1. Start

G15

M104 T0 S150 ; start heating the extruder now to save time

G92 Y0

G28 ; first home

G28 ; second home

G0 Z.3 X98 F2000 ; move extruder to edge of build plate

M107 ; fan off

G90 ; relative

M82 ; mm units

M104 T0 S185 ; set extruder temp

G92 E-15 ; set inital position of extruder

M109 T0 S185 ; wait for temp

G0 E0 ; repopulate extruder

M106 S255 ; turn on fan

G0 Z.3 Y15 X98 E5 F300 ; repopulate extruder and extrude test pile

G0 Y30 E10 F300; move extruder back to build plate

G92 E0 ; reset extruder

M106 S255

G16

1. End

G15

G91 ; Relative positioning

T0

G1 E-15 F1500; remove filament from melt chamber

;G1 Z10;

M104 T0 S0

G90 ; Absolute positioning

G92 Y0 Z0 E0; Reset position

G28 X ; home the x axis

G0 Y180 X95 ; move build plate to present part

M84 ; Turn steppers off

M107 ; Turn off fan

G92 Y0

G16