011 E0.01768

G1 X85.082 Y115.175 E0.03298

G1 X85.229 Y115.176 E0.00411

G1 X85.465 Y115.024 E0.00782

G1 X85.540 Y115.001 E0.00219

G1 X86.552 Y116.013 E0.03992

G1 X87.186 Y116.014 E0.01768

G1 X86.025 Y114.854 E0.04578

G1 X86.565 Y114.761 E0.01527

G1 X87.820 Y116.016 E0.04951

G1 X88.454 Y116.017 E0.01768

G1 X87.161 Y114.724 E0.05100

G1 X87.680 Y114.734 E0.01448

G1 X87.823 Y114.754 E0.00405

G1 X89.088 Y116.019 E0.04988

G1 X89.722 Y116.020 E0.01768

G1 X88.585 Y114.883 E0.04484

G1 X88.814 Y114.948 E0.00664

G1 X89.565 Y115.231 E0.02238

G1 X90.544 Y116.210 E0.03863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.565 Y115.231 E-0.76747

G1 X89.321 Y115.139 E-0.14453

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X84.906 Y109.939

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.057 Y110.388 E0.02502

G1 X82.801 Y111.144 E0.03820

G1 X82.192 Y111.468 E0.01798

G1 X81.936 Y111.559 E0.00707

G1 X81.902 Y111.373 E0.00492

G1 X81.885 Y110.034 E0.03491

G1 X81.905 Y109.938 E0.00255

G1 X84.846 Y109.939 E0.07663

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.057 Y110.388 E-0.50307

G1 X83.425 Y110.769 E-0.40893

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X81.675 Y109.548

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.772 Y109.520 E0.00265

G1 X85.880 Y109.522 E0.10703

G1 X86.144 Y109.570 E0.00699

G1 X86.159 Y109.589 E0.00063

G1 X86.143 Y109.627 E0.00107

G1 X85.968 Y109.795 E0.00631

G1 X85.662 Y110.012 E0.00979

G1 X84.262 Y110.752 E0.04125

G1 X83.007 Y111.508 E0.03818

G1 X82.361 Y111.851 E0.01907

G1 X81.735 Y112.074 E0.01730

G1 X81.701 Y112.061 E0.00095

G1 X81.618 Y111.915 E0.00438

G1 X81.540 Y111.713 E0.00563

G1 X81.484 Y111.414 E0.00793

G1 X81.466 Y109.993 E0.03703

G1 X81.524 Y109.716 E0.00736

G1 X81.635 Y109.592 E0.00433

M204 S1250

G1 X81.764 Y109.595 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.772 Y109.520 E-0.08629

G1 X83.262 Y109.521 E-0.82571

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X82.692 Y111.060

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y110.574 E0.02004

G1 X82.201 Y110.251 E0.00939

G1 X82.543 Y110.251 E0.00997

G1 X83.106 Y110.814 E0.02318

M204 S1250

G1 X83.499 Y110.294 F9000.000

G1 F2400.000

G1 X83.982 Y110.168 E0.00193

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.499 Y110.294 E-0.27652

G1 E-0.68348 F4200.00000

G1 Z10.900 F9000.000

G1 X89.611 Y109.947

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.582 Y109.937 E0.07739

G1 X92.598 Y110.020 E0.00219

G1 X92.584 Y111.321 E0.03392

G1 X92.546 Y111.480 E0.00425

G1 X92.504 Y111.542 E0.00196

G1 X92.060 Y111.360 E0.01251

G1 X90.428 Y110.367 E0.04976

G1 X89.666 Y109.973 E0.02236

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.311 Y109.953 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.828 Y109.554

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.884 Y109.596 E0.00180

G1 X92.999 Y109.845 E0.00716

G1 X93.016 Y109.997 E0.00397

G1 X93.001 Y111.374 E0.03589

G1 X92.934 Y111.652 E0.00744

G1 X92.838 Y111.793 E0.00444

G1 X92.798 Y112.036 E0.00643

G1 X92.743 Y112.061 E0.00158

G1 X92.635 Y112.040 E0.00287

G1 X92.153 Y111.863 E0.01339

G1 X91.863 Y111.729 E0.00832

G1 X90.222 Y110.731 E0.05004

G1 X89.594 Y110.401 E0.01850

G1 X89.040 Y110.140 E0.01594

G1 X88.812 Y109.979 E0.00727

G1 X88.627 Y109.887 E0.00539

G1 X88.407 Y109.704 E0.00746

G1 X88.308 Y109.593 E0.00387

G1 X88.487 Y109.533 E0.00493

G1 X92.709 Y109.519 E0.11000

G1 X92.771 Y109.537 E0.00168

M204 S1250

G1 X92.835 Y109.623 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.884 Y109.596 E-0.07044

G1 X92.999 Y109.845 E-0.15228

G1 X93.016 Y109.997 E-0.08443

G1 X93.004 Y111.088 E-0.60484

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.460 Y111.079

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.635 Y110.254 E0.03650

G1 X90.928 Y110.256 E0.02210

G1 X91.613 Y110.942 E0.03031

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.928 Y110.256 E-0.53723

G1 X91.604 Y110.254 E-0.37477

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X89.407 Y109.902

G1 Z10.700

G1 E3.20000 F2400.00000

G1 X88.891 Y109.761 E0.00215

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.407 Y109.902 E-0.29640

G1 E-0.66360 F4200.00000

G1 Z10.900 F9000.000

G1 X91.992 Y103.341

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y103.326 E0.18027

G1 X82.495 Y103.339 E0.06718

G1 X83.541 Y102.653 E0.03261

G1 X84.279 Y102.204 E0.02251

G1 X84.974 Y101.864 E0.02015

G1 X85.138 Y101.865 E0.00426

G1 X85.332 Y101.740 E0.00603

G1 X85.920 Y101.557 E0.01603

G1 X86.404 Y101.462 E0.01287

G1 X87.017 Y101.411 E0.01601

G1 X87.501 Y101.408 E0.01262

G1 X88.504 Y101.538 E0.02634

G1 X88.911 Y101.652 E0.01101

G1 X89.633 Y101.917 E0.02005

G1 X90.199 Y102.200 E0.01649

G1 X91.274 Y102.867 E0.03295

G1 X91.942 Y103.308 E0.02086

M204 S1250

G1 X92.821 Y103.625 F9000.000

M204 S800

G1 F1500.000

G1 X92.818 Y103.690 E0.00169

G1 X92.767 Y103.731 E0.00173

G1 X92.634 Y103.760 E0.00356

G1 X85.074 Y103.743 E0.19698

G1 X81.851 Y103.760 E0.08397

G1 X81.707 Y103.725 E0.00386

G1 X81.672 Y103.596 E0.00348

G1 X81.782 Y103.377 E0.00640

G1 X82.005 Y103.161 E0.00810

G1 X83.318 Y102.300 E0.04091

G1 X84.079 Y101.837 E0.02319

G1 X84.813 Y101.478 E0.02132

G1 X84.953 Y101.429 E0.00386

G1 X85.032 Y101.436 E0.00204

G1 X85.153 Y101.358 E0.00378

G1 X85.817 Y101.152 E0.01810

G1 X86.346 Y101.047 E0.01406

G1 X86.998 Y100.993 E0.01704

G1 X87.515 Y100.990 E0.01347

G1 X87.750 Y101.007 E0.00613

G1 X88.590 Y101.128 E0.02213

G1 X89.039 Y101.254 E0.01215

G1 X89.799 Y101.533 E0.02109

G1 X90.403 Y101.835 E0.01760

G1 X91.499 Y102.515 E0.03360

G1 X92.326 Y103.061 E0.02583

G1 X92.667 Y103.338 E0.01144

G1 X92.780 Y103.496 E0.00505

G1 X92.803 Y103.568 E0.00197

M204 S1250

G1 X92.770 Y103.664 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.818 Y103.690 E-0.06813

G1 X92.767 Y103.731 E-0.03670

G1 X92.634 Y103.760 E-0.07570

G1 X91.314 Y103.757 E-0.73147

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X83.706 Y102.700

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.024 Y103.018 E0.01255

G1 X84.653 Y103.014 E0.01755

G1 X84.236 Y102.597 E0.01646

G1 X84.645 Y102.374 E0.01301

G1 X85.284 Y103.013 E0.02520

G1 X85.918 Y103.014 E0.01768

G1 X85.082 Y102.178 E0.03297

G1 X85.229 Y102.179 E0.00410

G1 X85.466 Y102.026 E0.00787

G1 X85.540 Y102.003 E0.00215

G1 X86.552 Y103.016 E0.03993

G1 X87.186 Y103.017 E0.01768

G1 X86.025 Y101.856 E0.04580

G1 X86.564 Y101.763 E0.01527

G1 X87.820 Y103.018 E0.04953

G1 X88.454 Y103.020 E0.01768

G1 X87.161 Y101.726 E0.05102

G1 X87.680 Y101.736 E0.01448

G1 X87.823 Y101.756 E0.00404

G1 X89.088 Y103.021 E0.04990

G1 X89.722 Y103.023 E0.01768

G1 X88.585 Y101.886 E0.04484

G1 X88.814 Y101.950 E0.00663

G1 X89.565 Y102.233 E0.02238

G1 X90.544 Y103.212 E0.03863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.565 Y102.233 E-0.76746

G1 X89.321 Y102.141 E-0.14454

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X84.906 Y96.941

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.057 Y97.390 E0.02502

G1 X82.801 Y98.146 E0.03820

G1 X82.179 Y98.477 E0.01836

G1 X81.938 Y98.572 E0.00674

G1 X81.902 Y98.375 E0.00522

G1 X81.885 Y97.036 E0.03491

G1 X81.905 Y96.940 E0.00255

G1 X84.846 Y96.941 E0.07663

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.057 Y97.390 E-0.50310

G1 X83.425 Y97.771 E-0.40890

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X81.675 Y96.550

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.772 Y96.522 E0.00265

G1 X85.880 Y96.524 E0.10703

G1 X86.144 Y96.573 E0.00700

G1 X86.159 Y96.591 E0.00063

G1 X86.143 Y96.629 E0.00106

G1 X85.968 Y96.797 E0.00631

G1 X85.662 Y97.014 E0.00979

G1 X84.262 Y97.754 E0.04125

G1 X83.007 Y98.510 E0.03819

G1 X82.356 Y98.856 E0.01920

G1 X81.739 Y99.076 E0.01709

G1 X81.701 Y99.063 E0.00103

G1 X81.618 Y98.917 E0.00438

G1 X81.540 Y98.715 E0.00563

G1 X81.484 Y98.416 E0.00793

G1 X81.466 Y96.995 E0.03703

G1 X81.524 Y96.718 E0.00736

G1 X81.635 Y96.594 E0.00433

M204 S1250

G1 X81.764 Y96.597 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.772 Y96.522 E-0.08629

G1 X83.262 Y96.523 E-0.82571

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X82.692 Y98.062

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y97.576 E0.02005

G1 X82.201 Y97.253 E0.00939

G1 X82.543 Y97.253 E0.00997

G1 X83.106 Y97.816 E0.02318

M204 S1250

G1 X83.499 Y97.296 F9000.000

G1 F2400.000

G1 X83.982 Y97.170 E0.00193

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.499 Y97.296 E-0.27644

G1 E-0.68356 F4200.00000

G1 Z10.900 F9000.000

G1 X89.611 Y96.949

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.582 Y96.939 E0.07739

G1 X92.598 Y97.022 E0.00219

G1 X92.584 Y98.324 E0.03392

G1 X92.546 Y98.482 E0.00426

G1 X92.504 Y98.545 E0.00195

G1 X92.059 Y98.362 E0.01252

G1 X90.428 Y97.369 E0.04976

G1 X89.666 Y96.975 E0.02236

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.311 Y96.955 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.829 Y96.557

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.884 Y96.598 E0.00180

G1 X92.999 Y96.847 E0.00715

G1 X93.016 Y96.999 E0.00397

G1 X93.001 Y98.376 E0.03590

G1 X92.934 Y98.654 E0.00745

G1 X92.838 Y98.796 E0.00446

G1 X92.798 Y99.038 E0.00641

G1 X92.742 Y99.063 E0.00160

G1 X92.634 Y99.042 E0.00287

G1 X92.153 Y98.865 E0.01337

G1 X91.863 Y98.731 E0.00832

G1 X90.222 Y97.733 E0.05004

G1 X89.594 Y97.403 E0.01850

G1 X89.040 Y97.142 E0.01594

G1 X88.812 Y96.981 E0.00727

G1 X88.627 Y96.888 E0.00540

G1 X88.407 Y96.707 E0.00743

G1 X88.307 Y96.595 E0.00389

G1 X88.487 Y96.535 E0.00494

G1 X92.709 Y96.521 E0.10999

G1 X92.771 Y96.540 E0.00170

M204 S1250

G1 X92.835 Y96.626 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.884 Y96.598 E-0.07047

G1 X92.999 Y96.847 E-0.15202

G1 X93.016 Y96.999 E-0.08443

G1 X93.004 Y98.090 E-0.60508

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.460 Y98.081

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.635 Y97.256 E0.03650

G1 X90.928 Y97.258 E0.02210

G1 X91.613 Y97.944 E0.03031

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.928 Y97.258 E-0.53723

G1 X91.604 Y97.256 E-0.37477

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X89.407 Y96.904

G1 Z10.700

G1 E3.20000 F2400.00000

G1 X88.891 Y96.763 E0.00215

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.407 Y96.904 E-0.29640

G1 E-0.66360 F4200.00000

G1 Z10.900 F9000.000

G1 X91.992 Y90.343

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y90.328 E0.18027

G1 X82.495 Y90.341 E0.06718

G1 X83.541 Y89.655 E0.03261

G1 X84.279 Y89.206 E0.02251

G1 X84.974 Y88.866 E0.02015

G1 X85.137 Y88.869 E0.00424

G1 X85.333 Y88.741 E0.00609

G1 X85.920 Y88.559 E0.01601

G1 X86.404 Y88.464 E0.01286

G1 X87.016 Y88.413 E0.01601

G1 X87.502 Y88.411 E0.01265

G1 X88.504 Y88.540 E0.02632

G1 X88.911 Y88.654 E0.01101

G1 X89.633 Y88.919 E0.02005

G1 X90.199 Y89.202 E0.01649

G1 X91.274 Y89.869 E0.03295

G1 X91.942 Y90.310 E0.02086

M204 S1250

G1 X92.821 Y90.627 F9000.000

M204 S800

G1 F1500.000

G1 X92.818 Y90.692 E0.00168

G1 X92.767 Y90.733 E0.00172

G1 X92.634 Y90.762 E0.00356

G1 X85.074 Y90.745 E0.19698

G1 X81.851 Y90.762 E0.08397

G1 X81.707 Y90.727 E0.00385

G1 X81.672 Y90.598 E0.00348

G1 X81.782 Y90.379 E0.00638

G1 X82.005 Y90.163 E0.00811

G1 X83.318 Y89.302 E0.04090

G1 X84.079 Y88.839 E0.02319

G1 X84.813 Y88.480 E0.02132

G1 X84.953 Y88.431 E0.00385

G1 X85.031 Y88.439 E0.00205

G1 X85.154 Y88.359 E0.00380

G1 X85.817 Y88.154 E0.01810

G1 X86.346 Y88.049 E0.01405

G1 X86.998 Y87.995 E0.01704

G1 X87.515 Y87.993 E0.01348

G1 X87.750 Y88.009 E0.00613

G1 X88.590 Y88.130 E0.02212

G1 X89.039 Y88.256 E0.01215

G1 X89.799 Y88.535 E0.02109

G1 X90.403 Y88.837 E0.01760

G1 X91.499 Y89.517 E0.03360

G1 X92.326 Y90.063 E0.02583

G1 X92.667 Y90.341 E0.01146

G1 X92.780 Y90.498 E0.00503

G1 X92.803 Y90.570 E0.00199

M204 S1250

G1 X92.770 Y90.667 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.818 Y90.692 E-0.06779

G1 X92.767 Y90.733 E-0.03669

G1 X92.634 Y90.762 E-0.07571

G1 X91.313 Y90.759 E-0.73181

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X83.706 Y89.702

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.024 Y90.020 E0.01255

G1 X84.653 Y90.016 E0.01755

G1 X84.236 Y89.599 E0.01646

G1 X84.645 Y89.376 E0.01301

G1 X85.284 Y90.015 E0.02520

G1 X85.918 Y90.016 E0.01768

G1 X85.083 Y89.181 E0.03294

G1 X85.228 Y89.183 E0.00403

G1 X85.467 Y89.028 E0.00796

G1 X85.540 Y89.005 E0.00212

G1 X86.552 Y90.018 E0.03993

G1 X87.186 Y90.019 E0.01768

G1 X86.025 Y88.858 E0.04580

G1 X86.565 Y88.765 E0.01528

G1 X87.820 Y90.020 E0.04952

G1 X88.454 Y90.022 E0.01768

G1 X87.161 Y88.729 E0.05100

G1 X87.681 Y88.738 E0.01449

G1 X87.823 Y88.758 E0.00402

G1 X89.088 Y90.023 E0.04990

G1 X89.722 Y90.025 E0.01768

G1 X88.585 Y88.888 E0.04484

G1 X88.814 Y88.952 E0.00663

G1 X89.565 Y89.235 E0.02238

G1 X90.544 Y90.214 E0.03863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.565 Y89.235 E-0.76746

G1 X89.321 Y89.143 E-0.14454

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X84.904 Y83.944

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.057 Y84.392 E0.02498

G1 X82.801 Y85.148 E0.03820

G1 X82.179 Y85.479 E0.01836

G1 X81.938 Y85.574 E0.00674

G1 X81.902 Y85.377 E0.00522

G1 X81.885 Y84.038 E0.03491

G1 X81.905 Y83.943 E0.00252

G1 X84.844 Y83.944 E0.07660

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.057 Y84.392 E-0.50215

G1 X83.423 Y84.774 E-0.40985

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X81.674 Y83.553

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.772 Y83.525 E0.00266

G1 X85.880 Y83.527 E0.10703

G1 X86.144 Y83.575 E0.00699

G1 X86.159 Y83.594 E0.00062

G1 X86.143 Y83.631 E0.00106

G1 X85.968 Y83.799 E0.00631

G1 X85.662 Y84.017 E0.00980

G1 X84.262 Y84.756 E0.04124

G1 X83.007 Y85.512 E0.03819

G1 X82.356 Y85.858 E0.01920

G1 X81.739 Y86.079 E0.01709

G1 X81.701 Y86.065 E0.00104

G1 X81.618 Y85.919 E0.00438

G1 X81.540 Y85.717 E0.00563

G1 X81.484 Y85.418 E0.00793

G1 X81.466 Y83.997 E0.03703

G1 X81.524 Y83.721 E0.00736

G1 X81.634 Y83.597 E0.00431

M204 S1250

G1 X81.765 Y83.600 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.772 Y83.525 E-0.08646

G1 X83.262 Y83.526 E-0.82554

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X82.691 Y85.065

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y84.579 E0.02000

G1 X82.201 Y84.256 E0.00938

G1 X82.542 Y84.256 E0.00994

G1 X83.105 Y84.819 E0.02315

M204 S1250

G1 X83.498 Y84.299 F9000.000

G1 F2400.000

G1 X83.980 Y84.173 E0.00190

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.498 Y84.299 E-0.27630

G1 E-0.68370 F4200.00000

G1 Z10.900 F9000.000

G1 X89.611 Y83.951

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.582 Y83.941 E0.07740

G1 X92.598 Y84.025 E0.00221

G1 X92.584 Y85.326 E0.03390

G1 X92.546 Y85.485 E0.00426

G1 X92.504 Y85.547 E0.00195

G1 X92.060 Y85.364 E0.01252

G1 X90.428 Y84.371 E0.04976

G1 X89.665 Y83.977 E0.02237

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.311 Y83.957 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.829 Y83.559

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.884 Y83.600 E0.00180

G1 X92.999 Y83.849 E0.00715

G1 X93.016 Y84.002 E0.00400

G1 X93.001 Y85.378 E0.03587

G1 X92.934 Y85.656 E0.00746

G1 X92.838 Y85.797 E0.00444

G1 X92.798 Y86.041 E0.00642

G1 X92.743 Y86.066 E0.00159

G1 X92.635 Y86.045 E0.00287

G1 X92.153 Y85.867 E0.01338

G1 X91.863 Y85.733 E0.00832

G1 X90.222 Y84.735 E0.05004

G1 X89.594 Y84.405 E0.01850

G1 X89.040 Y84.145 E0.01593

G1 X88.813 Y83.983 E0.00727

G1 X88.627 Y83.891 E0.00540

G1 X88.407 Y83.709 E0.00744

G1 X88.308 Y83.597 E0.00389

G1 X88.487 Y83.537 E0.00494

G1 X92.709 Y83.523 E0.10999

G1 X92.771 Y83.542 E0.00170

M204 S1250

G1 X92.835 Y83.628 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.884 Y83.600 E-0.07047

G1 X92.999 Y83.849 E-0.15198

G1 X93.016 Y84.002 E-0.08498

G1 X93.004 Y85.092 E-0.60457

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.460 Y85.083

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.635 Y84.258 E0.03650

G1 X90.928 Y84.260 E0.02210

G1 X91.613 Y84.946 E0.03030

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.928 Y84.260 E-0.53711

G1 X91.604 Y84.258 E-0.37489

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X89.407 Y83.906

G1 Z10.700

G1 E3.20000 F2400.00000

G1 X88.890 Y83.765 E0.00218

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.407 Y83.906 E-0.29679

G1 E-0.66321 F4200.00000

G1 Z10.900 F9000.000

G1 X91.992 Y77.345

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y77.330 E0.18027

G1 X82.495 Y77.344 E0.06717

G1 X83.541 Y76.658 E0.03259

G1 X84.279 Y76.209 E0.02251

G1 X84.975 Y75.869 E0.02017

G1 X85.139 Y75.869 E0.00428

G1 X85.333 Y75.743 E0.00602

G1 X85.920 Y75.561 E0.01601

G1 X86.404 Y75.466 E0.01286

G1 X87.016 Y75.415 E0.01601

G1 X87.502 Y75.413 E0.01265

G1 X88.503 Y75.542 E0.02631

G1 X88.910 Y75.656 E0.01102

G1 X89.633 Y75.921 E0.02005

G1 X90.199 Y76.204 E0.01649

G1 X91.274 Y76.871 E0.03295

G1 X91.942 Y77.312 E0.02086

M204 S1250

G1 X92.821 Y77.629 F9000.000

M204 S800

G1 F1500.000

G1 X92.818 Y77.694 E0.00168

G1 X92.767 Y77.735 E0.00172

G1 X92.634 Y77.764 E0.00356

G1 X85.074 Y77.748 E0.19698

G1 X81.851 Y77.765 E0.08397

G1 X81.707 Y77.729 E0.00386

G1 X81.672 Y77.600 E0.00348

G1 X81.782 Y77.381 E0.00638

G1 X82.005 Y77.165 E0.00811

G1 X83.318 Y76.304 E0.04090

G1 X84.079 Y75.842 E0.02319

G1 X84.814 Y75.482 E0.02132

G1 X84.954 Y75.434 E0.00387

G1 X85.032 Y75.440 E0.00205

G1 X85.154 Y75.361 E0.00378

G1 X85.817 Y75.156 E0.01810

G1 X86.346 Y75.051 E0.01405

G1 X86.998 Y74.997 E0.01704

G1 X87.515 Y74.995 E0.01348

G1 X87.750 Y75.011 E0.00613

G1 X88.590 Y75.132 E0.02212

G1 X89.039 Y75.258 E0.01215

G1 X89.799 Y75.537 E0.02109

G1 X90.403 Y75.839 E0.01760

G1 X91.499 Y76.519 E0.03360

G1 X92.326 Y77.065 E0.02583

G1 X92.667 Y77.343 E0.01146

G1 X92.780 Y77.500 E0.00503

G1 X92.803 Y77.572 E0.00199

M204 S1250

G1 X92.770 Y77.669 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.818 Y77.694 E-0.06779

G1 X92.767 Y77.735 E-0.03669

G1 X92.634 Y77.764 E-0.07572

G1 X91.313 Y77.761 E-0.73181

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X83.706 Y76.704

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.024 Y77.022 E0.01255

G1 X84.654 Y77.019 E0.01755

G1 X84.237 Y76.602 E0.01645

G1 X84.646 Y76.378 E0.01301

G1 X85.284 Y77.017 E0.02518

G1 X85.918 Y77.018 E0.01768

G1 X85.082 Y76.182 E0.03297

G1 X85.231 Y76.183 E0.00415

G1 X85.467 Y76.030 E0.00784

G1 X85.540 Y76.007 E0.00213

G1 X86.552 Y77.020 E0.03994

G1 X87.186 Y77.021 E0.01768

G1 X86.025 Y75.860 E0.04581

G1 X86.565 Y75.767 E0.01528

G1 X87.820 Y77.022 E0.04952

G1 X88.454 Y77.024 E0.01768

G1 X87.161 Y75.731 E0.05100

G1 X87.681 Y75.740 E0.01449

G1 X87.823 Y75.760 E0.00402

G1 X89.088 Y77.025 E0.04990

G1 X89.722 Y77.027 E0.01768

G1 X88.586 Y75.890 E0.04483

G1 X88.814 Y75.954 E0.00662

G1 X89.565 Y76.237 E0.02239

G1 X90.544 Y77.216 E0.03863

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.565 Y76.237 E-0.76744

G1 X89.321 Y76.145 E-0.14456

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X84.904 Y70.946

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.057 Y71.394 E0.02498

G1 X82.801 Y72.151 E0.03820

G1 X82.179 Y72.481 E0.01835

G1 X81.938 Y72.577 E0.00675

G1 X81.902 Y72.379 E0.00523

G1 X81.885 Y71.040 E0.03492

G1 X81.905 Y70.945 E0.00252

G1 X84.844 Y70.946 E0.07660

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.057 Y71.394 E-0.50221

G1 X83.423 Y71.776 E-0.40979

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X81.674 Y70.555

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.772 Y70.527 E0.00266

G1 X85.880 Y70.529 E0.10704

G1 X86.144 Y70.577 E0.00699

G1 X86.159 Y70.596 E0.00062

G1 X86.143 Y70.633 E0.00107

G1 X85.968 Y70.801 E0.00632

G1 X85.662 Y71.019 E0.00979

G1 X84.262 Y71.758 E0.04124

G1 X83.007 Y72.515 E0.03819

G1 X82.356 Y72.860 E0.01919

G1 X81.739 Y73.081 E0.01708

G1 X81.701 Y73.067 E0.00105

G1 X81.618 Y72.921 E0.00438

G1 X81.540 Y72.720 E0.00562

G1 X81.484 Y72.420 E0.00793

G1 X81.466 Y70.999 E0.03704

G1 X81.524 Y70.723 E0.00736

G1 X81.634 Y70.599 E0.00431

M204 S1250

G1 X81.764 Y70.602 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.772 Y70.527 E-0.08644

G1 X83.262 Y70.528 E-0.82556

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X82.692 Y72.067

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y71.581 E0.02003

G1 X82.201 Y71.258 E0.00938

G1 X82.543 Y71.258 E0.00995

G1 X83.105 Y71.821 E0.02316

M204 S1250

G1 X83.498 Y71.301 F9000.000

G1 F2400.000

G1 X83.980 Y71.175 E0.00190

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.498 Y71.301 E-0.27602

G1 E-0.68398 F4200.00000

G1 Z10.900 F9000.000

G1 X89.611 Y70.954

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.582 Y70.944 E0.07740

G1 X92.598 Y71.027 E0.00220

G1 X92.584 Y72.328 E0.03391

G1 X92.546 Y72.487 E0.00427

G1 X92.504 Y72.549 E0.00195

G1 X92.060 Y72.366 E0.01251

G1 X90.428 Y71.373 E0.04978

G1 X89.665 Y70.979 E0.02235

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.311 Y70.959 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.829 Y70.561

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.884 Y70.602 E0.00180

G1 X92.999 Y70.851 E0.00715

G1 X93.016 Y71.004 E0.00400

G1 X93.001 Y72.380 E0.03587

G1 X92.934 Y72.659 E0.00746

G1 X92.838 Y72.800 E0.00444

G1 X92.798 Y73.043 E0.00641

G1 X92.743 Y73.068 E0.00159

G1 X92.635 Y73.047 E0.00287

G1 X92.153 Y72.870 E0.01337

G1 X91.863 Y72.736 E0.00832

G1 X90.222 Y71.737 E0.05006

G1 X89.594 Y71.407 E0.01849

G1 X89.040 Y71.147 E0.01594

G1 X88.812 Y70.986 E0.00727

G1 X88.627 Y70.894 E0.00539

G1 X88.407 Y70.711 E0.00745

G1 X88.308 Y70.600 E0.00389

G1 X88.487 Y70.540 E0.00492

G1 X92.709 Y70.525 E0.11000

G1 X92.771 Y70.544 E0.00169

M204 S1250

G1 X92.835 Y70.630 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.884 Y70.602 E-0.07042

G1 X92.999 Y70.851 E-0.15198

G1 X93.016 Y71.004 E-0.08498

G1 X93.004 Y72.095 E-0.60462

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.460 Y72.086

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.635 Y71.260 E0.03650

G1 X90.928 Y71.263 E0.02209

G1 X91.614 Y71.948 E0.03031

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.928 Y71.263 E-0.53712

G1 X91.605 Y71.260 E-0.37488

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X89.407 Y70.908

G1 Z10.700

G1 E3.20000 F2400.00000

G1 X88.891 Y70.768 E0.00215

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.407 Y70.908 E-0.29636

G1 E-0.66364 F4200.00000

G1 Z10.900 F9000.000

G1 X91.990 Y64.347

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y64.332 E0.18023

G1 X82.495 Y64.346 E0.06717

G1 X83.541 Y63.660 E0.03259

G1 X84.279 Y63.211 E0.02251

G1 X84.975 Y62.871 E0.02017

G1 X85.139 Y62.871 E0.00428

G1 X85.333 Y62.745 E0.00602

G1 X85.920 Y62.563 E0.01601

G1 X86.404 Y62.468 E0.01286

G1 X87.016 Y62.417 E0.01601

G1 X87.502 Y62.415 E0.01265

G1 X88.503 Y62.544 E0.02631

G1 X88.910 Y62.658 E0.01102

G1 X89.633 Y62.923 E0.02005

G1 X90.199 Y63.206 E0.01648

G1 X91.274 Y63.873 E0.03296

G1 X91.940 Y64.314 E0.02082

M204 S1250

G1 X92.821 Y64.632 F9000.000

M204 S800

G1 F1500.000

G1 X92.818 Y64.696 E0.00167

G1 X92.767 Y64.737 E0.00172

G1 X92.634 Y64.766 E0.00356

G1 X85.074 Y64.750 E0.19698

G1 X81.851 Y64.767 E0.08397

G1 X81.707 Y64.731 E0.00386

G1 X81.672 Y64.602 E0.00348

G1 X81.782 Y64.384 E0.00637

G1 X82.005 Y64.167 E0.00811

G1 X83.318 Y63.306 E0.04090

G1 X84.079 Y62.844 E0.02319

G1 X84.814 Y62.484 E0.02132

G1 X84.954 Y62.436 E0.00387

G1 X85.032 Y62.442 E0.00205

G1 X85.154 Y62.363 E0.00378

G1 X85.817 Y62.158 E0.01810

G1 X86.346 Y62.053 E0.01405

G1 X86.998 Y61.999 E0.01704

G1 X87.515 Y61.997 E0.01348

G1 X87.750 Y62.013 E0.00613

G1 X88.590 Y62.134 E0.02212

G1 X89.039 Y62.260 E0.01215

G1 X89.799 Y62.539 E0.02109

G1 X90.403 Y62.841 E0.01760

G1 X91.499 Y63.522 E0.03361

G1 X92.326 Y64.068 E0.02583

G1 X92.667 Y64.345 E0.01144

G1 X92.780 Y64.503 E0.00505

G1 X92.803 Y64.574 E0.00197

M204 S1250

G1 X92.771 Y64.671 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.818 Y64.696 E-0.06768

G1 X92.767 Y64.737 E-0.03669

G1 X92.634 Y64.766 E-0.07572

G1 X91.313 Y64.763 E-0.73191

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X83.706 Y63.706

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.024 Y64.024 E0.01254

G1 X84.653 Y64.021 E0.01754

G1 X84.237 Y63.604 E0.01644

G1 X84.646 Y63.381 E0.01300

G1 X85.284 Y64.019 E0.02517

G1 X85.918 Y64.020 E0.01768

G1 X85.082 Y63.184 E0.03297

G1 X85.231 Y63.185 E0.00416

G1 X85.467 Y63.032 E0.00784

G1 X85.539 Y63.009 E0.00211

G1 X86.552 Y64.022 E0.03993

G1 X87.185 Y64.023 E0.01768

G1 X86.024 Y62.862 E0.04579

G1 X86.564 Y62.769 E0.01527

G1 X87.819 Y64.024 E0.04951

G1 X88.453 Y64.026 E0.01768

G1 X87.160 Y62.733 E0.05099

G1 X87.681 Y62.742 E0.01451

G1 X87.822 Y62.762 E0.00398

G1 X89.087 Y64.027 E0.04989

G1 X89.721 Y64.029 E0.01768

G1 X88.584 Y62.892 E0.04484

G1 X88.814 Y62.956 E0.00667

G1 X89.563 Y63.238 E0.02230

G1 X90.543 Y64.218 E0.03867

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.563 Y63.238 E-0.76845

G1 X89.320 Y63.147 E-0.14355

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X84.906 Y57.948

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.057 Y58.397 E0.02502

G1 X82.801 Y59.153 E0.03819

G1 X82.192 Y59.477 E0.01798

G1 X81.936 Y59.568 E0.00707

G1 X81.902 Y59.382 E0.00493

G1 X81.885 Y58.042 E0.03491

G1 X81.905 Y57.947 E0.00253

G1 X84.846 Y57.948 E0.07663

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.057 Y58.397 E-0.50305

G1 X83.425 Y58.778 E-0.40895

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X81.675 Y57.557

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.772 Y57.529 E0.00265

G1 X85.880 Y57.531 E0.10704

G1 X86.144 Y57.579 E0.00699

G1 X86.159 Y57.598 E0.00062

G1 X86.143 Y57.635 E0.00107

G1 X85.968 Y57.803 E0.00632

G1 X85.662 Y58.021 E0.00980

G1 X84.262 Y58.761 E0.04124

G1 X83.007 Y59.517 E0.03818

G1 X82.361 Y59.860 E0.01906

G1 X81.736 Y60.083 E0.01728

G1 X81.701 Y60.069 E0.00097

G1 X81.618 Y59.922 E0.00439

G1 X81.540 Y59.722 E0.00560

G1 X81.484 Y59.422 E0.00794

G1 X81.466 Y58.001 E0.03704

G1 X81.524 Y57.726 E0.00734

G1 X81.635 Y57.601 E0.00433

M204 S1250

G1 X81.764 Y57.604 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.772 Y57.529 E-0.08629

G1 X83.262 Y57.530 E-0.82571

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X82.692 Y59.069

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y58.583 E0.02004

G1 X82.201 Y58.260 E0.00938

G1 X82.543 Y58.260 E0.00996

G1 X83.106 Y58.823 E0.02317

M204 S1250

G1 X83.499 Y58.303 F9000.000

G1 F2400.000

G1 X83.982 Y58.177 E0.00193

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.499 Y58.303 E-0.27650

G1 E-0.68350 F4200.00000

G1 Z10.900 F9000.000

G1 X89.612 Y57.956

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.582 Y57.946 E0.07739

G1 X92.598 Y58.029 E0.00219

G1 X92.584 Y59.330 E0.03390

G1 X92.546 Y59.489 E0.00427

G1 X92.504 Y59.551 E0.00196

G1 X92.060 Y59.369 E0.01251

G1 X90.428 Y58.376 E0.04977

G1 X89.666 Y57.982 E0.02235

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.311 Y57.962 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.829 Y57.563

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.884 Y57.604 E0.00178

G1 X92.999 Y57.854 E0.00717

G1 X93.016 Y58.006 E0.00397

G1 X93.001 Y59.382 E0.03587

G1 X92.934 Y59.661 E0.00746

G1 X92.838 Y59.802 E0.00444

G1 X92.798 Y60.045 E0.00641

G1 X92.742 Y60.070 E0.00160

G1 X92.635 Y60.049 E0.00285

G1 X92.153 Y59.872 E0.01339

G1 X91.863 Y59.738 E0.00832

G1 X90.222 Y58.739 E0.05005

G1 X89.594 Y58.409 E0.01849

G1 X89.040 Y58.149 E0.01594

G1 X88.812 Y57.988 E0.00727

G1 X88.627 Y57.896 E0.00539

G1 X88.407 Y57.713 E0.00745

G1 X88.308 Y57.602 E0.00389

G1 X88.487 Y57.542 E0.00493

G1 X92.709 Y57.528 E0.11001

G1 X92.771 Y57.546 E0.00169

M204 S1250

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G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.884 Y57.604 E-0.07006

G1 X92.999 Y57.854 E-0.15251

G1 X93.016 Y58.006 E-0.08450

G1 X93.004 Y59.097 E-0.60492

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.460 Y59.088

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.635 Y58.263 E0.03650

G1 X90.928 Y58.265 E0.02210

G1 X91.613 Y58.950 E0.03029

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.928 Y58.265 E-0.53692

G1 X91.605 Y58.263 E-0.37508

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X89.408 Y57.911

G1 Z10.700

G1 E3.20000 F2400.00000

G1 X88.891 Y57.770 E0.00215

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.408 Y57.911 E-0.29654

G1 E-0.66346 F4200.00000

G1 Z10.900 F9000.000

G1 X91.992 Y51.350

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.073 Y51.334 E0.18027

G1 X82.495 Y51.348 E0.06717

G1 X83.541 Y50.662 E0.03260

G1 X84.279 Y50.213 E0.02250

G1 X84.975 Y49.873 E0.02017

G1 X85.137 Y49.873 E0.00424

G1 X85.331 Y49.748 E0.00601

G1 X85.919 Y49.565 E0.01604

G1 X86.404 Y49.471 E0.01287

G1 X87.017 Y49.419 E0.01602

G1 X87.502 Y49.417 E0.01264

G1 X88.504 Y49.546 E0.02632

G1 X88.910 Y49.660 E0.01101

G1 X89.633 Y49.925 E0.02005

G1 X90.199 Y50.208 E0.01648

G1 X91.274 Y50.875 E0.03296

G1 X91.942 Y51.317 E0.02086

M204 S1250

G1 X92.821 Y51.634 F9000.000

M204 S800

G1 F1500.000

G1 X92.819 Y51.698 E0.00168

G1 X92.767 Y51.740 E0.00175

G1 X92.634 Y51.769 E0.00355

G1 X85.074 Y51.752 E0.19698

G1 X81.851 Y51.769 E0.08396

G1 X81.707 Y51.733 E0.00387

G1 X81.672 Y51.604 E0.00348

G1 X81.782 Y51.386 E0.00637

G1 X82.005 Y51.170 E0.00810

G1 X83.318 Y50.308 E0.04091

G1 X84.079 Y49.846 E0.02319

G1 X84.814 Y49.486 E0.02132

G1 X84.954 Y49.438 E0.00387

G1 X85.031 Y49.444 E0.00203

G1 X85.153 Y49.366 E0.00377

G1 X85.817 Y49.160 E0.01811

G1 X86.346 Y49.056 E0.01405

G1 X86.998 Y49.001 E0.01704

G1 X87.515 Y48.999 E0.01348

G1 X87.750 Y49.015 E0.00613

G1 X88.590 Y49.136 E0.02212

G1 X89.039 Y49.262 E0.01215

G1 X89.799 Y49.541 E0.02109

G1 X90.403 Y49.843 E0.01760

G1 X91.499 Y50.524 E0.03361

G1 X92.326 Y51.070 E0.02583

G1 X92.667 Y51.347 E0.01144

G1 X92.780 Y51.505 E0.00505

G1 X92.803 Y51.576 E0.00197

M204 S1250

G1 X92.770 Y51.673 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.819 Y51.698 E-0.06781

G1 X92.767 Y51.740 E-0.03727

G1 X92.634 Y51.769 E-0.07541

G1 X91.314 Y51.766 E-0.73151

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X83.706 Y50.708

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.024 Y51.026 E0.01254

G1 X84.653 Y51.023 E0.01755

G1 X84.236 Y50.606 E0.01644

G1 X84.646 Y50.383 E0.01300

G1 X85.284 Y51.021 E0.02517

G1 X85.918 Y51.022 E0.01768

G1 X85.082 Y50.186 E0.03298

G1 X85.229 Y50.187 E0.00411

G1 X85.465 Y50.035 E0.00783

G1 X85.540 Y50.012 E0.00218

G1 X86.552 Y51.024 E0.03992

G1 X87.186 Y51.025 E0.01768

G1 X86.025 Y49.864 E0.04580

G1 X86.565 Y49.772 E0.01528

G1 X87.820 Y51.027 E0.04951

G1 X88.454 Y51.028 E0.01768

G1 X87.160 Y49.735 E0.05101

G1 X87.680 Y49.744 E0.01451

G1 X87.822 Y49.764 E0.00399

G1 X89.088 Y51.030 E0.04992

G1 X89.722 Y51.031 E0.01768

G1 X88.584 Y49.894 E0.04487

G1 X88.814 Y49.958 E0.00666

G1 X89.563 Y50.240 E0.02232

G1 X90.544 Y51.221 E0.03869

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.563 Y50.240 E-0.76877

G1 X89.321 Y50.149 E-0.14323

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X84.906 Y44.950

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.057 Y45.399 E0.02502

G1 X82.801 Y46.155 E0.03819

G1 X82.192 Y46.479 E0.01798

G1 X81.936 Y46.570 E0.00707

G1 X81.902 Y46.384 E0.00491

G1 X81.885 Y45.044 E0.03493

G1 X81.905 Y44.949 E0.00253

G1 X84.846 Y44.950 E0.07663

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.057 Y45.399 E-0.50305

G1 X83.425 Y45.780 E-0.40895

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X81.675 Y44.559

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.772 Y44.531 E0.00265

G1 X85.880 Y44.533 E0.10703

G1 X86.144 Y44.581 E0.00699

G1 X86.159 Y44.600 E0.00063

G1 X86.143 Y44.637 E0.00106

G1 X85.968 Y44.805 E0.00630

G1 X85.662 Y45.023 E0.00980

G1 X84.262 Y45.763 E0.04124

G1 X83.007 Y46.519 E0.03818

G1 X82.361 Y46.862 E0.01906

G1 X81.735 Y47.085 E0.01730

G1 X81.701 Y47.072 E0.00095

G1 X81.618 Y46.926 E0.00438

G1 X81.540 Y46.724 E0.00563

G1 X81.484 Y46.425 E0.00793

G1 X81.466 Y45.003 E0.03706

G1 X81.524 Y44.728 E0.00734

G1 X81.635 Y44.603 E0.00433

M204 S1250

G1 X81.764 Y44.606 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.772 Y44.531 E-0.08629

G1 X83.262 Y44.532 E-0.82571

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X82.692 Y46.071

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.205 Y45.585 E0.02004

G1 X82.201 Y45.262 E0.00938

G1 X82.543 Y45.262 E0.00997

G1 X83.106 Y45.825 E0.02317

M204 S1250

G1 X83.499 Y45.305 F9000.000

G1 F2400.000

G1 X83.982 Y45.179 E0.00193

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.499 Y45.305 E-0.27650

G1 E-0.68350 F4200.00000

G1 Z10.900 F9000.000

G1 X89.612 Y44.958

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.582 Y44.948 E0.07739

G1 X92.598 Y45.031 E0.00219

G1 X92.584 Y46.332 E0.03390

G1 X92.546 Y46.491 E0.00427

G1 X92.504 Y46.553 E0.00196

G1 X92.060 Y46.371 E0.01251

G1 X90.428 Y45.378 E0.04977

G1 X89.666 Y44.984 E0.02235

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.311 Y44.964 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.829 Y44.565

G1 Z10.700

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.884 Y44.607 E0.00180

G1 X92.999 Y44.856 E0.00716

G1 X93.016 Y45.008 E0.00397

G1 X93.001 Y46.384 E0.03587

G1 X92.934 Y46.663 E0.00746

G1 X92.838 Y46.804 E0.00444

G1 X92.798 Y47.047 E0.00642

G1 X92.743 Y47.072 E0.00159

G1 X92.635 Y47.051 E0.00287

G1 X92.153 Y46.874 E0.01339

G1 X91.863 Y46.740 E0.00832

G1 X90.222 Y45.741 E0.05005

G1 X89.594 Y45.411 E0.01849

G1 X89.040 Y45.151 E0.01594

G1 X88.812 Y44.990 E0.00727

G1 X88.627 Y44.898 E0.00539

G1 X88.407 Y44.715 E0.00746

G1 X88.308 Y44.604 E0.00387

G1 X88.487 Y44.544 E0.00493

G1 X92.709 Y44.530 E0.11001

G1 X92.771 Y44.548 E0.00168

M204 S1250

G1 X92.835 Y44.634 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.884 Y44.607 E-0.07037

G1 X92.999 Y44.856 E-0.15237

G1 X93.016 Y45.008 E-0.08444

G1 X93.004 Y46.099 E-0.60482

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X92.460 Y46.090

G1 Z10.700

G1 E3.20000 F2400.00000

M73 P92 R5

M204 S1000

G1 F4800.000

G1 X91.635 Y45.265 E0.03650

G1 X90.928 Y45.267 E0.02210

G1 X91.613 Y45.952 E0.03030

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.928 Y45.267 E-0.53696

G1 X91.605 Y45.265 E-0.37504

G1 E-0.04800 F4200.00000

G1 Z10.900 F9000.000

G1 X89.408 Y44.913

G1 Z10.700

G1 E3.20000 F2400.00000

G1 X88.891 Y44.772 E0.00215

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;10.85

G1 Z10.850 F9000.000

;AFTER\_LAYER\_CHANGE

;10.85

G1 E-3.20000 F4200.00000

G1 Z11.050 F9000.000

G1 X84.642 Y45.085

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.717 Y45.591 E0.02748

G1 X82.263 Y46.495 E0.04460

G1 X81.901 Y46.694 E0.01076

G1 X81.888 Y45.167 E0.03979

G1 X81.902 Y45.088 E0.00209

G1 X84.582 Y45.085 E0.06983

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.717 Y45.591 E-0.55541

G1 X83.170 Y45.931 E-0.35659

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X81.678 Y44.690

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.766 Y44.670 E0.00235

G1 X85.592 Y44.667 E0.09969

G1 X85.749 Y44.692 E0.00413

G1 X85.653 Y44.913 E0.00626

G1 X85.395 Y45.125 E0.00870

G1 X84.953 Y45.391 E0.01345

G1 X83.927 Y45.952 E0.03047

G1 X82.474 Y46.856 E0.04459

G1 X81.867 Y47.190 E0.01807

G1 X81.683 Y47.216 E0.00484

G1 X81.577 Y47.128 E0.00358

G1 X81.518 Y46.983 E0.00408

G1 X81.475 Y46.664 E0.00840

G1 X81.470 Y45.130 E0.03997

G1 X81.511 Y44.903 E0.00600

G1 X81.641 Y44.737 E0.00549

M204 S1250

G1 X81.756 Y44.735 F9000.000

G1 X82.883 Y45.212

M204 S1000

G1 F4800.000

G1 X82.021 Y46.074 E0.03261

M204 S1250

G1 X83.264 Y45.443 F9000.000

G1 F2400.000

G1 X83.742 Y45.313 E0.00385

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.264 Y45.443 E-0.27457

G1 E-0.68543 F4200.00000

G1 Z11.050 F9000.000

G1 X82.700 Y51.214

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.594 Y50.628 E0.02785

G1 X84.598 Y50.023 E0.03054

G1 X85.651 Y49.520 E0.03039

G1 X86.349 Y49.291 E0.01913

G1 X86.785 Y49.196 E0.01163

G1 X87.209 Y49.169 E0.01107

G1 X87.975 Y49.269 E0.02012

G1 X88.304 Y49.351 E0.00882

G1 X88.431 Y49.431 E0.00392

G1 X88.707 Y49.506 E0.00746

G1 X89.365 Y49.756 E0.01835

G1 X90.067 Y50.129 E0.02070

G1 X91.267 Y50.871 E0.03677

G1 X91.800 Y51.223 E0.01664

G1 X88.410 Y51.222 E0.08833

G1 X85.074 Y51.184 E0.08693

G1 X82.760 Y51.213 E0.06028

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.594 Y50.628 E-0.56457

G1 X84.131 Y50.304 E-0.34743

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.594 Y51.394

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.627 Y51.553 E0.00422

G1 X92.435 Y51.642 E0.00550

G1 X88.407 Y51.640 E0.10496

G1 X85.074 Y51.602 E0.08686

G1 X82.025 Y51.640 E0.07946

G1 X81.883 Y51.605 E0.00381

G1 X81.867 Y51.463 E0.00370

G1 X81.975 Y51.268 E0.00580

G1 X82.209 Y51.036 E0.00858

G1 X83.372 Y50.274 E0.03624

G1 X84.400 Y49.654 E0.03128

G1 X85.495 Y49.132 E0.03162

G1 X86.239 Y48.888 E0.02039

G1 X86.727 Y48.781 E0.01302

G1 X87.223 Y48.750 E0.01295

G1 X88.053 Y48.858 E0.02180

G1 X88.470 Y48.962 E0.01121

G1 X88.601 Y49.044 E0.00403

G1 X88.836 Y49.108 E0.00636

G1 X89.538 Y49.375 E0.01957

G1 X90.275 Y49.766 E0.02174

G1 X91.492 Y50.519 E0.03729

G1 X92.077 Y50.906 E0.01827

G1 X92.452 Y51.205 E0.01249

G1 X92.558 Y51.346 E0.00461

M204 S1250

G1 X92.497 Y51.524 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.627 Y51.553 E-0.12068

G1 X92.435 Y51.642 E-0.11707

G1 X91.219 Y51.641 E-0.67426

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X85.433 Y49.763

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.316 Y50.880 E0.04192

G1 X84.926 Y50.873 E0.01617

G1 X86.093 Y49.705 E0.04382

G1 X86.431 Y49.594 E0.00944

G1 X86.897 Y49.503 E0.01259

G1 X85.524 Y50.876 E0.05151

G1 X86.119 Y50.883 E0.01579

G1 X87.481 Y49.521 E0.05111

G1 X88.004 Y49.599 E0.01404

G1 X86.714 Y50.889 E0.04842

G1 X87.310 Y50.896 E0.01579

G1 X88.446 Y49.760 E0.04264

G1 X88.895 Y49.912 E0.01259

G1 X87.905 Y50.903 E0.03716

G1 X88.501 Y50.908 E0.01582

G1 X89.321 Y50.088 E0.03080

G1 X89.714 Y50.296 E0.01181

G1 X89.102 Y50.909 E0.02298

G1 X89.704 Y50.909 E0.01596

G1 X90.097 Y50.516 E0.01476

G1 X90.469 Y50.746 E0.01160

G1 X90.117 Y51.097 E0.01319

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.469 Y50.746 E-0.27535

G1 X90.097 Y50.516 E-0.24227

G1 X89.704 Y50.909 E-0.30814

G1 X89.548 Y50.909 E-0.08624

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.526 Y46.673

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.486 Y45.414 E0.06246

G1 X89.853 Y45.078 E0.01865

G1 X92.578 Y45.081 E0.07100

G1 X92.598 Y45.193 E0.00295

G1 X92.583 Y46.618 E0.03713

G1 X92.565 Y46.669 E0.00141

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.156 Y45.819 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.829 Y44.701

