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| G-code | Arguments | Description |
| M1112 | - | Home |
| G92 | Xx Yy Zz Ee | Set current position to specified values |
| G0 | Xx Yy Zz Ee | Rapid move to specified coordinates |
| G1 | Xx Yy Zz Ee Ff | Controlled move to coordinates; extrude/retract with E at feedrate f |
| M104 | Ss | Set extruder temperature to s degrees |
| M106 | Ss | Set fan speed to s (0-255) |
| M107 | - | Turn off fan |
| G28 | - | Move to origin (home) on all axes |
| G90 | - | Set to absolute positioning |
| G91 | - | Set to relative positioning |
| M84 | - | Disable all motors |
| M82 | - | Set extruder to absolute mode |
| M83 | - | Set extruder to relative mode |
| M2000 | - | Switch to line-mode (typically for laser engraving) |
| M888 | P0 - Pen holder  P1 - Laser engraving  P2 – Pneumatic  P3 - 3D printing  P6 - Rotary tool | Set current tool or mode |
| M112 | - | Emergency stop command |