

I 3D 打印Gcode文件

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| 1 | <code>;This is a comment</code> | “;”后面的语句为注释 |
| 2 | <code>M190 S70</code> | 设置热床目标温度70°C, 等待达到目标温度后再处理下一条指令 |
| 3 | <code>M104 S205</code> | 设置喷嘴目标温度205°C, 继续执行下一条指令, 不等待目标温度达到 |
| 4 | <code>M109 S205</code> | 设置喷嘴目标温度205°C, 等待达到目标温度后再处理下一条指令 |
| 5 | <code>E82</code> | 用来覆盖G91效果, 让挤出机处于绝对坐标运动模式 |
| 6 | <code>G28</code> | 所有轴回零 |
| 7 | <code>G28 X0 Y0</code> | X和Y轴回零 |
| 8 | <code>G1 Z15.0 F3000</code> | 设置后续所有运动速度为3000mm/min, 然后Z轴运动到坐标15 |
| 9 | <code>G1 X10.0 Y10.0</code> | 运动到坐标X10 Y10 |
| 10 | <code>G92 E0</code> | 设置挤出机当前坐标为0 |
| 11 | <code>G1 F200 E3</code> | 以200mm/min的速度将挤出机运动到3mm位置 |
| 12 | <code>M107</code> | 关闭模型冷却风扇 |
| 13 | <code>G0 F1500 X-5 Y-2 Z0.3</code> | 设置后续所有运动速度为1500mm/min, 然后运动到坐标X-5 Y-2 Z0.3位置, 对于MOOZ, G1和G0没有区别 |
| 14 | <code>G1 F675 X-8 Y-7 E0.1</code> | 设置后续所有运动速度为675mm/min, 然后运动到坐标X-8 Y-7, 同时挤出机运动到0.1位置 |
| 15 | <code>M140 S70</code> | 设置热床目标温度70°C, 继续执行下一条指令, 不等待目标温度达到 |
| 16 | <code>M106 S255</code> | 设置模型冷却风扇速度 (0-255) 到最大, 对于MOOZ, 可以用M3取代M106指令 |

II Laser Engraving Gcode File

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| 1 | <code>M106 S0</code> | 设置激光强度 (0-255) 到0, 即关闭激光, 对于MOOZ, 可以用“M3 S0”或“M5”取代该指令 |
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III CNC Carving Gcode File

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| 1 | <code>G21</code> | 设置单位为mm, 由于mm是指令坐标解析默认单位, 这条代码是可有可无的 |
| 1 | <code>M106 S0</code> | 设置主轴转速 (0-255) 到0, 即关闭主轴, 对于MOOZ, 可以用“M3 S0”或“M5”取代该指令 |

更多详细解释, 请参考: <http://marlinfw.org/meta/gcode/>

I 3D Printing Gcode File

1	<code>;This is a comment</code>	Sentence started with “;” is comment
2	<code>M190 S70</code>	Set bed target temperature to 70°C, block new commands from the host until temperature is reached
3	<code>M104 S205</code>	Set nozzle temperature to 205°C, and continue without waiting
4	<code>M109 S205</code>	Set nozzle temperature to 205°C, wait until temperature is reached before processing new commands
5	<code>E82</code>	Used to overwrite G91 and put Extruder motion into absolute mode
6	<code>G28</code>	Auto home all axes
7	<code>G28 X0 Y0</code>	Auto home X and Y axes only
8	<code>G1 Z15.0 F3000</code>	Set all feedrate for all subsequent moves to 3000mm/min, and move to coordinate 15.0 on Z axis
9	<code>G1 X10.0 Y10.0</code>	Move to coordinate X10.0 Y10.0
10	<code>G92 E0</code>	Set extruder current position to 0
11	<code>G1 F200 E3</code>	Set feedrate to 200mm/min and move extruder axes to 3
12	<code>M107</code>	Turn print cooling fan off
13	<code>G0 F1500 X-5 Y-2 Z0.3</code>	Set feedrate to 1500mm/min and move to coordinate X-5 Y-2 Z0.3, G0 and G1 work in the same way for MOOZ
14	<code>G1 F675 X-8 Y-7 E0.1</code>	Set feedrate to 675mm/min and move to coordinate X-8 Y-7, extrude to 0.1mm position at the same time
15	<code>M140 S70</code>	Set bed target temperature to 70°C, and continue without waiting
16	<code>M106 S255</code>	Set print cooling fan speed (0-255) to Maximum, M3 can replace M106 since they are parsed the same way for MOOZ

II Laser Engraving Gcode File

1	<code>M106 S0</code>	Set laser intensity (0-255) to 0, i.e. turn the laser off. Use “M3 S0” or “M5” will achieve the same effect
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III CNC Carving Gcode File

1	<code>G21</code>	Set units to mm, since mm is default unit, this command is expendable
1	<code>M106 S0</code>	Set spindle speed (0-255) to 0, i.e. turn the spindle off. Use “M3 S0” or “M5” will achieve the same effect

For more information, please refer to: <http://marlinfw.org/meta/gcode/>