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.888 Y44.744 E0.00190

G1 X92.972 Y44.910 E0.00484

G1 X93.016 Y45.159 E0.00657

G1 X93.000 Y46.692 E0.03996

G1 X92.971 Y46.775 E0.00229

G1 X92.920 Y47.110 E0.00882

G1 X92.853 Y47.189 E0.00270

G1 X92.715 Y47.216 E0.00366

G1 X92.329 Y47.043 E0.01101

G1 X90.278 Y45.777 E0.06281

G1 X89.261 Y45.237 E0.03000

G1 X88.817 Y44.916 E0.01425

G1 X88.697 Y44.723 E0.00593

G1 X88.828 Y44.671 E0.00367

G1 X88.953 Y44.659 E0.00328

G1 X92.707 Y44.664 E0.09782

G1 X92.772 Y44.684 E0.00176

M204 S1250

G1 X92.836 Y44.774 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y44.744 E-0.07275

G1 X92.972 Y44.910 E-0.10304

G1 X93.016 Y45.159 E-0.13980

G1 X93.005 Y46.235 E-0.59640

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.330 Y45.786

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.723 Y45.394 E0.01734

G1 X92.282 Y45.394 E0.01750

G1 X92.281 Y45.544 E0.00469

G1 X91.770 Y46.056 E0.02260

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.281 Y45.544 E-0.40057

G1 X92.282 Y45.394 E-0.08319

G1 X91.723 Y45.394 E-0.31022

G1 X91.572 Y45.544 E-0.11803

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.578 Y58.079

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y58.191 E0.00295

G1 X92.583 Y59.616 E0.03713

G1 X92.562 Y59.687 E0.00193

G1 X90.486 Y58.412 E0.06348

G1 X89.853 Y58.076 E0.01865

G1 X92.518 Y58.079 E0.06943

M204 S1250

G1 X92.829 Y57.699 F9000.000

M204 S800

G1 F1500.000

G1 X92.888 Y57.742 E0.00190

G1 X92.972 Y57.908 E0.00484

G1 X93.016 Y58.157 E0.00657

G1 X93.000 Y59.690 E0.03996

G1 X92.971 Y59.773 E0.00229

G1 X92.920 Y60.108 E0.00882

G1 X92.853 Y60.186 E0.00268

G1 X92.714 Y60.214 E0.00369

G1 X92.329 Y60.041 E0.01100

G1 X90.278 Y58.775 E0.06281

G1 X89.261 Y58.235 E0.03000

G1 X88.817 Y57.914 E0.01425

G1 X88.697 Y57.721 E0.00594

G1 X88.827 Y57.669 E0.00366

G1 X88.953 Y57.657 E0.00328

G1 X92.707 Y57.662 E0.09782

G1 X92.772 Y57.682 E0.00176

M204 S1250

G1 X92.836 Y57.772 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y57.742 E-0.07276

G1 X92.972 Y57.908 E-0.10304

G1 X93.016 Y58.157 E-0.13980

G1 X93.005 Y59.233 E-0.59640

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.330 Y58.784

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.723 Y58.392 E0.01734

G1 X92.282 Y58.392 E0.01750

G1 X92.281 Y58.542 E0.00469

G1 X91.770 Y59.054 E0.02260

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.281 Y58.542 E-0.40057

G1 X92.282 Y58.392 E-0.08318

G1 X91.723 Y58.392 E-0.31023

G1 X91.572 Y58.542 E-0.11802

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.798 Y64.221

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.410 Y64.220 E0.08830

G1 X85.074 Y64.182 E0.08693

G1 X82.699 Y64.212 E0.06187

G1 X83.594 Y63.626 E0.02786

G1 X84.598 Y63.021 E0.03055

G1 X85.651 Y62.518 E0.03040

G1 X86.349 Y62.288 E0.01913

G1 X86.785 Y62.194 E0.01163

G1 X87.209 Y62.167 E0.01108

G1 X87.978 Y62.267 E0.02021

G1 X88.268 Y62.336 E0.00776

G1 X88.453 Y62.435 E0.00546

G1 X88.707 Y62.504 E0.00686

G1 X89.365 Y62.754 E0.01835

G1 X90.067 Y63.127 E0.02070

G1 X91.748 Y64.187 E0.05180

M204 S1250

G1 X92.594 Y64.392 F9000.000

M204 S800

G1 F1500.000

G1 X92.627 Y64.551 E0.00421

G1 X92.436 Y64.639 E0.00549

G1 X88.407 Y64.638 E0.10496

G1 X85.074 Y64.600 E0.08686

G1 X82.024 Y64.638 E0.07946

G1 X81.883 Y64.602 E0.00381

G1 X81.867 Y64.461 E0.00370

G1 X81.975 Y64.266 E0.00580

G1 X82.209 Y64.033 E0.00860

G1 X83.372 Y63.272 E0.03622

G1 X84.400 Y62.652 E0.03128

G1 X85.495 Y62.130 E0.03162

G1 X86.239 Y61.885 E0.02039

G1 X86.727 Y61.779 E0.01301

G1 X87.223 Y61.747 E0.01295

G1 X88.054 Y61.856 E0.02183

G1 X88.418 Y61.942 E0.00975

G1 X88.608 Y62.044 E0.00564

G1 X88.836 Y62.106 E0.00615

G1 X89.538 Y62.373 E0.01957

G1 X90.275 Y62.764 E0.02174

G1 X91.492 Y63.517 E0.03729

G1 X92.077 Y63.904 E0.01827

G1 X92.452 Y64.203 E0.01249

G1 X92.558 Y64.344 E0.00461

M204 S1250

G1 X92.498 Y64.522 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.627 Y64.551 E-0.12051

G1 X92.436 Y64.639 E-0.11679

G1 X91.218 Y64.638 E-0.67470

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X85.433 Y62.762

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.316 Y63.878 E0.04190

G1 X84.925 Y63.871 E0.01617

G1 X86.093 Y62.703 E0.04383

G1 X86.431 Y62.591 E0.00944

G1 X86.897 Y62.501 E0.01258

G1 X85.524 Y63.874 E0.05151

G1 X86.119 Y63.880 E0.01579

G1 X87.481 Y62.518 E0.05112

G1 X88.005 Y62.596 E0.01406

G1 X86.714 Y63.887 E0.04847

G1 X87.309 Y63.894 E0.01579

G1 X88.445 Y62.758 E0.04264

G1 X88.894 Y62.910 E0.01259

G1 X87.904 Y63.901 E0.03717

G1 X88.500 Y63.906 E0.01581

G1 X89.321 Y63.085 E0.03081

G1 X89.714 Y63.294 E0.01181

G1 X89.101 Y63.907 E0.02298

G1 X89.703 Y63.907 E0.01596

G1 X90.096 Y63.513 E0.01476

G1 X90.468 Y63.743 E0.01160

G1 X90.116 Y64.095 E0.01319

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.468 Y63.743 E-0.27543

G1 X90.096 Y63.513 E-0.24223

G1 X89.703 Y63.907 E-0.30826

G1 X89.547 Y63.907 E-0.08608

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X84.642 Y58.083

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.717 Y58.589 E0.02748

G1 X82.263 Y59.493 E0.04460

G1 X81.901 Y59.692 E0.01076

G1 X81.888 Y58.165 E0.03979

G1 X81.902 Y58.086 E0.00209

G1 X84.582 Y58.083 E0.06983

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.717 Y58.589 E-0.55541

G1 X83.170 Y58.929 E-0.35659

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X81.678 Y57.688

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.766 Y57.668 E0.00235

G1 X85.592 Y57.665 E0.09969

G1 X85.749 Y57.690 E0.00413

G1 X85.653 Y57.911 E0.00626

G1 X85.395 Y58.123 E0.00870

G1 X84.953 Y58.389 E0.01345

G1 X83.927 Y58.950 E0.03047

G1 X82.474 Y59.854 E0.04459

G1 X81.867 Y60.188 E0.01807

G1 X81.684 Y60.214 E0.00481

G1 X81.577 Y60.126 E0.00361

G1 X81.518 Y59.981 E0.00407

G1 X81.475 Y59.661 E0.00841

G1 X81.470 Y58.128 E0.03996

G1 X81.511 Y57.901 E0.00600

G1 X81.641 Y57.735 E0.00549

M204 S1250

G1 X81.756 Y57.733 F9000.000

G1 X82.883 Y58.210

M204 S1000

G1 F4800.000

G1 X82.021 Y59.072 E0.03260

M204 S1250

G1 X83.264 Y58.441 F9000.000

G1 F2400.000

G1 X83.742 Y58.311 E0.00385

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.264 Y58.441 E-0.27457

G1 E-0.68543 F4200.00000

G1 Z11.050 F9000.000

G1 X84.641 Y71.081

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.716 Y71.587 E0.02745

G1 X82.263 Y72.491 E0.04459

G1 X81.901 Y72.690 E0.01076

G1 X81.888 Y71.163 E0.03980

G1 X81.902 Y71.084 E0.00209

G1 X84.581 Y71.081 E0.06979

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.716 Y71.587 E-0.55489

G1 X83.169 Y71.927 E-0.35711

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X81.678 Y70.686

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.766 Y70.666 E0.00236

G1 X85.592 Y70.663 E0.09969

G1 X85.749 Y70.688 E0.00413

G1 X85.653 Y70.909 E0.00626

G1 X85.396 Y71.121 E0.00869

G1 X84.953 Y71.386 E0.01344

G1 X83.927 Y71.948 E0.03048

G1 X82.474 Y72.852 E0.04458

G1 X81.867 Y73.186 E0.01807

G1 X81.684 Y73.212 E0.00481

G1 X81.577 Y73.124 E0.00361

G1 X81.518 Y72.979 E0.00407

G1 X81.475 Y72.659 E0.00841

G1 X81.470 Y71.126 E0.03996

G1 X81.511 Y70.899 E0.00601

G1 X81.641 Y70.733 E0.00548

M204 S1250

G1 X81.756 Y70.731 F9000.000

G1 X82.883 Y71.208

M204 S1000

G1 F4800.000

G1 X82.021 Y72.070 E0.03261

M204 S1250

G1 X83.264 Y71.439 F9000.000

G1 F2400.000

G1 X83.742 Y71.309 E0.00385

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.264 Y71.439 E-0.27449

G1 E-0.68551 F4200.00000

G1 Z11.050 F9000.000

G1 X82.699 Y77.210

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.594 Y76.624 E0.02786

G1 X84.598 Y76.018 E0.03055

G1 X85.651 Y75.516 E0.03040

G1 X86.349 Y75.286 E0.01912

G1 X86.785 Y75.192 E0.01163

G1 X87.209 Y75.165 E0.01108

G1 X87.978 Y75.265 E0.02021

G1 X88.268 Y75.334 E0.00776

G1 X88.453 Y75.433 E0.00547

G1 X88.707 Y75.502 E0.00687

G1 X89.365 Y75.752 E0.01834

G1 X90.067 Y76.125 E0.02070

G1 X91.267 Y76.866 E0.03676

G1 X91.800 Y77.219 E0.01664

G1 X88.410 Y77.218 E0.08834

G1 X85.074 Y77.180 E0.08693

G1 X82.759 Y77.209 E0.06031

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.594 Y76.624 E-0.56485

G1 X84.131 Y76.301 E-0.34715

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.594 Y77.390

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.627 Y77.549 E0.00423

G1 X92.436 Y77.637 E0.00549

G1 X88.407 Y77.636 E0.10496

G1 X85.074 Y77.598 E0.08686

G1 X82.024 Y77.636 E0.07946

G1 X81.883 Y77.600 E0.00381

G1 X81.867 Y77.459 E0.00370

G1 X81.975 Y77.264 E0.00580

G1 X82.209 Y77.031 E0.00859

G1 X83.372 Y76.270 E0.03622

G1 X84.400 Y75.650 E0.03128

G1 X85.495 Y75.127 E0.03163

G1 X86.239 Y74.883 E0.02039

G1 X86.727 Y74.777 E0.01302

G1 X87.223 Y74.745 E0.01295

G1 X88.054 Y74.853 E0.02183

G1 X88.418 Y74.940 E0.00975

G1 X88.608 Y75.042 E0.00564

G1 X88.836 Y75.104 E0.00615

G1 X89.538 Y75.371 E0.01957

G1 X90.275 Y75.762 E0.02174

G1 X91.492 Y76.514 E0.03727

G1 X92.077 Y76.901 E0.01826

G1 X92.452 Y77.201 E0.01252

G1 X92.558 Y77.342 E0.00459

M204 S1250

G1 X92.497 Y77.520 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.627 Y77.549 E-0.12092

G1 X92.436 Y77.637 E-0.11679

G1 X91.219 Y77.636 E-0.67429

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X85.434 Y75.759

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.316 Y76.876 E0.04194

G1 X84.925 Y76.869 E0.01617

G1 X86.094 Y75.700 E0.04385

G1 X86.431 Y75.589 E0.00941

G1 X86.897 Y75.499 E0.01260

G1 X85.524 Y76.872 E0.05153

G1 X86.119 Y76.879 E0.01579

G1 X87.481 Y75.516 E0.05113

G1 X88.006 Y75.594 E0.01407

G1 X86.714 Y76.885 E0.04848

G1 X87.309 Y76.892 E0.01579

G1 X88.445 Y75.756 E0.04264

G1 X88.895 Y75.908 E0.01259

G1 X87.904 Y76.899 E0.03717

G1 X88.500 Y76.904 E0.01582

G1 X89.321 Y76.083 E0.03081

G1 X89.714 Y76.292 E0.01181

G1 X89.102 Y76.905 E0.02298

G1 X89.704 Y76.905 E0.01597

G1 X90.097 Y76.512 E0.01475

G1 X90.469 Y76.741 E0.01160

G1 X90.117 Y77.093 E0.01319

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X90.097 Y76.512 E-0.24230

G1 X89.704 Y76.905 E-0.30807

G1 X89.548 Y76.905 E-0.08626

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.526 Y72.669

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.485 Y71.409 E0.06247

G1 X89.854 Y71.074 E0.01864

G1 X92.578 Y71.077 E0.07099

G1 X92.598 Y71.189 E0.00296

G1 X92.583 Y72.614 E0.03714

G1 X92.565 Y72.665 E0.00140

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.156 Y71.814 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.829 Y70.697

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.888 Y70.741 E0.00192

G1 X92.972 Y70.905 E0.00482

G1 X93.016 Y71.155 E0.00659

G1 X93.000 Y72.688 E0.03996

G1 X92.971 Y72.771 E0.00229

G1 X92.920 Y73.106 E0.00882

G1 X92.853 Y73.184 E0.00268

G1 X92.714 Y73.212 E0.00369

G1 X92.329 Y73.038 E0.01100

G1 X90.278 Y71.772 E0.06282

G1 X89.261 Y71.233 E0.02999

G1 X88.817 Y70.912 E0.01425

G1 X88.697 Y70.719 E0.00594

G1 X88.827 Y70.667 E0.00366

G1 X88.953 Y70.655 E0.00328

G1 X92.707 Y70.659 E0.09781

G1 X92.771 Y70.679 E0.00177

M204 S1250

G1 X92.836 Y70.770 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y70.741 E-0.07301

G1 X92.972 Y70.905 E-0.10252

G1 X93.016 Y71.155 E-0.14024

G1 X93.005 Y72.230 E-0.59623

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.331 Y71.781

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.723 Y71.389 E0.01734

G1 X92.282 Y71.390 E0.01750

G1 X92.281 Y71.540 E0.00470

G1 X91.770 Y72.051 E0.02260

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.281 Y71.540 E-0.40051

G1 X92.282 Y71.390 E-0.08327

G1 X91.723 Y71.389 E-0.31018

G1 X91.572 Y71.540 E-0.11804

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.578 Y84.074

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y84.187 E0.00297

G1 X92.583 Y85.611 E0.03711

G1 X92.562 Y85.682 E0.00193

G1 X92.151 Y85.449 E0.01230

G1 X90.487 Y84.408 E0.05114

G1 X89.853 Y84.072 E0.01870

G1 X92.518 Y84.074 E0.06944

M204 S1250

G1 X92.829 Y83.695 F9000.000

M204 S800

G1 F1500.000

G1 X92.888 Y83.739 E0.00192

G1 X92.972 Y83.903 E0.00482

G1 X93.016 Y84.153 E0.00659

G1 X93.000 Y85.685 E0.03994

G1 X92.971 Y85.768 E0.00229

G1 X92.920 Y86.103 E0.00884

G1 X92.853 Y86.182 E0.00269

G1 X92.714 Y86.210 E0.00368

G1 X92.327 Y86.034 E0.01109

G1 X90.278 Y84.770 E0.06272

G1 X89.261 Y84.231 E0.03001

G1 X88.817 Y83.910 E0.01425

G1 X88.696 Y83.716 E0.00596

G1 X88.827 Y83.665 E0.00366

G1 X88.952 Y83.653 E0.00327

G1 X92.706 Y83.657 E0.09782

G1 X92.771 Y83.677 E0.00177

M204 S1250

G1 X92.836 Y83.769 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y83.739 E-0.07320

G1 X92.972 Y83.903 E-0.10252

G1 X93.016 Y84.153 E-0.14024

G1 X93.005 Y85.228 E-0.59605

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.336 Y84.792

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.741 Y84.387 E0.01790

G1 X92.282 Y84.387 E0.01692

G1 X92.281 Y84.557 E0.00529

G1 X91.773 Y85.065 E0.02247

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X92.282 Y84.387 E-0.09371

G1 X91.741 Y84.387 E-0.29989

G1 X91.588 Y84.540 E-0.12016

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.800 Y90.217

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.410 Y90.216 E0.08834

G1 X85.074 Y90.178 E0.08692

G1 X82.700 Y90.207 E0.06185

G1 X83.594 Y89.621 E0.02785

G1 X84.598 Y89.016 E0.03055

G1 X85.651 Y88.514 E0.03039

G1 X86.349 Y88.284 E0.01913

G1 X86.785 Y88.190 E0.01163

G1 X87.209 Y88.163 E0.01108

G1 X87.975 Y88.262 E0.02011

G1 X88.304 Y88.345 E0.00884

G1 X88.431 Y88.425 E0.00392

G1 X88.707 Y88.499 E0.00745

G1 X89.365 Y88.750 E0.01834

G1 X90.067 Y89.123 E0.02071

G1 X91.750 Y90.183 E0.05183

M204 S1250

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M204 S800

G1 F1500.000

G1 X92.627 Y90.546 E0.00422

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G1 X88.407 Y90.634 E0.10496

G1 X85.074 Y90.596 E0.08686

G1 X82.024 Y90.633 E0.07947

G1 X81.883 Y90.598 E0.00380

G1 X81.867 Y90.457 E0.00370

G1 X81.975 Y90.262 E0.00580

G1 X82.209 Y90.029 E0.00860

G1 X83.372 Y89.268 E0.03623

G1 X84.400 Y88.647 E0.03128

G1 X85.495 Y88.125 E0.03162

G1 X86.239 Y87.881 E0.02039

G1 X86.727 Y87.775 E0.01302

G1 X87.223 Y87.743 E0.01295

G1 X88.052 Y87.851 E0.02180

G1 X88.470 Y87.955 E0.01121

G1 X88.601 Y88.038 E0.00403

G1 X88.836 Y88.101 E0.00636

G1 X89.538 Y88.369 E0.01957

G1 X90.275 Y88.760 E0.02174

G1 X91.492 Y89.512 E0.03727

G1 X92.077 Y89.899 E0.01826

G1 X92.452 Y90.199 E0.01252

G1 X92.558 Y90.340 E0.00459

M204 S1250

G1 X92.497 Y90.518 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X92.435 Y90.635 E-0.11702

G1 X91.219 Y90.634 E-0.67432

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X85.433 Y88.756

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

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G1 X84.925 Y89.866 E0.01617

G1 X86.093 Y88.698 E0.04384

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G1 X86.897 Y88.497 E0.01259

G1 X85.524 Y89.869 E0.05152

G1 X86.119 Y89.876 E0.01579

G1 X87.481 Y88.514 E0.05113

G1 X88.004 Y88.593 E0.01404

G1 X86.714 Y89.883 E0.04842

G1 X87.309 Y89.890 E0.01579

G1 X88.446 Y88.753 E0.04265

G1 X88.895 Y88.906 E0.01259

G1 X87.904 Y89.897 E0.03718

G1 X88.500 Y89.902 E0.01582

G1 X89.321 Y89.081 E0.03082

G1 X89.714 Y89.290 E0.01181

G1 X89.102 Y89.903 E0.02298

G1 X89.704 Y89.903 E0.01597

G1 X90.097 Y89.510 E0.01475

G1 X90.469 Y89.739 E0.01160

G1 X90.117 Y90.091 E0.01319

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

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G1 X89.704 Y89.903 E-0.30810

G1 X89.548 Y89.903 E-0.08621

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X84.641 Y84.079

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

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G1 X82.263 Y85.489 E0.04460

G1 X81.901 Y85.688 E0.01076

G1 X81.888 Y84.160 E0.03980

G1 X81.902 Y84.082 E0.00208

G1 X84.581 Y84.079 E0.06979

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.716 Y84.584 E-0.55468

G1 X83.169 Y84.925 E-0.35732

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X81.678 Y83.684

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.766 Y83.664 E0.00236

G1 X85.592 Y83.661 E0.09969

G1 X85.748 Y83.686 E0.00413

G1 X85.653 Y83.907 E0.00625

G1 X85.395 Y84.119 E0.00870

G1 X84.953 Y84.384 E0.01343

G1 X83.927 Y84.945 E0.03048

G1 X82.474 Y85.850 E0.04459

G1 X81.867 Y86.184 E0.01807

G1 X81.684 Y86.210 E0.00481

G1 X81.577 Y86.121 E0.00361

G1 X81.518 Y85.976 E0.00408

G1 X81.475 Y85.657 E0.00839

G1 X81.470 Y84.123 E0.03996

G1 X81.511 Y83.896 E0.00602

G1 X81.641 Y83.731 E0.00547

M204 S1250

G1 X81.756 Y83.729 F9000.000

G1 X82.882 Y84.206

M204 S1000

G1 F4800.000

G1 X82.021 Y85.067 E0.03258

M204 S1250

G1 X83.263 Y84.437 F9000.000

G1 F2400.000

G1 X83.741 Y84.307 E0.00383

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.263 Y84.437 E-0.27436

G1 E-0.68564 F4200.00000

G1 Z11.050 F9000.000

G1 X84.642 Y97.076

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.716 Y97.582 E0.02749

G1 X82.263 Y98.487 E0.04460

G1 X81.901 Y98.686 E0.01076

G1 X81.888 Y97.158 E0.03980

G1 X81.902 Y97.079 E0.00210

G1 X84.582 Y97.076 E0.06983

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.716 Y97.582 E-0.55575

G1 X83.171 Y97.922 E-0.35625

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X81.678 Y96.681

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.766 Y96.661 E0.00235

G1 X85.592 Y96.658 E0.09969

G1 X85.748 Y96.684 E0.00414

G1 X85.653 Y96.905 E0.00626

G1 X85.395 Y97.116 E0.00868

G1 X84.953 Y97.383 E0.01345

G1 X83.927 Y97.943 E0.03047

G1 X82.474 Y98.847 E0.04459

G1 X81.867 Y99.182 E0.01807

G1 X81.684 Y99.208 E0.00481

G1 X81.577 Y99.119 E0.00361

G1 X81.518 Y98.974 E0.00408

G1 X81.475 Y98.655 E0.00839

G1 X81.470 Y97.121 E0.03996

G1 X81.511 Y96.894 E0.00602

G1 X81.641 Y96.728 E0.00548

M204 S1250

G1 X81.756 Y96.726 F9000.000

G1 X82.883 Y97.203

M204 S1000

G1 F4800.000

G1 X82.021 Y98.065 E0.03263

M204 S1250

G1 X83.264 Y97.434 F9000.000

G1 F2400.000

G1 X83.743 Y97.304 E0.00386

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.264 Y97.434 E-0.27458

G1 E-0.68542 F4200.00000

G1 Z11.050 F9000.000

G1 X82.700 Y103.205

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.594 Y102.619 E0.02785

G1 X84.598 Y102.014 E0.03055

G1 X85.651 Y101.512 E0.03039

G1 X86.349 Y101.282 E0.01914

G1 X86.785 Y101.187 E0.01163

G1 X87.209 Y101.161 E0.01106

G1 X87.975 Y101.261 E0.02014

G1 X88.303 Y101.342 E0.00879

G1 X88.430 Y101.423 E0.00392

G1 X88.707 Y101.497 E0.00749

G1 X89.365 Y101.748 E0.01834

G1 X90.067 Y102.121 E0.02071

G1 X91.267 Y102.862 E0.03676

G1 X91.800 Y103.214 E0.01663

G1 X88.410 Y103.213 E0.08833

G1 X85.074 Y103.176 E0.08693

G1 X82.760 Y103.204 E0.06028

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.594 Y102.619 E-0.56452

G1 X84.131 Y102.295 E-0.34748

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.594 Y103.386

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.627 Y103.544 E0.00422

G1 X92.435 Y103.633 E0.00550

G1 X88.407 Y103.631 E0.10496

G1 X85.074 Y103.594 E0.08686

G1 X82.025 Y103.631 E0.07946

G1 X81.883 Y103.596 E0.00382

G1 X81.867 Y103.455 E0.00368

G1 X81.975 Y103.259 E0.00582

G1 X82.209 Y103.027 E0.00858

G1 X83.372 Y102.266 E0.03624

G1 X84.400 Y101.645 E0.03128

G1 X85.495 Y101.123 E0.03162

G1 X86.239 Y100.879 E0.02039

G1 X86.727 Y100.772 E0.01302

G1 X87.223 Y100.741 E0.01294

G1 X88.053 Y100.849 E0.02180

G1 X88.470 Y100.953 E0.01119

G1 X88.600 Y101.036 E0.00404

G1 X88.836 Y101.099 E0.00637

G1 X89.538 Y101.367 E0.01957

G1 X90.275 Y101.758 E0.02174

G1 X91.492 Y102.510 E0.03727

G1 X92.077 Y102.897 E0.01827

G1 X92.452 Y103.196 E0.01250

G1 X92.558 Y103.337 E0.00460

M204 S1250

G1 X92.497 Y103.516 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.627 Y103.544 E-0.12076

G1 X92.435 Y103.633 E-0.11700

G1 X91.219 Y103.632 E-0.67424

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X85.433 Y101.754

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.316 Y102.872 E0.04192

G1 X84.925 Y102.864 E0.01617

G1 X86.093 Y101.696 E0.04383

G1 X86.432 Y101.585 E0.00945

G1 X86.897 Y101.494 E0.01258

G1 X85.524 Y102.867 E0.05153

G1 X86.119 Y102.874 E0.01579

G1 X87.481 Y101.512 E0.05111

G1 X88.004 Y101.591 E0.01404

G1 X86.714 Y102.881 E0.04841

G1 X87.309 Y102.887 E0.01579

G1 X88.445 Y101.751 E0.04263

G1 X88.894 Y101.904 E0.01259

G1 X87.904 Y102.894 E0.03715

G1 X88.500 Y102.900 E0.01582

G1 X89.321 Y102.079 E0.03079

G1 X89.714 Y102.288 E0.01181

G1 X89.102 Y102.900 E0.02296

G1 X89.703 Y102.900 E0.01596

G1 X90.096 Y102.507 E0.01474

G1 X90.468 Y102.737 E0.01160

G1 X90.117 Y103.088 E0.01318

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.468 Y102.737 E-0.27524

G1 X90.096 Y102.507 E-0.24228

G1 X89.703 Y102.900 E-0.30787

G1 X89.547 Y102.900 E-0.08661

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.518 Y98.660

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.487 Y97.406 E0.06218

G1 X89.853 Y97.069 E0.01872

G1 X92.578 Y97.072 E0.07100

G1 X92.598 Y97.184 E0.00295

G1 X92.583 Y98.609 E0.03714

G1 X92.563 Y98.668 E0.00162

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.157 Y97.813 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.829 Y96.693

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.888 Y96.737 E0.00192

G1 X92.972 Y96.901 E0.00482

G1 X93.016 Y97.150 E0.00657

G1 X93.000 Y98.683 E0.03996

G1 X92.971 Y98.766 E0.00229

G1 X92.920 Y99.101 E0.00884

G1 X92.853 Y99.180 E0.00269

G1 X92.714 Y99.208 E0.00368

G1 X92.327 Y99.032 E0.01109

G1 X90.278 Y97.768 E0.06271

G1 X89.261 Y97.228 E0.03003

G1 X88.817 Y96.908 E0.01425

G1 X88.696 Y96.714 E0.00594

G1 X88.828 Y96.662 E0.00368

G1 X88.953 Y96.650 E0.00328

G1 X92.706 Y96.655 E0.09780

G1 X92.771 Y96.675 E0.00177

M204 S1250

G1 X92.836 Y96.767 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y96.737 E-0.07320

G1 X92.972 Y96.901 E-0.10255

G1 X93.016 Y97.150 E-0.13969

G1 X93.005 Y98.226 E-0.59656

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.336 Y97.790

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.741 Y97.385 E0.01791

G1 X92.282 Y97.385 E0.01691

G1 X92.281 Y97.555 E0.00529

G1 X91.773 Y98.063 E0.02247

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.281 Y97.555 E-0.39824

G1 X92.282 Y97.385 E-0.09377

G1 X91.741 Y97.385 E-0.29976

G1 X91.588 Y97.538 E-0.12023

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X92.578 Y110.070

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.598 Y110.182 E0.00295

G1 X92.583 Y111.607 E0.03713

G1 X92.562 Y111.678 E0.00193

G1 X90.486 Y110.403 E0.06347

G1 X89.853 Y110.067 E0.01866

G1 X92.518 Y110.070 E0.06944

M204 S1250

G1 X92.828 Y109.691 F9000.000

M204 S800

G1 F1500.000

G1 X92.888 Y109.734 E0.00192

G1 X92.972 Y109.899 E0.00483

G1 X93.016 Y110.148 E0.00657

G1 X93.000 Y111.681 E0.03996

G1 X92.971 Y111.764 E0.00229

G1 X92.920 Y112.099 E0.00883

G1 X92.853 Y112.178 E0.00270

G1 X92.715 Y112.205 E0.00366

G1 X92.329 Y112.032 E0.01101

G1 X90.278 Y110.766 E0.06281

G1 X89.261 Y110.226 E0.03000

G1 X88.817 Y109.905 E0.01425

G1 X88.697 Y109.712 E0.00593

G1 X88.828 Y109.660 E0.00367

G1 X88.953 Y109.648 E0.00328

G1 X92.707 Y109.653 E0.09781

G1 X92.771 Y109.673 E0.00176

M204 S1250

G1 X92.836 Y109.764 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.888 Y109.734 E-0.07318

G1 X92.972 Y109.899 E-0.10272

G1 X93.016 Y110.148 E-0.13970

G1 X93.005 Y111.224 E-0.59641

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.330 Y110.775

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.723 Y110.383 E0.01734

G1 X92.282 Y110.383 E0.01750

G1 X92.281 Y110.534 E0.00470

G1 X91.770 Y111.045 E0.02260

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.281 Y110.534 E-0.40060

G1 X92.282 Y110.383 E-0.08323

G1 X91.723 Y110.383 E-0.31018

G1 X91.572 Y110.533 E-0.11799

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X91.800 Y116.212

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.410 Y116.211 E0.08833

G1 X85.074 Y116.173 E0.08693

G1 X82.700 Y116.203 E0.06184

G1 X83.594 Y115.617 E0.02785

G1 X84.598 Y115.012 E0.03054

G1 X85.651 Y114.509 E0.03039

G1 X86.349 Y114.280 E0.01913

G1 X86.785 Y114.185 E0.01163

G1 X87.209 Y114.158 E0.01107

G1 X87.975 Y114.258 E0.02012

G1 X88.302 Y114.339 E0.00879

G1 X88.430 Y114.421 E0.00396

G1 X88.708 Y114.495 E0.00748

G1 X89.365 Y114.746 E0.01833

G1 X90.067 Y115.118 E0.02070

G1 X91.750 Y116.179 E0.05183

M204 S1250

G1 X92.594 Y116.383 F9000.000

M204 S800

G1 F1500.000

G1 X92.627 Y116.542 E0.00422

G1 X92.435 Y116.631 E0.00550

G1 X88.407 Y116.629 E0.10496

G1 X85.074 Y116.591 E0.08686

G1 X82.025 Y116.629 E0.07946

G1 X81.883 Y116.594 E0.00381

G1 X81.867 Y116.452 E0.00370

G1 X81.975 Y116.257 E0.00580

G1 X82.209 Y116.025 E0.00858

G1 X83.372 Y115.263 E0.03624

G1 X84.400 Y114.643 E0.03128

G1 X85.495 Y114.121 E0.03162

G1 X86.239 Y113.877 E0.02039

G1 X86.727 Y113.770 E0.01302

G1 X87.223 Y113.739 E0.01295

G1 X88.053 Y113.847 E0.02180

G1 X88.470 Y113.950 E0.01120

G1 X88.601 Y114.034 E0.00405

G1 X88.837 Y114.097 E0.00636

G1 X89.538 Y114.365 E0.01957

G1 X90.275 Y114.755 E0.02173

G1 X91.492 Y115.508 E0.03728

G1 X92.077 Y115.895 E0.01827

G1 X92.452 Y116.194 E0.01250

G1 X92.558 Y116.335 E0.00460

M204 S1250

G1 X92.497 Y116.514 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.627 Y116.542 E-0.12081

G1 X92.435 Y116.631 E-0.11699

G1 X91.219 Y116.630 E-0.67420

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X85.433 Y114.752

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.316 Y115.869 E0.04192

G1 X84.926 Y115.862 E0.01617

G1 X86.093 Y114.694 E0.04382

G1 X86.431 Y114.583 E0.00944

G1 X86.897 Y114.492 E0.01259

G1 X85.524 Y115.865 E0.05151

G1 X86.119 Y115.872 E0.01579

G1 X87.481 Y114.510 E0.05111

G1 X88.004 Y114.588 E0.01404

G1 X86.714 Y115.878 E0.04842

G1 X87.309 Y115.885 E0.01579

G1 X88.445 Y114.749 E0.04262

G1 X88.895 Y114.902 E0.01259

G1 X87.905 Y115.892 E0.03716

G1 X88.501 Y115.897 E0.01582

G1 X89.321 Y115.077 E0.03079

G1 X89.714 Y115.286 E0.01181

G1 X89.102 Y115.898 E0.02297

G1 X89.704 Y115.898 E0.01596

G1 X90.097 Y115.505 E0.01475

G1 X90.469 Y115.735 E0.01160

G1 X90.117 Y116.086 E0.01319

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.469 Y115.735 E-0.27534

G1 X90.097 Y115.505 E-0.24227

G1 X89.704 Y115.898 E-0.30810

G1 X89.548 Y115.898 E-0.08629

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X84.642 Y110.074

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.717 Y110.580 E0.02748

G1 X82.263 Y111.484 E0.04461

G1 X81.901 Y111.683 E0.01076

G1 X81.888 Y110.156 E0.03979

G1 X81.902 Y110.077 E0.00210

G1 X84.582 Y110.074 E0.06983

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.717 Y110.580 E-0.55554

G1 X83.170 Y110.920 E-0.35646

G1 E-0.04800 F4200.00000

G1 Z11.050 F9000.000

G1 X81.678 Y109.679

G1 Z10.850

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.766 Y109.659 E0.00235

G1 X85.592 Y109.656 E0.09969

G1 X85.749 Y109.681 E0.00413

G1 X85.653 Y109.902 E0.00626

G1 X85.395 Y110.114 E0.00870

G1 X84.953 Y110.380 E0.01345

G1 X83.927 Y110.941 E0.03046

G1 X82.474 Y111.845 E0.04459

G1 X81.867 Y112.179 E0.01807

G1 X81.683 Y112.205 E0.00484

G1 X81.577 Y112.117 E0.00358

G1 X81.518 Y111.972 E0.00408

G1 X81.475 Y111.653 E0.00840

G1 X81.470 Y110.119 E0.03995

G1 X81.511 Y109.892 E0.00602

G1 X81.641 Y109.726 E0.00549

M204 S1250

G1 X81.756 Y109.724 F9000.000

G1 X82.883 Y110.201

M204 S1000

G1 F4800.000

G1 X82.021 Y111.063 E0.03260

M204 S1250

G1 X83.264 Y110.432 F9000.000

G1 F2400.000

G1 X83.742 Y110.302 E0.00385

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;11

G1 Z11.000 F9000.000

;AFTER\_LAYER\_CHANGE

;11

G1 X84.374 Y110.212

M204 S800

G1 F1500.000

G1 X83.717 Y110.579 E0.01960

G1 X81.889 Y111.723 E0.05621

G1 X81.904 Y110.223 E0.03909

G1 X84.314 Y110.212 E0.06278

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.717 Y110.579 E-0.38803

G1 X82.916 Y111.080 E-0.52397

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X81.615 Y109.859

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y109.831 E0.00117

G1 X81.765 Y109.806 E0.00307

G1 X85.275 Y109.790 E0.09145

G1 X85.412 Y109.837 E0.00378

G1 X85.442 Y109.882 E0.00140

G1 X85.370 Y109.998 E0.00355

G1 X85.068 Y110.274 E0.01068

G1 X84.644 Y110.539 E0.01301

G1 X83.930 Y110.938 E0.02132

G1 X81.891 Y112.215 E0.06270

G1 X81.798 Y112.252 E0.00259

G1 X81.678 Y112.252 E0.00315

G1 X81.544 Y112.162 E0.00421

G1 X81.500 Y112.089 E0.00223

G1 X81.471 Y111.916 E0.00456

G1 X81.474 Y110.251 E0.04339

G1 X81.517 Y110.024 E0.00600

G1 X81.585 Y109.911 E0.00345

M204 S1250

G1 X81.660 Y109.867 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.650 Y109.831 E-0.05726

G1 X81.765 Y109.806 E-0.06521

G1 X83.190 Y109.799 E-0.78953

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X83.041 Y110.854

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y110.533 E0.01285

G1 X82.214 Y110.535 E0.01426

G1 X82.213 Y110.668 E0.00375

G1 X82.646 Y111.101 E0.01732

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.213 Y110.668 E-0.33959

G1 X82.214 Y110.535 E-0.07349

G1 X82.719 Y110.533 E-0.27963

G1 X82.999 Y110.813 E-0.21929

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X82.904 Y116.060

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.644 Y114.991 E0.05320

G1 X85.617 Y114.484 E0.02860

G1 X86.162 Y114.265 E0.01528

G1 X86.830 Y114.090 E0.01801

G1 X87.218 Y114.075 E0.01010

G1 X87.270 Y114.056 E0.00144

G1 X87.766 Y114.107 E0.01301

G1 X87.993 Y114.197 E0.00637

G1 X88.239 Y114.258 E0.00659

G1 X88.828 Y114.466 E0.01628

G1 X89.227 Y114.652 E0.01148

G1 X90.046 Y115.106 E0.02438

G1 X91.581 Y116.068 E0.04722

G1 X87.968 Y116.056 E0.09414

G1 X85.072 Y116.023 E0.07546

G1 X82.964 Y116.059 E0.05493

M204 S1250

G1 X82.220 Y116.490 F9000.000

M204 S800

G1 F1500.000

G1 X82.085 Y116.447 E0.00368

G1 X82.071 Y116.346 E0.00267

G1 X82.177 Y116.142 E0.00598

G1 X82.382 Y115.934 E0.00763

G1 X82.661 Y115.720 E0.00914

G1 X83.145 Y115.407 E0.01501

G1 X84.439 Y114.626 E0.03939

G1 X85.443 Y114.104 E0.02947

G1 X86.030 Y113.868 E0.01650

G1 X86.768 Y113.674 E0.01989

G1 X87.135 Y113.660 E0.00956

G1 X87.196 Y113.638 E0.00168

G1 X87.405 Y113.638 E0.00545

G1 X87.872 Y113.700 E0.01228

G1 X88.121 Y113.799 E0.00698

G1 X88.359 Y113.857 E0.00639

G1 X88.986 Y114.079 E0.01734

G1 X89.417 Y114.280 E0.01238

G1 X90.257 Y114.745 E0.02503

G1 X91.828 Y115.731 E0.04832

G1 X92.194 Y116.015 E0.01208

G1 X92.403 Y116.313 E0.00948

G1 X92.407 Y116.409 E0.00250

G1 X92.241 Y116.489 E0.00480

G1 X87.965 Y116.474 E0.11142

G1 X85.073 Y116.441 E0.07535

G1 X82.280 Y116.489 E0.07279

M204 S1250

G1 X82.176 Y116.355 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.085 Y116.447 E-0.11037

G1 X82.071 Y116.346 E-0.05671

G1 X82.177 Y116.142 E-0.12721

G1 X82.382 Y115.934 E-0.16219

G1 X82.661 Y115.720 E-0.19448

G1 X83.056 Y115.465 E-0.26104

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X90.137 Y115.938

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.186 Y114.987 E0.03590

G1 X88.709 Y114.757 E0.01414

G1 X88.153 Y114.560 E0.01577

G1 X89.340 Y115.747 E0.04485

G1 X88.733 Y115.745 E0.01622

G1 X87.359 Y114.371 E0.05189

G1 X86.880 Y114.401 E0.01281

G1 X86.803 Y114.421 E0.00213

G1 X88.125 Y115.743 E0.04993

G1 X87.514 Y115.738 E0.01632

G1 X86.323 Y114.547 E0.04496

G1 X85.885 Y114.714 E0.01252

G1 X86.902 Y115.731 E0.03838

G1 X86.289 Y115.724 E0.01635

G1 X85.476 Y114.911 E0.03070

G1 X85.078 Y115.118 E0.01199

G1 X85.677 Y115.717 E0.02261

G1 X85.065 Y115.710 E0.01635

G1 X84.687 Y115.332 E0.01427

G1 X84.312 Y115.563 E0.01175

G1 X84.654 Y115.905 E0.01293

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.312 Y115.563 E-0.26835

G1 X84.687 Y115.332 E-0.24392

G1 X85.065 Y115.710 E-0.29617

G1 X85.252 Y115.712 E-0.10356

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X90.102 Y110.208

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.576 Y110.204 E0.06446

G1 X92.594 Y110.298 E0.00248

G1 X92.590 Y111.726 E0.03721

G1 X91.039 Y110.741 E0.04787

G1 X90.537 Y110.436 E0.01531

G1 X90.155 Y110.235 E0.01124

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y110.214 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X92.710 Y112.258

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y112.224 E0.00314

G1 X90.819 Y111.096 E0.05481

G1 X90.331 Y110.800 E0.01487

G1 X89.770 Y110.505 E0.01651

G1 X89.534 Y110.334 E0.00761

G1 X89.449 Y110.295 E0.00243

G1 X89.200 Y110.091 E0.00839

G1 X89.032 Y109.848 E0.00770

G1 X89.192 Y109.791 E0.00444

G1 X92.705 Y109.786 E0.09153

G1 X92.821 Y109.825 E0.00317

G1 X92.962 Y110.017 E0.00621

G1 X93.012 Y110.258 E0.00641

G1 X93.007 Y111.957 E0.04428

G1 X92.981 Y112.090 E0.00354

G1 X92.905 Y112.201 E0.00350

G1 X92.768 Y112.244 E0.00374

M204 S1250

G1 X92.651 Y112.153 F9000.000

G1 X92.466 Y111.349

M204 S1000

G1 F4800.000

G1 X91.590 Y110.472 E0.03875

M204 S1250

G1 X91.433 Y110.564 F9000.000

G1 F2400.000

G1 X90.976 Y110.434 E0.00477

G1 X89.903 Y110.141 F9000.000

G1 F2400.000

G1 X89.438 Y110.016 E0.00507

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.903 Y110.141 E-0.26683

G1 E-0.69317 F4200.00000

G1 Z11.200 F9000.000

G1 X92.590 Y98.729

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X91.039 Y97.743 E0.04788

G1 X90.537 Y97.438 E0.01532

G1 X90.102 Y97.210 E0.01280

G1 X92.576 Y97.206 E0.06446

G1 X92.594 Y97.300 E0.00248

G1 X92.590 Y98.669 E0.03567

M204 S1250

G1 X92.981 Y99.093 F9000.000

M204 S800

G1 F1500.000

G1 X92.889 Y99.217 E0.00403

G1 X92.710 Y99.260 E0.00481

G1 X92.594 Y99.227 E0.00313

G1 X90.819 Y98.098 E0.05481

G1 X90.331 Y97.802 E0.01487

G1 X89.770 Y97.507 E0.01651

G1 X89.534 Y97.336 E0.00761

G1 X89.449 Y97.297 E0.00243

G1 X89.200 Y97.093 E0.00839

G1 X89.032 Y96.850 E0.00770

G1 X89.192 Y96.793 E0.00444

G1 X92.705 Y96.788 E0.09152

G1 X92.821 Y96.827 E0.00318

G1 X92.962 Y97.019 E0.00621

G1 X93.012 Y97.260 E0.00641

G1 X93.007 Y98.959 E0.04428

G1 X92.993 Y99.034 E0.00199

M204 S1250

G1 X92.827 Y99.107 F9000.000

G1 X92.466 Y98.351

M204 S1000

G1 F4800.000

G1 X91.589 Y97.474 E0.03876

M204 S1250

G1 X91.433 Y97.566 F9000.000

G1 F2400.000

G1 X90.976 Y97.436 E0.00477

G1 X89.903 Y97.143 F9000.000

G1 F2400.000

G1 X89.438 Y97.018 E0.00507

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.903 Y97.143 E-0.26684

G1 E-0.69316 F4200.00000

G1 Z11.200 F9000.000

G1 X91.581 Y103.070

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.072 Y103.026 E0.16960

G1 X82.904 Y103.062 E0.05650

G1 X84.644 Y101.993 E0.05321

G1 X85.617 Y101.487 E0.02859

G1 X86.162 Y101.268 E0.01529

G1 X86.830 Y101.092 E0.01802

G1 X87.218 Y101.077 E0.01010

G1 X87.269 Y101.058 E0.00142

G1 X87.767 Y101.109 E0.01305

G1 X87.993 Y101.199 E0.00635

G1 X88.239 Y101.260 E0.00659

G1 X88.828 Y101.468 E0.01628

G1 X89.227 Y101.654 E0.01147

G1 X90.046 Y102.108 E0.02440

G1 X91.531 Y103.037 E0.04565

M204 S1250

G1 X92.403 Y103.316 F9000.000

M204 S800

G1 F1500.000

G1 X92.407 Y103.411 E0.00248

G1 X92.241 Y103.491 E0.00480

G1 X87.965 Y103.476 E0.11142

G1 X85.073 Y103.444 E0.07535

G1 X82.220 Y103.492 E0.07435

G1 X82.085 Y103.449 E0.00369

G1 X82.071 Y103.348 E0.00265

G1 X82.177 Y103.144 E0.00600

G1 X82.382 Y102.936 E0.00762

G1 X82.661 Y102.722 E0.00914

G1 X84.439 Y101.628 E0.05440

G1 X85.442 Y101.106 E0.02947

G1 X86.030 Y100.871 E0.01650

G1 X86.768 Y100.676 E0.01989

G1 X87.135 Y100.662 E0.00956

G1 X87.195 Y100.640 E0.00167

G1 X87.405 Y100.641 E0.00546

G1 X87.872 Y100.702 E0.01228

G1 X88.121 Y100.801 E0.00697

G1 X88.359 Y100.859 E0.00639

G1 X88.986 Y101.081 E0.01734

G1 X89.417 Y101.282 E0.01238

G1 X90.257 Y101.748 E0.02504

G1 X91.828 Y102.733 E0.04831

G1 X92.194 Y103.017 E0.01208

G1 X92.369 Y103.267 E0.00794

M204 S1250

G1 X92.338 Y103.385 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.407 Y103.411 E-0.08272

G1 X92.241 Y103.491 E-0.10203

G1 X90.929 Y103.486 E-0.72725

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X84.654 Y102.908

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.311 Y102.565 E0.01293

G1 X84.686 Y102.335 E0.01175

G1 X85.064 Y102.713 E0.01427

G1 X85.673 Y102.717 E0.01626

G1 X85.077 Y102.121 E0.02250

G1 X85.476 Y101.913 E0.01198

G1 X86.283 Y102.721 E0.03048

G1 X86.892 Y102.725 E0.01627

G1 X85.884 Y101.717 E0.03805

G1 X86.322 Y101.550 E0.01251

G1 X87.502 Y102.729 E0.04453

G1 X88.111 Y102.733 E0.01627

G1 X86.801 Y101.424 E0.04944

G1 X86.880 Y101.403 E0.00217

G1 X87.357 Y101.374 E0.01275

G1 X88.721 Y102.738 E0.05147

G1 X89.330 Y102.742 E0.01627

G1 X88.149 Y101.560 E0.04459

G1 X88.709 Y101.759 E0.01587

G1 X89.180 Y101.987 E0.01397

G1 X90.129 Y102.935 E0.03581

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.180 Y101.987 E-0.74349

G1 X88.907 Y101.854 E-0.16851

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X84.374 Y97.214

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.717 Y97.581 E0.01960

G1 X81.889 Y98.725 E0.05620

G1 X81.904 Y97.226 E0.03908

G1 X84.314 Y97.214 E0.06278

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.717 Y97.581 E-0.38820

G1 X82.916 Y98.083 E-0.52379

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X81.615 Y96.861

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y96.833 E0.00116

G1 X81.765 Y96.809 E0.00307

G1 X85.275 Y96.792 E0.09145

G1 X85.412 Y96.839 E0.00378

G1 X85.442 Y96.884 E0.00140

G1 X85.370 Y97.000 E0.00357

G1 X85.068 Y97.276 E0.01066

G1 X84.644 Y97.541 E0.01302

G1 X83.930 Y97.941 E0.02133

G1 X81.891 Y99.217 E0.06269

G1 X81.798 Y99.254 E0.00259

G1 X81.677 Y99.254 E0.00316

G1 X81.612 Y99.226 E0.00186

G1 X81.544 Y99.164 E0.00238

G1 X81.500 Y99.091 E0.00223

G1 X81.471 Y98.919 E0.00455

G1 X81.474 Y97.253 E0.04341

G1 X81.517 Y97.026 E0.00600

G1 X81.585 Y96.913 E0.00344

M204 S1250

G1 X81.659 Y96.869 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.650 Y96.833 E-0.05709

