```
G1 X10 Y10              move to X10 Y10
G28                     go home
G94                     switch to Rectangular coordinate system
G95                     switch to Angle coordinate system
M3                      pen down
M3S20                   pen move to 20°
M5                      pen up
M4 L10 T40              Set up default pen down angle (L) default pen up angle(T)
M203 X2000 Y2000        max feedrate
M201 X1000 Y1000        acceleration
M205 X0.8               motor jerk
M503                    View parameters
M501                    load EEPROM parameters
M502                    Restore factory settings
M500                    Save current settings,use this instruction for modification of each parameter
M369 X10 Y10            set current position to X10 Y10
M370                    set current position to X0 Y0,same as M369 X0 Y0
```