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## **MKS TFT28 Wifi Communication Instruction**

Link: TCP socket

## Communication instruction

- 1. Each instruction ends with Enter button;
- All gcode instruction forwards directly to the motherboard, in addition to special instruction in attached list, but go back to "ok\r\n";
- 3. Send-receive explanation on special instruction format:

Instruction Type	Corresponding operation
Modify the current file	1. Return to"ok\r\n"
system:	2. Invoke connector of alter file system, the
M998 0: set the file system	parameter is 0 or 1
as U disk	
M998 1: set the file system	
as SD card	
Get the printer's current state:	Return state:
M997	1. "M997 IDLE\r\n": free
	2. "M997 PRINTING\r\n": printing
	3. "M997 PAUSE\r\n": pause printing
List gcode file:	<ol> <li>Return to "ok\r\n"</li> </ol>
M20 xxx	2. If xxx is empty, it means that lists the
	files in the root directory of the current
	system; otherwise, list the file by xxx
	designating
	3. Return to "Begin file list\r\n"
	4. return to filelist
	5. Return to "End file list\r\n"
Choose the specified	1. Return to "ok\r\n"
file (folder)	2. Invoke connector of the specified file,
M23 xxx.gcode	the parameter is xxx.gcode

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Start(recover) file printing M24 2. Invoke connector of starting(recovering) file printing M25 2. Invoke connector of pause file printing M26 2. Invoke connector of pause file printing M26 2. Invoke connector of pause file printing M26 2. Invoke connector of canceling printing file Report process of printing M27 2. Invoke connector of canceling printing file M27 2. Invoke connector of pause file printing file M27 3. Invoke connector of pause file printing file M27 3. Invoke connector of pause file printing file M20 xxx.gcode 3. Invoke connector of printing, and return to it by "M27 xxxl\n" format M2 xxx.gcode 4. Return to "ok\r\n" 2. Invoke connector of deleting file, the parameter is xxx.gcode 3. Invoke connector of the specified file, the parameter is xxx.gcode 3. Invoke connector of starting file printing M28 xxx.gcode 3. Invoke connector of starting file printing M28 xxx.gcode 3. Write the Data received into the file by additional data create file, the parameter is xxx.gcode 3. Write the Data received into the file by additional data 6. Return to "ok\r\n" 8.		" " " " " " " " " " " " " " " " " "
printing  Pause file printing  M25  2. Invoke connector of pause file printing  M26  Report process of printing  M27  2. Invoke connector of canceling printing file  Report process of printing  M27  2. Invoke connector of canceling printing file  Report process of printing  M27  2. Invoke connector on process report of printing, and return to it by "M27 xxxx\r\n" format  Delete file  M30 xxx.gcode  1. Return to "ok\r\n"  2. Invoke connector of deleting file, the parameter is xxx.gcode  Choose and print the specified file  M32 xxx.gcode  1. Return to "ok\r\n"  2. Invoke connector of the specified file, the parameter is xxx.gcode  3. Invoke connector of starting file printing  Start writing the specified file to current directory  M28 xxx.gcode  3. Invoke connector of opening file and create file, the parameter is xxx.gcode  3. Write the Data received into the file by additional data  Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Yyy is moving speed, unit: mm/min  Control Y-axis motion  G1 xxx F yyy  Yyy is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"		• •
Pause file printing M25 2. Invoke connector of pause file printing M26 2. Invoke connector of canceling printing file Report process of printing M27 2. Invoke connector of canceling printing file Report process of printing M27 2. Invoke connector on process report of printing, and return to it by "M27 xxx\r\n" format  Delete file M30 xxx.gcode 1. Return to "ok\r\n" 2. Invoke connector of deleting file, the parameter is xxx.gcode Choose and print the specified file M32 xxx.gcode 1. Return to "ok\r\n" 2. Invoke connector of the specified file, the parameter is xxx.gcode 3. Invoke connector of starting file printing Start writing the specified file to current directory M28 xxx.gcode 3. Write the Data received into the file by additional data Check temperature: M105 1. Return to "ok\r\n"	M24	_ : : :