G1 X81.765 Y96.809 E-0.06529

G1 X83.190 Y96.802 E-0.78962

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X83.041 Y97.857

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y97.535 E0.01285

G1 X82.214 Y97.538 E0.01428

G1 X82.213 Y97.670 E0.00374

M73 P93 R4

G1 X82.647 Y98.103 E0.01733

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.213 Y97.670 E-0.33973

G1 X82.214 Y97.538 E-0.07329

G1 X82.719 Y97.535 E-0.27985

G1 X82.999 Y97.815 E-0.21913

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X81.889 Y85.728

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.904 Y84.228 E0.03907

G1 X84.372 Y84.217 E0.06430

G1 X83.717 Y84.583 E0.01956

G1 X81.940 Y85.696 E0.05464

M204 S1250

G1 X81.798 Y86.257 F9000.000

M204 S800

G1 F1500.000

G1 X81.677 Y86.257 E0.00316

G1 X81.612 Y86.228 E0.00186

G1 X81.544 Y86.166 E0.00239

G1 X81.500 Y86.093 E0.00223

G1 X81.471 Y85.921 E0.00455

G1 X81.474 Y84.255 E0.04341

G1 X81.517 Y84.028 E0.00600

G1 X81.615 Y83.864 E0.00499

G1 X81.650 Y83.836 E0.00116

G1 X81.765 Y83.811 E0.00308

G1 X85.275 Y83.795 E0.09145

G1 X85.412 Y83.842 E0.00378

G1 X85.442 Y83.887 E0.00140

G1 X85.370 Y84.002 E0.00354

G1 X85.068 Y84.278 E0.01067

G1 X84.644 Y84.543 E0.01301

G1 X83.930 Y84.943 E0.02133

G1 X81.854 Y86.234 E0.06370

M204 S1250

G1 X81.720 Y86.164 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.677 Y86.257 E-0.09887

G1 X81.612 Y86.228 E-0.03964

G1 X81.544 Y86.166 E-0.05076

G1 X81.500 Y86.093 E-0.04739

G1 X81.471 Y85.921 E-0.09685

G1 X81.473 Y84.877 E-0.57850

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X83.040 Y84.859

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y84.538 E0.01284

G1 X82.214 Y84.540 E0.01425

G1 X82.213 Y84.673 E0.00374

G1 X82.646 Y85.106 E0.01731

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.213 Y84.673 E-0.33948

G1 X82.214 Y84.540 E-0.07342

G1 X82.719 Y84.538 E-0.27958

G1 X82.999 Y84.818 E-0.21952

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X82.904 Y90.064

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.644 Y88.995 E0.05321

G1 X85.617 Y88.489 E0.02859

G1 X86.162 Y88.270 E0.01529

G1 X86.827 Y88.094 E0.01792

G1 X87.218 Y88.079 E0.01020

G1 X87.269 Y88.060 E0.00140

G1 X87.766 Y88.111 E0.01303

G1 X87.993 Y88.202 E0.00636

G1 X88.239 Y88.262 E0.00661

G1 X88.828 Y88.470 E0.01627

G1 X89.227 Y88.656 E0.01147

G1 X90.046 Y89.110 E0.02440

G1 X91.582 Y90.073 E0.04722

G1 X87.968 Y90.061 E0.09415

G1 X85.072 Y90.028 E0.07546

G1 X82.964 Y90.063 E0.05494

M204 S1250

G1 X82.220 Y90.494 F9000.000

M204 S800

G1 F1500.000

G1 X82.085 Y90.451 E0.00367

G1 X82.071 Y90.350 E0.00266

G1 X82.177 Y90.146 E0.00600

G1 X82.382 Y89.938 E0.00763

G1 X82.661 Y89.724 E0.00914

G1 X83.145 Y89.412 E0.01500

G1 X84.439 Y88.630 E0.03940

G1 X85.442 Y88.108 E0.02947

G1 X86.030 Y87.872 E0.01650

G1 X86.764 Y87.679 E0.01979

G1 X87.135 Y87.664 E0.00967

G1 X87.195 Y87.642 E0.00167

G1 X87.405 Y87.643 E0.00546

G1 X87.872 Y87.704 E0.01228

G1 X88.121 Y87.803 E0.00698

G1 X88.359 Y87.862 E0.00639

G1 X88.986 Y88.083 E0.01733

G1 X89.417 Y88.284 E0.01238

G1 X90.257 Y88.750 E0.02504

G1 X91.828 Y89.735 E0.04831

G1 X92.194 Y90.019 E0.01208

G1 X92.403 Y90.318 E0.00950

G1 X92.407 Y90.413 E0.00248

G1 X92.241 Y90.493 E0.00480

G1 X87.965 Y90.479 E0.11142

G1 X85.073 Y90.446 E0.07535

G1 X82.280 Y90.493 E0.07280

M204 S1250

G1 X82.175 Y90.360 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.085 Y90.451 E-0.11021

G1 X82.071 Y90.350 E-0.05650

G1 X82.177 Y90.146 E-0.12753

G1 X82.382 Y89.938 E-0.16229

G1 X82.661 Y89.724 E-0.19437

G1 X83.057 Y89.469 E-0.26110

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X90.137 Y89.943

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.185 Y88.991 E0.03593

G1 X88.710 Y88.761 E0.01411

G1 X88.152 Y88.564 E0.01578

G1 X89.340 Y89.752 E0.04486

G1 X88.733 Y89.750 E0.01622

G1 X87.359 Y88.376 E0.05189

G1 X86.877 Y88.405 E0.01289

G1 X86.802 Y88.425 E0.00206

G1 X88.126 Y89.748 E0.04996

G1 X87.514 Y89.742 E0.01632

G1 X86.323 Y88.551 E0.04497

G1 X85.885 Y88.719 E0.01252

G1 X86.902 Y89.735 E0.03839

G1 X86.289 Y89.728 E0.01635

G1 X85.476 Y88.915 E0.03071

G1 X85.078 Y89.122 E0.01199

G1 X85.677 Y89.721 E0.02262

G1 X85.065 Y89.715 E0.01635

G1 X84.687 Y89.337 E0.01428

G1 X84.312 Y89.567 E0.01175

G1 X84.654 Y89.910 E0.01293

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.312 Y89.567 E-0.26844

G1 X84.687 Y89.337 E-0.24393

G1 X85.065 Y89.715 E-0.29632

G1 X85.251 Y89.717 E-0.10330

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X90.102 Y84.212

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.576 Y84.208 E0.06445

G1 X92.594 Y84.302 E0.00249

G1 X92.590 Y85.731 E0.03723

G1 X91.039 Y84.745 E0.04788

G1 X90.537 Y84.440 E0.01532

G1 X90.155 Y84.240 E0.01123

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y84.218 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X92.710 Y86.262

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.594 Y86.229 E0.00313

G1 X90.819 Y85.100 E0.05481

G1 X90.331 Y84.804 E0.01487

G1 X89.770 Y84.509 E0.01651

G1 X89.533 Y84.337 E0.00764

G1 X89.448 Y84.299 E0.00242

G1 X89.200 Y84.096 E0.00836

G1 X89.031 Y83.852 E0.00772

G1 X89.192 Y83.795 E0.00444

G1 X92.705 Y83.790 E0.09153

G1 X92.821 Y83.829 E0.00318

G1 X92.962 Y84.021 E0.00621

G1 X93.012 Y84.262 E0.00642

G1 X93.007 Y85.961 E0.04427

G1 X92.981 Y86.095 E0.00355

G1 X92.906 Y86.205 E0.00348

G1 X92.768 Y86.248 E0.00376

M204 S1250

G1 X92.650 Y86.158 F9000.000

G1 X92.466 Y85.353

M204 S1000

G1 F4800.000

G1 X91.589 Y84.476 E0.03875

M204 S1250

G1 X91.433 Y84.568 F9000.000

G1 F2400.000

G1 X90.976 Y84.438 E0.00476

G1 X89.904 Y84.145 F9000.000

G1 F2400.000

G1 X89.438 Y84.021 E0.00503

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.904 Y84.145 E-0.26733

G1 E-0.69267 F4200.00000

G1 Z11.200 F9000.000

G1 X92.590 Y72.733

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X91.040 Y71.748 E0.04787

G1 X90.537 Y71.442 E0.01533

G1 X90.103 Y71.215 E0.01277

G1 X92.576 Y71.211 E0.06444

G1 X92.594 Y71.304 E0.00247

G1 X92.590 Y72.673 E0.03566

M204 S1250

G1 X92.981 Y73.097 F9000.000

M204 S800

G1 F1500.000

G1 X92.890 Y73.221 E0.00401

G1 X92.710 Y73.264 E0.00483

G1 X92.594 Y73.231 E0.00313

G1 X90.819 Y72.102 E0.05480

G1 X90.331 Y71.806 E0.01488

G1 X89.770 Y71.512 E0.01650

G1 X89.533 Y71.340 E0.00763

G1 X89.448 Y71.302 E0.00243

G1 X89.200 Y71.098 E0.00838

G1 X89.032 Y70.854 E0.00771

G1 X89.192 Y70.798 E0.00443

G1 X92.705 Y70.793 E0.09154

G1 X92.821 Y70.831 E0.00316

G1 X92.962 Y71.023 E0.00620

G1 X93.012 Y71.264 E0.00642

G1 X93.007 Y72.964 E0.04429

G1 X92.993 Y73.038 E0.00197

M204 S1250

G1 X92.828 Y73.111 F9000.000

G1 X92.466 Y72.356

M204 S1000

G1 F4800.000

G1 X91.590 Y71.480 E0.03873

M204 S1250

G1 X91.434 Y71.571 F9000.000

G1 F2400.000

G1 X90.977 Y71.441 E0.00475

G1 X89.904 Y71.148 F9000.000

G1 F2400.000

G1 X89.438 Y71.023 E0.00505

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.904 Y71.148 E-0.26727

G1 E-0.69273 F4200.00000

G1 Z11.200 F9000.000

G1 X91.583 Y77.075

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.968 Y77.063 E0.09418

G1 X85.072 Y77.030 E0.07546

G1 X82.904 Y77.066 E0.05650

G1 X84.644 Y75.998 E0.05320

G1 X85.617 Y75.490 E0.02860

G1 X86.162 Y75.272 E0.01529

G1 X86.827 Y75.096 E0.01792

G1 X87.218 Y75.081 E0.01020

G1 X87.268 Y75.062 E0.00140

G1 X87.766 Y75.113 E0.01304

G1 X87.993 Y75.204 E0.00636

G1 X88.239 Y75.264 E0.00660

G1 X88.828 Y75.473 E0.01629

G1 X89.228 Y75.658 E0.01147

G1 X90.046 Y76.112 E0.02439

G1 X91.532 Y77.042 E0.04568

M204 S1250

G1 X92.403 Y77.320 F9000.000

M204 S800

G1 F1500.000

G1 X92.407 Y77.416 E0.00249

G1 X92.241 Y77.495 E0.00480

G1 X87.965 Y77.481 E0.11142

G1 X85.074 Y77.448 E0.07535

G1 X82.220 Y77.496 E0.07437

G1 X82.085 Y77.454 E0.00366

G1 X82.071 Y77.353 E0.00267

G1 X82.177 Y77.148 E0.00600

G1 X82.382 Y76.940 E0.00762

G1 X82.661 Y76.726 E0.00914

G1 X84.439 Y75.633 E0.05439

G1 X85.443 Y75.110 E0.02948

G1 X86.030 Y74.874 E0.01650

G1 X86.764 Y74.681 E0.01979

G1 X87.135 Y74.666 E0.00967

G1 X87.195 Y74.644 E0.00167

G1 X87.405 Y74.645 E0.00546

G1 X87.872 Y74.706 E0.01228

G1 X88.121 Y74.805 E0.00698

G1 X88.359 Y74.864 E0.00639

G1 X88.986 Y75.086 E0.01734

G1 X89.417 Y75.286 E0.01237

G1 X90.257 Y75.752 E0.02503

G1 X91.828 Y76.737 E0.04831

G1 X92.194 Y77.021 E0.01208

G1 X92.369 Y77.271 E0.00794

M204 S1250

G1 X92.338 Y77.390 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.407 Y77.416 E-0.08295

G1 X92.241 Y77.495 E-0.10212

G1 X90.929 Y77.491 E-0.72693

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X84.654 Y76.912

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.312 Y76.569 E0.01294

G1 X84.687 Y76.339 E0.01176

G1 X85.065 Y76.717 E0.01428

G1 X85.677 Y76.724 E0.01635

G1 X85.078 Y76.125 E0.02263

G1 X85.476 Y75.917 E0.01199

G1 X86.290 Y76.731 E0.03072

G1 X86.902 Y76.738 E0.01635

G1 X85.885 Y75.721 E0.03841

G1 X86.323 Y75.553 E0.01253

G1 X87.515 Y76.745 E0.04499

G1 X88.126 Y76.750 E0.01632

G1 X86.803 Y75.427 E0.04997

G1 X86.877 Y75.407 E0.00205

G1 X87.359 Y75.378 E0.01290

G1 X88.734 Y76.752 E0.05190

G1 X89.341 Y76.754 E0.01622

G1 X88.153 Y75.566 E0.04487

G1 X88.710 Y75.764 E0.01578

G1 X89.186 Y75.993 E0.01411

G1 X90.137 Y76.945 E0.03593

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.186 Y75.993 E-0.74576

G1 X88.916 Y75.863 E-0.16624

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X84.372 Y71.219

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.717 Y71.586 E0.01957

G1 X81.889 Y72.730 E0.05619

G1 X81.904 Y71.230 E0.03908

G1 X84.312 Y71.219 E0.06274

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.717 Y71.586 E-0.38742

G1 X82.915 Y72.088 E-0.52458

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X81.615 Y70.866

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y70.838 E0.00117

G1 X81.765 Y70.813 E0.00307

G1 X85.275 Y70.797 E0.09145

G1 X85.412 Y70.844 E0.00378

G1 X85.442 Y70.889 E0.00140

G1 X85.370 Y71.005 E0.00353

G1 X85.068 Y71.281 E0.01067

G1 X84.645 Y71.545 E0.01300

G1 X83.930 Y71.945 E0.02134

G1 X81.891 Y73.222 E0.06268

G1 X81.798 Y73.259 E0.00259

G1 X81.677 Y73.259 E0.00316

G1 X81.612 Y73.230 E0.00186

G1 X81.544 Y73.168 E0.00239

G1 X81.500 Y73.095 E0.00222

G1 X81.471 Y72.923 E0.00456

G1 X81.474 Y71.257 E0.04340

G1 X81.517 Y71.031 E0.00600

G1 X81.585 Y70.918 E0.00344

M204 S1250

G1 X81.660 Y70.874 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.650 Y70.838 E-0.05732

G1 X81.765 Y70.813 E-0.06521

G1 X83.190 Y70.806 E-0.78947

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X83.041 Y71.861

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y71.540 E0.01284

G1 X82.214 Y71.542 E0.01426

G1 X82.213 Y71.675 E0.00374

G1 X82.646 Y72.108 E0.01732

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.213 Y71.675 E-0.33958

G1 X82.214 Y71.542 E-0.07339

G1 X82.719 Y71.540 E-0.27969

G1 X82.999 Y71.820 E-0.21935

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X81.889 Y59.732

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.904 Y58.232 E0.03908

G1 X84.374 Y58.221 E0.06434

G1 X83.717 Y58.588 E0.01959

G1 X81.940 Y59.700 E0.05464

M204 S1250

G1 X81.798 Y60.261 F9000.000

M204 S800

G1 F1500.000

G1 X81.677 Y60.261 E0.00316

G1 X81.612 Y60.232 E0.00186

G1 X81.544 Y60.170 E0.00239

G1 X81.500 Y60.097 E0.00222

G1 X81.471 Y59.925 E0.00456

G1 X81.474 Y58.259 E0.04340

G1 X81.517 Y58.033 E0.00599

G1 X81.615 Y57.868 E0.00501

G1 X81.650 Y57.840 E0.00117

G1 X81.765 Y57.815 E0.00307

G1 X85.275 Y57.799 E0.09145

G1 X85.412 Y57.846 E0.00378

G1 X85.442 Y57.891 E0.00140

G1 X85.370 Y58.007 E0.00355

G1 X85.068 Y58.283 E0.01068

G1 X84.644 Y58.548 E0.01301

G1 X83.930 Y58.947 E0.02132

G1 X81.854 Y60.238 E0.06370

M204 S1250

G1 X81.720 Y60.168 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.677 Y60.261 E-0.09893

G1 X81.612 Y60.232 E-0.03956

G1 X81.544 Y60.170 E-0.05082

G1 X81.500 Y60.097 E-0.04728

G1 X81.471 Y59.925 E-0.09695

G1 X81.473 Y58.881 E-0.57847

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X83.041 Y58.863

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y58.542 E0.01284

G1 X82.214 Y58.544 E0.01426

G1 X82.213 Y58.677 E0.00374

G1 X82.646 Y59.110 E0.01732

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.213 Y58.677 E-0.33956

G1 X82.214 Y58.544 E-0.07339

G1 X82.719 Y58.542 E-0.27967

G1 X82.999 Y58.822 E-0.21937

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X82.904 Y64.068

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.644 Y63.000 E0.05319

G1 X85.617 Y62.493 E0.02860

G1 X86.162 Y62.274 E0.01529

G1 X86.831 Y62.098 E0.01802

G1 X87.218 Y62.083 E0.01009

G1 X87.268 Y62.064 E0.00141

G1 X87.766 Y62.116 E0.01305

G1 X87.994 Y62.207 E0.00639

G1 X88.240 Y62.267 E0.00659

G1 X88.828 Y62.475 E0.01626

G1 X89.227 Y62.661 E0.01149

G1 X90.046 Y63.114 E0.02438

G1 X91.581 Y64.077 E0.04721

G1 X87.968 Y64.065 E0.09414

G1 X85.072 Y64.032 E0.07546

G1 X82.964 Y64.067 E0.05494

M204 S1250

G1 X82.220 Y64.498 F9000.000

M204 S800

G1 F1500.000

G1 X82.085 Y64.456 E0.00366

G1 X82.071 Y64.355 E0.00266

G1 X82.177 Y64.151 E0.00598

G1 X82.382 Y63.942 E0.00764

G1 X82.661 Y63.728 E0.00914

G1 X83.145 Y63.417 E0.01500

G1 X84.439 Y62.635 E0.03940

G1 X85.443 Y62.113 E0.02947

G1 X86.030 Y61.877 E0.01650

G1 X86.768 Y61.682 E0.01989

G1 X87.135 Y61.668 E0.00956

G1 X87.195 Y61.646 E0.00167

G1 X87.404 Y61.647 E0.00545

G1 X87.872 Y61.709 E0.01229

G1 X88.121 Y61.808 E0.00698

G1 X88.359 Y61.866 E0.00638

G1 X88.986 Y62.088 E0.01733

G1 X89.417 Y62.289 E0.01238

G1 X90.257 Y62.754 E0.02502

G1 X91.828 Y63.740 E0.04833

G1 X92.194 Y64.024 E0.01207

G1 X92.403 Y64.322 E0.00950

G1 X92.407 Y64.418 E0.00249

G1 X92.241 Y64.497 E0.00480

G1 X87.965 Y64.483 E0.11142

G1 X85.074 Y64.450 E0.07535

G1 X82.280 Y64.497 E0.07281

M204 S1250

G1 X82.175 Y64.364 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.085 Y64.456 E-0.11000

G1 X82.071 Y64.355 E-0.05664

G1 X82.177 Y64.151 E-0.12729

G1 X82.382 Y63.942 E-0.16248

G1 X82.661 Y63.728 E-0.19441

G1 X83.057 Y63.473 E-0.26118

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X90.137 Y63.947

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.186 Y62.997 E0.03589

G1 X88.709 Y62.765 E0.01416

G1 X88.152 Y62.568 E0.01578

G1 X89.341 Y63.756 E0.04487

G1 X88.733 Y63.754 E0.01622

G1 X87.359 Y62.380 E0.05189

G1 X86.880 Y62.409 E0.01279

G1 X86.803 Y62.429 E0.00215

G1 X88.126 Y63.752 E0.04995

G1 X87.514 Y63.747 E0.01632

G1 X86.323 Y62.556 E0.04497

G1 X85.885 Y62.723 E0.01252

G1 X86.902 Y63.740 E0.03838

G1 X86.290 Y63.733 E0.01635

G1 X85.477 Y62.920 E0.03070

G1 X85.078 Y63.127 E0.01199

G1 X85.677 Y63.726 E0.02261

G1 X85.065 Y63.719 E0.01635

G1 X84.687 Y63.341 E0.01427

G1 X84.312 Y63.572 E0.01175

G1 X84.655 Y63.914 E0.01293

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.312 Y63.572 E-0.26845

G1 X84.687 Y63.341 E-0.24394

G1 X85.065 Y63.719 E-0.29628

G1 X85.252 Y63.721 E-0.10333

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X90.102 Y58.217

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.576 Y58.213 E0.06446

G1 X92.594 Y58.307 E0.00248

G1 X92.590 Y59.735 E0.03721

G1 X91.039 Y58.750 E0.04787

G1 X90.537 Y58.445 E0.01532

G1 X90.155 Y58.244 E0.01123

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.801 Y58.223 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X92.708 Y60.267

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y60.233 E0.00308

G1 X90.819 Y59.105 E0.05481

G1 X90.331 Y58.809 E0.01487

G1 X89.770 Y58.514 E0.01651

G1 X89.534 Y58.343 E0.00761

G1 X89.449 Y58.304 E0.00243

G1 X89.200 Y58.100 E0.00839

G1 X89.032 Y57.856 E0.00771

G1 X89.192 Y57.800 E0.00443

G1 X92.705 Y57.795 E0.09154

G1 X92.821 Y57.833 E0.00316

G1 X92.962 Y58.026 E0.00622

G1 X93.012 Y58.267 E0.00642

G1 X93.007 Y59.966 E0.04428

G1 X92.981 Y60.099 E0.00354

G1 X92.906 Y60.209 E0.00347

G1 X92.766 Y60.252 E0.00381

M204 S1250

G1 X92.650 Y60.164 F9000.000

G1 X92.466 Y59.358

M204 S1000

G1 F4800.000

G1 X91.590 Y58.481 E0.03875

M204 S1250

G1 X91.433 Y58.573 F9000.000

G1 F2400.000

G1 X90.976 Y58.443 E0.00477

G1 X89.903 Y58.150 F9000.000

G1 F2400.000

G1 X89.438 Y58.025 E0.00507

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.903 Y58.150 E-0.26684

G1 E-0.69316 F4200.00000

G1 Z11.200 F9000.000

G1 X92.590 Y46.737

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X91.039 Y45.752 E0.04787

G1 X90.537 Y45.447 E0.01532

G1 X90.102 Y45.219 E0.01280

G1 X92.576 Y45.215 E0.06446

G1 X92.594 Y45.309 E0.00248

G1 X92.590 Y46.677 E0.03565

M204 S1250

G1 X92.981 Y47.101 F9000.000

M204 S800

G1 F1500.000

G1 X92.889 Y47.226 E0.00404

G1 X92.708 Y47.269 E0.00484

G1 X92.595 Y47.235 E0.00309

G1 X90.819 Y46.107 E0.05482

G1 X90.331 Y45.811 E0.01487

G1 X89.770 Y45.516 E0.01651

G1 X89.534 Y45.345 E0.00761

G1 X89.449 Y45.306 E0.00243

G1 X89.200 Y45.102 E0.00839

G1 X89.032 Y44.859 E0.00770

G1 X89.192 Y44.802 E0.00444

G1 X92.705 Y44.797 E0.09154

G1 X92.821 Y44.835 E0.00316

G1 X92.962 Y45.028 E0.00622

G1 X93.012 Y45.269 E0.00642

G1 X93.007 Y46.968 E0.04428

G1 X92.993 Y47.042 E0.00197

M204 S1250

G1 X92.827 Y47.116 F9000.000

G1 X92.466 Y46.360

M204 S1000

G1 F4800.000

G1 X91.590 Y45.483 E0.03875

M204 S1250

G1 X91.433 Y45.575 F9000.000

G1 F2400.000

G1 X90.976 Y45.445 E0.00477

G1 X89.903 Y45.152 F9000.000

G1 F2400.000

G1 X89.438 Y45.027 E0.00507

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.903 Y45.152 E-0.26689

G1 E-0.69311 F4200.00000

G1 Z11.200 F9000.000

G1 X91.581 Y51.079

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X87.968 Y51.067 E0.09414

G1 X85.072 Y51.034 E0.07546

G1 X82.904 Y51.071 E0.05650

G1 X84.644 Y50.002 E0.05320

G1 X85.617 Y49.495 E0.02860

G1 X86.162 Y49.276 E0.01528

G1 X86.831 Y49.101 E0.01803

G1 X87.214 Y49.085 E0.01000

G1 X87.265 Y49.067 E0.00141

G1 X87.766 Y49.118 E0.01312

G1 X87.993 Y49.208 E0.00637

G1 X88.239 Y49.269 E0.00660

G1 X88.828 Y49.477 E0.01627

G1 X89.227 Y49.663 E0.01148

G1 X90.046 Y50.116 E0.02438

G1 X91.531 Y51.046 E0.04566

M204 S1250

G1 X92.403 Y51.324 F9000.000

M204 S800

G1 F1500.000

G1 X92.407 Y51.420 E0.00249

G1 X92.241 Y51.500 E0.00480

G1 X87.965 Y51.485 E0.11141

G1 X85.073 Y51.452 E0.07535

G1 X82.220 Y51.501 E0.07435

G1 X82.085 Y51.458 E0.00368

G1 X82.071 Y51.357 E0.00267

G1 X82.177 Y51.153 E0.00598

G1 X82.382 Y50.945 E0.00763

G1 X82.661 Y50.731 E0.00914

G1 X83.145 Y50.418 E0.01501

G1 X84.439 Y49.637 E0.03939

G1 X85.443 Y49.115 E0.02947

G1 X86.030 Y48.879 E0.01650

G1 X86.769 Y48.685 E0.01990

G1 X87.134 Y48.670 E0.00953

G1 X87.194 Y48.649 E0.00167

G1 X87.405 Y48.649 E0.00549

G1 X87.872 Y48.711 E0.01228

G1 X88.121 Y48.810 E0.00698

G1 X88.359 Y48.868 E0.00639

G1 X88.986 Y49.090 E0.01734

G1 X89.417 Y49.291 E0.01238

G1 X90.257 Y49.756 E0.02502

G1 X91.828 Y50.742 E0.04833

G1 X92.194 Y51.026 E0.01207

G1 X92.369 Y51.275 E0.00793

M204 S1250

G1 X92.337 Y51.394 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.407 Y51.420 E-0.08300

G1 X92.241 Y51.500 E-0.10219

G1 X90.930 Y51.495 E-0.72681

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X84.654 Y50.916

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.312 Y50.574 E0.01293

G1 X84.687 Y50.343 E0.01175

G1 X85.065 Y50.721 E0.01427

G1 X85.677 Y50.728 E0.01635

G1 X85.078 Y50.129 E0.02261

G1 X85.476 Y49.922 E0.01199

G1 X86.290 Y50.735 E0.03070

G1 X86.902 Y50.742 E0.01635

G1 X85.885 Y49.725 E0.03839

G1 X86.323 Y49.558 E0.01252

G1 X87.514 Y50.749 E0.04497

G1 X88.125 Y50.754 E0.01632

G1 X86.803 Y49.432 E0.04993

G1 X86.881 Y49.412 E0.00215

G1 X87.359 Y49.382 E0.01279

G1 X88.733 Y50.756 E0.05189

G1 X89.341 Y50.758 E0.01622

G1 X88.153 Y49.571 E0.04485

G1 X88.709 Y49.767 E0.01576

G1 X89.186 Y49.999 E0.01415

G1 X90.137 Y50.949 E0.03590

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.186 Y49.999 E-0.74502

G1 X88.915 Y49.867 E-0.16698

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X84.374 Y45.223

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.717 Y45.590 E0.01959

G1 X81.889 Y46.734 E0.05620

G1 X81.904 Y45.234 E0.03908

G1 X84.314 Y45.223 E0.06278

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.717 Y45.590 E-0.38797

G1 X82.916 Y46.091 E-0.52403

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X81.615 Y44.870

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.650 Y44.842 E0.00117

G1 X81.765 Y44.817 E0.00307

G1 X85.275 Y44.801 E0.09145

G1 X85.412 Y44.848 E0.00378

G1 X85.442 Y44.893 E0.00140

G1 X85.370 Y45.009 E0.00355

G1 X85.068 Y45.285 E0.01068

G1 X84.644 Y45.550 E0.01301

G1 X83.930 Y45.949 E0.02132

G1 X81.891 Y47.226 E0.06269

G1 X81.798 Y47.263 E0.00259

G1 X81.677 Y47.263 E0.00316

G1 X81.612 Y47.234 E0.00186

G1 X81.544 Y47.173 E0.00238

G1 X81.500 Y47.099 E0.00222

G1 X81.471 Y46.927 E0.00456

G1 X81.474 Y45.261 E0.04340

G1 X81.517 Y45.035 E0.00599

G1 X81.585 Y44.922 E0.00345

M204 S1250

G1 X81.660 Y44.878 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.650 Y44.842 E-0.05726

G1 X81.765 Y44.817 E-0.06521

G1 X83.190 Y44.810 E-0.78953

G1 E-0.04800 F4200.00000

G1 Z11.200 F9000.000

G1 X83.041 Y45.865

G1 Z11.000

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.719 Y45.544 E0.01284

G1 X82.214 Y45.546 E0.01426

G1 X82.213 Y45.679 E0.00374

G1 X82.646 Y46.112 E0.01732

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;11.15

G1 Z11.150 F9000.000

;AFTER\_LAYER\_CHANGE

;11.15

G1 X81.889 Y46.744

M204 S800

G1 F1500.000

G1 X81.907 Y45.382 E0.03550

G1 X84.092 Y45.375 E0.05693

G1 X83.718 Y45.588 E0.01121

G1 X81.939 Y46.712 E0.05482

M204 S1250

G1 X81.732 Y47.282 F9000.000

M204 S800

G1 F1500.000

G1 X81.606 Y47.242 E0.00344

G1 X81.524 Y47.171 E0.00284

G1 X81.469 Y47.006 E0.00453

G1 X81.478 Y45.393 E0.04202

G1 X81.515 Y45.215 E0.00473

G1 X81.659 Y44.993 E0.00691

G1 X81.770 Y44.964 E0.00299

G1 X84.937 Y44.955 E0.08252

G1 X85.122 Y45.020 E0.00511

G1 X84.948 Y45.269 E0.00793

G1 X84.740 Y45.452 E0.00723

G1 X84.411 Y45.674 E0.01033

G1 X83.933 Y45.947 E0.01434

G1 X81.959 Y47.194 E0.06085

G1 X81.791 Y47.269 E0.00480

M204 S1250

G1 X81.668 Y47.166 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.606 Y47.242 E-0.10341

G1 X81.524 Y47.171 E-0.06033

G1 X81.469 Y47.006 E-0.09645

G1 X81.475 Y45.830 E-0.65181

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X82.461 Y45.505

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.025 Y45.942 E0.01929

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.461 Y45.505 E-0.34188

G1 E-0.61812 F4200.00000

G1 Z11.350 F9000.000

G1 X83.162 Y50.908

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.724 Y50.549 E0.01737

G1 X84.242 Y50.259 E0.01547

G1 X84.686 Y49.984 E0.01361

G1 X85.738 Y49.421 E0.03108

G1 X86.197 Y49.236 E0.01289

G1 X86.680 Y49.095 E0.01311

G1 X87.023 Y49.051 E0.00901

G1 X87.078 Y49.076 E0.00157

G1 X87.447 Y49.041 E0.00967

G1 X87.747 Y49.081 E0.00788

G1 X88.152 Y49.186 E0.01091

G1 X88.634 Y49.372 E0.01346

G1 X89.405 Y49.761 E0.02249

G1 X90.029 Y50.106 E0.01859

G1 X91.344 Y50.924 E0.04035

G1 X85.072 Y50.885 E0.16343

G1 X83.222 Y50.907 E0.04821

M204 S1250

G1 X82.431 Y51.334 F9000.000

M204 S800

G1 F1500.000

G1 X82.320 Y51.318 E0.00293

G1 X82.298 Y51.236 E0.00220

G1 X82.380 Y51.040 E0.00553

G1 X82.553 Y50.856 E0.00658

G1 X82.891 Y50.585 E0.01129

G1 X83.509 Y50.190 E0.01911

G1 X84.030 Y49.899 E0.01555

G1 X84.477 Y49.621 E0.01371

G1 X85.561 Y49.042 E0.03202

G1 X86.059 Y48.841 E0.01400

G1 X86.594 Y48.684 E0.01452

G1 X87.087 Y48.622 E0.01294

G1 X87.148 Y48.650 E0.00175

G1 X87.438 Y48.622 E0.00757

G1 X87.592 Y48.630 E0.00403

G1 X87.836 Y48.673 E0.00645

G1 X88.280 Y48.788 E0.01197

G1 X88.804 Y48.990 E0.01462

G1 X89.600 Y49.391 E0.02324

G1 X90.241 Y49.746 E0.01908

G1 X91.581 Y50.579 E0.04112

G1 X91.930 Y50.848 E0.01148

G1 X92.162 Y51.148 E0.00989

G1 X92.175 Y51.190 E0.00112

G1 X92.051 Y51.289 E0.00414

G1 X92.011 Y51.346 E0.00182

G1 X85.073 Y51.303 E0.18078

G1 X82.491 Y51.334 E0.06729

M204 S1250

G1 X82.385 Y51.232 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.320 Y51.318 E-0.09534

G1 X82.298 Y51.236 E-0.04688

G1 X82.380 Y51.040 E-0.11761

G1 X82.553 Y50.856 E-0.13995

G1 X82.891 Y50.585 E-0.24009

G1 X83.305 Y50.321 E-0.27213

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X89.598 Y50.788

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.956 Y50.430 E0.01383

G1 X89.562 Y50.205 E0.01240

G1 X89.170 Y50.597 E0.01513

G1 X88.554 Y50.593 E0.01681

G1 X89.160 Y49.988 E0.02338

G1 X88.748 Y49.780 E0.01259

G1 X87.939 Y50.589 E0.03125

G1 X87.323 Y50.586 E0.01681

G1 X88.321 Y49.588 E0.03855

G1 X88.060 Y49.487 E0.00765

G1 X87.851 Y49.438 E0.00585

G1 X86.708 Y50.582 E0.04416

G1 X86.092 Y50.578 E0.01681

G1 X87.294 Y49.376 E0.04642

G1 X87.020 Y49.394 E0.00750

G1 X86.975 Y49.373 E0.00137

G1 X86.744 Y49.402 E0.00636

G1 X86.609 Y49.442 E0.00383

G1 X85.477 Y50.574 E0.04373

G1 X84.858 Y50.574 E0.01691

G1 X85.968 Y49.464 E0.04289

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.858 Y50.574 E-0.87026

G1 X84.933 Y50.574 E-0.04174

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X90.399 Y45.374

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.574 Y45.383 E0.05665

G1 X92.589 Y45.442 E0.00159

G1 X92.592 Y46.739 E0.03379

G1 X91.032 Y45.744 E0.04818

G1 X90.451 Y45.405 E0.01754

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.097 Y45.388 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X92.989 Y47.116

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.905 Y47.222 E0.00351

G1 X92.704 Y47.271 E0.00539

G1 X92.599 Y47.239 E0.00286

G1 X90.815 Y46.101 E0.05515

G1 X89.933 Y45.586 E0.02662

G1 X89.604 Y45.338 E0.01072

G1 X89.512 Y45.246 E0.00339

G1 X89.351 Y45.009 E0.00747

G1 X89.472 Y44.953 E0.00346

G1 X92.718 Y44.965 E0.08458

G1 X92.801 Y44.982 E0.00219

G1 X92.952 Y45.176 E0.00640

G1 X93.007 Y45.388 E0.00570

G1 X93.004 Y47.058 E0.04351

M204 S1250

G1 X92.855 Y47.127 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.905 Y47.222 E-0.10576

G1 X92.704 Y47.271 E-0.11473

G1 X92.599 Y47.239 E-0.06086

G1 X91.640 Y46.627 E-0.63065

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X92.343 Y45.507

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.778 Y46.071 E0.02496

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.343 Y45.507 E-0.44232

G1 E-0.51768 F4200.00000

G1 Z11.350 F9000.000

G1 X92.574 Y58.380

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.589 Y58.440 E0.00159

G1 X92.592 Y59.737 E0.03379

G1 X91.032 Y58.742 E0.04818

G1 X90.399 Y58.372 E0.01913

G1 X92.514 Y58.380 E0.05511

M204 S1250

G1 X92.718 Y57.963 F9000.000

M204 S800

G1 F1500.000

G1 X92.801 Y57.980 E0.00220

G1 X92.952 Y58.174 E0.00640

G1 X93.007 Y58.386 E0.00570

G1 X93.010 Y60.030 E0.04285

G1 X92.989 Y60.114 E0.00225

G1 X92.906 Y60.219 E0.00349

G1 X92.704 Y60.268 E0.00541

G1 X92.599 Y60.237 E0.00286

G1 X90.815 Y59.099 E0.05514

G1 X89.938 Y58.587 E0.02646

G1 X89.600 Y58.331 E0.01105

G1 X89.512 Y58.244 E0.00322

G1 X89.351 Y58.006 E0.00748

G1 X89.472 Y57.951 E0.00347

G1 X92.658 Y57.963 E0.08300

M204 S1250

G1 X92.750 Y58.041 F9000.000

G1 X92.343 Y58.505

M204 S1000

G1 F4800.000

G1 X91.778 Y59.069 E0.02496

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.343 Y58.505 E-0.44245

G1 E-0.51755 F4200.00000

G1 Z11.350 F9000.000

G1 X90.198 Y58.314

G1 Z11.150

G1 E3.20000 F2400.00000

G1 X89.786 Y58.176 E0.00333

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.198 Y58.314 E-0.24054

G1 E-0.71946 F4200.00000

G1 Z11.350 F9000.000

G1 X91.342 Y63.921

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.072 Y63.883 E0.16337

G1 X83.162 Y63.905 E0.04979

G1 X83.723 Y63.547 E0.01737

G1 X84.242 Y63.257 E0.01548

G1 X84.686 Y62.982 E0.01361

G1 X85.738 Y62.419 E0.03108

G1 X86.197 Y62.234 E0.01290

G1 X86.680 Y62.092 E0.01311

G1 X87.026 Y62.049 E0.00909

G1 X87.080 Y62.072 E0.00154

G1 X87.446 Y62.039 E0.00957

G1 X87.748 Y62.079 E0.00794

G1 X88.153 Y62.183 E0.01089

G1 X88.634 Y62.370 E0.01345

G1 X89.405 Y62.759 E0.02250

G1 X90.029 Y63.104 E0.01859

G1 X91.291 Y63.889 E0.03873

M204 S1250

G1 X92.011 Y64.344 F9000.000

M204 S800

G1 F1500.000

G1 X85.073 Y64.301 E0.18078

G1 X82.431 Y64.332 E0.06886

G1 X82.320 Y64.316 E0.00293

G1 X82.298 Y64.234 E0.00220

G1 X82.380 Y64.038 E0.00553

G1 X82.553 Y63.854 E0.00659

G1 X82.891 Y63.582 E0.01129

G1 X83.509 Y63.188 E0.01910

G1 X84.030 Y62.897 E0.01555

G1 X84.477 Y62.619 E0.01371

G1 X85.561 Y62.040 E0.03202

G1 X86.060 Y61.839 E0.01401

G1 X86.594 Y61.681 E0.01452

G1 X87.088 Y61.620 E0.01297

G1 X87.149 Y61.646 E0.00173

G1 X87.437 Y61.620 E0.00754

G1 X87.836 Y61.671 E0.01048

G1 X88.281 Y61.785 E0.01196

G1 X88.804 Y61.988 E0.01462

G1 X89.600 Y62.389 E0.02324

G1 X90.241 Y62.744 E0.01908

G1 X91.581 Y63.577 E0.04112

G1 X91.930 Y63.846 E0.01148

G1 X92.162 Y64.146 E0.00989

G1 X92.175 Y64.188 E0.00112

G1 X92.046 Y64.295 E0.00439

M204 S1250

G1 X91.717 Y64.073 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.400 Y64.296 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X85.968 Y62.462

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.858 Y63.572 E0.04289

G1 X85.477 Y63.572 E0.01691

G1 X86.610 Y62.439 E0.04376

G1 X86.744 Y62.399 E0.00380

G1 X86.980 Y62.370 E0.00649

G1 X87.024 Y62.389 E0.00132

G1 X87.296 Y62.373 E0.00743

G1 X86.093 Y63.576 E0.04646

G1 X86.708 Y63.580 E0.01681

G1 X87.852 Y62.436 E0.04418

G1 X88.060 Y62.484 E0.00584

G1 X88.322 Y62.585 E0.00766

G1 X87.323 Y63.584 E0.03856

G1 X87.939 Y63.587 E0.01681

G1 X88.748 Y62.778 E0.03124

G1 X89.160 Y62.986 E0.01259

G1 X88.554 Y63.591 E0.02338

G1 X89.170 Y63.595 E0.01681

G1 X89.562 Y63.203 E0.01513

G1 X89.956 Y63.428 E0.01240

G1 X89.598 Y63.786 E0.01383

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.956 Y63.428 E-0.28068

G1 X89.562 Y63.203 E-0.25170

G1 X89.170 Y63.595 E-0.30707

G1 X89.039 Y63.594 E-0.07255

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X84.092 Y58.373

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.718 Y58.586 E0.01121

G1 X81.889 Y59.742 E0.05638

G1 X81.907 Y58.380 E0.03549

G1 X84.032 Y58.373 E0.05537

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.718 Y58.586 E-0.21021

G1 X82.647 Y59.263 E-0.70179

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X81.524 Y60.169

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.469 Y60.004 E0.00453

G1 X81.478 Y58.391 E0.04202

G1 X81.515 Y58.213 E0.00473

G1 X81.659 Y57.991 E0.00691

G1 X81.770 Y57.962 E0.00299

G1 X84.937 Y57.953 E0.08252

G1 X85.122 Y58.018 E0.00511

G1 X84.948 Y58.267 E0.00793

G1 X84.740 Y58.450 E0.00723

G1 X84.411 Y58.672 E0.01033

G1 X83.933 Y58.945 E0.01434

G1 X81.959 Y60.192 E0.06085

G1 X81.732 Y60.280 E0.00634

G1 X81.606 Y60.240 E0.00344

G1 X81.569 Y60.208 E0.00128

M204 S1250

G1 X81.603 Y60.014 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.469 Y60.004 E-0.12616

G1 X81.477 Y58.586 E-0.78584

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X82.461 Y58.503

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.025 Y58.940 E0.01929

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.461 Y58.503 E-0.34185

G1 E-0.61815 F4200.00000

G1 Z11.350 F9000.000

G1 X81.907 Y71.378

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.091 Y71.371 E0.05692

G1 X83.718 Y71.584 E0.01121

G1 X81.889 Y72.740 E0.05637

G1 X81.895 Y71.437 E0.03396

M204 S1250

G1 X81.770 Y70.960 F9000.000

M204 S800

G1 F1500.000

G1 X84.937 Y70.951 E0.08252

G1 X85.122 Y71.016 E0.00511

G1 X84.948 Y71.265 E0.00793

G1 X84.740 Y71.448 E0.00723

G1 X84.411 Y71.670 E0.01033

G1 X83.933 Y71.943 E0.01435

G1 X81.959 Y73.190 E0.06084

G1 X81.732 Y73.278 E0.00634

G1 X81.606 Y73.238 E0.00344

G1 X81.524 Y73.167 E0.00284

G1 X81.469 Y73.002 E0.00453

G1 X81.478 Y71.389 E0.04202

G1 X81.515 Y71.210 E0.00475

G1 X81.659 Y70.989 E0.00689

G1 X81.712 Y70.975 E0.00143

M204 S1250

G1 X82.052 Y71.244 F9000.000

G1 X82.025 Y71.938

M204 S1000

G1 F4800.000

G1 X82.461 Y71.501 E0.01929

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.025 Y71.938 E-0.34189

G1 E-0.61811 F4200.00000

G1 Z11.350 F9000.000

G1 X83.162 Y76.903

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.724 Y76.545 E0.01737

G1 X84.686 Y75.979 E0.02909

G1 X85.738 Y75.416 E0.03109

G1 X86.197 Y75.231 E0.01288

G1 X86.679 Y75.090 E0.01310

G1 X87.026 Y75.047 E0.00911

G1 X87.080 Y75.070 E0.00154

G1 X87.446 Y75.037 E0.00957

G1 X87.748 Y75.077 E0.00795

G1 X88.152 Y75.181 E0.01087

G1 X88.634 Y75.368 E0.01348

G1 X89.405 Y75.756 E0.02249

G1 X90.029 Y76.102 E0.01859

G1 X91.345 Y76.920 E0.04038

G1 X85.072 Y76.881 E0.16346

G1 X83.222 Y76.903 E0.04822

M204 S1250

G1 X82.431 Y77.330 F9000.000

M204 S800

G1 F1500.000

G1 X82.320 Y77.314 E0.00293

G1 X82.298 Y77.232 E0.00220

G1 X82.380 Y77.036 E0.00554

G1 X82.553 Y76.852 E0.00657

G1 X82.891 Y76.580 E0.01130

G1 X83.509 Y76.186 E0.01910

G1 X84.030 Y75.894 E0.01556

G1 X84.477 Y75.617 E0.01371

G1 X85.561 Y75.037 E0.03202

G1 X86.059 Y74.836 E0.01400

G1 X86.594 Y74.679 E0.01452

G1 X87.088 Y74.618 E0.01297

G1 X87.149 Y74.644 E0.00173

G1 X87.437 Y74.618 E0.00754

G1 X87.592 Y74.626 E0.00405

G1 X87.836 Y74.668 E0.00645

G1 X88.280 Y74.783 E0.01195

G1 X88.804 Y74.986 E0.01463

G1 X89.600 Y75.387 E0.02323

G1 X90.241 Y75.742 E0.01908

G1 X91.581 Y76.574 E0.04110

G1 X91.930 Y76.844 E0.01150

G1 X92.162 Y77.144 E0.00990

G1 X92.175 Y77.186 E0.00112

G1 X92.051 Y77.285 E0.00414

G1 X92.011 Y77.342 E0.00182

G1 X85.073 Y77.299 E0.18077

G1 X82.491 Y77.329 E0.06729

M204 S1250

G1 X82.384 Y77.227 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.320 Y77.314 E-0.09531

G1 X82.298 Y77.232 E-0.04675

G1 X82.380 Y77.036 E-0.11791

G1 X82.553 Y76.852 E-0.13977

G1 X82.891 Y76.580 E-0.24029

G1 X83.305 Y76.316 E-0.27198

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X89.597 Y76.784

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.955 Y76.425 E0.01389

G1 X89.560 Y76.200 E0.01246

G1 X89.167 Y76.593 E0.01522

G1 X88.550 Y76.589 E0.01688

G1 X89.157 Y75.982 E0.02351

G1 X88.744 Y75.774 E0.01265

G1 X87.933 Y76.585 E0.03140

G1 X87.316 Y76.582 E0.01688

G1 X88.316 Y75.581 E0.03872

G1 X88.060 Y75.482 E0.00754

G1 X87.845 Y75.432 E0.00603

G1 X86.699 Y76.578 E0.04435

G1 X86.082 Y76.574 E0.01688

G1 X87.285 Y75.372 E0.04654

G1 X87.024 Y75.387 E0.00715

G1 X86.980 Y75.368 E0.00133

G1 X86.743 Y75.398 E0.00652

G1 X86.594 Y75.441 E0.00424

G1 X85.466 Y76.570 E0.04369

G1 X84.845 Y76.570 E0.01699

G1 X85.948 Y75.467 E0.04271

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.845 Y76.570 E-0.86472

G1 X84.930 Y76.570 E-0.04728

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X90.397 Y71.370

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.574 Y71.378 E0.05671

G1 X92.589 Y71.437 E0.00157

G1 X92.592 Y72.734 E0.03380

G1 X91.100 Y71.782 E0.04611

G1 X90.449 Y71.400 E0.01966

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.095 Y71.383 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X92.989 Y73.112

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.906 Y73.217 E0.00350

G1 X92.704 Y73.266 E0.00541

G1 X92.599 Y73.234 E0.00286

G1 X90.882 Y72.138 E0.05308

G1 X89.933 Y71.582 E0.02866

G1 X89.604 Y71.333 E0.01074

G1 X89.512 Y71.241 E0.00339

G1 X89.351 Y71.004 E0.00747

G1 X89.472 Y70.949 E0.00347

G1 X92.718 Y70.961 E0.08457

G1 X92.801 Y70.978 E0.00221

G1 X92.952 Y71.171 E0.00639

G1 X93.007 Y71.383 E0.00570

G1 X93.004 Y73.054 E0.04353

M204 S1250

G1 X92.856 Y73.123 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.906 Y73.217 E-0.10553

G1 X92.704 Y73.266 E-0.11500

G1 X92.599 Y73.234 E-0.06080

G1 X91.640 Y72.622 E-0.63067

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X92.342 Y71.503

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.779 Y72.066 E0.02492

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.342 Y71.503 E-0.44163

G1 E-0.51837 F4200.00000

G1 Z11.350 F9000.000

G1 X92.574 Y84.376

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.589 Y84.435 E0.00159

G1 X92.592 Y85.732 E0.03381

G1 X91.032 Y84.737 E0.04820

G1 X90.398 Y84.367 E0.01912

G1 X92.514 Y84.375 E0.05512

M204 S1250

G1 X92.718 Y83.958 F9000.000

M204 S800

G1 F1500.000

G1 X92.800 Y83.976 E0.00221

G1 X92.952 Y84.169 E0.00640

G1 X93.007 Y84.381 E0.00570

G1 X93.010 Y86.026 E0.04285

G1 X92.989 Y86.110 E0.00226

G1 X92.905 Y86.215 E0.00351

G1 X92.704 Y86.264 E0.00539

G1 X92.599 Y86.232 E0.00286

G1 X90.815 Y85.094 E0.05515

G1 X89.938 Y84.583 E0.02644

G1 X89.600 Y84.326 E0.01107

G1 X89.512 Y84.239 E0.00321

G1 X89.351 Y84.002 E0.00748

G1 X89.472 Y83.946 E0.00346

G1 X92.658 Y83.958 E0.08300

M204 S1250

G1 X92.750 Y84.037 F9000.000

G1 X92.343 Y84.500

M204 S1000

G1 F4800.000

G1 X91.779 Y85.065 E0.02497

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.343 Y84.500 E-0.44261

G1 E-0.51739 F4200.00000

G1 Z11.350 F9000.000

G1 X90.197 Y84.310

G1 Z11.150

G1 E3.20000 F2400.00000

G1 X89.787 Y84.172 E0.00333

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.197 Y84.310 E-0.24014

G1 E-0.71986 F4200.00000

G1 Z11.350 F9000.000

G1 X91.342 Y89.916

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.072 Y89.878 E0.16337

G1 X83.162 Y89.901 E0.04978

G1 X83.724 Y89.542 E0.01737

G1 X84.686 Y88.977 E0.02908

G1 X85.738 Y88.414 E0.03108

G1 X86.197 Y88.229 E0.01289

G1 X86.679 Y88.088 E0.01310

G1 X87.026 Y88.045 E0.00911

G1 X87.081 Y88.069 E0.00157

G1 X87.445 Y88.034 E0.00953

G1 X87.748 Y88.075 E0.00796

G1 X88.152 Y88.179 E0.01088

G1 X88.634 Y88.365 E0.01346

G1 X89.405 Y88.754 E0.02249

G1 X90.029 Y89.100 E0.01860

G1 X91.291 Y89.884 E0.03871

M204 S1250

G1 X92.011 Y90.340 F9000.000

M204 S800

G1 F1500.000

G1 X85.073 Y90.296 E0.18077

G1 X82.431 Y90.328 E0.06885

G1 X82.320 Y90.311 E0.00295

G1 X82.298 Y90.229 E0.00219

G1 X82.380 Y90.033 E0.00554

G1 X82.553 Y89.849 E0.00658

G1 X82.891 Y89.578 E0.01128

G1 X83.509 Y89.184 E0.01911

G1 X84.477 Y88.614 E0.02926

G1 X85.561 Y88.035 E0.03201

G1 X86.059 Y87.834 E0.01400

G1 X86.594 Y87.677 E0.01452

G1 X87.088 Y87.616 E0.01297

G1 X87.149 Y87.643 E0.00175

G1 X87.437 Y87.615 E0.00753

G1 X87.836 Y87.666 E0.01049

G1 X88.280 Y87.781 E0.01196

G1 X88.804 Y87.983 E0.01462

G1 X89.600 Y88.385 E0.02324

G1 X90.241 Y88.740 E0.01909

G1 X91.581 Y89.572 E0.04110

G1 X91.930 Y89.842 E0.01150

G1 X92.162 Y90.142 E0.00988

G1 X92.175 Y90.183 E0.00113

G1 X92.046 Y90.291 E0.00439

M204 S1250

G1 X91.717 Y90.069 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.400 Y90.292 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X85.947 Y88.465

