

G21 ;metric values

G90 ;absolute positioning

M82 ;set extruder to absolute mode

M107 ;start with the fan off

G28 X0 Y0 ;move X/Y to min endstops

G28 Z0 ;move Z to min endstops

G1 Z15.0 F9000 ;move the platform down 15mm

G92 E0 ;zero the extruded length

G1 F200 E3 ;extrude 3mm of feed stock

G92 E0 ;zero the extruded length again

G1 F9000;Put printing message on LCD screen

M117 Printing..0