M25   2. Invoke connector of pause file printing   1. Return to "ok\r\n"   2. Invoke connector of canceling printing file   1. Return to "ok\r\n"   2. Invoke connector of canceling printing file   1. Return to "ok\r\n"   2. Invoke connector on process report of printing, and return to it by "M27 xxx\r\n" format   1. Return to "ok\r\n"   2. Invoke connector of deleting file, the parameter is xxx.gcode   2. Invoke connector of deleting file, the parameter is xxx.gcode   3. Invoke connector of starting file printing   1. Return to "ok\r\n"   2. Invoke connector of starting file printing   3. Invoke connector of starting file printing   3. Invoke connector of starting file printing   4. Invoke connector of opening file and create file, the parameter is xxx.gcode   3. Invoke connector of opening file and create file, the parameter is xxx.gcode   3. Write the Data received into the file by additional data   4. Return to "ok\r\n"   4		
Cancel file printing M26  Report process of printing M27  2. Invoke connector of canceling printing file 1. Return to "ok\r\n" 2. Invoke connector on process report of printing, and return to it by "M27 xxx\r\n" format  Delete file M30 xxx.gcode 1. Return to "ok\r\n" 2. Invoke connector of deleting file, the parameter is xxx.gcode  Choose and print the specified file year and the parameter is xxx.gcode 1. Return to "ok\r\n" 2. Invoke connector of the specified file, the parameter is xxx.gcode 3. Invoke connector of starting file printing  Start writing the specified file to current directory M28 xxx.gcode 3. Invoke connector of opening file and create file, the parameter is xxx.gcode 3. Write the Data received into the file by additional data  Check temperature: 1. Return to "ok\r\n"  Return to "ok\r\n"  M38 xxx.gcode 3. Write the Data received into the file by additional data  Check temperature: 1. Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  M39 xxx.gcode  3. Write the Data received into the file by additional data  Check temperature: 1. Return to "ok\r\n"  Return to "ok\r\n"  M39 xxx.gcode  3. Write the Data received into the file by additional data  Check temperature: 1. Return to "ok\r\n"  Return to "ok\r\n"  M30 xxx.gcode 3. Write the Data received into the file by additional data  Check temperature: 1. Return to "ok\r\n"  Return to "ok\r\n"  M30 xxx.gcode 3. Write the Data received into the file by additional data  Check temperature: 1. Return to "ok\r\n"  Axx Fyyy  yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm/min  xxx is moving distance, unit: mm/min  xxx is moving distance, unit: mm/min  xxx is moving speed, unit: mm/min  xxx is moving speed, unit: mm/min	Pause file printing	1. Return to "ok\r\n"
M26   2. Invoke connector of canceling printing file	M25	2. Invoke connector of pause file printing
Report process of printing M27  2.Invoke connector on process report of printing, and return to "tok\r\n" 2.Invoke connector of deleting file, the parameter is xxx.gcode Choose and print the specified file M32 xxx.gcode Choose and print the specified file Choose connector of the specified file, the parameter is xxx.gcode Choose connector of starting file printing Choose connector of opening file and create file, the parameter is xxx.gcode Choose connector of opening file and create file, the parameter is xxx.gcode Choose connector of the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gcode Choose and print the specified file, the parameter is xxx.gco	Cancel file printing	1. Return to "ok\r\n"
Delete file  Delete file  M30 xxx.gcode  Choose and print the specified file to current directory M28 xxx.gcode  Check temperature:  M105  Check temperature:  M105  M06ify motion coordinates to absolute coordinates G91  M06ify motion coordinates to relative coordinates G90  Control X-axis motion G1 X xxx F yyy  X-axis go back to zero  Delete file  1. Return to "ok\r\n" 2. Invoke connector of the specified file, the parameter is xxx.gcode 3. Invoke connector of starting file printing 1. Return to "ok\r\n" 2. Invoke connector of opening file and create file, the parameter is xxx.gcode 3. Write the Data received into the file by additional data 1. Return to temperature string  M105  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  Xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm/min	M26	2. Invoke connector of canceling printing file