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.845 Y89.568 E0.04267

G1 X85.466 Y89.567 E0.01699

G1 X86.594 Y88.439 E0.04365

G1 X86.743 Y88.396 E0.00426

G1 X86.980 Y88.366 E0.00652

G1 X87.025 Y88.386 E0.00137

G1 X87.284 Y88.370 E0.00708

G1 X86.082 Y89.571 E0.04649

G1 X86.699 Y89.575 E0.01688

G1 X87.844 Y88.430 E0.04432

G1 X88.060 Y88.480 E0.00607

G1 X88.316 Y88.579 E0.00751

G1 X87.316 Y89.579 E0.03872

G1 X87.933 Y89.583 E0.01688

G1 X88.744 Y88.772 E0.03140

G1 X89.157 Y88.980 E0.01265

G1 X88.549 Y89.587 E0.02350

G1 X89.166 Y89.591 E0.01688

G1 X89.559 Y89.198 E0.01521

G1 X89.955 Y89.423 E0.01246

G1 X89.596 Y89.781 E0.01389

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.955 Y89.423 E-0.28116

G1 X89.559 Y89.198 E-0.25222

G1 X89.166 Y89.591 E-0.30800

G1 X89.039 Y89.590 E-0.07062

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X84.096 Y84.369

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.267 Y84.861 E0.02510

G1 X81.889 Y85.737 E0.04257

G1 X81.907 Y84.376 E0.03548

G1 X84.036 Y84.369 E0.05548

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.267 Y84.861 E-0.50550

G1 X82.648 Y85.254 E-0.40650

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X81.524 Y86.165

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.469 Y86.000 E0.00454

G1 X81.478 Y84.386 E0.04204

G1 X81.515 Y84.208 E0.00473

G1 X81.659 Y83.987 E0.00688

G1 X81.770 Y83.958 E0.00300

G1 X84.937 Y83.949 E0.08252

G1 X85.122 Y84.013 E0.00510

G1 X84.948 Y84.262 E0.00791

G1 X84.739 Y84.445 E0.00724

G1 X84.410 Y84.669 E0.01038

G1 X83.486 Y85.217 E0.02798

G1 X81.958 Y86.188 E0.04717

G1 X81.732 Y86.276 E0.00633

G1 X81.606 Y86.236 E0.00344

G1 X81.569 Y86.204 E0.00128

M204 S1250

G1 X81.603 Y86.010 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.469 Y86.000 E-0.12621

G1 X81.477 Y84.582 E-0.78579

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X83.258 Y84.599

G1 Z11.150

G1 E3.20000 F2400.00000

G1 X82.797 Y84.730 E0.00330

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.258 Y84.599 E-0.26510

G1 E-0.69490 F4200.00000

G1 Z11.350 F9000.000

G1 X81.907 Y97.374

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.091 Y97.367 E0.05693

G1 X83.720 Y97.579 E0.01114

G1 X82.346 Y98.432 E0.04214

G1 X81.889 Y98.736 E0.01432

G1 X81.895 Y97.432 E0.03398

M204 S1250

G1 X81.770 Y96.956 F9000.000

M204 S800

G1 F1500.000

G1 X84.937 Y96.947 E0.08253

G1 X85.122 Y97.011 E0.00510

G1 X84.948 Y97.260 E0.00792

G1 X84.739 Y97.443 E0.00724

G1 X84.411 Y97.666 E0.01033

G1 X83.934 Y97.938 E0.01432

G1 X82.572 Y98.784 E0.04177

G1 X82.045 Y99.134 E0.01648

G1 X81.806 Y99.258 E0.00702

G1 X81.727 Y99.274 E0.00211

G1 X81.613 Y99.241 E0.00309

G1 X81.524 Y99.163 E0.00308

G1 X81.469 Y98.998 E0.00454

G1 X81.478 Y97.384 E0.04204

G1 X81.515 Y97.206 E0.00473

G1 X81.659 Y96.985 E0.00689

G1 X81.712 Y96.971 E0.00143

M204 S1250

G1 X82.052 Y97.239 F9000.000

G1 X82.025 Y97.934

M204 S1000

G1 F4800.000

G1 X82.461 Y97.497 E0.01931

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.025 Y97.934 E-0.34221

G1 E-0.61779 F4200.00000

G1 Z11.350 F9000.000

G1 X83.162 Y102.899

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.724 Y102.540 E0.01737

G1 X84.686 Y101.975 E0.02908

G1 X85.738 Y101.412 E0.03108

G1 X86.197 Y101.227 E0.01289

G1 X86.679 Y101.086 E0.01310

G1 X87.026 Y101.043 E0.00911

G1 X87.081 Y101.067 E0.00157

G1 X87.445 Y101.032 E0.00953

G1 X87.748 Y101.073 E0.00796

G1 X88.152 Y101.177 E0.01088

G1 X88.634 Y101.363 E0.01346

G1 X89.405 Y101.752 E0.02249

G1 X90.029 Y102.098 E0.01860

G1 X91.345 Y102.916 E0.04036

G1 X85.072 Y102.876 E0.16345

G1 X83.222 Y102.898 E0.04821

M204 S1250

G1 X82.431 Y103.326 F9000.000

M204 S800

G1 F1500.000

G1 X82.320 Y103.309 E0.00295

G1 X82.298 Y103.227 E0.00219

G1 X82.380 Y103.031 E0.00554

G1 X82.553 Y102.847 E0.00658

G1 X82.891 Y102.576 E0.01128

G1 X83.509 Y102.182 E0.01911

G1 X84.477 Y101.612 E0.02926

G1 X85.561 Y101.033 E0.03202

G1 X86.059 Y100.832 E0.01400

G1 X86.594 Y100.675 E0.01452

G1 X87.088 Y100.614 E0.01297

G1 X87.149 Y100.641 E0.00175

G1 X87.437 Y100.613 E0.00753

G1 X87.592 Y100.622 E0.00404

G1 X87.836 Y100.664 E0.00646

G1 X88.280 Y100.779 E0.01196

G1 X88.804 Y100.981 E0.01462

G1 X89.600 Y101.383 E0.02324

G1 X90.241 Y101.738 E0.01909

G1 X91.581 Y102.570 E0.04110

G1 X91.930 Y102.839 E0.01148

G1 X92.162 Y103.140 E0.00989

G1 X92.175 Y103.181 E0.00114

G1 X92.052 Y103.280 E0.00413

G1 X92.011 Y103.338 E0.00183

G1 X85.073 Y103.294 E0.18077

G1 X82.491 Y103.325 E0.06728

M204 S1250

G1 X82.385 Y103.223 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.320 Y103.309 E-0.09561

G1 X82.298 Y103.227 E-0.04664

G1 X82.380 Y103.031 E-0.11786

G1 X82.553 Y102.847 E-0.13989

G1 X82.891 Y102.576 E-0.23999

G1 X83.305 Y102.312 E-0.27202

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X89.596 Y102.779

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.955 Y102.421 E0.01388

G1 X89.559 Y102.196 E0.01246

G1 X89.166 Y102.589 E0.01521

G1 X88.549 Y102.585 E0.01688

G1 X89.157 Y101.978 E0.02350

G1 X88.744 Y101.770 E0.01265

G1 X87.933 Y102.581 E0.03140

G1 X87.316 Y102.577 E0.01688

G1 X88.316 Y101.577 E0.03872

G1 X88.060 Y101.478 E0.00751

G1 X87.844 Y101.428 E0.00607

G1 X86.699 Y102.573 E0.04432

G1 X86.083 Y102.569 E0.01688

G1 X87.284 Y101.368 E0.04649

G1 X87.025 Y101.384 E0.00708

G1 X86.980 Y101.364 E0.00137

G1 X86.743 Y101.394 E0.00652

G1 X86.594 Y101.437 E0.00426

G1 X85.466 Y102.565 E0.04365

G1 X84.845 Y102.566 E0.01699

G1 X85.947 Y101.463 E0.04267

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.845 Y102.566 E-0.86405

G1 X84.931 Y102.566 E-0.04795

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X90.398 Y97.365

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.574 Y97.374 E0.05668

G1 X92.589 Y97.433 E0.00159

G1 X92.592 Y98.730 E0.03381

G1 X91.032 Y97.735 E0.04820

G1 X90.450 Y97.396 E0.01756

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.096 Y97.379 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X92.989 Y99.108

G1 Z11.150

G1 E3.20000 F2400.00000

M73 P95 R3

M204 S800

G1 F1500.000

G1 X92.905 Y99.213 E0.00351

G1 X92.704 Y99.262 E0.00539

G1 X92.599 Y99.230 E0.00286

G1 X90.815 Y98.092 E0.05515

G1 X89.938 Y97.581 E0.02644

G1 X89.600 Y97.324 E0.01106

G1 X89.512 Y97.237 E0.00321

G1 X89.351 Y97.000 E0.00747

G1 X89.472 Y96.944 E0.00346

G1 X92.718 Y96.956 E0.08456

G1 X92.800 Y96.974 E0.00221

G1 X92.952 Y97.167 E0.00640

G1 X93.007 Y97.379 E0.00570

G1 X93.004 Y99.050 E0.04353

M204 S1250

G1 X92.855 Y99.119 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.905 Y99.213 E-0.10576

G1 X92.704 Y99.262 E-0.11474

G1 X92.599 Y99.230 E-0.06083

G1 X91.640 Y98.618 E-0.63066

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X91.779 Y98.063

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X92.343 Y97.498 E0.02497

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.779 Y98.063 E-0.44261

G1 E-0.51739 F4200.00000

G1 Z11.350 F9000.000

G1 X90.197 Y97.308

G1 Z11.150

G1 E3.20000 F2400.00000

G1 X89.787 Y97.170 E0.00333

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.197 Y97.308 E-0.24014

G1 E-0.71986 F4200.00000

G1 Z11.350 F9000.000

G1 X90.399 Y110.363

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.574 Y110.372 E0.05665

G1 X92.589 Y110.431 E0.00159

G1 X92.592 Y111.728 E0.03379

G1 X91.032 Y110.733 E0.04818

G1 X90.451 Y110.394 E0.01754

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.097 Y110.377 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X92.989 Y112.105

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.905 Y112.211 E0.00352

G1 X92.705 Y112.260 E0.00538

G1 X92.599 Y112.228 E0.00287

G1 X90.815 Y111.090 E0.05515

G1 X89.933 Y110.575 E0.02662

G1 X89.604 Y110.327 E0.01072

G1 X89.512 Y110.235 E0.00339

G1 X89.351 Y109.998 E0.00747

G1 X89.472 Y109.942 E0.00346

G1 X92.718 Y109.954 E0.08458

G1 X92.800 Y109.971 E0.00218

G1 X92.952 Y110.165 E0.00642

G1 X93.007 Y110.377 E0.00570

G1 X93.004 Y112.047 E0.04351

M204 S1250

G1 X92.855 Y112.116 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.905 Y112.211 E-0.10604

G1 X92.705 Y112.260 E-0.11448

G1 X92.599 Y112.228 E-0.06097

G1 X91.640 Y111.616 E-0.63052

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X92.343 Y110.496

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X91.778 Y111.060 E0.02496

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.343 Y110.496 E-0.44232

G1 E-0.51768 F4200.00000

G1 Z11.350 F9000.000

G1 X91.342 Y115.912

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.072 Y115.874 E0.16338

G1 X83.162 Y115.897 E0.04978

G1 X83.724 Y115.538 E0.01738

G1 X84.242 Y115.248 E0.01547

G1 X84.686 Y114.973 E0.01361

G1 X85.738 Y114.410 E0.03108

G1 X86.197 Y114.225 E0.01289

G1 X86.679 Y114.084 E0.01310

G1 X87.026 Y114.041 E0.00911

G1 X87.081 Y114.065 E0.00157

G1 X87.447 Y114.030 E0.00957

G1 X87.747 Y114.070 E0.00788

G1 X88.152 Y114.175 E0.01091

G1 X88.634 Y114.361 E0.01346

G1 X89.405 Y114.750 E0.02249

G1 X90.029 Y115.096 E0.01859

G1 X91.291 Y115.880 E0.03872

M204 S1250

G1 X92.011 Y116.336 F9000.000

M204 S800

G1 F1500.000

G1 X85.073 Y116.292 E0.18076

G1 X82.431 Y116.324 E0.06885

G1 X82.320 Y116.307 E0.00294

G1 X82.298 Y116.225 E0.00220

G1 X82.380 Y116.029 E0.00553

G1 X82.553 Y115.845 E0.00658

G1 X82.891 Y115.574 E0.01129

G1 X83.509 Y115.179 E0.01911

G1 X84.030 Y114.888 E0.01555

G1 X84.477 Y114.610 E0.01371

G1 X85.561 Y114.031 E0.03202

G1 X86.059 Y113.830 E0.01400

G1 X86.594 Y113.673 E0.01452

G1 X87.088 Y113.612 E0.01297

G1 X87.149 Y113.639 E0.00175

G1 X87.438 Y113.611 E0.00754

G1 X87.836 Y113.662 E0.01046

G1 X88.280 Y113.777 E0.01197

G1 X88.804 Y113.979 E0.01462

G1 X89.600 Y114.381 E0.02324

G1 X90.241 Y114.735 E0.01908

G1 X91.581 Y115.568 E0.04111

G1 X91.930 Y115.838 E0.01149

G1 X92.162 Y116.137 E0.00988

G1 X92.175 Y116.179 E0.00114

G1 X92.045 Y116.287 E0.00440

M204 S1250

G1 X91.717 Y116.065 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.400 Y116.288 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X85.968 Y114.453

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X84.858 Y115.563 E0.04289

G1 X85.477 Y115.563 E0.01692

G1 X86.609 Y114.431 E0.04374

G1 X86.743 Y114.392 E0.00381

G1 X86.980 Y114.362 E0.00651

G1 X87.026 Y114.382 E0.00138

G1 X87.295 Y114.365 E0.00736

G1 X86.093 Y115.567 E0.04643

G1 X86.708 Y115.571 E0.01681

G1 X87.852 Y114.427 E0.04417

G1 X88.060 Y114.476 E0.00585

G1 X88.322 Y114.577 E0.00766

G1 X87.323 Y115.575 E0.03856

G1 X87.939 Y115.579 E0.01681

G1 X88.748 Y114.770 E0.03125

G1 X89.160 Y114.977 E0.01260

G1 X88.554 Y115.583 E0.02338

G1 X89.170 Y115.587 E0.01681

G1 X89.562 Y115.195 E0.01513

G1 X89.957 Y115.419 E0.01241

G1 X89.598 Y115.777 E0.01383

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.957 Y115.419 E-0.28063

G1 X89.562 Y115.195 E-0.25173

G1 X89.170 Y115.587 E-0.30705

G1 X89.039 Y115.586 E-0.07259

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X84.092 Y110.365

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.720 Y110.576 E0.01113

G1 X82.346 Y111.430 E0.04215

G1 X81.889 Y111.734 E0.01432

G1 X81.907 Y110.371 E0.03552

G1 X84.032 Y110.365 E0.05536

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.720 Y110.576 E-0.20835

G1 X82.642 Y111.246 E-0.70365

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X81.643 Y112.250

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.524 Y112.161 E0.00387

G1 X81.469 Y111.995 E0.00455

G1 X81.478 Y110.382 E0.04201

G1 X81.515 Y110.204 E0.00474

G1 X81.659 Y109.982 E0.00691

G1 X81.770 Y109.953 E0.00299

G1 X84.937 Y109.945 E0.08253

G1 X85.122 Y110.009 E0.00510

G1 X84.948 Y110.258 E0.00792

G1 X84.739 Y110.441 E0.00724

G1 X84.411 Y110.664 E0.01032

G1 X83.934 Y110.935 E0.01431

G1 X82.572 Y111.781 E0.04177

G1 X82.045 Y112.132 E0.01649

G1 X81.806 Y112.256 E0.00701

G1 X81.701 Y112.265 E0.00276

M204 S1250

G1 X81.615 Y112.104 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.524 Y112.161 E-0.11376

G1 X81.469 Y111.995 E-0.09686

G1 X81.476 Y110.729 E-0.70138

G1 E-0.04800 F4200.00000

G1 Z11.350 F9000.000

G1 X82.453 Y110.495

G1 Z11.150

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X82.025 Y110.923 E0.01894

M204 S1250

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;11.3

G1 Z11.300 F9000.000

;AFTER\_LAYER\_CHANGE

;11.3

G1 E-3.20000 F4200.00000

G1 Z11.500 F9000.000

G1 X92.593 Y46.740

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X91.070 Y45.765 E0.04714

G1 X90.694 Y45.545 E0.01133

G1 X92.564 Y45.553 E0.04872

G1 X92.595 Y45.736 E0.00483

G1 X92.593 Y46.680 E0.02460

M204 S1250

G1 X92.991 Y47.111 F9000.000

M204 S800

G1 F1500.000

G1 X92.905 Y47.220 E0.00363

G1 X92.700 Y47.272 E0.00552

G1 X92.604 Y47.243 E0.00262

G1 X90.852 Y46.121 E0.05421

G1 X90.340 Y45.822 E0.01544

G1 X89.913 Y45.488 E0.01413

G1 X89.762 Y45.316 E0.00596

G1 X89.681 Y45.172 E0.00429

G1 X89.837 Y45.121 E0.00427

G1 X92.714 Y45.136 E0.07496

G1 X92.806 Y45.159 E0.00247

G1 X92.931 Y45.326 E0.00544

G1 X93.002 Y45.560 E0.00639

G1 X93.005 Y47.052 E0.03888

M204 S1250

G1 X92.853 Y47.123 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.905 Y47.220 E-0.10819

G1 X92.700 Y47.272 E-0.11732

G1 X92.604 Y47.243 E-0.05575

G1 X91.645 Y46.629 E-0.63074

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X91.061 Y50.752

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.422 Y50.746 E0.19902

G1 X83.743 Y50.537 E0.00998

G1 X84.715 Y49.972 E0.02928

G1 X85.701 Y49.439 E0.02920

G1 X86.196 Y49.237 E0.01393

G1 X86.668 Y49.097 E0.01284

G1 X87.062 Y49.040 E0.01037

G1 X87.146 Y49.062 E0.00227

G1 X87.448 Y49.042 E0.00787

G1 X87.645 Y49.060 E0.00517

G1 X88.203 Y49.205 E0.01502

G1 X88.655 Y49.382 E0.01265

G1 X89.584 Y49.859 E0.02719

G1 X90.495 Y50.387 E0.02745

G1 X91.010 Y50.720 E0.01597

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.365 Y50.725 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X82.610 Y50.923

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.844 Y50.669 E0.00900

G1 X83.154 Y50.422 E0.01033

G1 X83.525 Y50.181 E0.01151

G1 X84.511 Y49.608 E0.02972

G1 X85.522 Y49.061 E0.02995

G1 X86.057 Y48.842 E0.01507

G1 X86.579 Y48.688 E0.01417

G1 X87.086 Y48.614 E0.01336

G1 X87.187 Y48.640 E0.00273

G1 X87.453 Y48.623 E0.00694

G1 X87.717 Y48.647 E0.00690

G1 X88.332 Y48.807 E0.01657

G1 X88.828 Y49.000 E0.01385

G1 X89.784 Y49.492 E0.02802

G1 X90.713 Y50.031 E0.02799

G1 X91.374 Y50.457 E0.02049

G1 X91.682 Y50.704 E0.01028

G1 X91.945 Y51.071 E0.01178

G1 X91.883 Y51.160 E0.00281

G1 X91.820 Y51.172 E0.00166

G1 X85.074 Y51.153 E0.17579

G1 X82.660 Y51.168 E0.06288

G1 X82.575 Y51.156 E0.00224

G1 X82.543 Y51.085 E0.00201

G1 X82.587 Y50.978 E0.00301

M204 S1250

G1 X82.956 Y50.931 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.844 Y50.669 E-0.22288

G1 X83.154 Y50.422 E-0.21972

G1 X83.525 Y50.181 E-0.24481

G1 X83.875 Y49.977 E-0.22459

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X89.588 Y50.625

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.740 Y49.777 E0.03313

G1 X88.526 Y49.668 E0.00662

G1 X88.107 Y49.503 E0.01245

G1 X87.746 Y49.410 E0.01029

G1 X88.773 Y50.437 E0.04011

G1 X88.146 Y50.436 E0.01732

G1 X87.077 Y49.367 E0.04175

G1 X87.044 Y49.359 E0.00094

G1 X86.736 Y49.404 E0.00861

G1 X86.544 Y49.461 E0.00553

G1 X87.519 Y50.436 E0.03809

G1 X86.892 Y50.435 E0.01732

G1 X86.079 Y49.623 E0.03173

G1 X85.835 Y49.723 E0.00730

G1 X85.652 Y49.822 E0.00574

G1 X86.265 Y50.435 E0.02394

G1 X85.638 Y50.434 E0.01732

G1 X85.246 Y50.042 E0.01533

G1 X84.840 Y50.262 E0.01276

G1 X85.199 Y50.622 E0.01404

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.840 Y50.262 E-0.28168

G1 X85.246 Y50.042 E-0.25593

G1 X85.638 Y50.434 E-0.30756

G1 X85.759 Y50.434 E-0.06683

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X81.889 Y46.738

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.897 Y45.652 E0.02830

G1 X81.933 Y45.539 E0.00310

G1 X83.793 Y45.548 E0.04847

G1 X81.940 Y46.706 E0.05694

M204 S1250

G1 X81.806 Y47.267 F9000.000

M204 S800

G1 F1500.000

G1 X81.726 Y47.282 E0.00212

G1 X81.624 Y47.253 E0.00276

G1 X81.508 Y47.149 E0.00407

G1 X81.470 Y47.009 E0.00379

G1 X81.479 Y45.585 E0.03710

G1 X81.584 Y45.261 E0.00888

G1 X81.666 Y45.155 E0.00349

G1 X81.775 Y45.121 E0.00298

G1 X84.641 Y45.135 E0.07467

G1 X84.798 Y45.182 E0.00426

G1 X84.685 Y45.361 E0.00551

G1 X84.439 Y45.598 E0.00891

G1 X84.129 Y45.831 E0.01009

G1 X81.860 Y47.241 E0.06961

M204 S1250

G1 X81.745 Y47.212 F9000.000

G1 X82.021 Y45.757

M204 S1000

G1 F4800.000

G1 X82.483 Y46.219 E0.02043

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.021 Y45.757 E-0.36201

G1 E-0.59799 F4200.00000

G1 Z11.500 F9000.000

G1 X81.933 Y58.537

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.793 Y58.546 E0.04847

G1 X81.889 Y59.736 E0.05850

G1 X81.897 Y58.650 E0.02830

G1 X81.915 Y58.594 E0.00153

M204 S1250

G1 X81.643 Y58.174 F9000.000

M204 S800

G1 F1500.000

G1 X81.775 Y58.119 E0.00374

G1 X84.641 Y58.133 E0.07467

G1 X84.798 Y58.180 E0.00426

G1 X84.685 Y58.359 E0.00551

G1 X84.439 Y58.596 E0.00891

G1 X84.129 Y58.829 E0.01009

G1 X81.918 Y60.211 E0.06794

G1 X81.726 Y60.280 E0.00533

G1 X81.624 Y60.251 E0.00275

G1 X81.508 Y60.147 E0.00408

G1 X81.470 Y60.007 E0.00378

G1 X81.479 Y58.583 E0.03710

G1 X81.608 Y58.223 E0.00996

M204 S1250

G1 X81.780 Y58.215 F9000.000

G1 X82.483 Y59.217

M204 S1000

G1 F4800.000

G1 X82.021 Y58.756 E0.02041

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.483 Y59.217 E-0.36182

G1 E-0.59818 F4200.00000

G1 Z11.500 F9000.000

G1 X83.423 Y63.743

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.743 Y63.535 E0.00997

G1 X84.715 Y62.970 E0.02928

G1 X85.701 Y62.437 E0.02920

G1 X86.196 Y62.234 E0.01394

G1 X86.668 Y62.094 E0.01284

G1 X87.064 Y62.037 E0.01043

G1 X87.148 Y62.058 E0.00225

G1 X87.446 Y62.040 E0.00779

G1 X87.646 Y62.058 E0.00521

G1 X88.203 Y62.202 E0.01501

G1 X88.655 Y62.380 E0.01265

G1 X89.584 Y62.857 E0.02720

G1 X90.495 Y63.385 E0.02745

G1 X91.060 Y63.750 E0.01752

G1 X83.483 Y63.743 E0.19744

M204 S1250

G1 X82.610 Y63.921 F9000.000

M204 S800

G1 F1500.000

G1 X82.844 Y63.667 E0.00900

G1 X83.154 Y63.420 E0.01033

G1 X83.525 Y63.179 E0.01151

G1 X84.511 Y62.606 E0.02972

G1 X85.522 Y62.059 E0.02995

G1 X86.057 Y61.840 E0.01508

G1 X86.579 Y61.685 E0.01417

G1 X87.087 Y61.612 E0.01338

G1 X87.188 Y61.637 E0.00272

G1 X87.453 Y61.621 E0.00691

G1 X87.717 Y61.645 E0.00691

G1 X88.332 Y61.804 E0.01656

G1 X88.827 Y61.998 E0.01386

G1 X89.784 Y62.490 E0.02802

G1 X90.713 Y63.029 E0.02799

G1 X91.374 Y63.455 E0.02050

G1 X91.682 Y63.701 E0.01027

G1 X91.945 Y64.069 E0.01179

G1 X91.883 Y64.157 E0.00281

G1 X91.821 Y64.170 E0.00166

G1 X85.074 Y64.151 E0.17580

G1 X82.660 Y64.166 E0.06289

G1 X82.575 Y64.153 E0.00223

G1 X82.543 Y64.083 E0.00201

G1 X82.587 Y63.976 E0.00301

M204 S1250

G1 X82.956 Y63.929 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.844 Y63.667 E-0.22288

G1 X83.154 Y63.420 E-0.21972

G1 X83.525 Y63.179 E-0.24481

G1 X83.875 Y62.975 E-0.22459

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X89.587 Y63.623

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.739 Y62.775 E0.03312

G1 X88.526 Y62.665 E0.00663

G1 X88.107 Y62.501 E0.01244

G1 X87.745 Y62.408 E0.01030

G1 X88.772 Y63.435 E0.04011

G1 X88.146 Y63.434 E0.01731

G1 X87.074 Y62.363 E0.04184

G1 X87.048 Y62.356 E0.00076

G1 X86.736 Y62.401 E0.00871

G1 X86.543 Y62.458 E0.00554

G1 X87.519 Y63.433 E0.03809

G1 X86.892 Y63.433 E0.01731

G1 X86.080 Y62.621 E0.03173

G1 X85.835 Y62.721 E0.00730

G1 X85.652 Y62.820 E0.00574

G1 X86.265 Y63.432 E0.02393

G1 X85.638 Y63.432 E0.01731

G1 X85.246 Y63.040 E0.01532

G1 X84.840 Y63.260 E0.01275

G1 X85.200 Y63.620 E0.01404

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.840 Y63.260 E-0.28165

G1 X85.246 Y63.040 E-0.25591

G1 X85.638 Y63.432 E-0.30750

G1 X85.759 Y63.432 E-0.06695

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X90.694 Y58.543

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.564 Y58.552 E0.04873

G1 X92.595 Y58.734 E0.00479

G1 X92.593 Y59.738 E0.02616

G1 X91.070 Y58.763 E0.04714

G1 X90.746 Y58.574 E0.00977

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.391 Y58.554 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X92.991 Y60.109

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.905 Y60.218 E0.00362

G1 X92.700 Y60.270 E0.00552

G1 X92.603 Y60.240 E0.00262

G1 X90.852 Y59.119 E0.05420

G1 X90.340 Y58.820 E0.01544

G1 X89.913 Y58.485 E0.01415

G1 X89.762 Y58.313 E0.00595

G1 X89.681 Y58.171 E0.00428

G1 X89.837 Y58.119 E0.00427

G1 X91.424 Y58.141 E0.04136

G1 X92.714 Y58.134 E0.03362

G1 X92.806 Y58.156 E0.00245

G1 X92.931 Y58.324 E0.00545

G1 X93.002 Y58.558 E0.00639

G1 X93.005 Y60.050 E0.03888

M204 S1250

G1 X92.853 Y60.121 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.905 Y60.218 E-0.10807

G1 X92.700 Y60.270 E-0.11744

G1 X92.603 Y60.240 E-0.05578

G1 X91.645 Y59.627 E-0.63071

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X92.564 Y71.550

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y71.732 E0.00479

G1 X92.593 Y72.735 E0.02615

G1 X91.070 Y71.760 E0.04714

G1 X90.694 Y71.541 E0.01132

G1 X92.504 Y71.551 E0.04716

M204 S1250

G1 X92.714 Y71.132 F9000.000

M204 S800

G1 F1500.000

G1 X92.806 Y71.154 E0.00245

G1 X92.931 Y71.321 E0.00544

G1 X93.002 Y71.556 E0.00640

G1 X93.010 Y73.027 E0.03833

G1 X92.991 Y73.106 E0.00211

G1 X92.905 Y73.216 E0.00363

G1 X92.700 Y73.267 E0.00552

G1 X92.603 Y73.238 E0.00262

G1 X90.852 Y72.116 E0.05421

G1 X90.340 Y71.818 E0.01544

G1 X89.913 Y71.483 E0.01414

G1 X89.762 Y71.311 E0.00595

G1 X89.681 Y71.170 E0.00424

G1 X89.837 Y71.117 E0.00430

G1 X91.424 Y71.139 E0.04136

G1 X92.654 Y71.132 E0.03206

M204 S1250

G1 X92.748 Y71.220 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.806 Y71.154 E-0.08474

G1 X92.931 Y71.321 E-0.11579

G1 X93.002 Y71.556 E-0.13615

G1 X93.008 Y72.595 E-0.57533

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X91.061 Y76.748

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.423 Y76.741 E0.19903

G1 X83.744 Y76.533 E0.00997

G1 X84.715 Y75.968 E0.02928

G1 X85.701 Y75.434 E0.02920

G1 X86.196 Y75.232 E0.01393

G1 X86.668 Y75.092 E0.01283

G1 X87.064 Y75.035 E0.01044

G1 X87.148 Y75.056 E0.00225

G1 X87.446 Y75.038 E0.00779

G1 X87.646 Y75.056 E0.00521

G1 X88.203 Y75.200 E0.01500

G1 X88.655 Y75.378 E0.01265

G1 X89.584 Y75.854 E0.02720

G1 X90.495 Y76.382 E0.02745

G1 X91.011 Y76.715 E0.01599

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.365 Y76.721 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X82.610 Y76.919

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.844 Y76.665 E0.00900

G1 X83.154 Y76.418 E0.01033

G1 X83.525 Y76.177 E0.01151

G1 X84.511 Y75.603 E0.02972

G1 X85.522 Y75.056 E0.02995

G1 X86.057 Y74.837 E0.01507

G1 X86.578 Y74.683 E0.01416

G1 X87.087 Y74.610 E0.01338

G1 X87.188 Y74.635 E0.00272

G1 X87.453 Y74.619 E0.00691

G1 X87.717 Y74.643 E0.00691

G1 X88.332 Y74.802 E0.01656

G1 X88.827 Y74.996 E0.01386

G1 X89.784 Y75.488 E0.02802

G1 X90.713 Y76.026 E0.02798

G1 X91.374 Y76.453 E0.02050

G1 X91.682 Y76.699 E0.01028

G1 X91.945 Y77.067 E0.01179

G1 X91.883 Y77.156 E0.00282

G1 X91.821 Y77.168 E0.00164

G1 X85.074 Y77.149 E0.17580

G1 X82.660 Y77.164 E0.06289

G1 X82.575 Y77.151 E0.00223

G1 X82.543 Y77.081 E0.00201

G1 X82.587 Y76.974 E0.00301

M204 S1250

G1 X82.956 Y76.927 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.844 Y76.665 E-0.22288

G1 X83.154 Y76.418 E-0.21972

G1 X83.525 Y76.177 E-0.24484

G1 X83.875 Y75.973 E-0.22457

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X89.588 Y76.621

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.741 Y75.774 E0.03310

G1 X88.526 Y75.663 E0.00669

G1 X88.107 Y75.498 E0.01245

G1 X87.746 Y75.406 E0.01027

G1 X88.773 Y76.433 E0.04011

G1 X88.146 Y76.432 E0.01732

G1 X87.075 Y75.361 E0.04184

G1 X87.048 Y75.354 E0.00079

G1 X86.735 Y75.399 E0.00873

G1 X86.544 Y75.456 E0.00552

G1 X87.519 Y76.431 E0.03812

G1 X86.892 Y76.431 E0.01732

G1 X86.079 Y75.618 E0.03176

G1 X85.835 Y75.718 E0.00729

G1 X85.652 Y75.817 E0.00575

G1 X86.265 Y76.430 E0.02396

G1 X85.638 Y76.430 E0.01732

G1 X85.245 Y76.037 E0.01534

G1 X84.840 Y76.258 E0.01276

G1 X85.199 Y76.618 E0.01405

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.840 Y76.258 E-0.28179

G1 X85.245 Y76.037 E-0.25596

G1 X85.638 Y76.430 E-0.30776

G1 X85.758 Y76.430 E-0.06650

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X81.889 Y72.734

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.897 Y71.648 E0.02830

G1 X81.933 Y71.535 E0.00309

G1 X83.793 Y71.544 E0.04847

G1 X81.940 Y72.702 E0.05693

M204 S1250

G1 X81.806 Y73.262 F9000.000

M204 S800

G1 F1500.000

G1 X81.726 Y73.278 E0.00212

G1 X81.624 Y73.249 E0.00275

G1 X81.508 Y73.145 E0.00408

G1 X81.470 Y73.005 E0.00378

G1 X81.479 Y71.581 E0.03710

G1 X81.584 Y71.256 E0.00890

G1 X81.666 Y71.151 E0.00346

G1 X81.775 Y71.117 E0.00299

G1 X84.641 Y71.131 E0.07467

G1 X84.798 Y71.178 E0.00426

G1 X84.685 Y71.357 E0.00551

G1 X84.439 Y71.594 E0.00891

G1 X84.129 Y71.827 E0.01009

G1 X81.860 Y73.236 E0.06961

M204 S1250

G1 X81.745 Y73.208 F9000.000

G1 X82.021 Y71.754

M204 S1000

G1 F4800.000

G1 X82.483 Y72.215 E0.02041

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.021 Y71.754 E-0.36182

G1 E-0.59818 F4200.00000

G1 Z11.500 F9000.000

G1 X81.933 Y84.533

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.793 Y84.542 E0.04847

G1 X81.889 Y85.732 E0.05850

G1 X81.897 Y84.645 E0.02832

G1 X81.914 Y84.590 E0.00151

M204 S1250

G1 X81.643 Y84.170 F9000.000

M204 S800

G1 F1500.000

G1 X81.775 Y84.115 E0.00374

G1 X84.641 Y84.129 E0.07467

G1 X84.798 Y84.176 E0.00426

G1 X84.685 Y84.354 E0.00550

G1 X84.439 Y84.592 E0.00892

G1 X84.129 Y84.825 E0.01009

G1 X81.918 Y86.207 E0.06794

G1 X81.726 Y86.276 E0.00533

G1 X81.624 Y86.247 E0.00275

G1 X81.508 Y86.143 E0.00408

G1 X81.470 Y86.003 E0.00379

G1 X81.479 Y84.578 E0.03712

G1 X81.608 Y84.219 E0.00994

M204 S1250

G1 X81.781 Y84.211 F9000.000

G1 X82.483 Y85.213

M204 S1000

G1 F4800.000

G1 X82.021 Y84.752 E0.02041

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.483 Y85.213 E-0.36182

G1 E-0.59818 F4200.00000

G1 Z11.500 F9000.000

G1 X83.423 Y89.739

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.744 Y89.530 E0.00997

G1 X84.715 Y88.965 E0.02928

G1 X85.701 Y88.432 E0.02919

G1 X86.196 Y88.230 E0.01394

G1 X86.668 Y88.090 E0.01283

G1 X87.064 Y88.033 E0.01044

G1 X87.149 Y88.055 E0.00227

G1 X87.447 Y88.036 E0.00777

G1 X87.645 Y88.054 E0.00519

G1 X88.204 Y88.198 E0.01504

G1 X88.655 Y88.375 E0.01264

G1 X89.584 Y88.852 E0.02720

G1 X90.495 Y89.380 E0.02745

G1 X91.061 Y89.746 E0.01755

G1 X83.483 Y89.739 E0.19745

M204 S1250

G1 X82.610 Y89.916 F9000.000

M204 S800

G1 F1500.000

G1 X82.844 Y89.662 E0.00900

G1 X83.154 Y89.416 E0.01032

G1 X83.525 Y89.175 E0.01152

G1 X84.511 Y88.601 E0.02973

G1 X85.522 Y88.054 E0.02994

G1 X86.057 Y87.835 E0.01507

G1 X86.578 Y87.681 E0.01416

G1 X87.087 Y87.608 E0.01338

G1 X87.188 Y87.633 E0.00273

G1 X87.453 Y87.617 E0.00691

G1 X87.717 Y87.641 E0.00691

G1 X88.332 Y87.800 E0.01657

G1 X88.827 Y87.994 E0.01385

G1 X89.784 Y88.486 E0.02802

G1 X90.713 Y89.024 E0.02799

G1 X91.374 Y89.451 E0.02050

G1 X91.682 Y89.697 E0.01028

G1 X91.945 Y90.065 E0.01179

G1 X91.883 Y90.154 E0.00282

G1 X91.821 Y90.166 E0.00164

G1 X85.074 Y90.146 E0.17580

G1 X82.661 Y90.162 E0.06287

G1 X82.576 Y90.149 E0.00224

G1 X82.543 Y90.078 E0.00202

G1 X82.587 Y89.972 E0.00301

M204 S1250

G1 X82.955 Y89.924 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.844 Y89.662 E-0.22287

G1 X83.154 Y89.416 E-0.21947

G1 X83.525 Y89.175 E-0.24498

G1 X83.875 Y88.971 E-0.22468

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X89.588 Y89.619

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.740 Y88.771 E0.03314

G1 X88.526 Y88.661 E0.00664

G1 X88.107 Y88.497 E0.01243

G1 X87.746 Y88.404 E0.01029

G1 X88.773 Y89.430 E0.04011

G1 X88.146 Y89.430 E0.01732

G1 X87.075 Y88.359 E0.04183

G1 X87.048 Y88.352 E0.00078

G1 X86.735 Y88.397 E0.00872

G1 X86.544 Y88.454 E0.00552

G1 X87.519 Y89.429 E0.03811

G1 X86.892 Y89.429 E0.01732

G1 X86.079 Y88.616 E0.03175

G1 X85.652 Y88.815 E0.01303

G1 X86.265 Y89.428 E0.02395

G1 X85.638 Y89.428 E0.01732

G1 X85.245 Y89.035 E0.01534

G1 X84.839 Y89.256 E0.01276

G1 X85.199 Y89.615 E0.01405

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.839 Y89.256 E-0.28186

G1 X85.245 Y89.035 E-0.25598

G1 X85.638 Y89.428 E-0.30774

G1 X85.758 Y89.428 E-0.06643

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X90.694 Y84.538

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.564 Y84.548 E0.04874

G1 X92.595 Y84.729 E0.00478

G1 X92.593 Y85.733 E0.02617

G1 X91.070 Y84.758 E0.04714

G1 X90.746 Y84.569 E0.00977

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.391 Y84.550 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X92.991 Y86.104

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.905 Y86.214 E0.00363

G1 X92.700 Y86.265 E0.00552

G1 X92.603 Y86.236 E0.00262

G1 X90.852 Y85.114 E0.05421

G1 X90.340 Y84.816 E0.01544

G1 X89.913 Y84.481 E0.01414

G1 X89.762 Y84.309 E0.00594

G1 X89.681 Y84.166 E0.00430

G1 X89.837 Y84.114 E0.00427

G1 X91.424 Y84.137 E0.04136

G1 X92.714 Y84.129 E0.03361

G1 X92.806 Y84.152 E0.00246

G1 X92.932 Y84.319 E0.00544

G1 X93.002 Y84.554 E0.00639

G1 X93.005 Y86.046 E0.03889

M204 S1250

G1 X92.853 Y86.117 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.905 Y86.214 E-0.10822

G1 X92.700 Y86.265 E-0.11730

G1 X92.603 Y86.236 E-0.05582

G1 X91.645 Y85.622 E-0.63066

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X92.564 Y97.546

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.595 Y97.727 E0.00478

G1 X92.593 Y98.731 E0.02617

G1 X91.070 Y97.756 E0.04714

G1 X90.694 Y97.536 E0.01134

G1 X92.504 Y97.546 E0.04718

M204 S1250

G1 X92.714 Y97.127 F9000.000

M204 S800

G1 F1500.000

G1 X92.806 Y97.150 E0.00246

G1 X92.932 Y97.317 E0.00544

G1 X93.002 Y97.552 E0.00639

G1 X93.010 Y99.023 E0.03833

G1 X92.991 Y99.102 E0.00214

G1 X92.905 Y99.212 E0.00363

G1 X92.700 Y99.263 E0.00551

G1 X92.603 Y99.234 E0.00262

G1 X90.852 Y98.112 E0.05421

G1 X90.340 Y97.814 E0.01544

G1 X89.913 Y97.479 E0.01413

G1 X89.762 Y97.307 E0.00596

G1 X89.762 Y97.281 E0.00068

G1 X89.681 Y97.165 E0.00366

G1 X89.837 Y97.112 E0.00429

G1 X91.424 Y97.135 E0.04136

G1 X92.654 Y97.128 E0.03205

M204 S1250

G1 X92.747 Y97.216 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.806 Y97.150 E-0.08487

G1 X92.932 Y97.317 E-0.11568

G1 X93.002 Y97.552 E-0.13593

G1 X93.008 Y98.590 E-0.57551

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X91.062 Y102.744

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.423 Y102.737 E0.19903

G1 X83.744 Y102.528 E0.00997

G1 X84.715 Y101.963 E0.02929

G1 X85.701 Y101.430 E0.02919

G1 X86.195 Y101.228 E0.01393

G1 X86.668 Y101.088 E0.01283

G1 X87.064 Y101.031 E0.01043

G1 X87.149 Y101.053 E0.00227

G1 X87.447 Y101.034 E0.00780

G1 X87.645 Y101.051 E0.00518

G1 X88.203 Y101.196 E0.01502

G1 X88.655 Y101.373 E0.01265

G1 X89.584 Y101.850 E0.02720

G1 X90.495 Y102.379 E0.02745

G1 X91.011 Y102.711 E0.01599

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.365 Y102.717 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X82.610 Y102.914

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.844 Y102.660 E0.00900

G1 X83.154 Y102.414 E0.01032

G1 X83.525 Y102.173 E0.01152

G1 X84.511 Y101.599 E0.02973

G1 X85.522 Y101.052 E0.02995

G1 X86.057 Y100.833 E0.01507

G1 X86.578 Y100.679 E0.01416

G1 X87.087 Y100.606 E0.01338

G1 X87.188 Y100.631 E0.00273

G1 X87.453 Y100.615 E0.00692

G1 X87.717 Y100.638 E0.00690

G1 X88.332 Y100.798 E0.01657

G1 X88.827 Y100.992 E0.01386

G1 X89.784 Y101.484 E0.02802

G1 X90.713 Y102.022 E0.02799

G1 X91.374 Y102.448 E0.02049

G1 X91.682 Y102.694 E0.01028

G1 X91.945 Y103.063 E0.01179

G1 X91.883 Y103.152 E0.00282

G1 X91.821 Y103.164 E0.00164

G1 X85.074 Y103.144 E0.17580

G1 X82.661 Y103.160 E0.06287

G1 X82.576 Y103.147 E0.00224

G1 X82.543 Y103.076 E0.00202

G1 X82.587 Y102.970 E0.00301

M204 S1250

G1 X82.955 Y102.922 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.844 Y102.660 E-0.22287

G1 X83.154 Y102.414 E-0.21947

G1 X83.525 Y102.173 E-0.24498

G1 X83.875 Y101.969 E-0.22468

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X89.588 Y102.617

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.740 Y101.769 E0.03314

G1 X88.526 Y101.659 E0.00664

G1 X88.107 Y101.494 E0.01245

G1 X87.746 Y101.401 E0.01030

G1 X88.773 Y102.428 E0.04013

G1 X88.146 Y102.428 E0.01732

G1 X87.075 Y101.357 E0.04182

G1 X87.047 Y101.350 E0.00080

G1 X86.735 Y101.395 E0.00871

G1 X86.543 Y101.452 E0.00552

G1 X87.519 Y102.427 E0.03811

G1 X86.892 Y102.427 E0.01732

G1 X86.079 Y101.614 E0.03176

G1 X85.835 Y101.714 E0.00729

G1 X85.652 Y101.813 E0.00576

G1 X86.265 Y102.426 E0.02396

G1 X85.638 Y102.426 E0.01732

G1 X85.245 Y102.033 E0.01534

G1 X84.839 Y102.254 E0.01276

G1 X85.199 Y102.613 E0.01405

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.839 Y102.254 E-0.28186

G1 X85.245 Y102.033 E-0.25596

G1 X85.638 Y102.426 E-0.30779

G1 X85.758 Y102.426 E-0.06639

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X81.889 Y98.729

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.897 Y97.643 E0.02830

G1 X81.933 Y97.531 E0.00307

G1 X83.794 Y97.540 E0.04848

G1 X81.940 Y98.698 E0.05694

M204 S1250

G1 X81.806 Y99.258 F9000.000

M204 S800

G1 F1500.000

G1 X81.726 Y99.273 E0.00212

G1 X81.624 Y99.245 E0.00276

G1 X81.508 Y99.141 E0.00407

G1 X81.470 Y99.001 E0.00379

G1 X81.479 Y97.576 E0.03712

G1 X81.584 Y97.252 E0.00888

G1 X81.666 Y97.147 E0.00346

G1 X81.775 Y97.113 E0.00299

G1 X84.641 Y97.126 E0.07467

G1 X84.798 Y97.173 E0.00426

G1 X84.685 Y97.352 E0.00549

G1 X84.439 Y97.590 E0.00893

G1 X84.129 Y97.823 E0.01009

G1 X81.860 Y99.232 E0.06961

M204 S1250

G1 X81.745 Y99.204 F9000.000

G1 X82.021 Y97.750

M204 S1000

G1 F4800.000

G1 X82.483 Y98.211 E0.02040

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.021 Y97.750 E-0.36163

G1 E-0.59837 F4200.00000

G1 Z11.500 F9000.000

G1 X81.933 Y110.528

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.794 Y110.538 E0.04848

G1 X81.889 Y111.727 E0.05851

G1 X81.897 Y110.641 E0.02830

G1 X81.915 Y110.585 E0.00153

M204 S1250

G1 X81.643 Y110.165 F9000.000

M204 S800

G1 F1500.000

G1 X81.775 Y110.110 E0.00373

G1 X84.641 Y110.124 E0.07468

G1 X84.797 Y110.171 E0.00425

G1 X84.685 Y110.350 E0.00551

G1 X84.439 Y110.588 E0.00892

G1 X84.129 Y110.820 E0.01009

G1 X81.918 Y112.202 E0.06795

G1 X81.806 Y112.256 E0.00324

G1 X81.726 Y112.271 E0.00210

G1 X81.624 Y112.242 E0.00278

G1 X81.508 Y112.139 E0.00405

G1 X81.470 Y111.998 E0.00381

G1 X81.479 Y110.574 E0.03710

G1 X81.609 Y110.214 E0.00996

M204 S1250

G1 X81.781 Y110.206 F9000.000

G1 X82.483 Y111.208

M204 S1000

G1 F4800.000

G1 X82.021 Y110.746 E0.02044

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.483 Y111.208 E-0.36221

G1 E-0.59779 F4200.00000

G1 Z11.500 F9000.000

G1 X83.422 Y115.735

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.743 Y115.526 E0.01000

G1 X84.715 Y114.961 E0.02928

G1 X85.701 Y114.428 E0.02920

G1 X86.195 Y114.226 E0.01393

G1 X86.668 Y114.086 E0.01283

G1 X87.064 Y114.029 E0.01043

G1 X87.149 Y114.051 E0.00228

G1 X87.448 Y114.032 E0.00780

G1 X87.645 Y114.049 E0.00517

G1 X88.203 Y114.194 E0.01502

G1 X88.655 Y114.371 E0.01265

G1 X89.584 Y114.848 E0.02720

G1 X90.495 Y115.376 E0.02745

G1 X91.062 Y115.742 E0.01756

G1 X83.482 Y115.735 E0.19750

M204 S1250

G1 X82.610 Y115.912 F9000.000

M204 S800

G1 F1500.000

G1 X82.844 Y115.658 E0.00901

G1 X83.154 Y115.411 E0.01033

G1 X83.525 Y115.170 E0.01151

G1 X84.511 Y114.597 E0.02972

G1 X85.522 Y114.050 E0.02995

G1 X86.057 Y113.831 E0.01507

G1 X86.578 Y113.677 E0.01416

G1 X87.087 Y113.604 E0.01338

G1 X87.188 Y113.629 E0.00273

G1 X87.453 Y113.612 E0.00692

G1 X87.717 Y113.636 E0.00690

G1 X88.332 Y113.796 E0.01657

G1 X88.827 Y113.990 E0.01386

G1 X89.784 Y114.482 E0.02803

G1 X90.713 Y115.020 E0.02798

G1 X91.374 Y115.446 E0.02049

G1 X91.682 Y115.692 E0.01028

G1 X91.945 Y116.060 E0.01178

G1 X91.882 Y116.150 E0.00284

G1 X91.821 Y116.162 E0.00163

G1 X85.074 Y116.142 E0.17580

G1 X82.661 Y116.158 E0.06287

G1 X82.576 Y116.145 E0.00224

G1 X82.543 Y116.074 E0.00202

G1 X82.587 Y115.968 E0.00301

M204 S1250

G1 X82.956 Y115.920 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.844 Y115.658 E-0.22308

