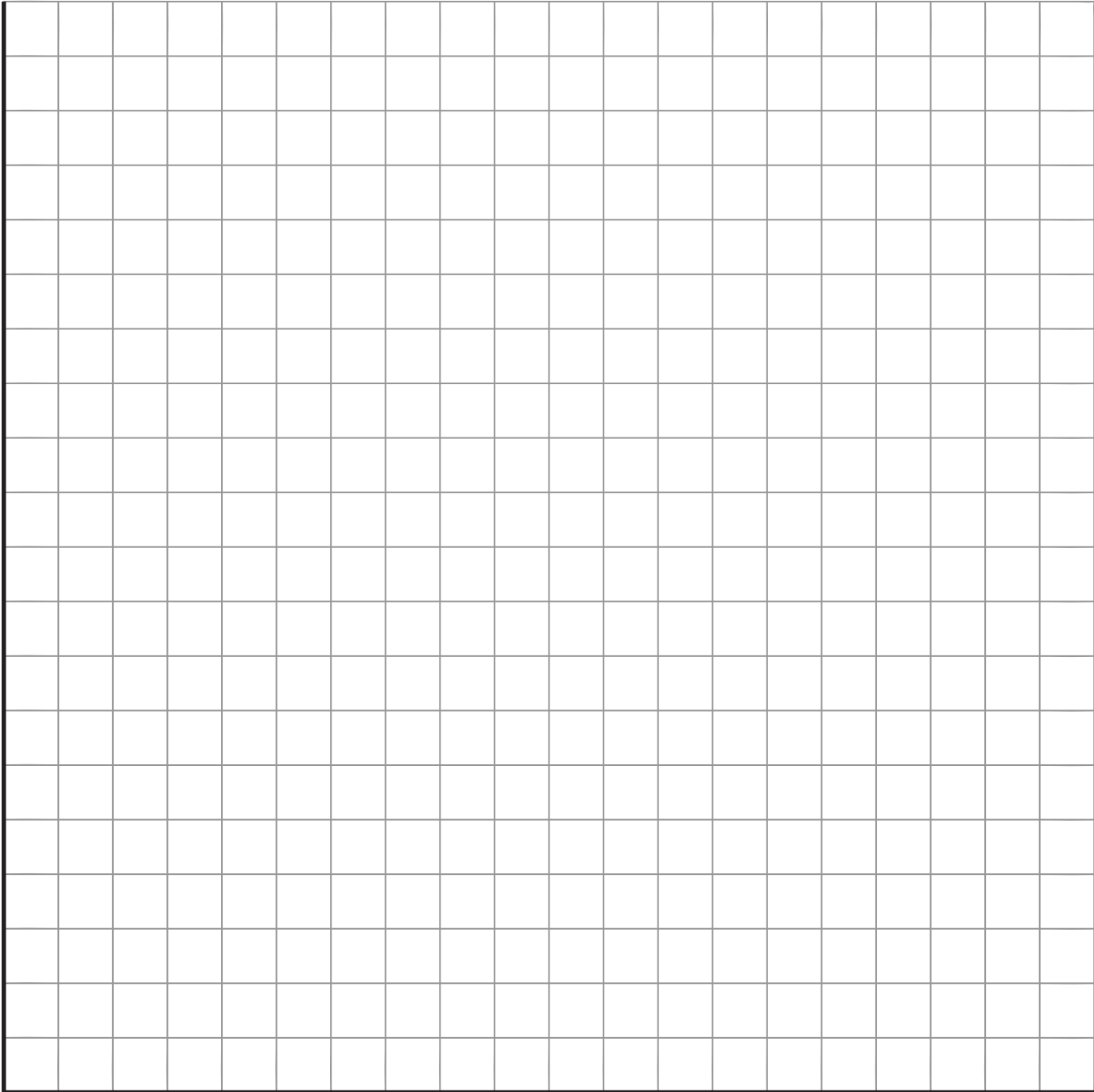


# 2D

Layer: \_\_\_\_\_

Height: \_\_\_\_\_

**y**

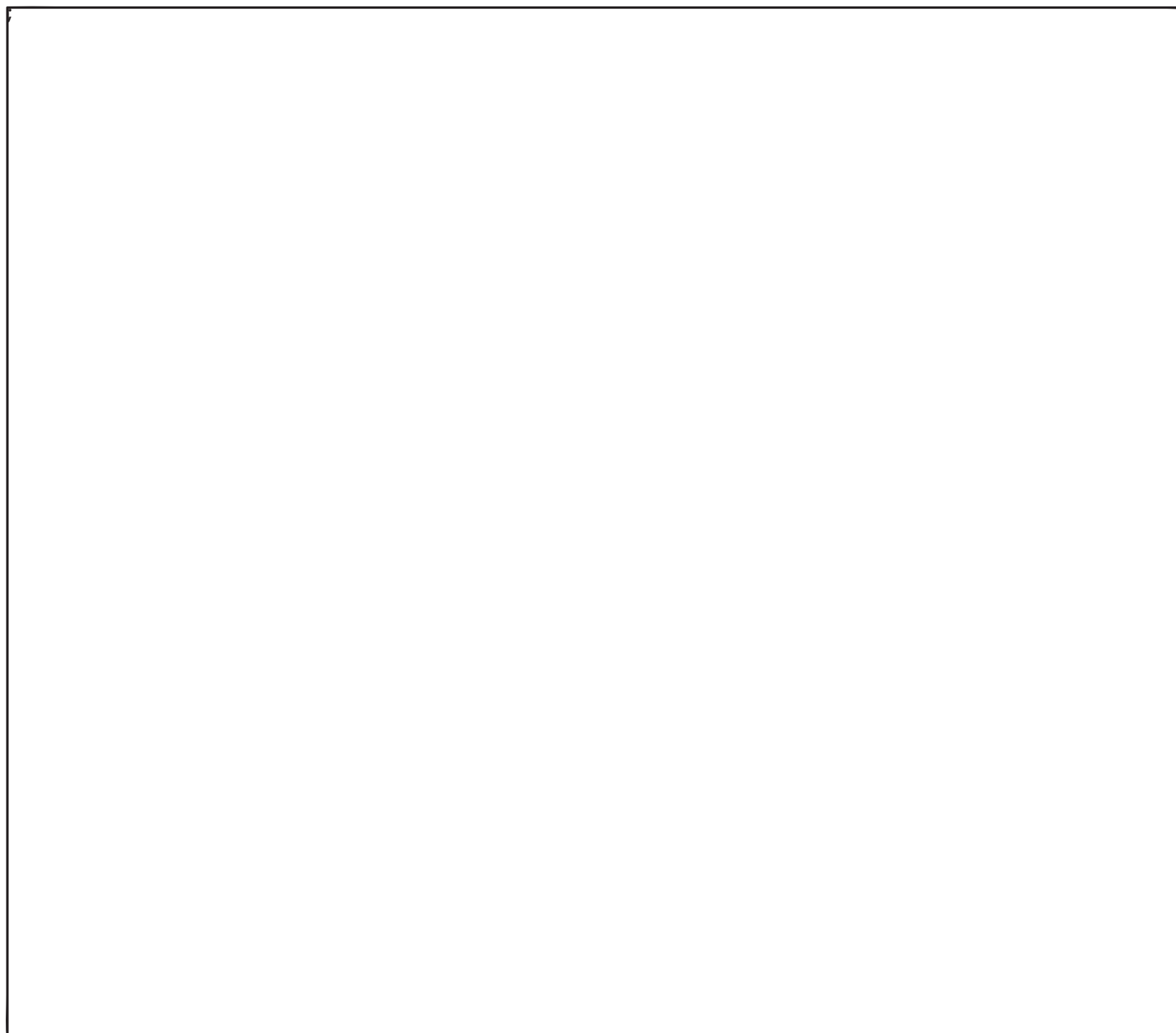


**(0,0,z)**

**x**

```
;start  
G21 "start mm"  
M107 "turn off fan"  
G28 "auto home x,y,z"  
G92 E0 "set home position"  
M82 "set E absolute 0"  
M104 S245 "set hot end temperature 245 celsius"  
M190 S87 "wait for bed temperature"
```

```
;body
```



```
end  
G1 X1 Y1 Z6 E0 ;F60  
M400 "wait until all movements are finished"  
M104 S0 "set hot end temperature to 0 celsius"  
G28 X Y "home position in X and Y direction"  
M84 "disable steppers"
```

# 3D