and return to it by "M27 xxx\r\n" format  Delete file  M30 xxx.gcode  Choose and print the specified file  M32 xxx.gcode  Choose and print the specified file  M32 xxx.gcode  Choose and print the specified file  Start writing the specified file to current directory  M28 xxx.gcode  Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates  G91  Modify motion coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Vanish and the parameter is to relative xxx F yyy  You so moving speed, unit: mm  G1 Y xxx F yyy  You so moving speed, unit: mm  G1 Z xxx F yyy  You so moving speed, unit: mm  G1 Z xxx F yyy  You so moving speed, unit: mm  G1 Z xxx F yyy  You so moving speed, unit: mm  G1 Z xxx F yyy  Return to "ok\r\n"	Report process of printing	1. Return to "ok\r\n"
Delete file  M30 xxx.gcode  Choose and print the specified file  M32 xxx.gcode  Choose and print the specified file  M32 xxx.gcode  Choose and print the specified file  M32 xxx.gcode  Start writing the specified file to current directory  M28 xxx.gcode  M28 xxx.gcode  M29 xxx.gcode  M20 xxx.gcode  M21 Return to "ok\r\n"  Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates to relative coordinates G90  Control X-axis motion  M34 xxx F yyy  Control Y-axis motion  M35 xxx is moving distance, unit: mm  M36 xxx F yyy  M37 xxx is moving distance, unit: mm  M38 xxx is moving distance, unit: mm  M39 xxx is moving distance, unit: mm  M30 xxx.gcode  1. Return to "ok\r\n"  M30 xxx.gcode  3. Invoke connector of the specified file, the parameter is xxx.gcode  3. Invoke connector of opening file and create file, the parameter is xxx.gcode  3. Write the Data received into the file by additional data  1. Return to "ok\r\n"  M84  Modify motion coordinates to absolute coordinates to relative coordinates  M30 xxx is moving distance, unit: mm  M30 xxx is moving speed, unit: mm/min	M27	2.Invoke connector on process report of printing,
Choose and print the specified file   2. Invoke connector of deleting file, the parameter is xxx.gcode   3. Invoke connector of starting file printing   1. Return to "ok\r\n"   2. Invoke connector of starting file printing   3. Invoke connector of starting file printing   3. Invoke connector of starting file printing   4. Return to "ok\r\n"   2. Invoke connector of opening file and create file, the parameter is xxx.gcode   3. Write the Data received into the file by additional data   3. Return to temperature string   4. Return to "ok\r\n"   4. Return to "ok\r\n"   5. Return to "ok\r\n"   6. Return		and return to it by "M27 xxx\r\n" format
parameter is xxx.gcode   Choose and print the specified file	Delete file	1. Return to "ok\r\n"
Choose and print the specified file  M32 xxx.gcode  Start writing the specified file to current directory  M28 xxx.gcode  Check temperature:  M36 Modify motion coordinates to absolute coordinates G90  Control X-axis motion  G1 X xxx F yyy  Control Y-axis motion  G1 Y xxx F yyy  Control Z-axis motion  G1 Z xxx F yyy  Y xxx goode  1. Return to "ok\r\n"  2. Invoke connector of starting file printing  1. Return to "ok\r\n"  2. Invoke connector of opening file and create file, the parameter is xxx.gcode  3. Write the Data received into the file by additional data  Create file, the parameter is xxx.gcode  3. Write the Data received into the file by additional data  Create file, the parameter is xxx.gcode  3. Write the Data received into the file by additional data  Return to "ok\r\n"  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"	M30 xxx.gcode	2. Invoke connector of deleting file, the
specified file  M32 xxx.gcode  M32 xxx.gcode  3. Invoke connector of the specified file, the parameter is xxx.gcode  3. Invoke connector of starting file printing  Start writing the specified file to current directory  M28 xxx.gcode  M28 xxx.gcode  Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates  G91  Modify motion coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Control Z-axis motion  G1 Z xxx F yyy  X-axis go back to zero  Return to "ok\r\n"  2. Invoke connector of the specified file, the parameter is xxx.gcode  3. Invoke connector of starting file printing  1. Return to "ok\r\n"  2. Invoke connector of starting file printing  1. Return to "ok\r\n"  Return to temperature string  1. Return to "ok\r\n"  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm/min  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"		parameter is xxx.gcode