G1 X83.154 Y115.411 E-0.21968

G1 X83.525 Y115.170 E-0.24481

G1 X83.875 Y114.966 E-0.22443

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X89.588 Y115.615

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.740 Y114.767 E0.03314

G1 X88.526 Y114.657 E0.00665

G1 X88.107 Y114.492 E0.01245

G1 X87.746 Y114.399 E0.01030

G1 X88.773 Y115.426 E0.04014

G1 X88.146 Y115.426 E0.01733

G1 X87.075 Y114.355 E0.04183

G1 X87.047 Y114.348 E0.00080

G1 X86.735 Y114.393 E0.00871

G1 X86.543 Y114.450 E0.00552

G1 X87.519 Y115.425 E0.03811

G1 X86.892 Y115.425 E0.01733

G1 X86.079 Y114.612 E0.03176

G1 X85.835 Y114.712 E0.00728

G1 X85.652 Y114.811 E0.00576

G1 X86.265 Y115.424 E0.02396

G1 X85.638 Y115.424 E0.01733

G1 X85.245 Y115.031 E0.01534

G1 X84.839 Y115.252 E0.01276

G1 X85.199 Y115.611 E0.01405

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.839 Y115.252 E-0.28176

G1 X85.245 Y115.031 E-0.25599

G1 X85.638 Y115.424 E-0.30771

G1 X85.758 Y115.424 E-0.06653

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X90.694 Y110.534

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.564 Y110.542 E0.04872

G1 X92.595 Y110.725 E0.00483

G1 X92.593 Y111.729 E0.02616

G1 X91.070 Y110.754 E0.04714

G1 X90.746 Y110.565 E0.00977

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.391 Y110.544 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.500 F9000.000

G1 X92.991 Y112.100

G1 Z11.300

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.905 Y112.210 E0.00364

G1 X92.700 Y112.261 E0.00550

G1 X92.604 Y112.232 E0.00263

G1 X90.852 Y111.110 E0.05421

G1 X90.340 Y110.811 E0.01544

G1 X89.913 Y110.477 E0.01413

G1 X89.762 Y110.305 E0.00596

G1 X89.681 Y110.162 E0.00428

G1 X89.837 Y110.110 E0.00427

G1 X92.713 Y110.125 E0.07495

G1 X92.806 Y110.148 E0.00248

G1 X92.931 Y110.315 E0.00544

G1 X93.002 Y110.550 E0.00639

G1 X93.005 Y112.042 E0.03888

M204 S1250

G1 X92.852 Y112.113 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;11.45

G1 Z11.450 F9000.000

;AFTER\_LAYER\_CHANGE

;11.45

G1 E-3.20000 F4200.00000

G1 Z11.650 F9000.000

G1 X92.594 Y46.731

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X91.014 Y45.734 E0.04868

G1 X92.546 Y45.726 E0.03992

G1 X92.588 Y45.868 E0.00386

G1 X92.596 Y45.985 E0.00306

G1 X92.594 Y46.671 E0.01789

M204 S1250

G1 X92.991 Y47.116 F9000.000

M204 S800

G1 F1500.000

G1 X92.909 Y47.218 E0.00342

G1 X92.719 Y47.279 E0.00521

G1 X92.611 Y47.247 E0.00293

G1 X92.129 Y46.921 E0.01517

G1 X90.686 Y46.021 E0.04430

G1 X90.221 Y45.636 E0.01575

G1 X90.023 Y45.355 E0.00894

G1 X90.027 Y45.334 E0.00056

G1 X90.132 Y45.304 E0.00283

G1 X90.744 Y45.317 E0.01596

G1 X92.700 Y45.307 E0.05096

G1 X92.807 Y45.348 E0.00298

G1 X92.909 Y45.478 E0.00431

G1 X93.002 Y45.794 E0.00858

G1 X93.004 Y47.057 E0.03292

M204 S1250

G1 X92.860 Y47.128 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.909 Y47.218 E-0.10377

G1 X92.719 Y47.279 E-0.11074

G1 X92.611 Y47.247 E-0.06234

G1 X92.129 Y46.921 E-0.32256

G1 X91.650 Y46.623 E-0.31259

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X90.604 Y50.454

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.762 Y50.574 E0.00517

G1 X86.557 Y50.550 E0.10955

G1 X83.711 Y50.569 E0.07417

G1 X84.748 Y49.959 E0.03134

G1 X85.655 Y49.460 E0.02699

G1 X86.194 Y49.237 E0.01520

G1 X86.652 Y49.101 E0.01245

G1 X87.068 Y49.038 E0.01096

G1 X87.360 Y49.063 E0.00763

G1 X87.492 Y49.046 E0.00347

G1 X87.656 Y49.060 E0.00429

G1 X88.245 Y49.220 E0.01589

G1 X88.676 Y49.391 E0.01208

G1 X90.006 Y50.092 E0.03918

G1 X90.552 Y50.423 E0.01665

M204 S1250

G1 X91.681 Y50.920 F9000.000

M204 S800

G1 F1500.000

G1 X91.681 Y50.963 E0.00111

G1 X91.562 Y50.988 E0.00317

G1 X89.675 Y50.997 E0.04917

G1 X86.557 Y50.968 E0.08126

G1 X82.940 Y50.991 E0.09423

G1 X82.810 Y50.927 E0.00379

G1 X82.896 Y50.745 E0.00526

G1 X83.328 Y50.326 E0.01567

G1 X83.588 Y50.145 E0.00826

G1 X84.545 Y49.594 E0.02878

G1 X85.200 Y49.246 E0.01933

G1 X85.226 Y49.211 E0.00111

G1 X85.480 Y49.081 E0.00743

G1 X86.055 Y48.843 E0.01621

G1 X86.561 Y48.692 E0.01378

G1 X87.135 Y48.610 E0.01509

G1 X87.350 Y48.643 E0.00569

G1 X87.484 Y48.625 E0.00351

G1 X87.716 Y48.646 E0.00607

G1 X87.893 Y48.682 E0.00470

G1 X88.381 Y48.824 E0.01325

G1 X88.851 Y49.011 E0.01317

G1 X90.212 Y49.728 E0.04008

G1 X90.838 Y50.108 E0.01910

G1 X91.407 Y50.538 E0.01859

G1 X91.595 Y50.756 E0.00749

G1 X91.653 Y50.867 E0.00327

M204 S1250

G1 X91.649 Y50.949 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.681 Y50.963 E-0.05539

G1 X91.562 Y50.988 E-0.06732

G1 X90.138 Y50.995 E-0.78929

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X86.364 Y49.317

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X85.437 Y50.244 E0.03614

G1 X86.067 Y50.240 E0.01735

G1 X86.930 Y49.376 E0.03367

G1 X87.080 Y49.354 E0.00418

G1 X87.368 Y49.378 E0.00794

G1 X87.491 Y49.362 E0.00342

G1 X87.560 Y49.371 E0.00194

G1 X86.694 Y50.238 E0.03377

G1 X87.316 Y50.241 E0.01714

G1 X88.064 Y49.493 E0.02917

G1 X88.517 Y49.665 E0.01337

G1 X87.938 Y50.245 E0.02260

G1 X88.559 Y50.248 E0.01714

G1 X88.929 Y49.878 E0.01441

G1 X89.338 Y50.094 E0.01276

G1 X88.994 Y50.439 E0.01343

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.338 Y50.094 E-0.26991

G1 X88.929 Y49.878 E-0.25647

G1 X88.559 Y50.248 E-0.28974

G1 X88.386 Y50.247 E-0.09589

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X83.461 Y45.728

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.282 Y45.863 E0.00584

G1 X81.888 Y46.733 E0.04282

G1 X81.889 Y45.987 E0.01944

G1 X81.939 Y45.722 E0.00703

G1 X83.401 Y45.728 E0.03810

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.282 Y45.863 E-0.09971

G1 X82.038 Y46.639 E-0.81229

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X81.730 Y47.284

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.641 Y47.263 E0.00238

G1 X81.513 Y47.147 E0.00451

G1 X81.470 Y47.007 E0.00382

G1 X81.471 Y45.948 E0.02759

G1 X81.540 Y45.583 E0.00967

G1 X81.610 Y45.401 E0.00508

G1 X81.672 Y45.339 E0.00229

G1 X81.778 Y45.303 E0.00290

G1 X84.343 Y45.315 E0.06683

G1 X84.469 Y45.360 E0.00350

G1 X84.423 Y45.451 E0.00264

G1 X84.161 Y45.725 E0.00988

G1 X83.518 Y46.208 E0.02094

G1 X81.886 Y47.227 E0.05014

G1 X81.786 Y47.263 E0.00278

M204 S1250

G1 X81.682 Y47.206 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.641 Y47.263 E-0.08052

G1 X81.513 Y47.147 E-0.09584

G1 X81.470 Y47.007 E-0.08128

G1 X81.471 Y45.948 E-0.58671

G1 X81.493 Y45.828 E-0.06764

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X81.939 Y58.719

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.461 Y58.726 E0.03966

G1 X83.282 Y58.861 E0.00584

G1 X81.888 Y59.731 E0.04282

G1 X81.889 Y58.984 E0.01944

G1 X81.928 Y58.778 E0.00547

M204 S1250

G1 X81.610 Y58.399 F9000.000

M204 S800

G1 F1500.000

G1 X81.672 Y58.337 E0.00229

G1 X81.778 Y58.301 E0.00292

G1 X84.343 Y58.313 E0.06682

G1 X84.469 Y58.358 E0.00350

G1 X84.423 Y58.449 E0.00264

G1 X84.161 Y58.723 E0.00988

G1 X83.518 Y59.206 E0.02094

G1 X81.877 Y60.230 E0.05041

G1 X81.719 Y60.280 E0.00433

G1 X81.641 Y60.261 E0.00208

G1 X81.513 Y60.144 E0.00452

G1 X81.470 Y60.004 E0.00381

G1 X81.471 Y58.945 E0.02760

G1 X81.540 Y58.581 E0.00966

G1 X81.588 Y58.455 E0.00352

M204 S1250

G1 X81.697 Y58.406 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.672 Y58.337 E-0.08012

G1 X81.778 Y58.301 E-0.06213

G1 X83.167 Y58.307 E-0.76975

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X83.812 Y63.496

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.655 Y62.458 E0.05512

G1 X86.195 Y62.235 E0.01521

G1 X86.652 Y62.098 E0.01245

G1 X87.072 Y62.035 E0.01105

G1 X87.358 Y62.060 E0.00747

G1 X87.491 Y62.043 E0.00350

G1 X87.794 Y62.086 E0.00796

G1 X88.245 Y62.217 E0.01225

G1 X88.675 Y62.389 E0.01207

G1 X90.006 Y63.090 E0.03918

G1 X90.604 Y63.452 E0.01821

G1 X90.761 Y63.571 E0.00515

G1 X86.557 Y63.548 E0.10953

G1 X83.711 Y63.567 E0.07417

G1 X83.763 Y63.530 E0.00165

M204 S1250

G1 X82.810 Y63.925 F9000.000

M204 S800

G1 F1500.000

G1 X82.896 Y63.743 E0.00525

G1 X83.328 Y63.324 E0.01567

G1 X83.588 Y63.143 E0.00826

G1 X84.545 Y62.592 E0.02878

G1 X85.200 Y62.244 E0.01933

G1 X85.226 Y62.209 E0.00111

G1 X85.480 Y62.079 E0.00743

G1 X86.055 Y61.841 E0.01622

G1 X86.561 Y61.690 E0.01378

G1 X87.136 Y61.608 E0.01513

G1 X87.349 Y61.640 E0.00562

G1 X87.484 Y61.623 E0.00352

G1 X87.716 Y61.644 E0.00609

G1 X87.893 Y61.680 E0.00470

G1 X88.381 Y61.821 E0.01324

G1 X88.851 Y62.009 E0.01317

G1 X90.212 Y62.726 E0.04009

G1 X90.838 Y63.106 E0.01910

G1 X91.407 Y63.536 E0.01859

G1 X91.595 Y63.754 E0.00749

G1 X91.681 Y63.918 E0.00482

G1 X91.681 Y63.961 E0.00111

G1 X91.563 Y63.985 E0.00316

G1 X89.675 Y63.995 E0.04917

G1 X86.557 Y63.966 E0.08126

G1 X82.941 Y63.989 E0.09422

G1 X82.864 Y63.951 E0.00223

M204 S1250

G1 X82.958 Y63.788 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.896 Y63.743 E-0.11702

G1 X83.328 Y63.324 E-0.33326

G1 X83.588 Y63.143 E-0.17573

G1 X84.035 Y62.885 E-0.28599

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X88.993 Y63.436

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.338 Y63.092 E0.01343

G1 X88.928 Y62.876 E0.01275

G1 X88.559 Y63.246 E0.01441

G1 X87.937 Y63.242 E0.01713

G1 X88.517 Y62.663 E0.02260

G1 X88.064 Y62.491 E0.01336

G1 X87.315 Y63.239 E0.02917

G1 X86.694 Y63.236 E0.01713

G1 X87.560 Y62.369 E0.03376

G1 X87.489 Y62.359 E0.00198

G1 X87.364 Y62.375 E0.00347

G1 X87.082 Y62.351 E0.00779

G1 X86.931 Y62.374 E0.00422

G1 X86.066 Y63.238 E0.03370

G1 X85.437 Y63.242 E0.01734

G1 X86.364 Y62.315 E0.03614

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.437 Y63.242 E-0.72652

G1 X85.772 Y63.240 E-0.18548

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X91.014 Y58.732

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.546 Y58.723 E0.03992

G1 X92.588 Y58.866 E0.00388

G1 X92.596 Y58.983 E0.00306

G1 X92.594 Y59.729 E0.01945

G1 X91.065 Y58.763 E0.04712

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.546 Y58.723 E-0.82118

G1 X92.588 Y58.866 E-0.08256

G1 X92.589 Y58.881 E-0.00825

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X92.991 Y60.114

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.909 Y60.216 E0.00342

G1 X92.719 Y60.277 E0.00520

G1 X92.610 Y60.245 E0.00294

G1 X92.129 Y59.919 E0.01516

G1 X90.686 Y59.019 E0.04430

G1 X90.221 Y58.633 E0.01575

G1 X90.023 Y58.353 E0.00894

G1 X90.027 Y58.332 E0.00057

G1 X90.131 Y58.302 E0.00283

G1 X90.744 Y58.315 E0.01597

G1 X92.700 Y58.304 E0.05095

G1 X92.807 Y58.346 E0.00299

G1 X92.909 Y58.476 E0.00432

G1 X93.002 Y58.792 E0.00858

G1 X93.004 Y60.055 E0.03292

M204 S1250

G1 X92.860 Y60.126 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.909 Y60.216 E-0.10366

G1 X92.719 Y60.277 E-0.11068

G1 X92.610 Y60.245 E-0.06248

G1 X92.129 Y59.919 E-0.32240

G1 X91.650 Y59.620 E-0.31278

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X83.461 Y71.724

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.282 Y71.859 E0.00584

G1 X81.888 Y72.729 E0.04282

G1 X81.889 Y71.982 E0.01944

G1 X81.939 Y71.717 E0.00704

G1 X83.401 Y71.724 E0.03810

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.282 Y71.859 E-0.09967

G1 X82.038 Y72.635 E-0.81233

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X81.719 Y73.278

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.641 Y73.259 E0.00208

G1 X81.513 Y73.142 E0.00452

G1 X81.470 Y73.002 E0.00381

G1 X81.471 Y71.943 E0.02760

G1 X81.540 Y71.579 E0.00966

G1 X81.610 Y71.397 E0.00508

G1 X81.672 Y71.335 E0.00229

G1 X81.778 Y71.299 E0.00292

G1 X84.343 Y71.311 E0.06682

G1 X84.469 Y71.356 E0.00350

G1 X84.423 Y71.447 E0.00264

G1 X84.161 Y71.721 E0.00988

G1 X83.518 Y72.204 E0.02094

G1 X81.877 Y73.228 E0.05041

G1 X81.778 Y73.268 E0.00279

M204 S1250

G1 X81.677 Y73.210 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.641 Y73.259 E-0.07596

G1 X81.513 Y73.142 E-0.09619

G1 X81.470 Y73.002 E-0.08101

G1 X81.471 Y71.943 E-0.58703

G1 X81.495 Y71.816 E-0.07182

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X83.812 Y76.494

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.655 Y75.456 E0.05512

G1 X86.194 Y75.232 E0.01520

G1 X86.652 Y75.096 E0.01244

G1 X87.072 Y75.033 E0.01106

G1 X87.358 Y75.058 E0.00747

G1 X87.491 Y75.041 E0.00350

G1 X87.794 Y75.083 E0.00798

G1 X88.245 Y75.214 E0.01222

G1 X88.675 Y75.387 E0.01208

G1 X90.006 Y76.088 E0.03920

G1 X90.604 Y76.450 E0.01820

G1 X90.762 Y76.569 E0.00517

G1 X86.557 Y76.546 E0.10955

G1 X83.711 Y76.565 E0.07417

G1 X83.763 Y76.528 E0.00166

M204 S1250

G1 X82.810 Y76.923 F9000.000

M204 S800

G1 F1500.000

G1 X82.896 Y76.740 E0.00525

G1 X83.328 Y76.322 E0.01567

G1 X83.588 Y76.141 E0.00826

G1 X84.546 Y75.589 E0.02879

G1 X85.200 Y75.241 E0.01931

G1 X85.225 Y75.207 E0.00110

G1 X85.480 Y75.076 E0.00745

G1 X86.055 Y74.838 E0.01622

G1 X86.561 Y74.688 E0.01377

G1 X87.136 Y74.606 E0.01513

G1 X87.349 Y74.638 E0.00562

G1 X87.484 Y74.621 E0.00352

G1 X87.717 Y74.642 E0.00609

G1 X87.893 Y74.677 E0.00469

G1 X88.381 Y74.819 E0.01323

G1 X88.851 Y75.007 E0.01318

G1 X90.212 Y75.724 E0.04009

G1 X90.838 Y76.103 E0.01909

G1 X91.407 Y76.534 E0.01860

G1 X91.595 Y76.752 E0.00749

G1 X91.681 Y76.916 E0.00482

G1 X91.681 Y76.959 E0.00111

G1 X91.563 Y76.983 E0.00316

G1 X89.675 Y76.993 E0.04917

G1 X86.557 Y76.964 E0.08126

G1 X82.941 Y76.987 E0.09422

G1 X82.864 Y76.949 E0.00223

M204 S1250

G1 X82.958 Y76.785 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.896 Y76.740 E-0.11711

G1 X83.328 Y76.322 E-0.33320

G1 X83.588 Y76.141 E-0.17577

G1 X84.035 Y75.883 E-0.28592

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X88.993 Y76.434

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.338 Y76.090 E0.01343

G1 X88.928 Y75.874 E0.01276

G1 X88.558 Y76.244 E0.01442

G1 X87.937 Y76.240 E0.01714

G1 X88.517 Y75.661 E0.02261

G1 X88.064 Y75.488 E0.01336

G1 X87.315 Y76.237 E0.02920

G1 X86.693 Y76.234 E0.01714

G1 X87.560 Y75.367 E0.03378

G1 X87.489 Y75.357 E0.00197

G1 X87.364 Y75.373 E0.00348

G1 X87.082 Y75.349 E0.00779

G1 X86.930 Y75.372 E0.00424

G1 X86.066 Y76.236 E0.03370

G1 X85.436 Y76.240 E0.01735

G1 X86.364 Y75.313 E0.03615

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.436 Y76.240 E-0.72674

G1 X85.771 Y76.238 E-0.18526

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X91.015 Y71.730

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.546 Y71.721 E0.03989

G1 X92.588 Y71.864 E0.00388

G1 X92.596 Y71.981 E0.00306

G1 X92.594 Y72.727 E0.01945

G1 X91.066 Y71.761 E0.04709

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.546 Y71.721 E-0.82038

G1 X92.588 Y71.864 E-0.08256

G1 X92.589 Y71.880 E-0.00905

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X92.991 Y73.111

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.909 Y73.214 E0.00344

G1 X92.719 Y73.275 E0.00517

G1 X92.610 Y73.243 E0.00296

G1 X92.129 Y72.917 E0.01515

G1 X90.686 Y72.016 E0.04431

G1 X90.221 Y71.631 E0.01574

G1 X90.023 Y71.351 E0.00894

G1 X90.027 Y71.330 E0.00058

G1 X90.132 Y71.299 E0.00283

G1 X90.744 Y71.313 E0.01596

G1 X92.700 Y71.302 E0.05096

G1 X92.807 Y71.344 E0.00299

G1 X92.909 Y71.474 E0.00433

G1 X93.002 Y71.790 E0.00858

G1 X93.005 Y73.052 E0.03290

M204 S1250

G1 X92.859 Y73.123 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.909 Y73.214 E-0.10418

G1 X92.719 Y73.275 E-0.11006

G1 X92.610 Y73.243 E-0.06299

G1 X92.129 Y72.917 E-0.32221

G1 X91.650 Y72.618 E-0.31256

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X92.546 Y84.719

G1 Z11.450

G1 E3.20000 F2400.00000

M73 P96 R2

M204 S800

G1 F1500.000

G1 X92.588 Y84.861 E0.00387

G1 X92.596 Y84.978 E0.00304

G1 X92.594 Y85.725 E0.01946

G1 X91.015 Y84.727 E0.04865

G1 X92.486 Y84.719 E0.03833

M204 S1250

G1 X92.700 Y84.300 F9000.000

M204 S800

G1 F1500.000

G1 X92.807 Y84.342 E0.00300

G1 X92.909 Y84.472 E0.00431

G1 X93.002 Y84.788 E0.00859

G1 X93.014 Y84.965 E0.00462

G1 X93.011 Y86.024 E0.02760

G1 X92.991 Y86.109 E0.00228

G1 X92.909 Y86.212 E0.00343

G1 X92.715 Y86.273 E0.00528

G1 X92.610 Y86.241 E0.00286

G1 X92.129 Y85.915 E0.01516

G1 X90.686 Y85.014 E0.04431

G1 X90.221 Y84.629 E0.01574

G1 X90.023 Y84.349 E0.00896

G1 X90.027 Y84.328 E0.00056

G1 X90.132 Y84.297 E0.00283

G1 X90.744 Y84.311 E0.01596

G1 X92.640 Y84.300 E0.04939

M204 S1250

G1 X92.731 Y84.411 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.807 Y84.342 E-0.09543

G1 X92.909 Y84.472 E-0.09159

G1 X93.002 Y84.788 E-0.18264

G1 X93.014 Y84.965 E-0.09832

G1 X93.011 Y85.766 E-0.44402

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X90.604 Y89.447

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.762 Y89.567 E0.00517

G1 X86.557 Y89.544 E0.10955

G1 X83.711 Y89.562 E0.07417

G1 X84.748 Y88.952 E0.03135

G1 X85.655 Y88.454 E0.02698

G1 X86.194 Y88.230 E0.01520

G1 X86.652 Y88.094 E0.01244

G1 X87.072 Y88.031 E0.01106

G1 X87.359 Y88.056 E0.00751

G1 X87.492 Y88.039 E0.00348

G1 X87.657 Y88.054 E0.00432

G1 X88.245 Y88.213 E0.01587

G1 X88.675 Y88.384 E0.01207

G1 X90.006 Y89.086 E0.03920

G1 X90.552 Y89.416 E0.01663

M204 S1250

G1 X91.681 Y89.914 F9000.000

M204 S800

G1 F1500.000

G1 X91.681 Y89.957 E0.00111

G1 X91.563 Y89.981 E0.00316

G1 X89.675 Y89.990 E0.04917

G1 X86.557 Y89.961 E0.08126

G1 X82.941 Y89.985 E0.09422

G1 X82.810 Y89.920 E0.00380

G1 X82.896 Y89.738 E0.00524

G1 X83.328 Y89.320 E0.01566

G1 X83.588 Y89.139 E0.00827

G1 X84.546 Y88.587 E0.02879

G1 X85.200 Y88.239 E0.01930

G1 X85.225 Y88.205 E0.00110

G1 X85.480 Y88.074 E0.00745

G1 X86.055 Y87.836 E0.01622

G1 X86.561 Y87.686 E0.01377

G1 X87.136 Y87.604 E0.01513

G1 X87.350 Y87.636 E0.00563

G1 X87.484 Y87.619 E0.00352

G1 X87.716 Y87.640 E0.00608

G1 X87.893 Y87.675 E0.00470

G1 X88.381 Y87.817 E0.01323

G1 X88.851 Y88.004 E0.01317

G1 X90.212 Y88.722 E0.04010

G1 X90.838 Y89.101 E0.01908

G1 X91.407 Y89.532 E0.01860

G1 X91.595 Y89.750 E0.00750

G1 X91.653 Y89.861 E0.00325

M204 S1250

G1 X91.649 Y89.943 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.681 Y89.957 E-0.05543

G1 X91.563 Y89.981 E-0.06721

G1 X90.138 Y89.988 E-0.78936

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X86.363 Y88.311

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X85.437 Y89.238 E0.03612

G1 X86.066 Y89.233 E0.01734

G1 X86.929 Y88.370 E0.03367

G1 X87.082 Y88.347 E0.00426

G1 X87.366 Y88.371 E0.00785

G1 X87.490 Y88.355 E0.00345

G1 X87.559 Y88.365 E0.00193

G1 X86.693 Y89.231 E0.03376

G1 X87.315 Y89.234 E0.01713

G1 X88.063 Y88.486 E0.02917

G1 X88.516 Y88.658 E0.01336

G1 X87.937 Y89.238 E0.02260

G1 X88.558 Y89.241 E0.01713

G1 X88.928 Y88.872 E0.01442

G1 X89.337 Y89.087 E0.01275

G1 X88.993 Y89.432 E0.01343

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.337 Y89.087 E-0.26993

G1 X88.928 Y88.872 E-0.25640

G1 X88.558 Y89.241 E-0.28981

G1 X88.385 Y89.240 E-0.09586

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X83.460 Y84.722

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.282 Y84.856 E0.00580

G1 X81.888 Y85.727 E0.04283

G1 X81.889 Y84.980 E0.01945

G1 X81.939 Y84.715 E0.00703

G1 X83.400 Y84.722 E0.03808

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.282 Y84.856 E-0.09895

G1 X82.038 Y85.633 E-0.81305

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X81.513 Y86.140

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.470 Y86.000 E0.00382

G1 X81.471 Y84.941 E0.02760

G1 X81.540 Y84.576 E0.00967

G1 X81.610 Y84.395 E0.00507

G1 X81.672 Y84.333 E0.00229

G1 X81.778 Y84.297 E0.00292

G1 X84.343 Y84.309 E0.06682

G1 X84.469 Y84.354 E0.00350

G1 X84.423 Y84.445 E0.00264

G1 X84.161 Y84.719 E0.00988

G1 X83.518 Y85.201 E0.02093

G1 X81.877 Y86.226 E0.05042

G1 X81.719 Y86.276 E0.00433

G1 X81.641 Y86.257 E0.00208

G1 X81.557 Y86.181 E0.00296

M204 S1250

G1 X81.585 Y86.013 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.470 Y86.000 E-0.11120

G1 X81.471 Y84.941 E-0.58698

G1 X81.540 Y84.576 E-0.20557

G1 X81.545 Y84.562 E-0.00826

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X81.939 Y97.713

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.461 Y97.719 E0.03967

G1 X83.282 Y97.854 E0.00583

G1 X81.888 Y98.724 E0.04283

G1 X81.889 Y97.978 E0.01944

G1 X81.927 Y97.772 E0.00547

M204 S1250

G1 X81.610 Y97.393 F9000.000

M204 S800

G1 F1500.000

G1 X81.672 Y97.331 E0.00229

G1 X81.778 Y97.295 E0.00292

G1 X84.342 Y97.306 E0.06681

G1 X84.469 Y97.352 E0.00351

G1 X84.423 Y97.442 E0.00262

G1 X84.161 Y97.717 E0.00991

G1 X83.518 Y98.199 E0.02092

G1 X81.886 Y99.218 E0.05014

G1 X81.727 Y99.275 E0.00440

G1 X81.641 Y99.255 E0.00232

G1 X81.513 Y99.138 E0.00451

G1 X81.470 Y98.998 E0.00382

G1 X81.471 Y97.939 E0.02760

G1 X81.540 Y97.574 E0.00967

G1 X81.588 Y97.449 E0.00351

M204 S1250

G1 X81.697 Y97.400 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.672 Y97.331 E-0.08016

G1 X81.778 Y97.295 E-0.06216

G1 X83.167 Y97.301 E-0.76969

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X83.812 Y102.490

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.656 Y101.451 E0.05514

G1 X86.194 Y101.228 E0.01518

G1 X86.652 Y101.092 E0.01245

G1 X87.072 Y101.029 E0.01105

G1 X87.359 Y101.054 E0.00752

G1 X87.492 Y101.037 E0.00350

G1 X87.794 Y101.079 E0.00792

G1 X88.245 Y101.211 E0.01225

G1 X88.675 Y101.382 E0.01207

G1 X90.006 Y102.084 E0.03920

G1 X90.604 Y102.445 E0.01819

G1 X90.762 Y102.565 E0.00517

G1 X86.557 Y102.541 E0.10955

G1 X83.711 Y102.560 E0.07416

G1 X83.763 Y102.524 E0.00165

M204 S1250

G1 X82.810 Y102.918 F9000.000

M204 S800

G1 F1500.000

G1 X82.896 Y102.737 E0.00524

G1 X83.328 Y102.318 E0.01566

G1 X83.588 Y102.137 E0.00827

G1 X84.546 Y101.585 E0.02879

G1 X85.200 Y101.237 E0.01930

G1 X85.225 Y101.203 E0.00111

G1 X85.480 Y101.072 E0.00746

G1 X86.054 Y100.834 E0.01621

G1 X86.561 Y100.684 E0.01377

G1 X87.136 Y100.602 E0.01513

G1 X87.350 Y100.634 E0.00564

G1 X87.484 Y100.617 E0.00353

G1 X87.716 Y100.638 E0.00607

G1 X87.893 Y100.673 E0.00470

G1 X88.381 Y100.815 E0.01324

G1 X88.851 Y101.002 E0.01317

G1 X90.212 Y101.720 E0.04010

G1 X90.838 Y102.099 E0.01908

G1 X91.407 Y102.530 E0.01860

G1 X91.595 Y102.748 E0.00750

G1 X91.681 Y102.912 E0.00482

G1 X91.681 Y102.955 E0.00111

G1 X91.563 Y102.979 E0.00316

G1 X89.675 Y102.988 E0.04917

G1 X86.557 Y102.959 E0.08126

G1 X82.941 Y102.983 E0.09422

G1 X82.864 Y102.945 E0.00224

M204 S1250

G1 X82.957 Y102.781 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X82.896 Y102.737 E-0.11692

G1 X83.328 Y102.318 E-0.33317

G1 X83.588 Y102.137 E-0.17587

G1 X84.035 Y101.879 E-0.28604

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X88.993 Y102.430

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X89.337 Y102.085 E0.01342

G1 X88.928 Y101.870 E0.01275

G1 X88.558 Y102.239 E0.01441

G1 X87.937 Y102.236 E0.01713

G1 X88.516 Y101.656 E0.02260

G1 X88.063 Y101.484 E0.01336

G1 X87.315 Y102.232 E0.02916

G1 X86.694 Y102.229 E0.01713

G1 X87.560 Y101.363 E0.03375

G1 X87.491 Y101.353 E0.00191

G1 X87.366 Y101.369 E0.00347

G1 X87.082 Y101.345 E0.00785

G1 X86.929 Y101.368 E0.00426

G1 X86.066 Y102.231 E0.03366

G1 X85.437 Y102.235 E0.01734

G1 X86.364 Y101.309 E0.03613

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.437 Y102.235 E-0.72638

G1 X85.772 Y102.233 E-0.18562

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X91.015 Y97.725

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.546 Y97.717 E0.03989

G1 X92.588 Y97.859 E0.00387

G1 X92.596 Y97.976 E0.00304

G1 X92.594 Y98.723 E0.01946

G1 X91.066 Y97.757 E0.04709

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.546 Y97.717 E-0.82059

G1 X92.588 Y97.859 E-0.08240

G1 X92.589 Y97.876 E-0.00901

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X92.991 Y99.107

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.909 Y99.210 E0.00343

G1 X92.719 Y99.271 E0.00517

G1 X92.610 Y99.239 E0.00296

G1 X92.129 Y98.913 E0.01516

G1 X90.686 Y98.012 E0.04431

G1 X90.221 Y97.627 E0.01574

G1 X90.023 Y97.347 E0.00896

G1 X90.027 Y97.326 E0.00056

G1 X90.132 Y97.295 E0.00283

G1 X90.744 Y97.309 E0.01596

G1 X92.700 Y97.298 E0.05095

G1 X92.807 Y97.340 E0.00300

G1 X92.909 Y97.470 E0.00431

G1 X93.002 Y97.786 E0.00859

G1 X93.004 Y99.049 E0.03291

M204 S1250

G1 X92.859 Y99.119 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.909 Y99.210 E-0.10408

G1 X92.719 Y99.271 E-0.11006

G1 X92.610 Y99.239 E-0.06294

G1 X92.129 Y98.913 E-0.32239

G1 X91.650 Y98.614 E-0.31253

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X92.546 Y110.715

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.588 Y110.857 E0.00388

G1 X92.596 Y110.974 E0.00304

G1 X92.594 Y111.720 E0.01945

G1 X91.014 Y110.723 E0.04868

G1 X92.486 Y110.715 E0.03836

M204 S1250

G1 X92.700 Y110.296 F9000.000

M204 S800

G1 F1500.000

G1 X92.807 Y110.338 E0.00300

G1 X92.909 Y110.468 E0.00431

G1 X93.002 Y110.784 E0.00859

G1 X93.014 Y110.961 E0.00462

G1 X93.011 Y112.020 E0.02760

G1 X92.991 Y112.105 E0.00227

G1 X92.909 Y112.208 E0.00343

G1 X92.716 Y112.269 E0.00527

G1 X92.611 Y112.236 E0.00286

G1 X92.129 Y111.910 E0.01517

G1 X90.686 Y111.010 E0.04430

G1 X90.221 Y110.625 E0.01573

G1 X90.023 Y110.345 E0.00896

G1 X90.027 Y110.323 E0.00056

G1 X90.132 Y110.293 E0.00284

G1 X90.744 Y110.306 E0.01596

G1 X92.640 Y110.296 E0.04939

M204 S1250

G1 X92.731 Y110.407 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.807 Y110.338 E-0.09546

G1 X92.909 Y110.468 E-0.09157

G1 X93.002 Y110.784 E-0.18266

G1 X93.014 Y110.961 E-0.09833

G1 X93.011 Y111.762 E-0.44398

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X90.604 Y115.443

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X90.762 Y115.563 E0.00517

G1 X86.557 Y115.539 E0.10956

G1 X83.710 Y115.558 E0.07420

G1 X84.748 Y114.948 E0.03137

G1 X85.656 Y114.449 E0.02700

G1 X86.194 Y114.226 E0.01518

G1 X86.652 Y114.090 E0.01245

G1 X87.072 Y114.027 E0.01105

G1 X87.360 Y114.052 E0.00755

G1 X87.492 Y114.035 E0.00346

G1 X87.656 Y114.050 E0.00431

G1 X88.245 Y114.208 E0.01588

G1 X88.675 Y114.380 E0.01208

G1 X90.006 Y115.082 E0.03919

G1 X90.552 Y115.412 E0.01664

M204 S1250

G1 X91.681 Y115.909 F9000.000

M204 S800

G1 F1500.000

G1 X91.681 Y115.953 E0.00113

G1 X91.563 Y115.977 E0.00316

G1 X89.675 Y115.986 E0.04917

G1 X86.557 Y115.957 E0.08126

G1 X82.941 Y115.981 E0.09422

G1 X82.810 Y115.916 E0.00380

G1 X82.896 Y115.734 E0.00524

G1 X83.328 Y115.315 E0.01568

G1 X83.588 Y115.134 E0.00826

G1 X84.545 Y114.583 E0.02878

G1 X85.200 Y114.235 E0.01931

G1 X85.225 Y114.201 E0.00111

G1 X85.480 Y114.070 E0.00746

G1 X86.054 Y113.832 E0.01621

G1 X86.561 Y113.682 E0.01377

G1 X87.136 Y113.600 E0.01513

G1 X87.350 Y113.632 E0.00565

G1 X87.484 Y113.614 E0.00351

G1 X87.716 Y113.636 E0.00608

G1 X87.893 Y113.671 E0.00470

G1 X88.381 Y113.813 E0.01324

G1 X88.851 Y114.000 E0.01318

G1 X90.212 Y114.718 E0.04009

G1 X90.839 Y115.097 E0.01909

G1 X91.407 Y115.527 E0.01859

G1 X91.595 Y115.745 E0.00749

G1 X91.653 Y115.856 E0.00327

M204 S1250

G1 X91.649 Y115.938 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X91.681 Y115.953 E-0.05567

G1 X91.563 Y115.977 E-0.06721

G1 X90.139 Y115.984 E-0.78912

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X86.364 Y114.307

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X85.437 Y115.233 E0.03613

G1 X86.066 Y115.229 E0.01735

G1 X86.929 Y114.366 E0.03364

G1 X87.084 Y114.343 E0.00431

G1 X87.368 Y114.367 E0.00785

G1 X87.490 Y114.351 E0.00341

G1 X87.560 Y114.361 E0.00194

G1 X86.694 Y115.227 E0.03377

G1 X87.315 Y115.230 E0.01713

G1 X88.063 Y114.482 E0.02917

G1 X88.516 Y114.654 E0.01336

G1 X87.937 Y115.234 E0.02260

G1 X88.558 Y115.237 E0.01713

G1 X88.928 Y114.868 E0.01441

G1 X89.337 Y115.083 E0.01275

G1 X88.993 Y115.428 E0.01342

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X89.337 Y115.083 E-0.26989

G1 X88.928 Y114.868 E-0.25642

G1 X88.558 Y115.237 E-0.28972

G1 X88.385 Y115.236 E-0.09597

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X83.461 Y110.717

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.282 Y110.852 E0.00584

G1 X81.888 Y111.722 E0.04283

G1 X81.889 Y110.976 E0.01944

G1 X81.939 Y110.711 E0.00703

G1 X83.401 Y110.717 E0.03810

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.282 Y110.852 E-0.09969

G1 X82.039 Y111.628 E-0.81231

G1 E-0.04800 F4200.00000

G1 Z11.650 F9000.000

G1 X81.730 Y112.273

G1 Z11.450

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.641 Y112.252 E0.00238

G1 X81.513 Y112.136 E0.00450

G1 X81.470 Y111.996 E0.00383

G1 X81.471 Y110.937 E0.02759

G1 X81.540 Y110.572 E0.00967

G1 X81.610 Y110.390 E0.00508

G1 X81.672 Y110.328 E0.00229

G1 X81.778 Y110.292 E0.00290

G1 X84.343 Y110.304 E0.06683

G1 X84.469 Y110.349 E0.00350

G1 X84.423 Y110.440 E0.00264

G1 X84.161 Y110.714 E0.00989

G1 X83.518 Y111.197 E0.02093

G1 X81.886 Y112.216 E0.05014

G1 X81.786 Y112.252 E0.00278

M204 S1250

G1 X81.682 Y112.195 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;11.6

G1 Z11.600 F9000.000

;AFTER\_LAYER\_CHANGE

;11.6

G1 X81.888 Y111.722

M204 S800

G1 F1500.000

G1 X81.889 Y111.236 E0.01265

G1 X81.951 Y110.926 E0.00823

G1 X83.107 Y110.925 E0.03011

G1 X82.965 Y111.037 E0.00471

G1 X81.940 Y111.692 E0.03169

M204 S1250

G1 X81.791 Y112.260 F9000.000

M204 S800

G1 F1500.000

G1 X81.717 Y112.270 E0.00193

G1 X81.640 Y112.251 E0.00208

G1 X81.501 Y112.119 E0.00499

G1 X81.470 Y112.004 E0.00309

G1 X81.471 Y111.194 E0.02110

G1 X81.569 Y110.709 E0.01289

G1 X81.691 Y110.541 E0.00543

G1 X81.780 Y110.509 E0.00246

G1 X83.994 Y110.506 E0.05769

G1 X84.083 Y110.559 E0.00270

G1 X84.065 Y110.635 E0.00204

G1 X83.881 Y110.843 E0.00724

G1 X83.209 Y111.377 E0.02236

G1 X82.279 Y111.979 E0.02888

G1 X81.843 Y112.230 E0.01311

M204 S1250

G1 X81.737 Y112.208 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.717 Y112.270 E-0.07295

G1 X81.640 Y112.251 E-0.04426

G1 X81.501 Y112.119 E-0.10612

G1 X81.470 Y112.004 E-0.06579

G1 X81.471 Y111.194 E-0.44872

G1 X81.533 Y110.886 E-0.17415

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X84.073 Y115.349

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.305 Y114.653 E0.03687

G1 X85.335 Y114.613 E0.00132

G1 X85.617 Y114.468 E0.00824

G1 X86.193 Y114.226 E0.01627

G1 X86.636 Y114.094 E0.01206

G1 X87.098 Y114.022 E0.01218

G1 X87.663 Y114.051 E0.01474

G1 X88.299 Y114.228 E0.01720

G1 X88.698 Y114.390 E0.01123

G1 X89.976 Y115.064 E0.03763

G1 X90.408 Y115.357 E0.01360

G1 X88.697 Y115.339 E0.04459

G1 X84.133 Y115.349 E0.11893

M204 S1250

G1 X83.283 Y115.453 F9000.000

M204 S800

G1 F1500.000

G1 X83.468 Y115.274 E0.00670

G1 X83.604 Y115.196 E0.00410

G1 X83.734 Y115.070 E0.00470

G1 X83.954 Y114.929 E0.00681

G1 X85.025 Y114.331 E0.03196

G1 X85.060 Y114.285 E0.00151

G1 X85.440 Y114.089 E0.01114

G1 X86.052 Y113.832 E0.01729

G1 X86.544 Y113.686 E0.01338

G1 X87.174 Y113.600 E0.01656

G1 X87.748 Y113.641 E0.01499

G1 X88.434 Y113.832 E0.01856

G1 X88.875 Y114.011 E0.01240

G1 X90.191 Y114.706 E0.03877

G1 X90.933 Y115.207 E0.02334

G1 X91.245 Y115.511 E0.01136

G1 X91.361 Y115.707 E0.00594

G1 X91.346 Y115.766 E0.00158

G1 X91.286 Y115.784 E0.00163

G1 X88.695 Y115.756 E0.06750

G1 X83.237 Y115.769 E0.14223

G1 X83.187 Y115.746 E0.00144

G1 X83.280 Y115.513 E0.00653

M204 S1250

G1 X83.540 Y115.469 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.468 Y115.274 E-0.16867

G1 X83.604 Y115.196 E-0.08711

G1 X83.734 Y115.070 E-0.09994

G1 X83.954 Y114.929 E-0.14485

G1 X84.602 Y114.567 E-0.41142

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X88.910 Y115.215

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.236 Y114.541 E0.02546

G1 X87.615 Y114.363 E0.01723

G1 X87.447 Y114.357 E0.00448

G1 X88.116 Y115.027 E0.02527

G1 X87.513 Y115.028 E0.01611

G1 X86.865 Y114.380 E0.02443

G1 X86.702 Y114.402 E0.00440

G1 X86.378 Y114.498 E0.00901

G1 X86.909 Y115.029 E0.02004

G1 X86.305 Y115.031 E0.01611

G1 X85.945 Y114.670 E0.01361

G1 X85.536 Y114.867 E0.01210

G1 X85.889 Y115.220 E0.01332

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.536 Y114.867 E-0.27661

G1 X85.945 Y114.670 E-0.25121

G1 X86.305 Y115.031 E-0.28265

G1 X86.488 Y115.030 E-0.10153

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X91.349 Y110.917

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.527 Y110.916 E0.03070

G1 X92.587 Y111.122 E0.00560

G1 X92.595 Y111.731 E0.01586

G1 X92.354 Y111.552 E0.00783

G1 X91.397 Y110.954 E0.02940

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.527 Y110.916 E-0.62685

G1 X92.587 Y111.122 E-0.11914

G1 X92.591 Y111.422 E-0.16600

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X92.990 Y112.103

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.912 Y112.204 E0.00334

G1 X92.735 Y112.269 E0.00491

G1 X92.612 Y112.239 E0.00328

G1 X92.116 Y111.896 E0.01574

G1 X91.236 Y111.357 E0.02688

G1 X90.710 Y110.954 E0.01727

G1 X90.555 Y110.801 E0.00566

G1 X90.388 Y110.582 E0.00718

G1 X90.377 Y110.525 E0.00151

G1 X90.482 Y110.542 E0.00276

G1 X90.516 Y110.501 E0.00139

G1 X92.694 Y110.498 E0.05675

G1 X92.798 Y110.544 E0.00298

G1 X92.885 Y110.650 E0.00356

G1 X93.002 Y111.051 E0.01090

G1 X93.015 Y111.293 E0.00631

G1 X93.004 Y112.045 E0.01958

M204 S1250

G1 X92.863 Y112.114 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.912 Y112.204 E-0.10226

G1 X92.735 Y112.269 E-0.10449

G1 X92.612 Y112.239 E-0.06971

G1 X92.116 Y111.896 E-0.33472

G1 X91.653 Y111.612 E-0.30081

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X92.595 Y98.734

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.354 Y98.554 E0.00782

G1 X91.473 Y98.015 E0.02693

G1 X91.349 Y97.920 E0.00407

G1 X92.527 Y97.918 E0.03070

G1 X92.587 Y98.124 E0.00560

G1 X92.595 Y98.674 E0.01431

M204 S1250

G1 X92.990 Y99.105 F9000.000

M204 S800

G1 F1500.000

G1 X92.912 Y99.207 E0.00334

G1 X92.735 Y99.271 E0.00490

G1 X92.612 Y99.242 E0.00329

G1 X92.290 Y99.034 E0.00998

G1 X92.116 Y98.898 E0.00575

G1 X91.236 Y98.360 E0.02688

G1 X90.710 Y97.956 E0.01728

G1 X90.555 Y97.803 E0.00567

G1 X90.388 Y97.584 E0.00717

G1 X90.377 Y97.528 E0.00149

G1 X90.482 Y97.545 E0.00275

G1 X90.516 Y97.503 E0.00140

G1 X92.694 Y97.500 E0.05675

G1 X92.798 Y97.546 E0.00297

G1 X92.885 Y97.652 E0.00356

G1 X93.002 Y98.053 E0.01090

G1 X93.015 Y98.295 E0.00631

G1 X93.004 Y99.047 E0.01959

M204 S1250

G1 X92.862 Y99.116 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.912 Y99.207 E-0.10238

G1 X92.735 Y99.271 E-0.10430

G1 X92.612 Y99.242 E-0.06996

G1 X92.290 Y99.034 E-0.21235

G1 X92.116 Y98.898 E-0.12237

G1 X91.653 Y98.615 E-0.30064

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X90.408 Y102.359

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.697 Y102.341 E0.04459

G1 X84.073 Y102.352 E0.12049

G1 X85.305 Y101.655 E0.03688

G1 X85.335 Y101.615 E0.00132

G1 X85.617 Y101.470 E0.00824

G1 X86.193 Y101.228 E0.01627

G1 X86.636 Y101.096 E0.01206

G1 X87.098 Y101.024 E0.01218

G1 X87.665 Y101.054 E0.01478

G1 X88.299 Y101.230 E0.01716

G1 X88.698 Y101.392 E0.01123

G1 X89.976 Y102.067 E0.03763

G1 X90.358 Y102.325 E0.01204

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.713 Y102.340 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X83.283 Y102.456

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.468 Y102.277 E0.00670

G1 X83.605 Y102.198 E0.00411

G1 X83.734 Y102.072 E0.00469

G1 X83.954 Y101.932 E0.00681

G1 X85.025 Y101.333 E0.03197

G1 X85.060 Y101.287 E0.00151

G1 X85.440 Y101.091 E0.01114

G1 X86.052 Y100.834 E0.01729

G1 X86.544 Y100.688 E0.01338

G1 X87.174 Y100.602 E0.01656

G1 X87.748 Y100.643 E0.01500

G1 X88.434 Y100.834 E0.01855

G1 X88.875 Y101.013 E0.01240

G1 X90.191 Y101.708 E0.03877

G1 X90.933 Y102.209 E0.02334

G1 X91.245 Y102.513 E0.01137

G1 X91.361 Y102.710 E0.00594

G1 X91.346 Y102.768 E0.00157

G1 X91.286 Y102.786 E0.00164

G1 X88.695 Y102.758 E0.06750

G1 X83.237 Y102.771 E0.14223

G1 X83.186 Y102.748 E0.00145

G1 X83.280 Y102.516 E0.00652

M204 S1250

G1 X83.540 Y102.471 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.468 Y102.277 E-0.16855

G1 X83.605 Y102.198 E-0.08739

G1 X83.734 Y102.072 E-0.09976

G1 X83.954 Y101.932 E-0.14474

G1 X84.602 Y101.569 E-0.41156

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X88.910 Y102.217

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.235 Y101.543 E0.02547

G1 X87.616 Y101.366 E0.01719

G1 X87.447 Y101.359 E0.00452

G1 X88.116 Y102.029 E0.02527

G1 X87.512 Y102.030 E0.01611

G1 X86.865 Y101.382 E0.02444

G1 X86.702 Y101.404 E0.00438

G1 X86.378 Y101.500 E0.00903

G1 X86.909 Y102.031 E0.02005

G1 X86.305 Y102.033 E0.01611

G1 X85.944 Y101.672 E0.01361

G1 X85.536 Y101.869 E0.01210

G1 X85.889 Y102.222 E0.01332

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.536 Y101.869 E-0.27649

G1 X85.944 Y101.672 E-0.25120

G1 X86.305 Y102.033 E-0.28268

G1 X86.488 Y102.032 E-0.10162

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X82.965 Y98.039

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y98.724 E0.03326

G1 X81.889 Y98.238 E0.01266

G1 X81.951 Y97.928 E0.00823

G1 X83.107 Y97.927 E0.03011

G1 X83.012 Y98.002 E0.00315

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.888 Y98.724 E-0.74051

G1 X81.889 Y98.415 E-0.17149

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X81.790 Y99.262

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.717 Y99.272 E0.00194

G1 X81.640 Y99.254 E0.00206

G1 X81.501 Y99.121 E0.00500

G1 X81.470 Y99.006 E0.00309

G1 X81.471 Y98.196 E0.02111

G1 X81.569 Y97.711 E0.01289

G1 X81.691 Y97.543 E0.00543

G1 X81.781 Y97.511 E0.00247

G1 X83.994 Y97.508 E0.05768

G1 X84.083 Y97.561 E0.00270

G1 X84.065 Y97.637 E0.00204

G1 X83.881 Y97.846 E0.00725

G1 X83.209 Y98.379 E0.02234

G1 X82.279 Y98.982 E0.02889

G1 X81.842 Y99.232 E0.01311

M204 S1250

G1 X81.737 Y99.210 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.717 Y99.272 E-0.07313

G1 X81.640 Y99.254 E-0.04389

G1 X81.501 Y99.121 E-0.10639

G1 X81.470 Y99.006 E-0.06572

G1 X81.471 Y98.196 E-0.44888

G1 X81.533 Y97.889 E-0.17398

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X81.888 Y85.726

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.889 Y85.240 E0.01267

G1 X81.951 Y84.931 E0.00823

G1 X83.106 Y84.929 E0.03010

G1 X82.965 Y85.041 E0.00469

G1 X81.940 Y85.697 E0.03170

M204 S1250

G1 X81.790 Y86.264 F9000.000

M204 S800

G1 F1500.000

G1 X81.717 Y86.275 E0.00193

G1 X81.640 Y86.256 E0.00206

G1 X81.501 Y86.123 E0.00501

G1 X81.470 Y86.008 E0.00309

G1 X81.471 Y85.198 E0.02111

G1 X81.569 Y84.714 E0.01288

G1 X81.691 Y84.545 E0.00543

G1 X81.781 Y84.513 E0.00247

G1 X83.995 Y84.510 E0.05769

G1 X84.083 Y84.563 E0.00269

G1 X84.065 Y84.640 E0.00205

G1 X83.881 Y84.848 E0.00723

G1 X83.209 Y85.381 E0.02235

G1 X82.279 Y85.984 E0.02889

G1 X81.842 Y86.234 E0.01312

M204 S1250

G1 X81.737 Y86.213 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.717 Y86.275 E-0.07307

G1 X81.640 Y86.256 E-0.04379

G1 X81.501 Y86.123 E-0.10652

G1 X81.470 Y86.008 E-0.06572

G1 X81.471 Y85.198 E-0.44888

G1 X81.533 Y84.891 E-0.17401

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X84.073 Y89.354

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.305 Y88.657 E0.03688

G1 X85.335 Y88.617 E0.00131

G1 X85.616 Y88.472 E0.00824

G1 X86.193 Y88.231 E0.01629

G1 X86.636 Y88.098 E0.01206

G1 X87.099 Y88.027 E0.01219

G1 X87.665 Y88.056 E0.01476

G1 X88.299 Y88.232 E0.01716

G1 X88.698 Y88.394 E0.01123

G1 X89.975 Y89.068 E0.03763

G1 X90.408 Y89.361 E0.01360

G1 X88.697 Y89.343 E0.04458

G1 X84.133 Y89.354 E0.11893

M204 S1250

G1 X83.283 Y89.458 F9000.000

M204 S800

G1 F1500.000

G1 X83.468 Y89.279 E0.00670

G1 X83.605 Y89.200 E0.00411

G1 X83.734 Y89.074 E0.00469

G1 X83.954 Y88.934 E0.00681

G1 X85.025 Y88.335 E0.03197

G1 X85.060 Y88.289 E0.00150

G1 X85.440 Y88.093 E0.01114

G1 X86.052 Y87.837 E0.01730

G1 X86.544 Y87.690 E0.01338

G1 X87.174 Y87.604 E0.01657

G1 X87.748 Y87.645 E0.01499

G1 X88.434 Y87.836 E0.01855

G1 X88.875 Y88.015 E0.01240

G1 X90.191 Y88.710 E0.03877

G1 X90.933 Y89.212 E0.02336

G1 X91.246 Y89.515 E0.01135

G1 X91.361 Y89.712 E0.00594

G1 X91.346 Y89.770 E0.00157

G1 X91.286 Y89.788 E0.00164

G1 X88.695 Y89.761 E0.06749

G1 X83.237 Y89.773 E0.14223

G1 X83.187 Y89.750 E0.00144

G1 X83.280 Y89.518 E0.00652

M204 S1250

G1 X83.540 Y89.473 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.468 Y89.279 E-0.16855

G1 X83.605 Y89.200 E-0.08739

G1 X83.734 Y89.074 E-0.09976

G1 X83.954 Y88.934 E-0.14474

G1 X84.602 Y88.571 E-0.41156

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X88.911 Y89.220

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.236 Y88.545 E0.02549

G1 X87.616 Y88.368 E0.01721

G1 X87.447 Y88.361 E0.00452

G1 X88.117 Y89.031 E0.02530

G1 X87.513 Y89.033 E0.01612

G1 X86.865 Y88.384 E0.02447

G1 X86.702 Y88.406 E0.00438

G1 X86.378 Y88.503 E0.00904

G1 X86.909 Y89.034 E0.02005

G1 X86.305 Y89.035 E0.01612

G1 X85.944 Y88.675 E0.01361

G1 X85.536 Y88.871 E0.01211

G1 X85.889 Y89.224 E0.01332

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.536 Y88.871 E-0.27654

G1 X85.944 Y88.675 E-0.25134

G1 X86.305 Y89.035 E-0.28254

G1 X86.488 Y89.035 E-0.10158

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X91.349 Y84.922

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.527 Y84.920 E0.03070

G1 X92.587 Y85.126 E0.00560

G1 X92.595 Y85.736 E0.01587

G1 X92.354 Y85.556 E0.00782

G1 X91.397 Y84.958 E0.02942

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.527 Y84.920 E-0.62682

G1 X92.587 Y85.126 E-0.11917

G1 X92.591 Y85.426 E-0.16601

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X92.990 Y86.107

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.912 Y86.209 E0.00334

G1 X92.735 Y86.273 E0.00490

G1 X92.612 Y86.244 E0.00329

G1 X92.290 Y86.036 E0.00998

G1 X92.116 Y85.900 E0.00575

G1 X91.236 Y85.362 E0.02688

G1 X90.710 Y84.958 E0.01728

G1 X90.555 Y84.805 E0.00567

G1 X90.388 Y84.586 E0.00717

G1 X90.377 Y84.530 E0.00149

G1 X90.482 Y84.546 E0.00277

G1 X90.516 Y84.505 E0.00137

G1 X92.694 Y84.502 E0.05675

G1 X92.798 Y84.548 E0.00297

G1 X92.885 Y84.654 E0.00357

G1 X93.002 Y85.055 E0.01089

G1 X93.015 Y85.297 E0.00631

G1 X93.004 Y86.049 E0.01959

M204 S1250

G1 X92.862 Y86.118 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.912 Y86.209 E-0.10238

G1 X92.735 Y86.273 E-0.10430

G1 X92.612 Y86.244 E-0.06996

G1 X92.290 Y86.036 E-0.21235

G1 X92.116 Y85.900 E-0.12237

G1 X91.653 Y85.617 E-0.30064

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X92.595 Y72.738

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.354 Y72.559 E0.00782

G1 X91.473 Y72.019 E0.02691

G1 X91.349 Y71.924 E0.00406

G1 X92.527 Y71.922 E0.03069

G1 X92.587 Y72.128 E0.00559

G1 X92.595 Y72.678 E0.01431

M204 S1250

G1 X92.990 Y73.109 F9000.000

M204 S800

G1 F1500.000

G1 X92.912 Y73.211 E0.00335

G1 X92.735 Y73.275 E0.00490

G1 X92.612 Y73.246 E0.00329

G1 X92.116 Y72.903 E0.01572

G1 X91.236 Y72.364 E0.02688

G1 X90.710 Y71.960 E0.01728

G1 X90.555 Y71.807 E0.00567

G1 X90.388 Y71.589 E0.00716

G1 X90.377 Y71.532 E0.00150

G1 X90.482 Y71.549 E0.00277

G1 X90.516 Y71.507 E0.00139

G1 X92.694 Y71.504 E0.05674

G1 X92.798 Y71.550 E0.00296

G1 X92.885 Y71.657 E0.00358

G1 X93.002 Y72.057 E0.01088

G1 X93.015 Y72.300 E0.00634

G1 X93.005 Y73.051 E0.01956

M204 S1250

G1 X92.862 Y73.120 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.912 Y73.211 E-0.10249

G1 X92.735 Y73.275 E-0.10430

G1 X92.612 Y73.246 E-0.06996

G1 X92.116 Y72.903 E-0.33430

G1 X91.653 Y72.619 E-0.30095

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X90.408 Y76.363

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.697 Y76.346 E0.04458

G1 X84.073 Y76.356 E0.12050

G1 X85.305 Y75.659 E0.03689

G1 X85.335 Y75.619 E0.00131

G1 X85.616 Y75.474 E0.00824

G1 X86.193 Y75.233 E0.01629

G1 X86.636 Y75.100 E0.01206

G1 X87.099 Y75.029 E0.01219

G1 X87.665 Y75.058 E0.01476

G1 X88.299 Y75.234 E0.01715

G1 X88.698 Y75.397 E0.01123

G1 X89.975 Y76.070 E0.03763

G1 X90.358 Y76.329 E0.01204

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.713 Y76.345 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X83.283 Y76.460

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.468 Y76.281 E0.00669

G1 X83.605 Y76.203 E0.00411

G1 X83.734 Y76.076 E0.00471

G1 X83.954 Y75.936 E0.00680

G1 X85.025 Y75.337 E0.03197

G1 X85.060 Y75.291 E0.00150

G1 X85.440 Y75.095 E0.01114

G1 X86.052 Y74.839 E0.01730

G1 X86.544 Y74.692 E0.01338

G1 X87.174 Y74.606 E0.01657

G1 X87.748 Y74.647 E0.01499

G1 X88.434 Y74.838 E0.01855

G1 X88.875 Y75.017 E0.01240

G1 X90.191 Y75.712 E0.03876

G1 X90.933 Y76.214 E0.02336

G1 X91.245 Y76.518 E0.01136

G1 X91.361 Y76.714 E0.00594

G1 X91.346 Y76.772 E0.00156

G1 X91.286 Y76.790 E0.00164

G1 X88.695 Y76.763 E0.06749

G1 X83.237 Y76.775 E0.14223

G1 X83.187 Y76.752 E0.00144

G1 X83.280 Y76.520 E0.00652

M204 S1250

G1 X83.540 Y76.475 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.468 Y76.281 E-0.16837

G1 X83.605 Y76.203 E-0.08738

G1 X83.734 Y76.076 E-0.10015

G1 X83.954 Y75.936 E-0.14461

G1 X84.602 Y75.574 E-0.41150

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X88.911 Y76.222

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.236 Y75.547 E0.02551

G1 X87.616 Y75.370 E0.01721

G1 X87.447 Y75.363 E0.00452

G1 X88.117 Y76.033 E0.02531

G1 X87.513 Y76.035 E0.01613

G1 X86.865 Y75.386 E0.02448

G1 X86.702 Y75.408 E0.00438

G1 X86.378 Y75.505 E0.00904

G1 X86.909 Y76.036 E0.02006

G1 X86.305 Y76.037 E0.01613

G1 X85.944 Y75.677 E0.01362

G1 X85.536 Y75.874 E0.01211

G1 X85.888 Y76.226 E0.01332

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.536 Y75.874 E-0.27655

G1 X85.944 Y75.677 E-0.25134

G1 X86.305 Y76.037 E-0.28265

G1 X86.488 Y76.037 E-0.10146

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X82.965 Y72.044

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y72.728 E0.03325

G1 X81.889 Y72.242 E0.01267

G1 X81.951 Y71.933 E0.00823

G1 X83.107 Y71.931 E0.03011

G1 X83.012 Y72.006 E0.00315

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.888 Y72.728 E-0.74032

G1 X81.889 Y72.419 E-0.17168

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X81.790 Y73.266

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.717 Y73.277 E0.00193

G1 X81.640 Y73.258 E0.00206

G1 X81.501 Y73.125 E0.00501

G1 X81.470 Y73.011 E0.00307

G1 X81.471 Y72.200 E0.02112

G1 X81.569 Y71.716 E0.01288

G1 X81.691 Y71.547 E0.00543

G1 X81.781 Y71.515 E0.00247

G1 X83.995 Y71.512 E0.05769

G1 X84.083 Y71.565 E0.00269

G1 X84.065 Y71.642 E0.00205

G1 X83.881 Y71.850 E0.00723

G1 X83.209 Y72.383 E0.02235

G1 X82.279 Y72.986 E0.02888

G1 X81.842 Y73.236 E0.01312

M204 S1250

G1 X81.737 Y73.215 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.717 Y73.277 E-0.07307

G1 X81.640 Y73.258 E-0.04379

G1 X81.501 Y73.125 E-0.10658

G1 X81.470 Y73.011 E-0.06537

G1 X81.471 Y72.200 E-0.44919

G1 X81.533 Y71.893 E-0.17399

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X81.888 Y59.730

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.889 Y59.244 E0.01267

G1 X81.951 Y58.935 E0.00823

G1 X83.107 Y58.933 E0.03011

G1 X82.965 Y59.046 E0.00471

G1 X81.940 Y59.701 E0.03169

M204 S1250

G1 X81.790 Y60.268 F9000.000

M204 S800

G1 F1500.000

G1 X81.717 Y60.279 E0.00193

G1 X81.640 Y60.260 E0.00206

G1 X81.501 Y60.127 E0.00501

G1 X81.470 Y60.013 E0.00307

G1 X81.471 Y59.202 E0.02112

G1 X81.569 Y58.718 E0.01288

G1 X81.691 Y58.549 E0.00543

G1 X81.781 Y58.517 E0.00247

G1 X83.994 Y58.515 E0.05769

G1 X84.083 Y58.567 E0.00269

G1 X84.065 Y58.644 E0.00205

G1 X83.881 Y58.852 E0.00724

G1 X83.209 Y59.385 E0.02235

G1 X82.279 Y59.988 E0.02888

G1 X81.842 Y60.238 E0.01312

M204 S1250

G1 X81.737 Y60.217 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.717 Y60.279 E-0.07307

G1 X81.640 Y60.260 E-0.04379

G1 X81.501 Y60.127 E-0.10658

G1 X81.470 Y60.013 E-0.06537

G1 X81.471 Y59.202 E-0.44919

G1 X81.533 Y58.895 E-0.17399

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X84.073 Y63.358

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.307 Y62.661 E0.03691

G1 X85.337 Y62.620 E0.00132

G1 X85.616 Y62.477 E0.00817

G1 X86.193 Y62.235 E0.01630

G1 X86.637 Y62.102 E0.01206

G1 X87.099 Y62.031 E0.01219

G1 X87.664 Y62.060 E0.01474

G1 X88.299 Y62.237 E0.01718

G1 X88.698 Y62.399 E0.01123

G1 X89.975 Y63.072 E0.03762

G1 X90.408 Y63.365 E0.01361

G1 X88.697 Y63.348 E0.04458

G1 X84.133 Y63.358 E0.11891

M204 S1250

G1 X83.283 Y63.462 F9000.000

M204 S800

G1 F1500.000

G1 X83.468 Y63.283 E0.00670

G1 X83.604 Y63.205 E0.00410

G1 X83.734 Y63.079 E0.00470

G1 X83.954 Y62.938 E0.00681

G1 X85.026 Y62.340 E0.03199

G1 X85.060 Y62.293 E0.00152

G1 X85.440 Y62.098 E0.01111

G1 X86.052 Y61.841 E0.01730

G1 X86.544 Y61.694 E0.01339

G1 X87.174 Y61.608 E0.01657

G1 X87.748 Y61.650 E0.01499

G1 X88.434 Y61.841 E0.01856

G1 X88.875 Y62.019 E0.01240

G1 X90.191 Y62.714 E0.03876

G1 X90.933 Y63.216 E0.02336

G1 X91.245 Y63.520 E0.01136

G1 X91.361 Y63.716 E0.00594

G1 X91.346 Y63.774 E0.00156

G1 X91.286 Y63.792 E0.00164

G1 X88.695 Y63.765 E0.06749

G1 X83.237 Y63.777 E0.14223

G1 X83.187 Y63.754 E0.00144

G1 X83.280 Y63.522 E0.00651

M204 S1250

G1 X83.540 Y63.478 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.468 Y63.283 E-0.16868

G1 X83.604 Y63.205 E-0.08711

G1 X83.734 Y63.079 E-0.09994

G1 X83.954 Y62.938 E-0.14485

G1 X84.602 Y62.576 E-0.41141

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X88.912 Y63.224

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.237 Y62.550 E0.02546

G1 X87.615 Y62.372 E0.01727

G1 X87.447 Y62.365 E0.00448

G1 X88.118 Y63.035 E0.02529

G1 X87.514 Y63.037 E0.01611

G1 X86.865 Y62.388 E0.02447

G1 X86.702 Y62.410 E0.00438

G1 X86.379 Y62.507 E0.00902

G1 X86.910 Y63.038 E0.02005

G1 X86.306 Y63.039 E0.01611

G1 X85.945 Y62.679 E0.01361

G1 X85.537 Y62.876 E0.01209

G1 X85.890 Y63.228 E0.01330

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.537 Y62.876 E-0.27616

G1 X85.945 Y62.679 E-0.25108

G1 X86.306 Y63.039 E-0.28273

G1 X86.490 Y63.039 E-0.10202

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X91.349 Y58.926

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.527 Y58.924 E0.03071

G1 X92.587 Y59.130 E0.00559

G1 X92.595 Y59.740 E0.01588

G1 X92.354 Y59.561 E0.00783

G1 X91.396 Y58.963 E0.02941

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.527 Y58.924 E-0.62703

G1 X92.587 Y59.130 E-0.11893

G1 X92.591 Y59.430 E-0.16604

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X92.990 Y60.112

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.912 Y60.213 E0.00333

G1 X92.734 Y60.277 E0.00493

G1 X92.612 Y60.248 E0.00326

G1 X92.116 Y59.905 E0.01573

G1 X91.236 Y59.366 E0.02688

G1 X90.710 Y58.963 E0.01727

G1 X90.555 Y58.809 E0.00568

G1 X90.388 Y58.591 E0.00716

G1 X90.377 Y58.534 E0.00150

G1 X90.482 Y58.551 E0.00277

G1 X90.516 Y58.509 E0.00139

G1 X92.694 Y58.506 E0.05674

G1 X92.798 Y58.553 E0.00297

G1 X92.885 Y58.659 E0.00357

G1 X93.002 Y59.059 E0.01088

G1 X93.015 Y59.302 E0.00634

G1 X93.005 Y60.053 E0.01957

M204 S1250

G1 X92.863 Y60.122 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.912 Y60.213 E-0.10209

G1 X92.734 Y60.277 E-0.10488

G1 X92.612 Y60.248 E-0.06940

G1 X92.116 Y59.905 E-0.33462

G1 X91.652 Y59.621 E-0.30101

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X92.595 Y46.742

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.354 Y46.563 E0.00783

G1 X91.473 Y46.023 E0.02691

G1 X91.349 Y45.928 E0.00406

G1 X92.527 Y45.927 E0.03070

G1 X92.587 Y46.132 E0.00558

G1 X92.595 Y46.682 E0.01431

M204 S1250

G1 X92.990 Y47.114 F9000.000

M204 S800

G1 F1500.000

G1 X92.912 Y47.215 E0.00333

G1 X92.734 Y47.279 E0.00494

G1 X92.612 Y47.250 E0.00326

G1 X92.116 Y46.907 E0.01574

G1 X91.236 Y46.368 E0.02688

G1 X90.710 Y45.965 E0.01727

G1 X90.555 Y45.812 E0.00567

G1 X90.388 Y45.593 E0.00717

G1 X90.377 Y45.536 E0.00151

G1 X90.482 Y45.553 E0.00276

G1 X90.516 Y45.512 E0.00139

G1 X92.694 Y45.509 E0.05676

G1 X92.798 Y45.555 E0.00297

G1 X92.885 Y45.661 E0.00357

G1 X93.002 Y46.061 E0.01088

G1 X93.015 Y46.304 E0.00634

G1 X93.004 Y47.056 E0.01958

M204 S1250

G1 X92.863 Y47.124 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.912 Y47.215 E-0.10200

G1 X92.734 Y47.279 E-0.10497

G1 X92.612 Y47.250 E-0.06930

G1 X92.116 Y46.907 E-0.33472

G1 X91.652 Y46.623 E-0.30100

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X90.409 Y50.368

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X88.697 Y50.350 E0.04460

G1 X84.073 Y50.360 E0.12048

G1 X85.307 Y49.663 E0.03691

G1 X85.337 Y49.622 E0.00132

G1 X85.616 Y49.479 E0.00817

G1 X86.193 Y49.237 E0.01629

G1 X86.637 Y49.105 E0.01207

G1 X87.095 Y49.033 E0.01209

G1 X87.664 Y49.062 E0.01483

G1 X88.299 Y49.239 E0.01719

G1 X88.699 Y49.401 E0.01123

G1 X89.975 Y50.074 E0.03761

G1 X90.359 Y50.334 E0.01207

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.713 Y50.349 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X83.283 Y50.464

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.468 Y50.285 E0.00670

G1 X83.604 Y50.207 E0.00410

G1 X83.734 Y50.081 E0.00470

G1 X83.954 Y49.940 E0.00681

G1 X85.026 Y49.342 E0.03199

G1 X85.060 Y49.295 E0.00152

G1 X85.440 Y49.100 E0.01111

G1 X86.052 Y48.843 E0.01730

G1 X86.544 Y48.696 E0.01338

G1 X87.173 Y48.610 E0.01653

G1 X87.207 Y48.625 E0.00097

G1 X87.574 Y48.629 E0.00958

G1 X87.748 Y48.652 E0.00456

G1 X88.434 Y48.843 E0.01856

G1 X88.875 Y49.021 E0.01239

G1 X90.191 Y49.716 E0.03876

G1 X90.933 Y50.218 E0.02336

G1 X91.245 Y50.522 E0.01136

G1 X91.361 Y50.718 E0.00594

G1 X91.346 Y50.777 E0.00158

G1 X91.286 Y50.795 E0.00163

G1 X88.695 Y50.767 E0.06750

G1 X83.237 Y50.779 E0.14224

G1 X83.187 Y50.756 E0.00143

G1 X83.280 Y50.524 E0.00652

M204 S1250

G1 X83.540 Y50.480 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.468 Y50.285 E-0.16868

G1 X83.604 Y50.207 E-0.08711

G1 X83.734 Y50.081 E-0.09994

G1 X83.954 Y49.940 E-0.14485

G1 X84.602 Y49.578 E-0.41142

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X88.912 Y50.226

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S1000

G1 F4800.000

G1 X88.238 Y49.553 E0.02544

G1 X87.615 Y49.374 E0.01729

G1 X87.448 Y49.368 E0.00447

G1 X88.118 Y50.037 E0.02527

G1 X87.514 Y50.039 E0.01612

G1 X86.866 Y49.391 E0.02445

G1 X86.702 Y49.412 E0.00441

G1 X86.379 Y49.509 E0.00901

G1 X86.910 Y50.040 E0.02005

G1 X86.306 Y50.041 E0.01612

G1 X85.945 Y49.681 E0.01362

G1 X85.537 Y49.878 E0.01209

G1 X85.890 Y50.230 E0.01330

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.537 Y49.878 E-0.27618

G1 X85.945 Y49.681 E-0.25109

G1 X86.306 Y50.041 E-0.28274

G1 X86.490 Y50.041 E-0.10199

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X82.965 Y46.048

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.888 Y46.733 E0.03325

G1 X81.889 Y46.247 E0.01266

G1 X81.951 Y45.937 E0.00823

G1 X83.107 Y45.936 E0.03011

G1 X83.012 Y46.011 E0.00315

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.888 Y46.733 E-0.74027

G1 X81.889 Y46.423 E-0.17173

G1 E-0.04800 F4200.00000

G1 Z11.800 F9000.000

G1 X81.790 Y47.271

G1 Z11.600

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.717 Y47.281 E0.00193

G1 X81.640 Y47.262 E0.00207

G1 X81.501 Y47.130 E0.00499

G1 X81.470 Y47.015 E0.00309

G1 X81.471 Y46.205 E0.02111

G1 X81.569 Y45.720 E0.01288

G1 X81.691 Y45.552 E0.00544

G1 X81.780 Y45.520 E0.00246

G1 X83.994 Y45.517 E0.05769

G1 X84.083 Y45.570 E0.00270

G1 X84.065 Y45.646 E0.00204

G1 X83.881 Y45.854 E0.00724

G1 X83.209 Y46.388 E0.02236

G1 X82.279 Y46.990 E0.02887

G1 X81.842 Y47.241 E0.01312

M204 S1250

G1 X81.737 Y47.219 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;11.75

G1 Z11.750 F9000.000

;AFTER\_LAYER\_CHANGE

;11.75

G1 E-3.20000 F4200.00000

G1 Z11.950 F9000.000

G1 X81.961 Y111.159

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.734 Y111.159 E0.02014

G1 X82.132 Y111.576 E0.01907

G1 X81.890 Y111.717 E0.00732

G1 X81.895 Y111.435 E0.00734

G1 X81.932 Y111.211 E0.00593

M204 S1250

G1 X81.778 Y110.741 F9000.000

M204 S800

G1 F1500.000

G1 X83.659 Y110.741 E0.04901

G1 X83.719 Y110.771 E0.00174

G1 X83.717 Y110.799 E0.00074

G1 X83.534 Y111.038 E0.00783

G1 X83.198 Y111.336 E0.01171

G1 X82.355 Y111.929 E0.02685

G1 X81.786 Y112.261 E0.01715

G1 X81.716 Y112.269 E0.00184

G1 X81.626 Y112.246 E0.00242

G1 X81.544 Y112.175 E0.00283

G1 X81.499 Y112.116 E0.00194

G1 X81.470 Y112.010 E0.00285

G1 X81.478 Y111.397 E0.01596

G1 X81.528 Y111.075 E0.00849

G1 X81.721 Y110.760 E0.00964

M204 S1250

G1 X82.092 Y110.988 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.366 Y110.744 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X84.517 Y115.095

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.129 Y114.751 E0.01829

G1 X85.170 Y114.697 E0.00178

G1 X85.577 Y114.486 E0.01194

G1 X86.191 Y114.227 E0.01736

G1 X86.621 Y114.098 E0.01169

G1 X87.088 Y114.023 E0.01234

G1 X87.526 Y114.034 E0.01142

G1 X87.708 Y114.061 E0.00479

G1 X88.346 Y114.245 E0.01731

G1 X88.719 Y114.399 E0.01051

G1 X89.668 Y114.910 E0.02809

G1 X90.024 Y115.139 E0.01104

G1 X84.449 Y115.139 E0.14527

G1 X84.466 Y115.128 E0.00054

M204 S1250

G1 X83.521 Y115.478 F9000.000

M204 S800

G1 F1500.000

G1 X83.690 Y115.199 E0.00849

G1 X84.005 Y114.928 E0.01082

G1 X84.325 Y114.722 E0.00993

G1 X84.848 Y114.429 E0.01563

G1 X84.894 Y114.369 E0.00197

G1 X85.400 Y114.108 E0.01483

G1 X86.049 Y113.833 E0.01837

G1 X86.527 Y113.690 E0.01299

G1 X87.058 Y113.604 E0.01403

G1 X87.563 Y113.617 E0.01315

G1 X87.797 Y113.651 E0.00616

G1 X88.485 Y113.850 E0.01866

G1 X88.898 Y114.022 E0.01166

G1 X89.881 Y114.550 E0.02907

G1 X90.485 Y114.939 E0.01873

G1 X90.837 Y115.248 E0.01220

G1 X90.998 Y115.550 E0.00892

G1 X83.529 Y115.556 E0.19460

G1 X83.517 Y115.537 E0.00059

M204 S1250

G1 X83.774 Y115.273 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.690 Y115.199 E-0.21063

G1 X84.005 Y114.928 E-0.23016

G1 X84.325 Y114.722 E-0.21116

G1 X84.735 Y114.493 E-0.26005

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X85.290 Y114.884

G1 Z11.750

G1 E3.20000 F2400.00000

G1 X85.890 Y114.763 E0.01067

G1 X86.311 Y115.014 F9000.000

M204 S1000

G1 F3746

G1 X86.964 Y114.360 E0.02559

G1 X87.110 Y114.337 E0.00410

G1 X87.587 Y114.365 E0.01322

G1 X87.127 Y114.826 E0.01803

G1 X87.754 Y114.826 E0.01739

G1 X88.085 Y114.496 E0.01293

G1 X88.543 Y114.666 E0.01353

G1 X88.194 Y115.014 E0.01364

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.543 Y114.666 E-0.27290

G1 X88.085 Y114.496 E-0.27073

G1 X87.754 Y114.826 E-0.25870

G1 X87.557 Y114.826 E-0.10967

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X91.782 Y111.150

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.531 Y111.149 E0.01951

G1 X92.579 Y111.364 E0.00575

G1 X92.587 Y111.725 E0.00941

G1 X92.329 Y111.529 E0.00844

G1 X92.006 Y111.342 E0.00972

G1 X91.830 Y111.187 E0.00613

M204 S1250

G1 X92.750 Y112.269 F9000.000

M204 S800

G1 F1500.000

G1 X92.617 Y112.243 E0.00353

G1 X92.311 Y112.045 E0.00950

G1 X92.095 Y111.877 E0.00713

G1 X91.755 Y111.679 E0.01025

G1 X91.625 Y111.557 E0.00466

G1 X90.955 Y111.040 E0.02203

G1 X90.786 Y110.807 E0.00750

G1 X90.846 Y110.734 E0.00247

G1 X92.604 Y110.731 E0.04582

G1 X92.717 Y110.736 E0.00294

G1 X92.800 Y110.763 E0.00228

G1 X92.865 Y110.840 E0.00262

G1 X92.925 Y110.998 E0.00440

G1 X92.996 Y111.314 E0.00844

G1 X93.010 Y112.019 E0.01837

G1 X92.990 Y112.100 E0.00219

G1 X92.915 Y112.202 E0.00329

G1 X92.805 Y112.246 E0.00308

M204 S1250

G1 X92.673 Y112.157 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.617 Y112.243 E-0.10445

G1 X92.311 Y112.045 E-0.20212

G1 X92.095 Y111.877 E-0.15170

G1 X91.755 Y111.679 E-0.21798

G1 X91.625 Y111.557 E-0.09906

G1 X91.430 Y111.406 E-0.13670

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X92.587 Y98.728

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.330 Y98.532 E0.00843

G1 X92.006 Y98.344 E0.00974

G1 X91.783 Y98.152 E0.00769

G1 X92.531 Y98.151 E0.01950

G1 X92.579 Y98.366 E0.00575

G1 X92.585 Y98.668 E0.00787

M204 S1250

G1 X92.990 Y99.102 F9000.000

M204 S800

G1 F1500.000

G1 X92.915 Y99.204 E0.00330

G1 X92.750 Y99.271 E0.00463

G1 X92.617 Y99.245 E0.00354

G1 X92.311 Y99.048 E0.00948

G1 X92.095 Y98.879 E0.00714

G1 X91.755 Y98.681 E0.01026

G1 X91.625 Y98.559 E0.00466

G1 X90.955 Y98.042 E0.02203

G1 X90.786 Y97.810 E0.00749

G1 X90.846 Y97.736 E0.00247

G1 X92.604 Y97.733 E0.04582

G1 X92.717 Y97.738 E0.00294

G1 X92.800 Y97.765 E0.00228

G1 X92.865 Y97.842 E0.00262

G1 X92.925 Y98.000 E0.00440

G1 X92.996 Y98.316 E0.00844

G1 X93.005 Y99.044 E0.01898

M204 S1250

G1 X92.864 Y99.117 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.915 Y99.204 E-0.10163

G1 X92.750 Y99.271 E-0.09845

G1 X92.617 Y99.245 E-0.07532

G1 X92.311 Y99.048 E-0.20166

G1 X92.095 Y98.879 E-0.15185

G1 X91.755 Y98.681 E-0.21818

G1 X91.670 Y98.601 E-0.06490

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X90.025 Y102.142

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.448 Y102.142 E0.14530

G1 X85.129 Y101.753 E0.02042

G1 X85.170 Y101.699 E0.00178

G1 X85.577 Y101.488 E0.01194

G1 X86.191 Y101.229 E0.01736

G1 X86.621 Y101.100 E0.01169

G1 X87.088 Y101.025 E0.01234

G1 X87.526 Y101.037 E0.01142

G1 X87.709 Y101.063 E0.00481

G1 X88.346 Y101.247 E0.01728

G1 X88.719 Y101.401 E0.01051

G1 X89.668 Y101.912 E0.02809

G1 X89.974 Y102.109 E0.00948

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.328 Y102.119 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X83.521 Y102.480

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.690 Y102.201 E0.00850

G1 X84.005 Y101.930 E0.01082

G1 X84.325 Y101.724 E0.00993

G1 X84.848 Y101.431 E0.01563

G1 X84.894 Y101.371 E0.00197

G1 X85.400 Y101.110 E0.01483

G1 X86.049 Y100.835 E0.01837

G1 X86.527 Y100.692 E0.01299

G1 X87.058 Y100.606 E0.01403

G1 X87.563 Y100.620 E0.01315

G1 X87.797 Y100.653 E0.00616

G1 X88.485 Y100.852 E0.01864

G1 X88.898 Y101.024 E0.01166

G1 X89.881 Y101.552 E0.02907

G1 X90.485 Y101.941 E0.01872

G1 X90.837 Y102.250 E0.01221

G1 X90.998 Y102.552 E0.00891

G1 X83.529 Y102.559 E0.19459

G1 X83.517 Y102.540 E0.00061

M204 S1250

G1 X83.774 Y102.275 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.690 Y102.201 E-0.21081

G1 X84.005 Y101.930 E-0.23003

G1 X84.325 Y101.724 E-0.21110

G1 X84.734 Y101.495 E-0.26007

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X85.289 Y101.887

G1 Z11.750

G1 E3.20000 F2400.00000

G1 X85.889 Y101.765 E0.01065

G1 X86.310 Y102.016 F9000.000

M204 S1000

G1 F3746

G1 X86.964 Y101.362 E0.02562

G1 X87.110 Y101.339 E0.00412

G1 X87.586 Y101.368 E0.01321

G1 X87.126 Y101.828 E0.01805

G1 X87.754 Y101.828 E0.01741

G1 X88.085 Y101.498 E0.01295

G1 X88.543 Y101.668 E0.01354

G1 X88.194 Y102.016 E0.01365

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.543 Y101.668 E-0.27309

G1 X88.085 Y101.498 E-0.27085

G1 X87.754 Y101.828 E-0.25901

G1 X87.557 Y101.828 E-0.10905

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X82.734 Y98.161

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.132 Y98.578 E0.01909

G1 X81.890 Y98.720 E0.00731

G1 X81.895 Y98.437 E0.00735

G1 X81.929 Y98.217 E0.00581

G1 X81.961 Y98.161 E0.00169

G1 X82.674 Y98.161 E0.01858

M204 S1250

G1 X81.716 Y99.271 F9000.000

M204 S800

G1 F1500.000

G1 X81.627 Y99.248 E0.00240

G1 X81.544 Y99.177 E0.00285

G1 X81.499 Y99.118 E0.00194

G1 X81.470 Y99.012 E0.00285

G1 X81.478 Y98.399 E0.01596

G1 X81.528 Y98.078 E0.00849

G1 X81.703 Y97.768 E0.00928

G1 X81.778 Y97.743 E0.00204

G1 X83.659 Y97.743 E0.04901

G1 X83.719 Y97.773 E0.00174

G1 X83.717 Y97.801 E0.00075

G1 X83.534 Y98.041 E0.00785

G1 X83.198 Y98.338 E0.01169

G1 X82.355 Y98.932 E0.02687

G1 X81.775 Y99.264 E0.01741

M204 S1250

G1 X81.668 Y99.192 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.627 Y99.248 E-0.08297

G1 X81.544 Y99.177 E-0.06052

G1 X81.499 Y99.118 E-0.04126

G1 X81.470 Y99.012 E-0.06063

G1 X81.478 Y98.399 E-0.33946

G1 X81.528 Y98.078 E-0.18058

G1 X81.658 Y97.847 E-0.14658

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X81.890 Y85.722

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.895 Y85.439 E0.00735

G1 X81.929 Y85.220 E0.00580

G1 X81.961 Y85.163 E0.00171

G1 X82.734 Y85.163 E0.02014

G1 X82.132 Y85.581 E0.01909

G1 X81.941 Y85.691 E0.00575

M204 S1250

G1 X81.786 Y86.265 F9000.000

M204 S800

G1 F1500.000

G1 X81.716 Y86.274 E0.00184

G1 X81.627 Y86.250 E0.00240

G1 X81.499 Y86.120 E0.00477

G1 X81.470 Y86.014 E0.00285

G1 X81.478 Y85.402 E0.01596

G1 X81.528 Y85.080 E0.00847

G1 X81.704 Y84.769 E0.00930

G1 X81.778 Y84.745 E0.00204

G1 X83.659 Y84.746 E0.04901

G1 X83.719 Y84.775 E0.00174

G1 X83.717 Y84.804 E0.00075

G1 X83.534 Y85.043 E0.00784

G1 X83.198 Y85.341 E0.01171

G1 X82.355 Y85.934 E0.02686

G1 X81.838 Y86.235 E0.01559

M204 S1250

G1 X81.735 Y86.216 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.716 Y86.274 E-0.07091

G1 X81.627 Y86.250 E-0.05106

G1 X81.499 Y86.120 E-0.10135

G1 X81.470 Y86.014 E-0.06063

G1 X81.478 Y85.402 E-0.33944

G1 X81.528 Y85.080 E-0.18013

G1 X81.624 Y84.910 E-0.10849

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X84.448 Y89.144

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.129 Y88.755 E0.02042

G1 X85.170 Y88.701 E0.00177

G1 X85.577 Y88.491 E0.01194

G1 X86.191 Y88.231 E0.01738

G1 X86.621 Y88.102 E0.01168

G1 X87.089 Y88.027 E0.01235

G1 X87.526 Y88.039 E0.01141

G1 X87.709 Y88.065 E0.00481

G1 X88.346 Y88.249 E0.01728

G1 X88.719 Y88.403 E0.01051

G1 X89.668 Y88.914 E0.02809

G1 X90.026 Y89.144 E0.01107

G1 X84.508 Y89.144 E0.14376

M204 S1250

G1 X83.521 Y89.482 F9000.000

M204 S800

G1 F1500.000

G1 X83.690 Y89.203 E0.00850

G1 X84.005 Y88.933 E0.01081

G1 X84.325 Y88.726 E0.00994

G1 X84.848 Y88.433 E0.01563

G1 X84.894 Y88.373 E0.00197

G1 X85.400 Y88.113 E0.01482

G1 X86.049 Y87.838 E0.01838

G1 X86.527 Y87.694 E0.01299

G1 X87.059 Y87.609 E0.01403

G1 X87.563 Y87.622 E0.01315

G1 X87.797 Y87.655 E0.00616

G1 X88.485 Y87.854 E0.01864

G1 X88.898 Y88.026 E0.01166

G1 X89.881 Y88.554 E0.02907

G1 X90.485 Y88.943 E0.01872

G1 X90.837 Y89.252 E0.01221

G1 X90.998 Y89.555 E0.00894

G1 X83.529 Y89.561 E0.19460

G1 X83.517 Y89.542 E0.00061

M204 S1250

G1 X83.774 Y89.277 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.690 Y89.203 E-0.21074

G1 X84.005 Y88.933 E-0.22987

G1 X84.325 Y88.726 E-0.21137

G1 X84.735 Y88.497 E-0.26002

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X85.289 Y88.889

G1 Z11.750

G1 E3.20000 F2400.00000

G1 X85.890 Y88.768 E0.01067

G1 X86.311 Y89.019 F9000.000

M204 S1000

G1 F3746

G1 X86.965 Y88.364 E0.02563

G1 X87.111 Y88.341 E0.00411

G1 X87.588 Y88.370 E0.01323

G1 X87.127 Y88.831 E0.01806

G1 X87.755 Y88.831 E0.01741

G1 X88.086 Y88.500 E0.01296

G1 X88.544 Y88.670 E0.01354

G1 X88.196 Y89.019 E0.01366

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.544 Y88.670 E-0.27317

G1 X88.086 Y88.500 E-0.27083

G1 X87.755 Y88.831 E-0.25914

G1 X87.559 Y88.831 E-0.10885

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X91.783 Y85.154

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.531 Y85.153 E0.01950

G1 X92.579 Y85.369 E0.00575

G1 X92.587 Y85.730 E0.00943

G1 X92.330 Y85.534 E0.00842

G1 X92.006 Y85.346 E0.00974

G1 X91.830 Y85.191 E0.00612

M204 S1250

G1 X92.750 Y86.273 F9000.000

M204 S800

G1 F1500.000

G1 X92.617 Y86.247 E0.00354

G1 X92.311 Y86.050 E0.00948

G1 X92.095 Y85.881 E0.00714

G1 X91.755 Y85.683 E0.01026

G1 X91.625 Y85.561 E0.00466

G1 X90.955 Y85.044 E0.02203

G1 X90.786 Y84.812 E0.00749

G1 X90.846 Y84.738 E0.00247

G1 X92.604 Y84.735 E0.04582

G1 X92.717 Y84.740 E0.00295

G1 X92.800 Y84.767 E0.00227

G1 X92.865 Y84.845 E0.00264

G1 X92.925 Y85.002 E0.00439

G1 X92.996 Y85.318 E0.00844

G1 X93.010 Y86.023 E0.01837

G1 X92.990 Y86.104 E0.00219

G1 X92.915 Y86.206 E0.00330

G1 X92.806 Y86.250 E0.00307

M204 S1250

G1 X92.673 Y86.161 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.617 Y86.247 E-0.10480

G1 X92.311 Y86.050 E-0.20166

G1 X92.095 Y85.881 E-0.15185

G1 X91.755 Y85.683 E-0.21818

G1 X91.625 Y85.561 E-0.09908

G1 X91.430 Y85.410 E-0.13643

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X92.587 Y72.732

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.329 Y72.537 E0.00842

G1 X92.007 Y72.349 E0.00973

G1 X91.783 Y72.157 E0.00768

G1 X92.531 Y72.156 E0.01950

G1 X92.579 Y72.371 E0.00573

G1 X92.585 Y72.672 E0.00786

M204 S1250

G1 X92.990 Y73.106 F9000.000

M204 S800

G1 F1500.000

G1 X92.915 Y73.208 E0.00330

G1 X92.750 Y73.275 E0.00463

G1 X92.617 Y73.249 E0.00354

G1 X92.311 Y73.052 E0.00949

G1 X92.095 Y72.884 E0.00712

G1 X91.755 Y72.686 E0.01026

G1 X91.625 Y72.563 E0.00466

G1 X90.955 Y72.046 E0.02204

G1 X90.786 Y71.814 E0.00748

G1 X90.846 Y71.740 E0.00248

G1 X92.604 Y71.738 E0.04581

G1 X92.718 Y71.742 E0.00296

G1 X92.800 Y71.770 E0.00226

G1 X92.865 Y71.847 E0.00262

G1 X92.925 Y72.004 E0.00439

G1 X92.996 Y72.320 E0.00844

G1 X93.005 Y73.048 E0.01897

M204 S1250

G1 X92.864 Y73.121 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.915 Y73.208 E-0.10175

G1 X92.750 Y73.275 E-0.09845

G1 X92.617 Y73.249 E-0.07532

G1 X92.311 Y73.052 E-0.20181

G1 X92.095 Y72.884 E-0.15148

G1 X91.755 Y72.686 E-0.21821

G1 X91.670 Y72.605 E-0.06498

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X90.026 Y76.146

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.448 Y76.146 E0.14533

M73 P98 R1

G1 X85.129 Y75.757 E0.02042

G1 X85.170 Y75.703 E0.00177

G1 X85.577 Y75.493 E0.01194

G1 X86.191 Y75.233 E0.01738

G1 X86.621 Y75.104 E0.01168

G1 X87.089 Y75.029 E0.01235

G1 X87.675 Y75.059 E0.01530

G1 X87.860 Y75.099 E0.00494

G1 X88.340 Y75.249 E0.01309

G1 X88.719 Y75.406 E0.01068

G1 X89.668 Y75.916 E0.02809

G1 X89.975 Y76.114 E0.00951

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.329 Y76.123 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X83.521 Y76.484

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.690 Y76.206 E0.00848

G1 X84.005 Y75.935 E0.01083

G1 X84.325 Y75.728 E0.00993

G1 X84.848 Y75.435 E0.01563

G1 X84.894 Y75.375 E0.00197

G1 X85.400 Y75.115 E0.01482

G1 X86.049 Y74.840 E0.01838

G1 X86.527 Y74.696 E0.01299

G1 X87.059 Y74.611 E0.01403

G1 X87.733 Y74.644 E0.01759

G1 X87.966 Y74.695 E0.00623

G1 X88.482 Y74.855 E0.01408

G1 X88.898 Y75.028 E0.01173

G1 X89.881 Y75.556 E0.02907

G1 X90.485 Y75.945 E0.01872

G1 X90.837 Y76.254 E0.01221

G1 X90.998 Y76.557 E0.00894

G1 X83.529 Y76.563 E0.19460

G1 X83.517 Y76.544 E0.00060

M204 S1250

G1 X83.774 Y76.280 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.690 Y76.206 E-0.21045

G1 X84.005 Y75.935 E-0.23038

G1 X84.325 Y75.728 E-0.21127

G1 X84.734 Y75.499 E-0.25991

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X85.289 Y75.891

G1 Z11.750

G1 E3.20000 F2400.00000

G1 X85.890 Y75.770 E0.01067

G1 X86.311 Y76.021 F9000.000

M204 S1000

G1 F3746

G1 X86.965 Y75.366 E0.02563

G1 X87.111 Y75.343 E0.00411

G1 X87.592 Y75.368 E0.01333

G1 X87.127 Y75.833 E0.01821

G1 X87.755 Y75.833 E0.01740

G1 X88.089 Y75.499 E0.01309

G1 X88.544 Y75.672 E0.01348

G1 X88.195 Y76.021 E0.01366

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.544 Y75.672 E-0.27314

G1 X88.089 Y75.499 E-0.26970

G1 X87.755 Y75.833 E-0.26183

G1 X87.561 Y75.833 E-0.10733

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X82.735 Y72.165

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.132 Y72.582 E0.01909

G1 X81.890 Y72.724 E0.00731

G1 X81.895 Y72.442 E0.00734

G1 X81.929 Y72.222 E0.00580

G1 X81.961 Y72.165 E0.00171

G1 X82.675 Y72.165 E0.01858

M204 S1250

G1 X81.716 Y73.276 F9000.000

M204 S800

G1 F1500.000

G1 X81.627 Y73.252 E0.00240

G1 X81.544 Y73.181 E0.00285

G1 X81.498 Y73.122 E0.00194

G1 X81.470 Y73.017 E0.00283

G1 X81.478 Y72.404 E0.01597

G1 X81.528 Y72.082 E0.00848

G1 X81.704 Y71.771 E0.00930

G1 X81.778 Y71.747 E0.00204

G1 X83.659 Y71.748 E0.04901

G1 X83.719 Y71.777 E0.00174

G1 X83.717 Y71.806 E0.00075

G1 X83.534 Y72.045 E0.00784

G1 X83.198 Y72.343 E0.01171

G1 X82.355 Y72.936 E0.02685

G1 X81.775 Y73.268 E0.01741

M204 S1250

G1 X81.668 Y73.197 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.627 Y73.252 E-0.08290

G1 X81.544 Y73.181 E-0.06059

G1 X81.498 Y73.122 E-0.04134

G1 X81.470 Y73.017 E-0.06018

G1 X81.478 Y72.404 E-0.33965

G1 X81.528 Y72.082 E-0.18031

G1 X81.658 Y71.851 E-0.14703

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X81.890 Y59.726

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X81.895 Y59.444 E0.00734

G1 X81.929 Y59.224 E0.00580

G1 X81.961 Y59.167 E0.00170

G1 X82.734 Y59.167 E0.02014

G1 X82.132 Y59.584 E0.01908

G1 X81.941 Y59.695 E0.00575

M204 S1250

G1 X81.786 Y60.269 F9000.000

M204 S800

G1 F1500.000

G1 X81.716 Y60.278 E0.00184

G1 X81.627 Y60.254 E0.00240

G1 X81.498 Y60.124 E0.00477

G1 X81.470 Y60.019 E0.00283

G1 X81.478 Y59.406 E0.01597

G1 X81.528 Y59.084 E0.00848

G1 X81.704 Y58.773 E0.00930

G1 X81.778 Y58.749 E0.00204

G1 X83.659 Y58.750 E0.04901

G1 X83.719 Y58.779 E0.00174

G1 X83.717 Y58.808 E0.00074

G1 X83.534 Y59.047 E0.00784

G1 X83.198 Y59.345 E0.01171

G1 X82.355 Y59.938 E0.02685

G1 X81.838 Y60.239 E0.01559

M204 S1250

G1 X81.735 Y60.220 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.716 Y60.278 E-0.07091

G1 X81.627 Y60.254 E-0.05106

G1 X81.498 Y60.124 E-0.10142

G1 X81.470 Y60.019 E-0.06018

G1 X81.478 Y59.406 E-0.33965

G1 X81.528 Y59.084 E-0.18031

G1 X81.624 Y58.914 E-0.10846

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X84.449 Y63.148

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X85.131 Y62.759 E0.02044

G1 X85.172 Y62.704 E0.00179

G1 X85.577 Y62.496 E0.01187

G1 X86.191 Y62.236 E0.01739

G1 X86.621 Y62.106 E0.01168

G1 X87.089 Y62.031 E0.01235

G1 X87.675 Y62.062 E0.01529

G1 X87.860 Y62.101 E0.00493

G1 X88.340 Y62.251 E0.01311

G1 X88.719 Y62.408 E0.01068

G1 X89.668 Y62.918 E0.02807

G1 X90.025 Y63.148 E0.01106

G1 X84.509 Y63.148 E0.14372

M204 S1250

G1 X83.521 Y63.487 F9000.000

M204 S800

G1 F1500.000

G1 X83.690 Y63.208 E0.00849

G1 X84.005 Y62.937 E0.01082

G1 X84.325 Y62.731 E0.00993

G1 X84.849 Y62.438 E0.01565

G1 X84.895 Y62.377 E0.00199

G1 X85.400 Y62.117 E0.01479

G1 X86.049 Y61.842 E0.01838

G1 X86.527 Y61.698 E0.01299

G1 X87.059 Y61.613 E0.01403

G1 X87.733 Y61.647 E0.01759

G1 X87.966 Y61.697 E0.00622

G1 X88.482 Y61.858 E0.01409

G1 X88.898 Y62.030 E0.01172

G1 X89.881 Y62.558 E0.02906

G1 X90.485 Y62.948 E0.01874

G1 X90.837 Y63.256 E0.01219

G1 X90.998 Y63.559 E0.00894

G1 X83.529 Y63.565 E0.19460

G1 X83.517 Y63.546 E0.00059

M204 S1250

G1 X83.774 Y63.282 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.690 Y63.208 E-0.21064