the parameter is xxx.gcode 3. Invoke connector of starting file printing  Start writing the specified file to current directory  M28 xxx.gcode  Tun off motor M84  Modify motion coordinates to absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion G1 X xxx F yyy  Control Y-axis motion G1 Y xxx F yyy  X-axis go back to zero  Tun off starting file printing  1. Return to "ok\r\n"  Return to "ok\r\n"  Return to temperature string  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min	Choose and print the	1. Return to "ok\r\n"
3. Invoke connector of starting file printing  Start writing the specified file to current directory 2. Invoke connector of opening file and create file, the parameter is xxx.gcode 3. Write the Data received into the file by additional data  Check temperature: 1. Return to temperature string  M105  Turn off motor M84  Modify motion coordinates to absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion G1 X xxx F yyy  Control Y-axis motion G1 Y xxx F yyy  Yyy is moving distance, unit: mm G1 Y xxx F yyy  Yyy is moving speed, unit: mm/min  Control Z-axis motion G1 Z xxx F yyy  Yyy is moving distance, unit: mm G1 Z xxx F yyy  Yyy is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"	specified file	2. Invoke connector of the specified file,
Start writing the specified file to current directory M28 xxx.gcode  Check temperature: M105  Turn off motor M84  Modify motion coordinates to absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion G1 X xxx F yyy  Control Y-axis motion G1 Y xxx F yyy  Control Z-axis motion G1 Z xxx F yyy  X-axis go back to zero  1. Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  Return to "ok\r\n"  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min x-axis go back to zero  Return to "ok\r\n"	M32 xxx.gcode	the parameter is xxx.gcode
to current directory  M28 xxx.gcode  3. Write the Data received into the file by additional data  Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates  G91  Modify motion coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Control Y-axis motion  G1 Y xxx F yyy  Control Z-axis motion  G1 Z xxx F yyy  Yyy is moving speed, unit: mm/min  Control Z-axis motion  G1 Z xxx F yyy  Yyy is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"		3. Invoke connector of starting file printing
Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Control Y-axis motion  G1 Z xxx F yyy  X-axis go back to zero  Check temperature:  1. Return to temperature string  Return to "ok\r\n"  xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min xxx is moving distance, unit: mm yyy is moving speed, unit: mm/min  Return to "ok\r\n"	Start writing the specified file	1. Return to "ok\r\n"
3. Write the Data received into the file by additional data  Check temperature: M105  Turn off motor M84  Modify motion coordinates to absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion G1 X xxx F yyy  Control Y-axis motion G1 Y xxx F yyy  Control Z-axis motion G1 Y xxx F yyy  Control Z-axis motion G1 Z xxx F yyy  Xxx is moving distance, unit: mm Yyy is moving speed, unit: mm/min  Xxx is moving distance, unit: mm Yyy is moving speed, unit: mm/min  Control Z-axis motion Xxx is moving distance, unit: mm Xxx is moving distance, unit: mm Yyy is moving speed, unit: mm/min  Xxx is moving distance, unit: mm Xxx is moving distance, unit: mm Xxx is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"	to current directory	2. Invoke connector of opening file and
Additional data  Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates  G91  Modify motion coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Control Y-axis motion  G1 Y xxx F yyy  Control Z-axis motion  G1 Y xxx F yyy  Control Z-axis motion  G1 Y xxx F yyy  Control Z-axis motion  Control Z-axis motion  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Y-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Return to "ok\r\n"  Return to "ok\r\n"	M28 xxx.gcode	create file, the parameter is xxx.gcode
Check temperature:  M105  Turn off motor  M84  Modify motion coordinates to absolute coordinates  G91  Modify motion coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Control Y-axis motion  G1 Y xxx F yyy  Control Z-axis motion  G1 Y xxx F yyy  Control Z-axis motion  Control Z-axis motion  Control Z-axis motion  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Control Z-axis motion  Xxx is moving distance, unit: mm  Min  Return to "ok\r\n"		3. Write the Data received into the file by