G1 X84.005 Y62.937 E-0.23016

G1 X84.325 Y62.731 E-0.21116

G1 X84.735 Y62.502 E-0.26004

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X85.291 Y62.893

G1 Z11.750

G1 E3.20000 F2400.00000

G1 X85.890 Y62.772 E0.01064

G1 X86.311 Y63.023 F9000.000

M204 S1000

G1 F3746

G1 X86.965 Y62.368 E0.02563

G1 X87.111 Y62.345 E0.00410

G1 X87.592 Y62.370 E0.01333

G1 X87.127 Y62.835 E0.01820

G1 X87.755 Y62.835 E0.01740

G1 X88.089 Y62.501 E0.01307

G1 X88.544 Y62.674 E0.01349

G1 X88.195 Y63.023 E0.01365

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.544 Y62.674 E-0.27303

G1 X88.089 Y62.501 E-0.26978

G1 X87.755 Y62.835 E-0.26143

G1 X87.561 Y62.835 E-0.10777

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X91.782 Y59.159

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.531 Y59.158 E0.01952

G1 X92.579 Y59.373 E0.00573

G1 X92.587 Y59.734 E0.00943

G1 X92.329 Y59.538 E0.00844

G1 X92.006 Y59.351 E0.00972

G1 X91.829 Y59.196 E0.00614

M204 S1250

G1 X92.990 Y60.109 F9000.000

M204 S800

G1 F1500.000

G1 X92.915 Y60.210 E0.00329

G1 X92.749 Y60.277 E0.00465

G1 X92.617 Y60.252 E0.00351

G1 X92.311 Y60.054 E0.00950

G1 X92.095 Y59.886 E0.00713

G1 X91.755 Y59.688 E0.01025

G1 X91.625 Y59.566 E0.00466

G1 X90.956 Y59.048 E0.02204

G1 X90.786 Y58.816 E0.00749

G1 X90.846 Y58.742 E0.00248

G1 X92.604 Y58.740 E0.04581

G1 X92.717 Y58.744 E0.00294

G1 X92.800 Y58.772 E0.00228

G1 X92.865 Y58.849 E0.00262

G1 X92.925 Y59.006 E0.00438

G1 X92.996 Y59.322 E0.00844

G1 X93.005 Y60.050 E0.01898

M204 S1250

G1 X92.865 Y60.123 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.915 Y60.210 E-0.10153

G1 X92.749 Y60.277 E-0.09898

G1 X92.617 Y60.252 E-0.07473

G1 X92.311 Y60.054 E-0.20207

G1 X92.095 Y59.886 E-0.15170

G1 X91.755 Y59.688 E-0.21798

G1 X91.669 Y59.608 E-0.06501

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X92.587 Y46.736

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X92.329 Y46.540 E0.00844

G1 X92.006 Y46.353 E0.00972

G1 X91.782 Y46.161 E0.00769

G1 X92.531 Y46.160 E0.01951

G1 X92.579 Y46.375 E0.00573

G1 X92.585 Y46.676 E0.00786

M204 S1250

G1 X92.990 Y47.111 F9000.000

M204 S800

G1 F1500.000

G1 X92.915 Y47.212 E0.00328

G1 X92.749 Y47.279 E0.00466

G1 X92.617 Y47.254 E0.00351

G1 X92.311 Y47.056 E0.00950

G1 X92.095 Y46.888 E0.00713

G1 X91.755 Y46.690 E0.01025

G1 X91.625 Y46.568 E0.00466

G1 X90.956 Y46.051 E0.02203

G1 X90.786 Y45.818 E0.00751

G1 X90.846 Y45.745 E0.00246

G1 X92.604 Y45.742 E0.04582

G1 X92.717 Y45.747 E0.00294

G1 X92.800 Y45.774 E0.00228

G1 X92.865 Y45.851 E0.00262

G1 X92.925 Y46.009 E0.00440

G1 X92.996 Y46.324 E0.00843

G1 X93.005 Y47.053 E0.01899

M204 S1250

G1 X92.865 Y47.126 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.915 Y47.212 E-0.10122

G1 X92.749 Y47.279 E-0.09910

G1 X92.617 Y47.254 E-0.07469

G1 X92.311 Y47.056 E-0.20212

G1 X92.095 Y46.888 E-0.15170

G1 X91.755 Y46.690 E-0.21798

G1 X91.669 Y46.610 E-0.06520

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X90.025 Y50.150

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X84.449 Y50.150 E0.14528

G1 X85.131 Y49.761 E0.02045

G1 X85.172 Y49.706 E0.00179

G1 X85.577 Y49.498 E0.01187

G1 X86.191 Y49.238 E0.01738

G1 X86.621 Y49.109 E0.01168

G1 X87.087 Y49.033 E0.01232

G1 X87.676 Y49.064 E0.01534

G1 X87.860 Y49.103 E0.00491

G1 X88.340 Y49.254 E0.01311

G1 X88.719 Y49.410 E0.01068

G1 X89.668 Y49.920 E0.02807

G1 X89.974 Y50.118 E0.00950

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.329 Y50.127 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X83.521 Y50.489

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X83.690 Y50.210 E0.00849

G1 X84.005 Y49.939 E0.01082

G1 X84.325 Y49.733 E0.00993

G1 X84.849 Y49.440 E0.01565

G1 X84.895 Y49.379 E0.00199

G1 X85.400 Y49.119 E0.01479

G1 X86.049 Y48.844 E0.01838

G1 X86.527 Y48.701 E0.01299

G1 X87.058 Y48.615 E0.01402

G1 X87.733 Y48.649 E0.01760

G1 X87.966 Y48.699 E0.00622

G1 X88.482 Y48.860 E0.01409

G1 X88.898 Y49.032 E0.01172

G1 X89.881 Y49.560 E0.02906

G1 X90.485 Y49.950 E0.01874

G1 X90.837 Y50.259 E0.01220

G1 X90.998 Y50.561 E0.00892

G1 X83.529 Y50.567 E0.19460

G1 X83.517 Y50.548 E0.00059

M204 S1250

G1 X83.774 Y50.284 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X83.690 Y50.210 E-0.21063

G1 X84.005 Y49.939 E-0.23016

G1 X84.325 Y49.733 E-0.21116

G1 X84.735 Y49.504 E-0.26005

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X85.291 Y49.895

G1 Z11.750

G1 E3.20000 F2400.00000

G1 X85.890 Y49.774 E0.01064

G1 X86.311 Y50.025 F9000.000

M204 S1000

G1 F3746

G1 X86.965 Y49.371 E0.02563

G1 X87.109 Y49.347 E0.00405

G1 X87.592 Y49.372 E0.01337

G1 X87.127 Y49.837 E0.01819

G1 X87.755 Y49.837 E0.01740

G1 X88.089 Y49.503 E0.01307

G1 X88.544 Y49.677 E0.01349

G1 X88.196 Y50.025 E0.01365

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.544 Y49.677 E-0.27302

G1 X88.089 Y49.503 E-0.26981

G1 X87.755 Y49.837 E-0.26136

G1 X87.561 Y49.837 E-0.10781

G1 E-0.04800 F4200.00000

G1 Z11.950 F9000.000

G1 X82.734 Y46.170

G1 Z11.750

G1 E3.20000 F2400.00000

M204 S800

G1 F1500.000

G1 X82.132 Y46.586 E0.01909

G1 X81.890 Y46.728 E0.00732

G1 X81.895 Y46.446 E0.00735

G1 X81.929 Y46.226 E0.00580

G1 X81.961 Y46.169 E0.00170

G1 X82.674 Y46.169 E0.01858

M204 S1250

G1 X81.716 Y47.280 F9000.000

M204 S800

G1 F1500.000

G1 X81.626 Y47.257 E0.00242

G1 X81.544 Y47.186 E0.00283

G1 X81.499 Y47.127 E0.00194

G1 X81.470 Y47.021 E0.00285

G1 X81.478 Y46.408 E0.01597

G1 X81.528 Y46.086 E0.00848

G1 X81.704 Y45.776 E0.00929

G1 X81.778 Y45.751 E0.00204

G1 X83.658 Y45.752 E0.04900

G1 X83.719 Y45.782 E0.00174

G1 X83.717 Y45.810 E0.00074

G1 X83.534 Y46.049 E0.00783

G1 X83.198 Y46.347 E0.01171

G1 X82.355 Y46.940 E0.02685

G1 X81.776 Y47.273 E0.01741

M204 S1250

G1 X81.668 Y47.200 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;11.9

G1 Z11.900 F9000.000

;AFTER\_LAYER\_CHANGE

;11.9

G1 E-3.20000 F4200.00000

G1 Z12.100 F9000.000

G1 X81.978 Y111.393

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X82.341 Y111.393 E0.00946

G1 X81.925 Y111.678 E0.01315

G1 X81.967 Y111.452 E0.00601

M204 S1250

G1 X81.593 Y112.227 F9000.000

M204 S800

G1 F1302

G1 X81.493 Y112.098 E0.00424

G1 X81.474 Y112.016 E0.00219

G1 X81.481 Y111.780 E0.00616

G1 X81.582 Y111.238 E0.01434

G1 X81.705 Y111.016 E0.00663

G1 X81.808 Y110.974 E0.00291

G1 X83.255 Y110.977 E0.03769

G1 X83.299 Y111.033 E0.00187

G1 X82.849 Y111.525 E0.01738

G1 X82.484 Y111.812 E0.01209

G1 X81.783 Y112.262 E0.02171

G1 X81.646 Y112.255 E0.00358

M204 S1250

G1 X81.583 Y112.065 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.493 Y112.098 E-0.12121

G1 X81.474 Y112.016 E-0.04666

G1 X81.481 Y111.780 E-0.13101

G1 X81.582 Y111.238 E-0.30507

G1 X81.705 Y111.016 E-0.14095

G1 X81.808 Y110.974 E-0.06179

G1 X81.998 Y110.975 E-0.10530

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X84.928 Y114.870

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X85.606 Y114.481 E0.02036

G1 X86.191 Y114.227 E0.01664

G1 X86.605 Y114.102 E0.01125

G1 X87.081 Y114.023 E0.01258

G1 X87.283 Y114.020 E0.00525

G1 X87.630 Y114.045 E0.00908

G1 X87.897 Y114.101 E0.00710

G1 X88.376 Y114.256 E0.01311

G1 X88.815 Y114.457 E0.01260

G1 X89.540 Y114.877 E0.02182

G1 X84.988 Y114.870 E0.11860

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.606 Y114.481 E-0.40446

G1 X86.191 Y114.227 E-0.35383

G1 X86.457 Y114.147 E-0.15370

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X90.557 Y115.293

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X83.882 Y115.274 E0.17393

G1 X83.938 Y115.168 E0.00313

G1 X84.002 Y115.119 E0.00210

G1 X84.019 Y115.074 E0.00126

G1 X84.174 Y114.952 E0.00515

G1 X84.351 Y114.765 E0.00672

G1 X84.710 Y114.512 E0.01142

G1 X85.418 Y114.107 E0.02126

G1 X86.047 Y113.834 E0.01788

G1 X86.510 Y113.695 E0.01258

G1 X87.044 Y113.605 E0.01410

G1 X87.295 Y113.602 E0.00656

G1 X87.689 Y113.631 E0.01027

G1 X88.004 Y113.697 E0.00840

G1 X88.527 Y113.866 E0.01433

G1 X89.004 Y114.084 E0.01366

G1 X89.492 Y114.355 E0.01456

G1 X90.024 Y114.687 E0.01632

G1 X90.549 Y115.176 E0.01872

G1 X90.572 Y115.249 E0.00198

M204 S1250

G1 X90.173 Y115.180 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.926 Y115.255 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X88.669 Y114.620

G1 Z11.900

G1 E3.20000 F2400.00000

G1 F1302

G1 X87.734 Y114.472 E0.01541

G1 X86.815 Y114.465 F9000.000

G1 F1302

G1 X86.326 Y114.537 E0.01070

G1

G1 X85.838 Y114.608 E0.00916

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.326 Y114.537 E-0.27370

G1 E-0.68630 F4200.00000

G1 Z12.100 F9000.000

G1 X92.218 Y111.428

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X92.489 Y111.438 E0.00706

G1 X92.563 Y111.628 E0.00529

G1 X92.567 Y111.698 E0.00184

G1 X92.262 Y111.469 E0.00994

M204 S1250

G1 X92.773 Y112.265 F9000.000

M204 S800

G1 F1302

G1 X92.696 Y112.266 E0.00199

G1 X92.603 Y112.234 E0.00258

G1 X92.057 Y111.851 E0.01737

G1 X91.332 Y111.165 E0.02599

G1 X91.218 Y111.081 E0.00370

G1 X91.187 Y110.993 E0.00241

G1 X92.796 Y111.038 E0.04194

G1 X92.870 Y111.140 E0.00328

G1 X92.901 Y111.366 E0.00594

G1 X92.974 Y111.521 E0.00449

G1 X93.005 Y112.008 E0.01270

G1 X92.986 Y112.102 E0.00251

G1 X92.917 Y112.199 E0.00309

G1 X92.827 Y112.240 E0.00258

M204 S1250

G1 X92.721 Y112.209 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.696 Y112.266 E-0.07387

G1 X92.603 Y112.234 E-0.05478

G1 X92.057 Y111.851 E-0.36940

G1 X91.515 Y111.338 E-0.41395

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X92.567 Y98.700

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X92.322 Y98.528 E0.00779

G1 X92.218 Y98.430 E0.00373

G1 X92.489 Y98.440 E0.00706

G1 X92.563 Y98.640 E0.00556

M204 S1250

G1 X92.870 Y98.142 F9000.000

M204 S800

G1 F1302

G1 X92.901 Y98.368 E0.00595

G1 X92.974 Y98.524 E0.00448

G1 X93.005 Y99.010 E0.01270

G1 X92.986 Y99.105 E0.00251

G1 X92.917 Y99.202 E0.00310

G1 X92.773 Y99.267 E0.00413

G1 X92.696 Y99.268 E0.00200

G1 X92.603 Y99.236 E0.00257

G1 X92.057 Y98.853 E0.01737

G1 X91.332 Y98.167 E0.02599

G1 X91.218 Y98.083 E0.00370

G1 X91.187 Y97.995 E0.00241

G1 X92.776 Y98.033 E0.04140

G1 X92.841 Y98.089 E0.00225

M204 S1250

G1 X92.768 Y98.347 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.901 Y98.368 E-0.15803

G1 X92.974 Y98.524 E-0.09533

G1 X93.005 Y99.010 E-0.27004

G1 X92.986 Y99.105 E-0.05348

G1 X92.917 Y99.202 E-0.06599

G1 X92.773 Y99.267 E-0.08780

G1 X92.696 Y99.268 E-0.04256

G1 X92.603 Y99.236 E-0.05476

G1 X92.479 Y99.149 E-0.08401

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X89.541 Y101.880

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X84.927 Y101.872 E0.12021

G1 X85.606 Y101.483 E0.02037

G1 X86.191 Y101.229 E0.01664

G1 X86.605 Y101.104 E0.01125

G1 X87.081 Y101.025 E0.01258

G1 X87.283 Y101.022 E0.00525

G1 X87.629 Y101.047 E0.00906

G1 X87.897 Y101.104 E0.00712

G1 X88.376 Y101.258 E0.01312

G1 X88.815 Y101.459 E0.01258

G1 X89.490 Y101.848 E0.02029

M204 S1250

G1 X90.557 Y102.296 F9000.000

M204 S800

G1 F1302

G1 X83.882 Y102.276 E0.17392

G1 X83.938 Y102.170 E0.00313

G1 X84.002 Y102.122 E0.00210

G1 X84.019 Y102.075 E0.00127

G1 X84.174 Y101.954 E0.00514

G1 X84.351 Y101.767 E0.00672

G1 X84.710 Y101.514 E0.01142

G1 X85.418 Y101.109 E0.02126

G1 X86.047 Y100.836 E0.01788

G1 X86.510 Y100.697 E0.01258

G1 X87.044 Y100.607 E0.01410

G1 X87.295 Y100.604 E0.00656

G1 X87.688 Y100.633 E0.01027

G1 X88.004 Y100.700 E0.00841

G1 X88.528 Y100.868 E0.01433

G1 X89.004 Y101.086 E0.01365

G1 X89.492 Y101.357 E0.01456

G1 X90.024 Y101.689 E0.01632

G1 X90.549 Y102.178 E0.01872

G1 X90.573 Y102.252 E0.00201

M204 S1250

G1 X90.173 Y102.183 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.927 Y102.258 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X88.670 Y101.622

G1 Z11.900

G1 E3.20000 F2400.00000

G1 F1302

G1 X87.741 Y101.476 E0.01527

G1 X86.812 Y101.468 F9000.000

G1 F1302

G1 X86.325 Y101.539 E0.01066

G1

G1 X85.837 Y101.610 E0.00914

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.325 Y101.539 E-0.27303

G1 E-0.68697 F4200.00000

G1 Z12.100 F9000.000

G1 X82.341 Y98.395

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X81.925 Y98.681 E0.01315

G1 X81.978 Y98.395 E0.00758

G1 X82.281 Y98.395 E0.00790

M204 S1250

G1 X81.782 Y99.264 F9000.000

M204 S800

G1 F1302

G1 X81.705 Y99.271 E0.00203

G1 X81.593 Y99.229 E0.00313

G1 X81.493 Y99.100 E0.00424

G1 X81.474 Y99.018 E0.00219

G1 X81.481 Y98.782 E0.00616

G1 X81.582 Y98.240 E0.01434

G1 X81.705 Y98.018 E0.00663

G1 X81.808 Y97.976 E0.00291

G1 X83.255 Y97.979 E0.03769

G1 X83.299 Y98.035 E0.00187

G1 X82.849 Y98.527 E0.01738

G1 X82.484 Y98.814 E0.01209

G1 X81.834 Y99.234 E0.02016

M204 S1250

G1 X81.727 Y99.209 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.705 Y99.271 E-0.07460

G1 X81.593 Y99.229 E-0.06651

G1 X81.493 Y99.100 E-0.09022

G1 X81.474 Y99.018 E-0.04666

G1 X81.481 Y98.782 E-0.13101

G1 X81.582 Y98.240 E-0.30507

G1 X81.705 Y98.018 E-0.14095

G1 X81.800 Y97.980 E-0.05698

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X81.925 Y85.683

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X81.978 Y85.397 E0.00758

G1 X82.342 Y85.397 E0.00947

G1 X81.975 Y85.650 E0.01160

M204 S1250

G1 X81.782 Y86.266 F9000.000

M204 S800

G1 F1302

G1 X81.705 Y86.273 E0.00203

G1 X81.593 Y86.231 E0.00313

G1 X81.493 Y86.102 E0.00424

G1 X81.474 Y86.020 E0.00219

G1 X81.481 Y85.784 E0.00616

G1 X81.582 Y85.243 E0.01433

G1 X81.705 Y85.020 E0.00664

G1 X81.808 Y84.978 E0.00290

G1 X83.255 Y84.981 E0.03769

G1 X83.299 Y85.037 E0.00187

G1 X82.849 Y85.530 E0.01740

G1 X82.485 Y85.816 E0.01207

G1 X81.834 Y86.236 E0.02017

M204 S1250

G1 X81.727 Y86.211 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.705 Y86.273 E-0.07459

G1 X81.593 Y86.231 E-0.06651

G1 X81.493 Y86.102 E-0.09022

G1 X81.474 Y86.020 E-0.04666

G1 X81.481 Y85.784 E-0.13100

G1 X81.582 Y85.243 E-0.30482

G1 X81.705 Y85.020 E-0.14121

G1 X81.800 Y84.982 E-0.05698

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X84.927 Y88.875

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X85.605 Y88.486 E0.02038

G1 X86.192 Y88.231 E0.01666

G1 X86.605 Y88.106 E0.01125

G1 X87.082 Y88.027 E0.01259

G1 X87.284 Y88.024 E0.00527

G1 X87.629 Y88.049 E0.00903

G1 X87.897 Y88.106 E0.00712

G1 X88.376 Y88.260 E0.01312

G1 X88.815 Y88.461 E0.01258

G1 X89.540 Y88.882 E0.02185

G1 X84.987 Y88.875 E0.11865

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.605 Y88.486 E-0.40491

G1 X86.192 Y88.231 E-0.35426

G1 X86.456 Y88.152 E-0.15284

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X90.557 Y89.298

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X83.882 Y89.279 E0.17393

G1 X83.938 Y89.172 E0.00314

G1 X84.002 Y89.124 E0.00210

G1 X84.019 Y89.078 E0.00127

G1 X84.174 Y88.957 E0.00513

G1 X84.351 Y88.770 E0.00672

G1 X84.710 Y88.516 E0.01143

G1 X85.418 Y88.112 E0.02125

G1 X86.048 Y87.839 E0.01788

G1 X86.510 Y87.699 E0.01259

G1 X87.044 Y87.610 E0.01410

G1 X87.296 Y87.606 E0.00656

G1 X87.688 Y87.635 E0.01026

G1 X88.004 Y87.702 E0.00841

G1 X88.528 Y87.870 E0.01432

G1 X89.004 Y88.088 E0.01365

G1 X89.492 Y88.360 E0.01457

G1 X90.024 Y88.691 E0.01631

G1 X90.549 Y89.180 E0.01871

G1 X90.573 Y89.254 E0.00201

M204 S1250

G1 X90.173 Y89.185 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.927 Y89.260 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X88.669 Y88.624

G1 Z11.900

G1 E3.20000 F2400.00000

G1 F1302

G1 X87.745 Y88.479 E0.01519

G1 X86.814 Y88.470 F9000.000

G1 F1302

G1 X86.325 Y88.542 E0.01071

G1

G1 X85.836 Y88.614 E0.00917

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.325 Y88.542 E-0.27381

G1 E-0.68619 F4200.00000

G1 Z12.100 F9000.000

G1 X92.218 Y85.432

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X92.489 Y85.442 E0.00706

G1 X92.563 Y85.632 E0.00530

G1 X92.567 Y85.702 E0.00183

G1 X92.262 Y85.473 E0.00994

M204 S1250

G1 X92.773 Y86.269 F9000.000

M204 S800

G1 F1302

G1 X92.696 Y86.270 E0.00200

G1 X92.603 Y86.238 E0.00257

G1 X92.057 Y85.855 E0.01737

G1 X91.332 Y85.169 E0.02599

G1 X91.218 Y85.085 E0.00370

G1 X91.187 Y84.997 E0.00241

G1 X92.151 Y85.011 E0.02510

G1 X92.797 Y85.042 E0.01686

G1 X92.870 Y85.144 E0.00326

G1 X92.901 Y85.370 E0.00594

G1 X92.974 Y85.526 E0.00450

G1 X93.005 Y86.012 E0.01268

G1 X92.986 Y86.107 E0.00251

G1 X92.917 Y86.204 E0.00310

G1 X92.828 Y86.245 E0.00256

M204 S1250

G1 X92.721 Y86.213 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.696 Y86.270 E-0.07414

G1 X92.603 Y86.238 E-0.05476

G1 X92.057 Y85.855 E-0.36940

G1 X91.515 Y85.342 E-0.41370

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X92.567 Y72.705

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X92.322 Y72.533 E0.00779

G1 X92.218 Y72.435 E0.00373

G1 X92.489 Y72.445 E0.00707

G1 X92.563 Y72.645 E0.00555

M204 S1250

G1 X92.870 Y72.146 F9000.000

M204 S800

G1 F1302

G1 X92.901 Y72.372 E0.00594

G1 X92.974 Y72.528 E0.00450

G1 X93.005 Y73.015 E0.01270

G1 X92.986 Y73.108 E0.00249

G1 X92.917 Y73.206 E0.00311

G1 X92.773 Y73.271 E0.00413

G1 X92.696 Y73.272 E0.00200

G1 X92.603 Y73.240 E0.00258

G1 X92.057 Y72.858 E0.01735

G1 X91.332 Y72.172 E0.02599

G1 X91.218 Y72.087 E0.00370

G1 X91.187 Y71.999 E0.00243

G1 X92.776 Y72.038 E0.04142

G1 X92.841 Y72.093 E0.00223

M204 S1250

G1 X92.768 Y72.350 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.901 Y72.372 E-0.15790

G1 X92.974 Y72.528 E-0.09576

G1 X93.005 Y73.015 E-0.27012

G1 X92.986 Y73.108 E-0.05300

G1 X92.917 Y73.206 E-0.06606

G1 X92.773 Y73.271 E-0.08780

G1 X92.696 Y73.272 E-0.04257

G1 X92.603 Y73.240 E-0.05483

G1 X92.479 Y73.153 E-0.08397

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X89.540 Y75.884

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X84.927 Y75.877 E0.12021

G1 X85.605 Y75.488 E0.02038

G1 X86.192 Y75.233 E0.01666

G1 X86.605 Y75.108 E0.01125

G1 X87.082 Y75.029 E0.01259

G1 X87.284 Y75.026 E0.00527

G1 X87.629 Y75.051 E0.00903

G1 X87.897 Y75.108 E0.00712

G1 X88.376 Y75.262 E0.01312

G1 X88.815 Y75.463 E0.01258

G1 X89.489 Y75.852 E0.02029

M204 S1250

G1 X90.557 Y76.300 F9000.000

M204 S800

G1 F1302

G1 X83.882 Y76.281 E0.17393

G1 X83.938 Y76.175 E0.00312

G1 X84.002 Y76.127 E0.00210

G1 X84.019 Y76.080 E0.00129

G1 X84.174 Y75.958 E0.00514

G1 X84.351 Y75.772 E0.00671

G1 X84.710 Y75.518 E0.01143

G1 X85.418 Y75.114 E0.02125

G1 X86.048 Y74.841 E0.01788

G1 X86.510 Y74.701 E0.01259

G1 X87.044 Y74.612 E0.01410

G1 X87.296 Y74.608 E0.00656

G1 X87.688 Y74.637 E0.01026

G1 X88.004 Y74.704 E0.00841

G1 X88.528 Y74.872 E0.01432

G1 X89.004 Y75.090 E0.01365

G1 X89.492 Y75.362 E0.01457

G1 X90.024 Y75.693 E0.01631

G1 X90.549 Y76.183 E0.01871

G1 X90.573 Y76.256 E0.00201

M204 S1250

G1 X90.173 Y76.187 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.927 Y76.262 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X88.669 Y75.626

G1 Z11.900

G1 E3.20000 F2400.00000

G1 F1302

G1 X87.745 Y75.481 E0.01519

G1 X86.814 Y75.472 F9000.000

G1 F1302

G1 X86.325 Y75.544 E0.01071

G1

G1 X85.836 Y75.616 E0.00917

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.325 Y75.544 E-0.27381

G1 E-0.68619 F4200.00000

G1 Z12.100 F9000.000

G1 X82.342 Y72.399

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X81.925 Y72.685 E0.01315

G1 X81.978 Y72.399 E0.00758

G1 X82.282 Y72.399 E0.00791

M204 S1250

G1 X81.782 Y73.268 F9000.000

M204 S800

G1 F1302

G1 X81.656 Y73.267 E0.00330

G1 X81.593 Y73.234 E0.00185

G1 X81.493 Y73.104 E0.00426

G1 X81.474 Y73.023 E0.00217

G1 X81.481 Y72.787 E0.00615

G1 X81.582 Y72.245 E0.01435

G1 X81.705 Y72.022 E0.00664

G1 X81.808 Y71.980 E0.00290

G1 X83.255 Y71.983 E0.03769

G1 X83.299 Y72.040 E0.00187

G1 X82.849 Y72.532 E0.01739

G1 X82.485 Y72.818 E0.01207

G1 X81.834 Y73.238 E0.02017

M204 S1250

G1 X81.699 Y73.173 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.656 Y73.267 E-0.10014

G1 X81.593 Y73.234 E-0.03943

G1 X81.493 Y73.104 E-0.09067

G1 X81.474 Y73.023 E-0.04618

G1 X81.481 Y72.787 E-0.13087

G1 X81.582 Y72.245 E-0.30522

G1 X81.705 Y72.022 E-0.14133

G1 X81.802 Y71.983 E-0.05817

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X81.925 Y59.686

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X81.978 Y59.401 E0.00757

G1 X82.341 Y59.402 E0.00946

G1 X81.975 Y59.654 E0.01158

M204 S1250

G1 X81.782 Y60.270 F9000.000

M204 S800

G1 F1302

G1 X81.656 Y60.269 E0.00330

G1 X81.593 Y60.236 E0.00185

G1 X81.493 Y60.106 E0.00426

G1 X81.474 Y60.025 E0.00217

G1 X81.481 Y59.789 E0.00616

G1 X81.582 Y59.247 E0.01434

G1 X81.705 Y59.024 E0.00665

G1 X81.808 Y58.983 E0.00290

G1 X83.255 Y58.986 E0.03769

G1 X83.299 Y59.042 E0.00186

G1 X82.849 Y59.534 E0.01738

G1 X82.485 Y59.820 E0.01207

G1 X81.834 Y60.240 E0.02017

M204 S1250

G1 X81.699 Y60.175 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.656 Y60.269 E-0.10014

G1 X81.593 Y60.236 E-0.03943

G1 X81.493 Y60.106 E-0.09068

G1 X81.474 Y60.025 E-0.04613

G1 X81.481 Y59.789 E-0.13092

G1 X81.582 Y59.247 E-0.30507

G1 X81.705 Y59.024 E-0.14153

G1 X81.802 Y58.985 E-0.05811

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X84.928 Y62.879

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X85.606 Y62.490 E0.02036

G1 X86.192 Y62.235 E0.01665

G1 X86.605 Y62.110 E0.01125

G1 X87.082 Y62.031 E0.01259

G1 X87.284 Y62.028 E0.00527

G1 X87.629 Y62.053 E0.00903

G1 X87.896 Y62.110 E0.00711

G1 X88.376 Y62.265 E0.01314

G1 X88.815 Y62.466 E0.01258

G1 X89.540 Y62.886 E0.02183

G1 X84.988 Y62.879 E0.11862

M204 S1250

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X85.606 Y62.490 E-0.40450

G1 X86.192 Y62.235 E-0.35409

G1 X86.457 Y62.155 E-0.15341

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X90.557 Y63.302

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X83.882 Y63.283 E0.17392

G1 X83.938 Y63.177 E0.00313

G1 X84.002 Y63.129 E0.00210

G1 X84.019 Y63.082 E0.00129

G1 X84.174 Y62.960 E0.00514

G1 X84.351 Y62.774 E0.00671

G1 X84.710 Y62.521 E0.01142

G1 X85.418 Y62.116 E0.02126

G1 X86.048 Y61.843 E0.01788

G1 X86.510 Y61.703 E0.01259

G1 X87.044 Y61.614 E0.01410

G1 X87.296 Y61.610 E0.00656

G1 X87.688 Y61.639 E0.01026

G1 X88.004 Y61.706 E0.00841

G1 X88.528 Y61.875 E0.01434

G1 X89.004 Y62.092 E0.01365

G1 X89.492 Y62.364 E0.01456

G1 X90.024 Y62.695 E0.01631

G1 X90.549 Y63.185 E0.01871

G1 X90.573 Y63.258 E0.00201

M204 S1250

G1 X90.173 Y63.189 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.927 Y63.264 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X88.671 Y62.629

G1 Z11.900

G1 E3.20000 F2400.00000

G1 F1302

G1 X87.745 Y62.483 E0.01518

G1 X86.814 Y62.474 F9000.000

G1 F1302

G1 X86.325 Y62.546 E0.01071

G1

G1 X85.836 Y62.618 E0.00917

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.325 Y62.546 E-0.27384

G1 E-0.68616 F4200.00000

G1 Z12.100 F9000.000

G1 X92.218 Y59.437

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X92.489 Y59.447 E0.00708

G1 X92.563 Y59.636 E0.00529

G1 X92.567 Y59.707 E0.00185

G1 X92.261 Y59.478 E0.00996

M204 S1250

G1 X92.773 Y60.274 F9000.000

M204 S800

G1 F1302

G1 X92.696 Y60.274 E0.00200

G1 X92.603 Y60.243 E0.00256

G1 X92.057 Y59.860 E0.01737

G1 X91.333 Y59.174 E0.02599

G1 X91.218 Y59.089 E0.00371

G1 X91.187 Y59.001 E0.00243

G1 X92.776 Y59.040 E0.04140

G1 X92.827 Y59.070 E0.00156

G1 X92.870 Y59.148 E0.00232

G1 X92.901 Y59.374 E0.00594

G1 X92.974 Y59.530 E0.00450

G1 X93.005 Y60.017 E0.01270

G1 X92.986 Y60.111 E0.00249

G1 X92.917 Y60.208 E0.00310

G1 X92.827 Y60.249 E0.00258

M204 S1250

G1 X92.720 Y60.217 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.696 Y60.274 E-0.07417

G1 X92.603 Y60.243 E-0.05439

G1 X92.057 Y59.860 E-0.36940

G1 X91.514 Y59.346 E-0.41404

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X92.567 Y46.709

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X92.322 Y46.537 E0.00779

G1 X92.218 Y46.439 E0.00373

G1 X92.489 Y46.449 E0.00706

G1 X92.563 Y46.649 E0.00556

M204 S1250

G1 X92.870 Y46.151 F9000.000

M204 S800

G1 F1302

G1 X92.901 Y46.376 E0.00592

G1 X92.974 Y46.532 E0.00450

G1 X93.005 Y47.019 E0.01270

G1 X92.986 Y47.113 E0.00251

G1 X92.918 Y47.210 E0.00308

G1 X92.773 Y47.276 E0.00415

G1 X92.696 Y47.276 E0.00200

G1 X92.603 Y47.245 E0.00256

G1 X92.057 Y46.862 E0.01737

G1 X91.332 Y46.176 E0.02599

G1 X91.218 Y46.092 E0.00370

G1 X91.187 Y46.004 E0.00241

G1 X92.776 Y46.042 E0.04140

G1 X92.841 Y46.098 E0.00225

M204 S1250

G1 X92.769 Y46.355 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.901 Y46.376 E-0.15757

G1 X92.974 Y46.532 E-0.09574

G1 X93.005 Y47.019 E-0.27019

G1 X92.986 Y47.113 E-0.05338

G1 X92.918 Y47.210 E-0.06554

G1 X92.773 Y47.276 E-0.08837

G1 X92.696 Y47.276 E-0.04254

G1 X92.603 Y47.245 E-0.05439

G1 X92.478 Y47.157 E-0.08428

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X89.541 Y49.888

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X84.928 Y49.881 E0.12019

G1 X85.606 Y49.492 E0.02036

G1 X86.192 Y49.238 E0.01665

G1 X86.605 Y49.112 E0.01125

G1 X87.081 Y49.033 E0.01256

G1 X87.283 Y49.031 E0.00528

G1 X87.630 Y49.056 E0.00906

G1 X87.896 Y49.112 E0.00709

G1 X88.376 Y49.267 E0.01314

G1 X88.815 Y49.468 E0.01258

G1 X89.490 Y49.856 E0.02028

M204 S1250

G1 X90.557 Y50.304 F9000.000

M204 S800

G1 F1302

G1 X83.882 Y50.285 E0.17393

G1 X83.938 Y50.179 E0.00313

G1 X84.002 Y50.130 E0.00210

G1 X84.019 Y50.084 E0.00127

G1 X84.174 Y49.962 E0.00514

G1 X84.351 Y49.776 E0.00671

G1 X84.710 Y49.523 E0.01142

G1 X85.418 Y49.118 E0.02127

G1 X86.047 Y48.845 E0.01788

G1 X86.510 Y48.705 E0.01259

G1 X87.043 Y48.616 E0.01409

G1 X87.296 Y48.613 E0.00657

G1 X87.689 Y48.641 E0.01027

G1 X88.004 Y48.708 E0.00840

G1 X88.528 Y48.877 E0.01434

G1 X89.004 Y49.094 E0.01365

G1 X89.492 Y49.366 E0.01456

G1 X90.024 Y49.697 E0.01631

G1 X90.549 Y50.186 E0.01871

G1 X90.572 Y50.260 E0.00201

M204 S1250

G1 X90.173 Y50.191 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.927 Y50.266 E-0.91200

G1 E-0.04800 F4200.00000

G1 Z12.100 F9000.000

G1 X88.671 Y49.631

G1 Z11.900

G1 E3.20000 F2400.00000

G1 F1302

G1 X87.744 Y49.484 E0.01523

G1 X86.813 Y49.476 F9000.000

G1 F1302

G1 X86.325 Y49.548 E0.01070

G1

G1 X85.836 Y49.620 E0.00916

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.325 Y49.548 E-0.27365

G1 E-0.68635 F4200.00000

G1 Z12.100 F9000.000

G1 X82.342 Y46.404

G1 Z11.900

G1 E3.20000 F2400.00000

M204 S800

G1 F1302

G1 X81.925 Y46.689 E0.01317

G1 X81.978 Y46.403 E0.00760

G1 X82.282 Y46.403 E0.00792

M204 S1250

G1 X81.783 Y47.273 F9000.000

M204 S800

G1 F1302

G1 X81.655 Y47.271 E0.00333

G1 X81.593 Y47.238 E0.00184

G1 X81.493 Y47.109 E0.00424

G1 X81.474 Y47.027 E0.00219

G1 X81.481 Y46.791 E0.00616

G1 X81.582 Y46.249 E0.01434

G1 X81.705 Y46.026 E0.00664

G1 X81.809 Y45.985 E0.00291

G1 X83.255 Y45.988 E0.03768

G1 X83.299 Y46.044 E0.00187

G1 X82.849 Y46.536 E0.01738

G1 X82.484 Y46.823 E0.01209

G1 X81.835 Y47.243 E0.02015

M204 S1250

G1 X81.699 Y47.176 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;12.05

G1 Z12.050 F9000.000

;AFTER\_LAYER\_CHANGE

;12.05

G1 E-3.20000 F4200.00000

G1 Z12.250 F9000.000

G1 X81.807 Y112.215

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X81.744 Y112.226 E0.00166

G1 X81.657 Y112.210 E0.00230

G1 X81.521 Y112.057 E0.00532

G1 X81.509 Y111.993 E0.00170

G1 X81.625 Y111.456 E0.01433

G1 X81.695 Y111.359 E0.00311

G1 X81.795 Y111.284 E0.00325

G1 X82.835 Y111.289 E0.02710

G1 X82.556 Y111.616 E0.01120

G1 X82.179 Y111.953 E0.01318

G1 X81.848 Y112.172 E0.01034

M204 S1250

G1 X81.758 Y112.174 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.744 Y112.226 E-0.06505

G1 X81.657 Y112.210 E-0.04891

G1 X81.521 Y112.057 E-0.11315

G1 X81.509 Y111.993 E-0.03608

G1 X81.625 Y111.456 E-0.30468

G1 X81.695 Y111.359 E-0.06621

G1 X81.795 Y111.284 E-0.06913

G1 X82.172 Y111.286 E-0.20879

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X85.558 Y114.572

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X85.764 Y114.444 E0.00631

G1 X86.192 Y114.261 E0.01213

G1 X86.815 Y114.069 E0.01701

G1 X87.035 Y114.042 E0.00575

G1 X87.589 Y114.057 E0.01445

G1 X88.118 Y114.193 E0.01424

G1 X88.496 Y114.343 E0.01059

G1 X88.913 Y114.553 E0.01215

G1 X85.618 Y114.571 E0.08586

M204 S1250

G1 X84.537 Y114.960 F9000.000

M204 S800

G1 F969

G1 X84.383 Y114.951 E0.00400

G1 X84.508 Y114.802 E0.00506

G1 X84.852 Y114.517 E0.01163

G1 X85.570 Y114.072 E0.02201

G1 X86.048 Y113.868 E0.01352

G1 X86.727 Y113.659 E0.01853

G1 X87.009 Y113.624 E0.00739

G1 X87.312 Y113.624 E0.00790

G1 X87.652 Y113.642 E0.00888

G1 X88.248 Y113.795 E0.01602

G1 X88.667 Y113.962 E0.01175

G1 X89.135 Y114.197 E0.01363

G1 X89.797 Y114.643 E0.02082

G1 X90.062 Y114.913 E0.00985

G1 X90.091 Y114.964 E0.00152

G1 X84.591 Y114.984 E0.14330

M204 S1250

G1 X84.464 Y114.824 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.383 Y114.951 E-0.11663

G1 X84.508 Y114.802 E-0.10771

G1 X84.852 Y114.517 E-0.24736

G1 X85.528 Y114.099 E-0.44029

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X87.706 Y114.327

G1 Z12.050

G1 E3.20000 F2400.00000

G1 F969

G1 X87.551 Y114.308 E0.00085

G1 X87.051 Y114.303 E0.00272

G1 X86.747 Y114.333 E0.00166

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.051 Y114.303 E-0.16924

G1 X87.551 Y114.308 E-0.27709

G1 X87.706 Y114.327 E-0.08670

G1 E-0.42697 F4200.00000

G1 Z12.250 F9000.000

G1 X92.872 Y112.197

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X92.815 Y112.217 E0.00156

G1 X92.646 Y112.207 E0.00441

G1 X92.543 Y112.143 E0.00316

G1 X92.014 Y111.723 E0.01760

G1 X91.728 Y111.394 E0.01136

G1 X91.733 Y111.285 E0.00283

G1 X92.768 Y111.325 E0.02700

G1 X92.807 Y111.371 E0.00158

G1 X92.942 Y111.744 E0.01032

G1 X92.970 Y112.029 E0.00747

G1 X92.902 Y112.145 E0.00350

M204 S1250

G1 X92.815 Y112.177 F9000.000

G1 X92.432 Y111.521

G1 F969

G1 X92.709 Y111.942 E0.00232

G1 X92.732 Y112.003 E0.00030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.709 Y111.942 E-0.03591

G1 X92.432 Y111.521 E-0.27952

G1 E-0.64458 F4200.00000

G1 Z12.250 F9000.000

G1 X92.815 Y99.219

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X92.646 Y99.209 E0.00442

G1 X92.543 Y99.146 E0.00315

G1 X92.014 Y98.725 E0.01760

G1 X91.728 Y98.396 E0.01136

G1 X91.733 Y98.287 E0.00283

G1 X92.768 Y98.327 E0.02699

G1 X92.807 Y98.374 E0.00160

G1 X92.942 Y98.746 E0.01032

G1 X92.967 Y98.923 E0.00465

G1 X92.970 Y99.030 E0.00280

G1 X92.871 Y99.199 E0.00510

M204 S1250

G1 X92.688 Y99.107 F9000.000

G1 X92.431 Y98.523

G1 F969

G1 X92.710 Y98.945 E0.00236

G1 X92.732 Y99.005 E0.00030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.710 Y98.945 E-0.03541

G1 X92.431 Y98.523 E-0.28023

G1 E-0.64436 F4200.00000

G1 Z12.250 F9000.000

G1 X88.913 Y101.555

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X85.558 Y101.574 E0.08742

G1 X85.764 Y101.446 E0.00631

G1 X86.191 Y101.263 E0.01212

G1 X86.816 Y101.072 E0.01702

G1 X87.035 Y101.044 E0.00576

G1 X87.589 Y101.059 E0.01443

G1 X88.118 Y101.195 E0.01424

G1 X88.496 Y101.345 E0.01059

G1 X88.860 Y101.528 E0.01061

M204 S1250

G1 X90.062 Y101.915 F9000.000

M204 S800

G1 F969

G1 X90.091 Y101.966 E0.00153

G1 X84.614 Y101.997 E0.14270

G1 X84.537 Y101.962 E0.00223

G1 X84.383 Y101.953 E0.00400

G1 X84.508 Y101.804 E0.00506

G1 X84.852 Y101.520 E0.01162

G1 X85.570 Y101.074 E0.02203

G1 X86.048 Y100.870 E0.01352

G1 X86.728 Y100.662 E0.01853

G1 X87.009 Y100.626 E0.00739

G1 X87.652 Y100.644 E0.01677

G1 X88.248 Y100.797 E0.01602

G1 X88.667 Y100.964 E0.01175

G1 X89.134 Y101.198 E0.01363

G1 X89.797 Y101.646 E0.02083

G1 X90.020 Y101.872 E0.00827

M204 S1250

G1 X90.039 Y101.969 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.091 Y101.966 E-0.06522

G1 X88.563 Y101.975 E-0.84678

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X86.748 Y101.335

G1 Z12.050

G1 E3.20000 F2400.00000

G1 F969

G1 X87.052 Y101.305 E0.00166

G1 X87.550 Y101.310 E0.00272

G1 X87.707 Y101.329 E0.00086

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.550 Y101.310 E-0.08718

G1 X87.052 Y101.305 E-0.27637

G1 X86.748 Y101.335 E-0.16906

G1 E-0.42739 F4200.00000

G1 Z12.250 F9000.000

G1 X81.807 Y99.218

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X81.745 Y99.228 E0.00162

G1 X81.657 Y99.212 E0.00234

G1 X81.521 Y99.060 E0.00532

G1 X81.509 Y98.995 E0.00170

G1 X81.625 Y98.458 E0.01433

G1 X81.695 Y98.361 E0.00311

G1 X81.795 Y98.286 E0.00326

G1 X82.835 Y98.291 E0.02710

G1 X82.556 Y98.618 E0.01119

G1 X82.179 Y98.955 E0.01318

G1 X81.848 Y99.174 E0.01035

M204 S1250

G1 X81.759 Y99.177 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.745 Y99.228 E-0.06418

G1 X81.657 Y99.212 E-0.04982

G1 X81.521 Y99.060 E-0.11306

G1 X81.509 Y98.995 E-0.03617

G1 X81.625 Y98.458 E-0.30467

G1 X81.695 Y98.361 E-0.06607

G1 X81.795 Y98.286 E-0.06924

G1 X82.172 Y98.288 E-0.20879

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X81.745 Y86.230

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X81.657 Y86.214 E0.00234

G1 X81.521 Y86.062 E0.00532

G1 X81.509 Y85.997 E0.00170

G1 X81.625 Y85.460 E0.01432

G1 X81.695 Y85.363 E0.00311

G1 X81.795 Y85.288 E0.00325

G1 X82.835 Y85.294 E0.02710

G1 X82.556 Y85.620 E0.01119

G1 X82.374 Y85.766 E0.00609

G1 X82.179 Y85.957 E0.00710

G1 X81.858 Y86.165 E0.00997

G1 X81.804 Y86.221 E0.00203

M204 S1250

G1 X81.695 Y86.155 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.657 Y86.214 E-0.08175

G1 X81.521 Y86.062 E-0.11306

G1 X81.509 Y85.997 E-0.03617

G1 X81.625 Y85.460 E-0.30467

G1 X81.695 Y85.363 E-0.06608

G1 X81.795 Y85.288 E-0.06917

G1 X82.230 Y85.291 E-0.24111

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X85.558 Y88.576

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X85.763 Y88.448 E0.00630

G1 X86.191 Y88.266 E0.01212

G1 X86.815 Y88.074 E0.01701

G1 X87.035 Y88.047 E0.00578

G1 X87.589 Y88.061 E0.01443

G1 X88.118 Y88.197 E0.01423

G1 X88.495 Y88.348 E0.01059

G1 X88.912 Y88.557 E0.01216

G1 X85.618 Y88.576 E0.08584

M204 S1250

G1 X84.536 Y88.964 F9000.000

M204 S800

G1 F969

G1 X84.384 Y88.955 E0.00399

G1 X84.508 Y88.807 E0.00504

G1 X84.852 Y88.522 E0.01164

G1 X85.570 Y88.077 E0.02202

G1 X86.048 Y87.873 E0.01352

G1 X86.727 Y87.664 E0.01854

G1 X87.009 Y87.629 E0.00739

G1 X87.312 Y87.628 E0.00791

G1 X87.652 Y87.646 E0.00887

G1 X88.248 Y87.799 E0.01602

G1 X88.667 Y87.966 E0.01176

G1 X89.135 Y88.201 E0.01364

G1 X89.797 Y88.648 E0.02082

G1 X90.062 Y88.917 E0.00983

G1 X90.091 Y88.969 E0.00155

G1 X84.591 Y88.988 E0.14331

M204 S1250

G1 X84.464 Y88.828 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.384 Y88.955 E-0.11651

G1 X84.508 Y88.807 E-0.10720

G1 X84.852 Y88.522 E-0.24752

G1 X85.528 Y88.103 E-0.44078

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X87.708 Y88.332

G1 Z12.050

G1 E3.20000 F2400.00000

G1 F969

G1 X87.550 Y88.312 E0.00087

G1 X87.052 Y88.307 E0.00273

G1 X86.748 Y88.337 E0.00167

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.052 Y88.307 E-0.16901

G1 X87.550 Y88.312 E-0.27638

G1 X87.708 Y88.332 E-0.08786

G1 E-0.42676 F4200.00000

G1 Z12.250 F9000.000

G1 X92.872 Y86.201

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X92.815 Y86.221 E0.00156

G1 X92.646 Y86.211 E0.00443

G1 X92.543 Y86.148 E0.00315

G1 X92.014 Y85.727 E0.01760

G1 X91.728 Y85.398 E0.01137

G1 X91.733 Y85.289 E0.00283

G1 X92.768 Y85.330 E0.02700

G1 X92.807 Y85.376 E0.00158

G1 X92.942 Y85.748 E0.01031

G1 X92.970 Y86.032 E0.00744

G1 X92.902 Y86.149 E0.00352

M204 S1250

G1 X92.815 Y86.181 F9000.000

G1 X92.430 Y85.525

G1 F969

G1 X92.709 Y85.947 E0.00237

G1 X92.731 Y86.007 E0.00030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.709 Y85.947 E-0.03504

G1 X92.430 Y85.525 E-0.28018

G1 E-0.64478 F4200.00000

G1 Z12.250 F9000.000

G1 X92.815 Y73.223

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X92.646 Y73.213 E0.00443

G1 X92.543 Y73.150 E0.00315

G1 X92.014 Y72.729 E0.01760

G1 X91.728 Y72.400 E0.01136

G1 X91.733 Y72.291 E0.00284

G1 X92.768 Y72.332 E0.02700

G1 X92.807 Y72.378 E0.00158

G1 X92.942 Y72.750 E0.01031

G1 X92.967 Y72.927 E0.00466

G1 X92.970 Y73.034 E0.00279

G1 X92.871 Y73.203 E0.00509

M204 S1250

G1 X92.688 Y73.111 F9000.000

G1 X92.430 Y72.527

G1 F969

G1 X92.709 Y72.949 E0.00237

G1 X92.732 Y73.009 E0.00030

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.709 Y72.949 E-0.03538

G1 X92.430 Y72.527 E-0.28017

G1 E-0.64445 F4200.00000

G1 Z12.250 F9000.000

G1 X88.912 Y75.559

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X85.557 Y75.578 E0.08742

G1 X85.763 Y75.450 E0.00632

G1 X86.191 Y75.268 E0.01212

G1 X86.815 Y75.076 E0.01701

G1 X87.035 Y75.049 E0.00578

G1 X87.588 Y75.063 E0.01442

G1 X88.118 Y75.200 E0.01424

G1 X88.496 Y75.350 E0.01060

G1 X88.859 Y75.533 E0.01059

M204 S1250

G1 X90.062 Y75.920 F9000.000

M204 S800

G1 F969

G1 X90.091 Y75.971 E0.00153

G1 X84.615 Y76.002 E0.14268

G1 X84.537 Y75.966 E0.00223

G1 X84.384 Y75.957 E0.00401

G1 X84.508 Y75.809 E0.00504

G1 X84.852 Y75.524 E0.01164

G1 X85.570 Y75.079 E0.02202

G1 X86.048 Y74.875 E0.01352

G1 X86.727 Y74.666 E0.01854

G1 X87.009 Y74.631 E0.00739

G1 X87.652 Y74.648 E0.01676

G1 X88.248 Y74.802 E0.01603

G1 X88.667 Y74.969 E0.01176

G1 X89.135 Y75.204 E0.01363

G1 X89.797 Y75.650 E0.02082

G1 X90.020 Y75.877 E0.00828

M204 S1250

G1 X90.039 Y75.974 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.091 Y75.971 E-0.06517

G1 X88.563 Y75.979 E-0.84683

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X86.747 Y75.340

G1 Z12.050

G1 E3.20000 F2400.00000

G1 F969

G1 X87.052 Y75.309 E0.00168

G1 X87.550 Y75.314 E0.00273

G1 X87.708 Y75.334 E0.00087

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.550 Y75.314 E-0.08813

G1 X87.052 Y75.309 E-0.27605

G1 X86.747 Y75.340 E-0.16965

G1 E-0.42617 F4200.00000

G1 Z12.250 F9000.000

G1 X81.807 Y73.221

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X81.744 Y73.232 E0.00168

G1 X81.657 Y73.216 E0.00229

G1 X81.521 Y73.064 E0.00533

G1 X81.509 Y72.999 E0.00170

G1 X81.625 Y72.463 E0.01431

G1 X81.695 Y72.365 E0.00313

G1 X81.795 Y72.290 E0.00324

G1 X82.835 Y72.296 E0.02710

G1 X82.556 Y72.622 E0.01118

G1 X82.374 Y72.769 E0.00610

G1 X82.179 Y72.960 E0.00711

G1 X81.848 Y73.178 E0.01033

M204 S1250

G1 X81.758 Y73.179 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.744 Y73.232 E-0.06535

G1 X81.657 Y73.216 E-0.04879

G1 X81.521 Y73.064 E-0.11326

G1 X81.509 Y72.999 E-0.03612

G1 X81.625 Y72.463 E-0.30434

G1 X81.695 Y72.365 E-0.06655

G1 X81.795 Y72.290 E-0.06899

G1 X82.171 Y72.292 E-0.20859

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X81.742 Y60.234

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X81.657 Y60.219 E0.00224

G1 X81.521 Y60.065 E0.00535

G1 X81.509 Y60.002 E0.00168

G1 X81.625 Y59.465 E0.01433

G1 X81.695 Y59.368 E0.00311

G1 X81.795 Y59.293 E0.00325

G1 X82.835 Y59.298 E0.02710

G1 X82.556 Y59.625 E0.01119

G1 X82.374 Y59.771 E0.00609

G1 X82.179 Y59.962 E0.00710

G1 X81.858 Y60.169 E0.00995

G1 X81.801 Y60.226 E0.00211

M204 S1250

G1 X81.694 Y60.163 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.657 Y60.219 E-0.07988

G1 X81.521 Y60.065 E-0.11371

G1 X81.509 Y60.002 E-0.03563

G1 X81.625 Y59.465 E-0.30468

G1 X81.695 Y59.368 E-0.06621

G1 X81.795 Y59.293 E-0.06914

G1 X82.233 Y59.295 E-0.24276

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X85.557 Y62.580

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X85.763 Y62.452 E0.00632

G1 X86.191 Y62.270 E0.01212

G1 X86.815 Y62.078 E0.01701

G1 X87.035 Y62.051 E0.00578

G1 X87.588 Y62.065 E0.01442

G1 X88.118 Y62.202 E0.01424

G1 X88.496 Y62.352 E0.01060

G1 X88.912 Y62.561 E0.01215

G1 X85.617 Y62.580 E0.08586

M204 S1250

G1 X84.537 Y62.968 F9000.000

M204 S800

G1 F969

G1 X84.384 Y62.959 E0.00401

G1 X84.508 Y62.811 E0.00504

G1 X84.852 Y62.526 E0.01164

G1 X85.570 Y62.081 E0.02202

G1 X86.048 Y61.877 E0.01352

G1 X86.727 Y61.668 E0.01854

G1 X87.009 Y61.633 E0.00739

G1 X87.312 Y61.632 E0.00791

G1 X87.652 Y61.650 E0.00886

G1 X88.248 Y61.804 E0.01603

G1 X88.667 Y61.971 E0.01176

G1 X89.135 Y62.206 E0.01363

G1 X89.797 Y62.652 E0.02082

G1 X90.062 Y62.922 E0.00985

G1 X90.091 Y62.973 E0.00153

G1 X84.592 Y62.993 E0.14329

M204 S1250

G1 X84.465 Y62.832 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X84.384 Y62.959 E-0.11682

G1 X84.508 Y62.811 E-0.10719

G1 X84.852 Y62.526 E-0.24749

G1 X85.528 Y62.107 E-0.44051

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X87.708 Y62.336

G1 Z12.050

G1 E3.20000 F2400.00000

G1 F969

G1 X87.550 Y62.316 E0.00087

G1 X87.052 Y62.311 E0.00273

G1 X86.747 Y62.342 E0.00168

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.052 Y62.311 E-0.16965

G1 X87.550 Y62.316 E-0.27605

G1 X87.708 Y62.336 E-0.08813

G1 E-0.42617 F4200.00000

G1 Z12.250 F9000.000

G1 X92.871 Y60.205

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X92.816 Y60.225 E0.00153

G1 X92.646 Y60.215 E0.00444

G1 X92.543 Y60.152 E0.00315

G1 X92.014 Y59.732 E0.01760

G1 X91.728 Y59.402 E0.01137

G1 X91.733 Y59.293 E0.00285

G1 X92.768 Y59.334 E0.02700

G1 X92.807 Y59.380 E0.00158

G1 X92.942 Y59.752 E0.01031

G1 X92.970 Y60.037 E0.00746

G1 X92.902 Y60.154 E0.00351

M204 S1250

G1 X92.816 Y60.186 F9000.000

G1 X92.431 Y59.529

G1 F969

G1 X92.749 Y60.001 E0.00265

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.431 Y59.529 E-0.31511

G1 E-0.64489 F4200.00000

G1 Z12.250 F9000.000

G1 X92.816 Y47.227

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X92.646 Y47.217 E0.00443

G1 X92.543 Y47.154 E0.00315

G1 X92.014 Y46.734 E0.01760

G1 X91.728 Y46.405 E0.01136

G1 X91.733 Y46.296 E0.00283

G1 X92.768 Y46.336 E0.02700

G1 X92.807 Y46.382 E0.00158

G1 X92.942 Y46.755 E0.01032

G1 X92.967 Y46.931 E0.00465

G1 X92.970 Y47.040 E0.00283

G1 X92.872 Y47.208 E0.00506

M204 S1250

G1 X92.688 Y47.115 F9000.000

G1 X92.432 Y46.532

G1 F969

G1 X92.749 Y47.003 E0.00265

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.432 Y46.532 E-0.31501

G1 E-0.64499 F4200.00000

G1 Z12.250 F9000.000

G1 X88.913 Y49.564

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X85.557 Y49.583 E0.08744

G1 X85.763 Y49.454 E0.00634

G1 X86.191 Y49.272 E0.01212

G1 X86.815 Y49.080 E0.01701

G1 X87.035 Y49.053 E0.00576

G1 X87.589 Y49.067 E0.01445

G1 X88.118 Y49.204 E0.01423

G1 X88.496 Y49.354 E0.01060

G1 X88.859 Y49.537 E0.01059

M204 S1250

G1 X90.062 Y49.924 F9000.000

M204 S800

G1 F969

G1 X90.091 Y49.975 E0.00153

G1 X84.614 Y50.006 E0.14270

G1 X84.537 Y49.971 E0.00223

G1 X84.383 Y49.962 E0.00401

G1 X84.508 Y49.813 E0.00507

G1 X84.852 Y49.528 E0.01164

G1 X85.570 Y49.083 E0.02202

G1 X86.048 Y48.879 E0.01352

G1 X86.727 Y48.670 E0.01854

G1 X87.009 Y48.635 E0.00739

G1 X87.652 Y48.652 E0.01678

G1 X88.248 Y48.806 E0.01602

G1 X88.667 Y48.973 E0.01176

G1 X89.135 Y49.208 E0.01363

G1 X89.797 Y49.654 E0.02082

G1 X90.020 Y49.881 E0.00828

M204 S1250

G1 X90.039 Y49.978 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X90.091 Y49.975 E-0.06519

G1 X88.563 Y49.983 E-0.84681

G1 E-0.04800 F4200.00000

G1 Z12.250 F9000.000

G1 X86.746 Y49.344

G1 Z12.050

G1 E3.20000 F2400.00000

G1 F969

G1 X87.051 Y49.314 E0.00167

G1 X87.551 Y49.319 E0.00274

G1 X87.708 Y49.338 E0.00087

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.551 Y49.319 E-0.08771

G1 X87.051 Y49.314 E-0.27706

G1 X86.746 Y49.344 E-0.16954

G1 E-0.42569 F4200.00000

G1 Z12.250 F9000.000

G1 X81.807 Y47.226

G1 Z12.050

G1 E3.20000 F2400.00000

M204 S800

G1 F969

G1 X81.744 Y47.237 E0.00166

G1 X81.657 Y47.221 E0.00230

G1 X81.521 Y47.068 E0.00532

G1 X81.509 Y47.004 E0.00170

G1 X81.625 Y46.467 E0.01433

G1 X81.695 Y46.370 E0.00311

G1 X81.795 Y46.295 E0.00325

G1 X82.835 Y46.300 E0.02710

G1 X82.556 Y46.627 E0.01120

G1 X82.179 Y46.964 E0.01318

G1 X81.848 Y47.183 E0.01034

M204 S1250

G1 X81.758 Y47.185 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;12.2

G1 Z12.200 F9000.000

;AFTER\_LAYER\_CHANGE

;12.2

G1 E-3.20000 F4200.00000

G1 Z12.400 F9000.000

G1 X81.657 Y112.105

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X81.621 Y112.057 E0.00156

G1 X81.620 Y111.971 E0.00222

G1 X81.703 Y111.729 E0.00668

G1 X81.764 Y111.662 E0.00236

G1 X82.156 Y111.645 E0.01022

G1 X82.133 Y111.824 E0.00470

G1 X82.088 Y111.874 E0.00174

G1 X82.028 Y111.898 E0.00168

G1 X81.840 Y112.068 E0.00661

G1 X81.716 Y112.093 E0.00331

M204 S1250

G1 X81.653 Y112.045 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.621 Y112.057 E-0.05605

G1 X81.620 Y111.971 E-0.04732

G1 X81.703 Y111.729 E-0.14197

G1 X81.764 Y111.662 E-0.05018

G1 X82.156 Y111.645 E-0.21731

G1 X82.133 Y111.824 E-0.10000

G1 X82.088 Y111.874 E-0.03702

G1 X82.028 Y111.898 E-0.03583

G1 X81.840 Y112.068 E-0.14057

G1 X81.716 Y112.093 E-0.07037

G1 E-0.06339 F4200.00000

G1 Z12.400 F9000.000

G1 X86.557 Y114.218

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.041 Y114.104 E0.01294

G1 X87.313 Y114.101 E0.00709

G1 X87.548 Y114.113 E0.00613

G1 X87.971 Y114.219 E0.01137

G1 X86.617 Y114.218 E0.03527

M204 S1250

G1 X86.617 Y114.636 F9000.000

M204 S800

G1 F900

G1 X85.058 Y114.634 E0.04061

G1 X85.074 Y114.555 E0.00212

G1 X85.429 Y114.287 E0.01158

G1 X85.941 Y114.062 E0.01458

G1 X85.914 Y114.017 E0.00135

G1 X86.032 Y113.961 E0.00341

G1 X86.302 Y113.856 E0.00755

G1 X86.647 Y113.758 E0.00934

G1 X86.996 Y113.687 E0.00929

G1 X87.321 Y113.683 E0.00846

G1 X87.599 Y113.697 E0.00725

G1 X87.881 Y113.753 E0.00749

G1 X88.360 Y113.904 E0.01309

G1 X88.975 Y114.234 E0.01820

G1 X89.355 Y114.503 E0.01213

G1 X89.452 Y114.638 E0.00433

G1 X86.677 Y114.636 E0.07231

M204 S1250

G1 X86.411 Y114.292 F9000.000

G1 X86.240 Y114.427

G1 F900

G1 X86.263 Y114.282 E0.00135

G1

G1 X86.287 Y114.137 E0.00111

G1

G1 X86.220 Y114.112 E0.00043

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.287 Y114.137 E-0.03974

G1 E-0.92026 F4200.00000

G1 Z12.400 F9000.000

G1 X92.860 Y112.040

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X92.764 Y112.126 E0.00337

G1 X92.645 Y112.091 E0.00324

G1 X92.284 Y111.731 E0.01327

G1 X92.287 Y111.654 E0.00200

G1 X92.702 Y111.668 E0.01082

G1 X92.746 Y111.687 E0.00125

G1 X92.820 Y111.894 E0.00572

G1 X92.830 Y111.994 E0.00261

M204 S1250

G1 X92.731 Y112.049 F9000.000

G1 E-2.24000 F4200.00000

M73 P99 R0

G1 F7200.000

G1 X92.764 Y112.126 E-0.08209

G1 X92.645 Y112.091 E-0.06891

G1 X92.284 Y111.731 E-0.28231

G1 X92.287 Y111.654 E-0.04259

G1 X92.702 Y111.668 E-0.23014

G1 X92.746 Y111.687 E-0.02652

G1 X92.820 Y111.894 E-0.12161

G1 X92.830 Y111.994 E-0.05559

G1 E-0.05025 F4200.00000

G1 Z12.400 F9000.000

G1 X92.764 Y99.129

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X92.645 Y99.093 E0.00323

G1 X92.284 Y98.733 E0.01329

G1 X92.287 Y98.656 E0.00200

G1 X92.702 Y98.670 E0.01082

G1 X92.746 Y98.689 E0.00124

G1 X92.820 Y98.896 E0.00572

G1 X92.833 Y99.022 E0.00329

G1 X92.860 Y99.042 E0.00088

G1 X92.812 Y99.092 E0.00183

M204 S1250

G1 X92.688 Y99.031 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.645 Y99.093 E-0.09227

G1 X92.284 Y98.733 E-0.28257

G1 X92.287 Y98.656 E-0.04259

G1 X92.702 Y98.670 E-0.23014

G1 X92.746 Y98.689 E-0.02648

G1 X92.820 Y98.896 E-0.12174

G1 X92.833 Y99.022 E-0.06992

G1 X92.860 Y99.042 E-0.01881

G1 X92.826 Y99.078 E-0.02747

G1 E-0.04800 F4200.00000

G1 Z12.400 F9000.000

G1 X87.969 Y101.221

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X86.556 Y101.220 E0.03682

G1 X87.041 Y101.106 E0.01298

G1 X87.547 Y101.115 E0.01319

G1 X87.912 Y101.203 E0.00978

M204 S1250

G1 X88.360 Y100.907 F9000.000

M204 S800

G1 F900

G1 X88.975 Y101.236 E0.01819

G1 X89.355 Y101.505 E0.01213

G1 X89.452 Y101.640 E0.00433

G1 X85.058 Y101.637 E0.11449

G1 X85.074 Y101.557 E0.00214

G1 X85.429 Y101.289 E0.01157

G1 X85.940 Y101.065 E0.01456

G1 X85.913 Y101.020 E0.00137

G1 X86.302 Y100.858 E0.01098

G1 X86.647 Y100.761 E0.00933

G1 X86.996 Y100.689 E0.00929

G1 X87.598 Y100.699 E0.01570

G1 X87.880 Y100.755 E0.00749

G1 X88.303 Y100.889 E0.01154

M204 S1250

G1 X88.403 Y101.305 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.975 Y101.236 E-0.41953

G1 X89.355 Y101.505 E-0.25795

G1 X89.452 Y101.640 E-0.09208

G1 X89.195 Y101.640 E-0.14244

G1 E-0.04800 F4200.00000

G1 Z12.400 F9000.000

G1 X86.285 Y101.140

G1 Z12.200

G1 E3.20000 F2400.00000

G1 F900

G1 X86.218 Y101.115 E0.00043

G1 X86.285 Y101.140 F9000.000

G1 F900

G1 X86.263 Y101.284 E0.00111

G1

G1 X86.241 Y101.429 E0.00134

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.263 Y101.284 E-0.08111

G1 E-0.87889 F4200.00000

G1 Z12.400 F9000.000

G1 X81.657 Y99.107

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X81.621 Y99.059 E0.00156

G1 X81.620 Y98.973 E0.00222

G1 X81.703 Y98.732 E0.00665

G1 X81.765 Y98.665 E0.00237

G1 X82.156 Y98.648 E0.01021

G1 X82.133 Y98.827 E0.00471

G1 X82.089 Y98.876 E0.00172

G1 X82.029 Y98.899 E0.00166

G1 X81.840 Y99.070 E0.00665

G1 X81.716 Y99.095 E0.00331

M204 S1250

G1 X81.653 Y99.047 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.621 Y99.059 E-0.05596

G1 X81.620 Y98.973 E-0.04727

G1 X81.703 Y98.732 E-0.14154

G1 X81.765 Y98.665 E-0.05034

G1 X82.156 Y98.648 E-0.21723

G1 X82.133 Y98.827 E-0.10008

G1 X82.089 Y98.876 E-0.03657

G1 X82.029 Y98.899 E-0.03538

G1 X81.840 Y99.070 E-0.14144

G1 X81.716 Y99.095 E-0.07047

G1 E-0.06373 F4200.00000

G1 Z12.400 F9000.000

G1 X81.657 Y86.109

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X81.621 Y86.061 E0.00157

G1 X81.620 Y85.976 E0.00220

G1 X81.703 Y85.734 E0.00668

G1 X81.764 Y85.667 E0.00236

G1 X82.156 Y85.650 E0.01022

G1 X82.133 Y85.829 E0.00469

G1 X82.089 Y85.878 E0.00172

G1 X82.029 Y85.901 E0.00166

G1 X81.839 Y86.073 E0.00667

G1 X81.716 Y86.097 E0.00329

M204 S1250

G1 X81.653 Y86.049 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.621 Y86.061 E-0.05612

G1 X81.620 Y85.976 E-0.04690

G1 X81.703 Y85.734 E-0.14200

G1 X81.764 Y85.667 E-0.05019

G1 X82.156 Y85.650 E-0.21727

G1 X82.133 Y85.829 E-0.09969

G1 X82.089 Y85.878 E-0.03658

G1 X82.029 Y85.901 E-0.03538

G1 X81.839 Y86.073 E-0.14196

G1 X81.716 Y86.097 E-0.06988

G1 E-0.06403 F4200.00000

G1 Z12.400 F9000.000

G1 X86.556 Y88.223

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.041 Y88.109 E0.01299

G1 X87.313 Y88.105 E0.00710

G1 X87.547 Y88.117 E0.00609

G1 X87.971 Y88.224 E0.01140

G1 X86.616 Y88.223 E0.03531

M204 S1250

G1 X86.615 Y88.641 F9000.000

M204 S800

G1 F900

G1 X85.058 Y88.639 E0.04057

G1 X85.074 Y88.559 E0.00214

G1 X85.429 Y88.292 E0.01157

G1 X85.940 Y88.067 E0.01456

G1 X85.913 Y88.022 E0.00135

G1 X86.032 Y87.966 E0.00342

G1 X86.302 Y87.860 E0.00756

G1 X86.647 Y87.763 E0.00933

G1 X86.996 Y87.692 E0.00929

G1 X87.321 Y87.687 E0.00846

G1 X87.598 Y87.701 E0.00724

G1 X87.880 Y87.757 E0.00749

G1 X88.360 Y87.909 E0.01310

G1 X88.975 Y88.238 E0.01819

G1 X89.355 Y88.508 E0.01212

G1 X89.453 Y88.643 E0.00436

G1 X86.675 Y88.641 E0.07237

M204 S1250

G1 X86.410 Y88.297 F9000.000

G1 X86.239 Y88.431

G1 F900

G1 X86.262 Y88.287 E0.00134

G1

G1 X86.285 Y88.142 E0.00110

G1

G1 X86.218 Y88.117 E0.00043

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.285 Y88.142 E-0.03966

G1 E-0.92034 F4200.00000

G1 Z12.400 F9000.000

G1 X92.860 Y86.045

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X92.764 Y86.131 E0.00336

G1 X92.645 Y86.095 E0.00323

G1 X92.284 Y85.735 E0.01329

G1 X92.287 Y85.658 E0.00200

G1 X92.702 Y85.672 E0.01081

G1 X92.746 Y85.692 E0.00126

G1 X92.820 Y85.898 E0.00571

G1 X92.830 Y85.999 E0.00264

M204 S1250

G1 X92.732 Y86.053 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.764 Y86.131 E-0.08188

G1 X92.645 Y86.095 E-0.06862

G1 X92.284 Y85.735 E-0.28257

G1 X92.287 Y85.658 E-0.04259

G1 X92.702 Y85.672 E-0.22988

G1 X92.746 Y85.692 E-0.02678

G1 X92.820 Y85.898 E-0.12150

G1 X92.830 Y85.999 E-0.05605

G1 E-0.05012 F4200.00000

G1 Z12.400 F9000.000

G1 X92.764 Y73.133

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X92.645 Y73.097 E0.00323

G1 X92.284 Y72.737 E0.01329

G1 X92.287 Y72.661 E0.00199

G1 X92.702 Y72.675 E0.01081

G1 X92.746 Y72.694 E0.00125

G1 X92.820 Y72.900 E0.00571

G1 X92.833 Y73.027 E0.00332

G1 X92.860 Y73.047 E0.00088

G1 X92.812 Y73.096 E0.00181

M204 S1250

G1 X92.688 Y73.035 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.645 Y73.097 E-0.09233

G1 X92.284 Y72.737 E-0.28255

G1 X92.287 Y72.661 E-0.04227

G1 X92.702 Y72.675 E-0.23001

G1 X92.746 Y72.694 E-0.02664

G1 X92.820 Y72.900 E-0.12150

G1 X92.833 Y73.027 E-0.07063

G1 X92.860 Y73.047 E-0.01868

G1 X92.826 Y73.082 E-0.02739

G1 E-0.04800 F4200.00000

G1 Z12.400 F9000.000

G1 X87.971 Y75.226

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X86.557 Y75.225 E0.03683

G1 X87.041 Y75.111 E0.01296

G1 X87.313 Y75.107 E0.00707

G1 X87.547 Y75.119 E0.00610

G1 X87.914 Y75.208 E0.00984

M204 S1250

G1 X88.360 Y74.911 F9000.000

M204 S800

G1 F900

G1 X88.975 Y75.241 E0.01820

G1 X89.355 Y75.510 E0.01212

G1 X89.453 Y75.645 E0.00436

G1 X85.058 Y75.641 E0.11451

G1 X85.074 Y75.561 E0.00214

G1 X85.429 Y75.294 E0.01157

G1 X85.940 Y75.069 E0.01456

G1 X85.913 Y75.024 E0.00135

G1 X86.302 Y74.863 E0.01097

G1 X86.647 Y74.765 E0.00934

G1 X86.996 Y74.694 E0.00930

G1 X87.598 Y74.703 E0.01569

G1 X87.881 Y74.760 E0.00750

G1 X88.303 Y74.893 E0.01153

M204 S1250

G1 X88.402 Y75.309 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.975 Y75.241 E-0.41987

G1 X89.355 Y75.510 E-0.25770

G1 X89.453 Y75.645 E-0.09264

G1 X89.197 Y75.645 E-0.14178

G1 E-0.04800 F4200.00000

G1 Z12.400 F9000.000

G1 X86.286 Y75.145

G1 Z12.200

G1 E3.20000 F2400.00000

G1 F900

G1 X86.219 Y75.119 E0.00044

G1 X86.286 Y75.145 F9000.000

G1 F900

G1 X86.263 Y75.289 E0.00112

G1

G1 X86.239 Y75.434 E0.00136

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.263 Y75.289 E-0.08105

G1 E-0.87895 F4200.00000

G1 Z12.400 F9000.000

G1 X81.657 Y73.111

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X81.621 Y73.063 E0.00157

G1 X81.620 Y72.978 E0.00220

G1 X81.703 Y72.736 E0.00668

G1 X81.764 Y72.669 E0.00236

G1 X82.156 Y72.652 E0.01022

G1 X82.133 Y72.831 E0.00469

G1 X82.088 Y72.880 E0.00174

G1 X82.029 Y72.904 E0.00167

G1 X81.840 Y73.074 E0.00662

G1 X81.716 Y73.099 E0.00331

M204 S1250

G1 X81.653 Y73.051 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.621 Y73.063 E-0.05612

G1 X81.620 Y72.978 E-0.04690

G1 X81.703 Y72.736 E-0.14200

G1 X81.764 Y72.669 E-0.05019

G1 X82.156 Y72.652 E-0.21727

G1 X82.133 Y72.831 E-0.09969

G1 X82.088 Y72.880 E-0.03707

G1 X82.029 Y72.904 E-0.03553

G1 X81.840 Y73.074 E-0.14082

G1 X81.716 Y73.099 E-0.07037

G1 E-0.06404 F4200.00000

G1 Z12.400 F9000.000

G1 X81.658 Y60.114

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X81.621 Y60.065 E0.00159

G1 X81.620 Y59.980 E0.00220

G1 X81.703 Y59.738 E0.00668

G1 X81.764 Y59.671 E0.00236

G1 X82.156 Y59.654 E0.01022

G1 X82.133 Y59.833 E0.00469

G1 X82.088 Y59.883 E0.00176

G1 X82.028 Y59.907 E0.00167

G1 X81.841 Y60.076 E0.00657

G1 X81.716 Y60.102 E0.00332

M204 S1250

G1 X81.653 Y60.053 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X81.621 Y60.065 E-0.05652

G1 X81.620 Y59.980 E-0.04683

G1 X81.703 Y59.738 E-0.14197

G1 X81.764 Y59.671 E-0.05018

G1 X82.156 Y59.654 E-0.21727

G1 X82.133 Y59.833 E-0.09972

G1 X82.088 Y59.883 E-0.03738

G1 X82.028 Y59.907 E-0.03554

G1 X81.841 Y60.076 E-0.13967

G1 X81.716 Y60.102 E-0.07068

G1 E-0.06422 F4200.00000

G1 Z12.400 F9000.000

G1 X86.557 Y62.227

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.041 Y62.113 E0.01296

G1 X87.313 Y62.109 E0.00708

G1 X87.547 Y62.121 E0.00609

G1 X87.971 Y62.228 E0.01140

G1 X86.617 Y62.227 E0.03527

M204 S1250

G1 X86.617 Y62.645 F9000.000

M204 S800

G1 F900

G1 X85.058 Y62.643 E0.04062

G1 X85.074 Y62.563 E0.00214

G1 X85.428 Y62.296 E0.01156

G1 X85.941 Y62.071 E0.01458

G1 X85.914 Y62.026 E0.00135

G1 X86.032 Y61.970 E0.00341

G1 X86.302 Y61.865 E0.00755

G1 X86.647 Y61.767 E0.00934

G1 X86.996 Y61.696 E0.00930

G1 X87.321 Y61.691 E0.00846

G1 X87.598 Y61.705 E0.00724

G1 X87.881 Y61.762 E0.00750

G1 X88.360 Y61.913 E0.01310

G1 X88.975 Y62.243 E0.01820

G1 X89.355 Y62.513 E0.01214

G1 X89.453 Y62.647 E0.00433

G1 X86.677 Y62.645 E0.07232

M204 S1250

G1 X86.411 Y62.301 F9000.000

G1 X86.241 Y62.436

G1 F900

G1 X86.264 Y62.291 E0.00134

G1

G1 X86.287 Y62.146 E0.00111

G1

G1 X86.219 Y62.121 E0.00043

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.287 Y62.146 E-0.03986

G1 E-0.92014 F4200.00000

G1 Z12.400 F9000.000

G1 X92.860 Y60.050

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X92.764 Y60.135 E0.00335

G1 X92.645 Y60.099 E0.00323

G1 X92.284 Y59.739 E0.01329

G1 X92.287 Y59.663 E0.00199

G1 X92.702 Y59.677 E0.01081

G1 X92.746 Y59.696 E0.00125

G1 X92.820 Y59.903 E0.00573

G1 X92.831 Y60.004 E0.00264

M204 S1250

G1 X92.732 Y60.058 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.764 Y60.135 E-0.08163

G1 X92.645 Y60.099 E-0.06873

G1 X92.284 Y59.739 E-0.28262

G1 X92.287 Y59.663 E-0.04227

G1 X92.702 Y59.677 E-0.23001

G1 X92.746 Y59.696 E-0.02659

G1 X92.820 Y59.903 E-0.12181

G1 X92.831 Y60.004 E-0.05625

G1 E-0.05010 F4200.00000

G1 Z12.400 F9000.000

G1 X92.764 Y47.137

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X92.645 Y47.102 E0.00324

G1 X92.284 Y46.742 E0.01327

G1 X92.287 Y46.665 E0.00200

G1 X92.702 Y46.679 E0.01082

G1 X92.746 Y46.698 E0.00125

G1 X92.820 Y46.905 E0.00572

G1 X92.833 Y47.032 E0.00333

G1 X92.860 Y47.052 E0.00087

G1 X92.812 Y47.101 E0.00180

M204 S1250

G1 X92.688 Y47.039 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X92.645 Y47.102 E-0.09250

G1 X92.284 Y46.742 E-0.28231

G1 X92.287 Y46.665 E-0.04259

G1 X92.702 Y46.679 E-0.23014

G1 X92.746 Y46.698 E-0.02652

G1 X92.820 Y46.905 E-0.12161

G1 X92.833 Y47.032 E-0.07081

G1 X92.860 Y47.052 E-0.01846

G1 X92.826 Y47.086 E-0.02705

G1 E-0.04800 F4200.00000

G1 Z12.400 F9000.000

G1 X87.971 Y49.230

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X86.557 Y49.229 E0.03683

G1 X87.041 Y49.115 E0.01296

G1 X87.313 Y49.111 E0.00707

G1 X87.547 Y49.124 E0.00611

G1 X87.914 Y49.212 E0.00983

M204 S1250

G1 X88.360 Y48.915 F9000.000

M204 S800

G1 F900

G1 X88.975 Y49.245 E0.01820

G1 X89.355 Y49.515 E0.01214

G1 X89.453 Y49.649 E0.00433

G1 X85.058 Y49.645 E0.11450

G1 X85.074 Y49.565 E0.00214

G1 X85.429 Y49.298 E0.01156

G1 X85.941 Y49.073 E0.01458

G1 X85.914 Y49.028 E0.00135

G1 X86.302 Y48.867 E0.01096

G1 X86.647 Y48.769 E0.00934

G1 X86.996 Y48.698 E0.00930

G1 X87.598 Y48.708 E0.01569

G1 X87.881 Y48.764 E0.00750

G1 X88.303 Y48.897 E0.01153

M204 S1250

G1 X88.403 Y49.313 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X88.975 Y49.245 E-0.41978

G1 X89.355 Y49.515 E-0.25811

G1 X89.453 Y49.649 E-0.09212

G1 X89.196 Y49.649 E-0.14199

G1 E-0.04800 F4200.00000

G1 Z12.400 F9000.000

G1 X86.287 Y49.148

G1 Z12.200

G1 E3.20000 F2400.00000

G1 F900

G1 X86.220 Y49.123 E0.00043

G1 X86.287 Y49.148 F9000.000

G1 F900

G1 X86.263 Y49.293 E0.00111

G1

G1 X86.240 Y49.438 E0.00135

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X86.263 Y49.293 E-0.08123

G1 E-0.87877 F4200.00000

G1 Z12.400 F9000.000

G1 X81.657 Y47.116

G1 Z12.200

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X81.621 Y47.067 E0.00158

G1 X81.620 Y46.982 E0.00222

G1 X81.703 Y46.740 E0.00668

G1 X81.764 Y46.673 E0.00236

G1 X82.156 Y46.656 E0.01022

G1 X82.133 Y46.835 E0.00469

G1 X82.088 Y46.885 E0.00176

G1 X82.028 Y46.909 E0.00168

G1 X81.840 Y47.079 E0.00661

G1 X81.716 Y47.104 E0.00329

M204 S1250

G1 X81.653 Y47.056 F9000.000

;BEFORE\_LAYER\_CHANGE

G92 E0.0

;12.35

G1 Z12.350 F9000.000

;AFTER\_LAYER\_CHANGE

;12.35

G1 E-3.20000 F4200.00000

G1 Z12.550 F9000.000

G1 X87.458 Y113.897

G1 Z12.350

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.538 Y113.824 E0.00283

G1 X87.859 Y113.892 E0.00854

G1 X88.062 Y113.974 E0.00570

G1 X88.249 Y114.092 E0.00577

G1 X87.748 Y114.113 E0.01308

G1 X86.210 Y114.128 E0.04008

G1 X86.198 Y114.108 E0.00061

G1 X86.244 Y114.064 E0.00167

G1 X86.351 Y114.030 E0.00292

G1 X86.425 Y113.970 E0.00249

G1 X86.500 Y113.941 E0.00209

G1 X86.614 Y113.939 E0.00297

G1 X86.695 Y113.887 E0.00251

G1 X86.885 Y113.868 E0.00497

G1 X86.915 Y113.838 E0.00110

G1 X87.122 Y113.823 E0.00541

G1 X87.399 Y113.884 E0.00739

M204 S1250

G1 X87.548 Y113.957 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.538 Y113.824 E-0.08386

G1 X87.859 Y113.892 E-0.18172

G1 X88.062 Y113.974 E-0.12127

G1 X88.249 Y114.092 E-0.12265

G1 X87.748 Y114.113 E-0.27813

G1 X87.524 Y114.115 E-0.12438

G1 E-0.04800 F4200.00000

G1 Z12.550 F9000.000

G1 X87.458 Y100.899

G1 Z12.350

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.538 Y100.826 E0.00281

G1 X87.859 Y100.894 E0.00856

G1 X88.062 Y100.976 E0.00569

G1 X88.249 Y101.094 E0.00576

G1 X87.748 Y101.115 E0.01307

G1 X86.209 Y101.130 E0.04010

G1 X86.197 Y101.111 E0.00059

G1 X86.244 Y101.066 E0.00168

G1 X86.351 Y101.032 E0.00292

G1 X86.425 Y100.972 E0.00250

G1 X86.500 Y100.943 E0.00209

G1 X86.613 Y100.941 E0.00294

G1 X86.695 Y100.890 E0.00251

G1 X86.885 Y100.869 E0.00499

G1 X86.915 Y100.840 E0.00109

G1 X87.122 Y100.825 E0.00541

G1 X87.399 Y100.886 E0.00739

M204 S1250

G1 X87.548 Y100.959 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.538 Y100.826 E-0.08345

G1 X87.859 Y100.894 E-0.18210

G1 X88.062 Y100.976 E-0.12111

G1 X88.249 Y101.094 E-0.12252

G1 X87.748 Y101.115 E-0.27797

G1 X87.523 Y101.117 E-0.12485

G1 E-0.04800 F4200.00000

G1 Z12.550 F9000.000

G1 X87.458 Y87.901

G1 Z12.350

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.538 Y87.828 E0.00281

G1 X87.859 Y87.896 E0.00856

G1 X88.062 Y87.978 E0.00569

G1 X88.250 Y88.096 E0.00578

G1 X87.748 Y88.118 E0.01309

G1 X86.209 Y88.133 E0.04009

G1 X86.198 Y88.114 E0.00059

G1 X86.244 Y88.068 E0.00170

G1 X86.350 Y88.035 E0.00289

G1 X86.425 Y87.975 E0.00249

G1 X86.501 Y87.946 E0.00213

G1 X86.614 Y87.942 E0.00294

G1 X86.694 Y87.892 E0.00247

G1 X86.886 Y87.872 E0.00502

G1 X86.916 Y87.842 E0.00111

G1 X87.122 Y87.827 E0.00539

G1 X87.399 Y87.888 E0.00739

M204 S1250

G1 X87.548 Y87.961 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.538 Y87.828 E-0.08345

G1 X87.859 Y87.896 E-0.18210

G1 X88.062 Y87.978 E-0.12111

G1 X88.250 Y88.096 E-0.12297

G1 X87.748 Y88.118 E-0.27835

G1 X87.524 Y88.120 E-0.12402

G1 E-0.04800 F4200.00000

G1 Z12.550 F9000.000

G1 X88.250 Y75.098

G1 Z12.350

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.748 Y75.120 E0.01310

G1 X86.210 Y75.135 E0.04008

G1 X86.198 Y75.116 E0.00060

G1 X86.244 Y75.070 E0.00170

G1 X86.350 Y75.037 E0.00289

G1 X86.424 Y74.977 E0.00248

G1 X86.501 Y74.948 E0.00212

G1 X86.614 Y74.945 E0.00295

G1 X86.694 Y74.894 E0.00248

G1 X86.886 Y74.874 E0.00503

G1 X86.917 Y74.844 E0.00112

G1 X87.122 Y74.829 E0.00537

G1 X87.458 Y74.903 E0.00895

G1 X87.538 Y74.830 E0.00281

G1 X87.629 Y74.844 E0.00240

G1 X87.859 Y74.898 E0.00617

G1 X88.062 Y74.980 E0.00569

G1 X88.199 Y75.066 E0.00423

M204 S1250

G1 X87.853 Y75.047 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.748 Y75.120 E-0.25187

G1 X86.557 Y75.132 E-0.66013

G1 E-0.04800 F4200.00000

G1 Z12.550 F9000.000

G1 X88.249 Y62.101

G1 Z12.350

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.748 Y62.122 E0.01308

G1 X86.210 Y62.137 E0.04008

G1 X86.198 Y62.117 E0.00061

G1 X86.244 Y62.073 E0.00167

G1 X86.351 Y62.039 E0.00292

G1 X86.425 Y61.979 E0.00249

G1 X86.500 Y61.950 E0.00209

G1 X86.614 Y61.948 E0.00297

G1 X86.695 Y61.896 E0.00251

G1 X86.885 Y61.877 E0.00497

G1 X86.915 Y61.847 E0.00111

G1 X87.122 Y61.831 E0.00540

G1 X87.458 Y61.905 E0.00897

G1 X87.538 Y61.832 E0.00281

G1 X87.629 Y61.846 E0.00240

G1 X87.859 Y61.900 E0.00616

G1 X88.061 Y61.983 E0.00570

G1 X88.198 Y62.069 E0.00421

M204 S1250

G1 X87.853 Y62.049 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000

G1 X87.748 Y62.122 E-0.25142

G1 X86.556 Y62.134 E-0.66058

G1 E-0.04800 F4200.00000

G1 Z12.550 F9000.000

G1 X87.457 Y48.908

G1 Z12.350

G1 E3.20000 F2400.00000

M204 S800

G1 F900

G1 X87.538 Y48.835 E0.00283

G1 X87.859 Y48.902 E0.00855

G1 X88.061 Y48.985 E0.00570

G1 X88.249 Y49.103 E0.00578

G1 X87.748 Y49.124 E0.01308

G1 X86.210 Y49.139 E0.04008

G1 X86.198 Y49.119 E0.00061

G1 X86.244 Y49.075 E0.00167

G1 X86.351 Y49.041 E0.00292

G1 X86.425 Y48.981 E0.00249

G1 X86.500 Y48.952 E0.00209

G1 X86.614 Y48.950 E0.00297

G1 X86.695 Y48.898 E0.00251

G1 X86.885 Y48.879 E0.00497

G1 X86.915 Y48.849 E0.00111

G1 X87.122 Y48.833 E0.00540

G1 X87.399 Y48.894 E0.00738

M204 S1250

G1 X87.547 Y48.968 F9000.000

G1 E-2.24000 F4200.00000

G1 F7200.000;\_WIPE

G1 X87.538 Y48.835 E-0.08398

G1 F7200.000;\_WIPE

G1 X87.859 Y48.902 E-0.18188

G1 F7200.000;\_WIPE

G1 X88.061 Y48.985 E-0.12124

G1 F7200.000;\_WIPE

G1 X88.249 Y49.103 E-0.12287

G1 F7200.000;\_WIPE

G1 X87.748 Y49.124 E-0.27813

G1 F7200.000;\_WIPE

G1 X87.524 Y49.126 E-0.12389

G1 E-0.04800 F4200.00000

G1 Z12.550 F9000.000

M107

; Filament-specific end gcode

G1 E-1 F2100 ; retract

G1 Z17.55 F720 ; Move print head up

G1 X178 Y180 F4200 ; park print head

G4 ; wait

M104 S0 ; turn off temperature

M140 S0 ; turn off heatbed

M107 ; turn off fan

M221 S100 ; reset flow

M84 ; disable motors

M73 P100 R0

; filament used [mm] = 2808.3

; filament used [cm3] = 6.8

; filament used [g] = 8.4

; filament cost = 0.2

; total filament used [g] = 8.4

; total filament cost = 0.2

; estimated printing time (normal mode) = 1h 10m 46s

; avoid\_crossing\_perimeters = 0

; bed\_custom\_model =

; bed\_custom\_texture =

; bed\_shape = 0x0,180x0,180x180,0x180

; bed\_temperature = 60

; before\_layer\_gcode = ;BEFORE\_LAYER\_CHANGE\nG92 E0.0\n;[layer\_z]\n\n

; between\_objects\_gcode =

; bottom\_fill\_pattern = rectilinear

; bottom\_solid\_layers = 5

; bottom\_solid\_min\_thickness = 0.5

; bridge\_acceleration = 1000

; bridge\_angle = 0

; bridge\_fan\_speed = 100

; bridge\_flow\_ratio = 0.85

; bridge\_speed = 30

; brim\_width = 0

; clip\_multipart\_objects = 1

; compatible\_printers\_condition\_cummulative = "printer\_notes=~/.\*PRINTER\_VENDOR\_PRUSA3D.\*/ and printer\_notes=~/.\*PRINTER\_MODEL\_MINI.\*/ and nozzle\_diameter[0]==0.4";"! (printer\_notes=~/.\*PRINTER\_VENDOR\_PRUSA3D.\*/ and printer\_notes=~/.\*PRINTER\_MODEL\_MK(2.5|3).\*/ and single\_extruder\_multi\_material)"

; complete\_objects = 0

; cooling = 1

; cooling\_tube\_length = 5

; cooling\_tube\_retraction = 91.5

; default\_acceleration = 1250

; default\_filament\_profile = "Prusament PLA"

; default\_print\_profile = 0.15mm QUALITY @MINI

; deretract\_speed = 40

; disable\_fan\_first\_layers = 1

; dont\_support\_bridges = 1

; draft\_shield = 0

; duplicate\_distance = 6

; elefant\_foot\_compensation = 0.2

; end\_filament\_gcode = "; Filament-specific end gcode"

; end\_gcode = G1 E-1 F2100 ; retract\n{if layer\_z < max\_print\_height}G1 Z{z\_offset+min(layer\_z+5, max\_print\_height)}{endif} F720 ; Move print head up\nG1 X178 Y180 F4200 ; park print head\nG4 ; wait\nM104 S0 ; turn off temperature\nM140 S0 ; turn off heatbed\nM107 ; turn off fan\nM221 S100 ; reset flow\nM84 ; disable motors

; ensure\_vertical\_shell\_thickness = 1

; external\_perimeter\_extrusion\_width = 0.45

; external\_perimeter\_speed = 30

; external\_perimeters\_first = 0

; extra\_loading\_move = -2

; extra\_perimeters = 0

; extruder\_clearance\_height = 20

; extruder\_clearance\_radius = 35

; extruder\_colour = ""

; extruder\_offset = 0x0

; extrusion\_axis = E

; extrusion\_multiplier = 1

; extrusion\_width = 0.45

; fan\_always\_on = 1

; fan\_below\_layer\_time = 100

; filament\_colour = #FF8000

; filament\_cooling\_final\_speed = 3.4

; filament\_cooling\_initial\_speed = 2.2

; filament\_cooling\_moves = 4

; filament\_cost = 24.99

; filament\_density = 1.24

; filament\_diameter = 1.75

; filament\_load\_time = 0

; filament\_loading\_speed = 28

; filament\_loading\_speed\_start = 3

; filament\_max\_volumetric\_speed = 15

; filament\_minimal\_purge\_on\_wipe\_tower = 15

; filament\_notes = "Affordable filament for everyday printing in premium quality manufactured in-house by Josef Prusa"

; filament\_ramming\_parameters = "120 100 6.6 6.8 7.2 7.6 7.9 8.2 8.7 9.4 9.9 10.0| 0.05 6.6 0.45 6.8 0.95 7.8 1.45 8.3 1.95 9.7 2.45 10 2.95 7.6 3.45 7.6 3.95 7.6 4.45 7.6 4.95 7.6"

; filament\_settings\_id = "Prusament PLA"

; filament\_soluble = 0

; filament\_toolchange\_delay = 0

; filament\_type = PLA

; filament\_unload\_time = 0

; filament\_unloading\_speed = 90

; filament\_unloading\_speed\_start = 100

; filament\_vendor = Prusa Polymers

; fill\_angle = 45

; fill\_density = 15%

; fill\_pattern = gyroid

; first\_layer\_acceleration = 800

; first\_layer\_bed\_temperature = 60

; first\_layer\_extrusion\_width = 0.42

; first\_layer\_height = 0.2

; first\_layer\_speed = 20

; first\_layer\_temperature = 215

; gap\_fill\_speed = 40

; gcode\_comments = 0

; gcode\_flavor = marlin

; gcode\_label\_objects = 0

; high\_current\_on\_filament\_swap = 0

; host\_type = octoprint

; infill\_acceleration = 1000

; infill\_every\_layers = 1

; infill\_extruder = 1

; infill\_extrusion\_width = 0.45

; infill\_first = 0

; infill\_only\_where\_needed = 0

; infill\_overlap = 25%

; infill\_speed = 80

; interface\_shells = 0

; layer\_gcode = ;AFTER\_LAYER\_CHANGE\n;[layer\_z]

; layer\_height = 0.15

; machine\_max\_acceleration\_e = 5000

; machine\_max\_acceleration\_extruding = 1250

; machine\_max\_acceleration\_retracting = 1250

; machine\_max\_acceleration\_x = 1250

; machine\_max\_acceleration\_y = 1250

; machine\_max\_acceleration\_z = 400

; machine\_max\_feedrate\_e = 80

; machine\_max\_feedrate\_x = 180

; machine\_max\_feedrate\_y = 180

; machine\_max\_feedrate\_z = 12

; machine\_max\_jerk\_e = 10

; machine\_max\_jerk\_x = 8

; machine\_max\_jerk\_y = 8

; machine\_max\_jerk\_z = 2

; machine\_min\_extruding\_rate = 0

; machine\_min\_travel\_rate = 0

; max\_fan\_speed = 100

; max\_layer\_height = 0.25

; max\_print\_height = 180

; max\_print\_speed = 150

; max\_volumetric\_speed = 0

; min\_fan\_speed = 100

; min\_layer\_height = 0.07

; min\_print\_speed = 15

; min\_skirt\_length = 4

; notes =

; nozzle\_diameter = 0.4

; only\_retract\_when\_crossing\_perimeters = 0

; ooze\_prevention = 0

; output\_filename\_format = {input\_filename\_base}\_{layer\_height}mm\_{filament\_type[0]}\_{printer\_model}\_{print\_time}.gcode

; overhangs = 0

; parking\_pos\_retraction = 92

; perimeter\_acceleration = 800

; perimeter\_extruder = 1

; perimeter\_extrusion\_width = 0.45

; perimeter\_speed = 40

; perimeters = 2

; post\_process =

; print\_settings\_id = 0.15mm QUALITY @MINI

; printer\_model = MINI

; printer\_notes = Don't remove the following keywords! These keywords are used in the "compatible printer" condition of the print and filament profiles to link the particular print and filament profiles to this printer profile.\nPRINTER\_VENDOR\_PRUSA3D\nPRINTER\_MODEL\_MINI\n

; printer\_settings\_id = Original Prusa MINI

; printer\_technology = FFF

; printer\_variant = 0.4

; printer\_vendor =

; raft\_layers = 0

; remaining\_times = 1

; resolution = 0

; retract\_before\_travel = 1.5

; retract\_before\_wipe = 70%

; retract\_layer\_change = 0

; retract\_length = 3.2

; retract\_length\_toolchange = 4

; retract\_lift = 0.2

; retract\_lift\_above = 0

; retract\_lift\_below = 179

; retract\_restart\_extra = 0

; retract\_restart\_extra\_toolchange = 0

; retract\_speed = 70

; seam\_position = nearest

; serial\_port =

; serial\_speed = 250000

; silent\_mode = 0

; single\_extruder\_multi\_material = 0

; single\_extruder\_multi\_material\_priming = 1

; skirt\_distance = 2

; skirt\_height = 3

; skirts = 1

; slice\_closing\_radius = 0.049

; slowdown\_below\_layer\_time = 20

; small\_perimeter\_speed = 25

; solid\_infill\_below\_area = 0

; solid\_infill\_every\_layers = 0

; solid\_infill\_extruder = 1

; solid\_infill\_extrusion\_width = 0.45

; solid\_infill\_speed = 80

; spiral\_vase = 0

; standby\_temperature\_delta = -5

; start\_filament\_gcode = "M900 K{if printer\_notes=~/.\*PRINTER\_MODEL\_MINI.\*/ and nozzle\_diameter[0]==0.6}0.12{elsif printer\_notes=~/.\*PRINTER\_MODEL\_MINI.\*/}0.2{elsif printer\_notes=~/.\*PRINTER\_HAS\_BOWDEN.\*/}200{elsif nozzle\_diameter[0]==0.6}18{else}30{endif} ; Filament gcode"

; start\_gcode = G90 ; use absolute coordinates\nM83 ; extruder relative mode\nM104 S170 ; set extruder temp for bed leveling\nM140 S[first\_layer\_bed\_temperature] ; set bed temp\nM109 R170 ; wait for bed leveling temp\nM190 S[first\_layer\_bed\_temperature] ; wait for bed temp\nG28 ; home all without mesh bed level\nG29 ; mesh bed leveling \nM104 S[first\_layer\_temperature] ; set extruder temp\nG92 E0.0\nG1 Y-2.0 X179 F2400\nG1 Z3 F720\nM109 S[first\_layer\_temperature] ; wait for extruder temp\n\n; intro line\nG1 X170 F1000\nG1 Z0.2 F720\nG1 X110.0 E8.0 F900\nG1 X40.0 E10.0 F700\nG92 E0.0\n\nM221 S95 ; set flow

; support\_material = 0

; support\_material\_angle = 0

; support\_material\_auto = 1

; support\_material\_buildplate\_only = 0

; support\_material\_contact\_distance = 0.1

; support\_material\_enforce\_layers = 0

; support\_material\_extruder = 0

; support\_material\_extrusion\_width = 0.35

; support\_material\_interface\_contact\_loops = 0

; support\_material\_interface\_extruder = 0

; support\_material\_interface\_layers = 2

; support\_material\_interface\_spacing = 0.2

; support\_material\_interface\_speed = 100%

; support\_material\_pattern = rectilinear

; support\_material\_spacing = 2

; support\_material\_speed = 40

; support\_material\_synchronize\_layers = 0

; support\_material\_threshold = 55

; support\_material\_with\_sheath = 0

; support\_material\_xy\_spacing = 60%

; temperature = 215

; thin\_walls = 0

; threads = 4

; thumbnails = 16x16,220x124

; toolchange\_gcode =

; top\_fill\_pattern = rectilinear

; top\_infill\_extrusion\_width = 0.4

; top\_solid\_infill\_speed = 40

; top\_solid\_layers = 7

; top\_solid\_min\_thickness = 0.6

; travel\_speed = 150

; use\_firmware\_retraction = 0

; use\_relative\_e\_distances = 1

; use\_volumetric\_e = 0

; variable\_layer\_height = 1

; wipe = 1

; wipe\_into\_infill = 0

; wipe\_into\_objects = 0

; wipe\_tower = 0

; wipe\_tower\_bridging = 10

; wipe\_tower\_no\_sparse\_layers = 0

; wipe\_tower\_rotation\_angle = 0

; wipe\_tower\_width = 60

; wipe\_tower\_x = 170

; wipe\_tower\_y = 140

; wiping\_volumes\_extruders = 70,70

; wiping\_volumes\_matrix = 0

; xy\_size\_compensation = 0

; z\_offset = 0