Turn off motor  M84  Modify motion coordinates to absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion G1 X xxx F yyy  Control Y-axis motion G1 Y xxx F yyy  Xxx is moving distance, unit: mm G1 Y xxx F yyy  Xxx is moving distance, unit: mm G1 Y xxx F yyy  Xxx is moving distance, unit: mm G1 Y xxx F yyy  Xxx is moving distance, unit: mm X-axis go back to zero  Return to "ok\r\n"		additional data
Turn off motor  M84  Modify motion coordinates to absolute coordinates to relative coordinates  G90  Control X-axis motion  G1 X xxx F yyy  Control Y-axis motion  G1 Y xxx F yyy  Control Z-axis motion  G1 X xxx F yyy  Xxx is moving distance, unit: mm  G1 Y xxx F yyy  Xxx is moving distance, unit: mm  G1 Y xxx F yyy  Xxx is moving distance, unit: mm  Yyy is moving speed, unit: mm/min  Xxx is moving distance, unit: mm  Xxx is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"	Check temperature :	1. Return to temperature string
M84  Modify motion coordinates to absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion	M105	
Modify motion coordinates to absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion	Turn off motor	Return to "ok\r\n"
absolute coordinates G91  Modify motion coordinates to relative coordinates G90  Control X-axis motion	M84	
Modify motion coordinates to relative coordinates G90  Control X-axis motion	Modify motion coordinates to	Return to "ok\r\n"
Modify motion coordinates to relative coordinates  G90  Control X-axis motion	absolute coordinates	
relative coordinates G90  Control X-axis motion	G91	
Control X-axis motion  G1 X xxx F yyy  Control Y-axis motion  G1 Y xxx F yyy  Yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm  yyy is moving speed, unit: mm/min  xxx is moving speed, unit: mm/min  xxx is moving distance, unit: mm/min  xxx is moving distance, unit: mm  G1 Z xxx F yyy  yyy is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"	Modify motion coordinates to	Return to "ok\r\n"
Control X-axis motion  G1 X xxx F yyy  yyy is moving speed, unit: mm/min  Control Y-axis motion  G1 Y xxx F yyy  yyy is moving distance, unit: mm  yyy is moving speed, unit: mm/min  Control Z-axis motion  xxx is moving distance, unit: mm/min  xxx is moving distance, unit: mm  yyy is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"	relative coordinates	
G1 X xxx F yyy  yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm  G1 Y xxx F yyy  yyy is moving speed, unit: mm/min  xxx is moving distance, unit: mm/min  xxx is moving distance, unit: mm  yyy is moving speed, unit: mm/min  X-axis go back to zero  Return to "ok\r\n"	G90	
Control Y-axis motion xxx is moving distance, unit: mm G1 Y xxx F yyy yy is moving speed, unit: mm/min  Control Z-axis motion xxx is moving distance, unit: mm G1 Z xxx F yyy yy is moving speed, unit: mm/min  X-axis go back to zero Return to "ok\r\n"	Control X-axis motion	xxx is moving distance, unit: mm
G1 Y xxx F yyy yyy is moving speed, unit: mm/min  Control Z-axis motion xxx is moving distance, unit: mm  G1 Z xxx F yyy yyis moving speed, unit: mm/min  X-axis go back to zero Return to "ok\r\n"	G1 X xxx F yyy	yyy is moving speed, unit: mm/min
Control Z-axis motion xxx is moving distance, unit: mm G1 Z xxx F yyy yy is moving speed, unit: mm/min X-axis go back to zero Return to "ok\r\n"	Control Y-axis motion	xxx is moving distance, unit: mm
G1 Z xxx F yyy yyy is moving speed, unit: mm/min X-axis go back to zero Return to "ok\r\n"	G1 Y ххх F ууу	yyy is moving speed, unit: mm/min
X-axis go back to zero Return to "ok\r\n"	Control Z-axis motion	xxx is moving distance, unit: mm
	G1 Z xxx F yyy	yyy is moving speed, unit: mm/min
G28 X0	X-axis go back to zero	Return to "ok\r\n"
, · · · · · · · · · · · · · · · · · · ·	G28 X0	

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Y-axis back to zero	Return to "ok\r\n"
G28 Y0	
Z-axis back to zero	Return to "ok\r\n"
G28 Z0	
Tri-axial back to zero	Return to "ok\r\n"
G28	
Control the printhead out	xxx is extrusive distance , unit: mm
G1 Exxx Fyyy	yyy is extrusive speed, unit: mm/min
Set printhead temperature	xxx is degree centigrade
M104 Sxxx	
Set heated-bed temperature	xxx is degree centigrade
M140 Sxxx	

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