

44 ; Mon Apr 03 2023 14:40:48

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46 T0 WHAT DOES "T0" DO HERE AT THE BEGINNING?

47 M82 ;absolute extrusion mode

48 ;--- Start G-code Begin ---

49 M205 J0.05 ADVANCED SETTINGS, WHAT DOES "J0.5" DO?

50 M201 X10000 Y10000 Z100 E10000 PRINTER MOVING LIMIT

51 M204 P1000 T2000 R10000 ACCELERATION SETTINGS WHAT IS "P", "T" & "R" STAND FOR?

52 M900 T0 K0.035
53 M900 T1 K0.035 WHAT DOES "T0" & "T1" MEAN FOR LINEAR ADVANCE. ALSO, WHAT IS THE K-FACTOR DO?

54 M104 S200 ;Set Hotend Temperature

55 M140 P0 S70 ;Set Bed Temperature

56 M109 S200 ;Wait Hotend Temperature

57 M190 P0 S70 ;Set Bed Temperature

58 M107 TURN FAN OFF

59 M107 P1 TURN FAN OFF WHAT DOES THE "P1" FOR INDEX DO?

60 G28 GO TO HOME POINT

61 G0 Z0.5 X0 Y-0.5 F6000 GO TO Z0.5, X0, Y-0.5 AT A RATE OF F6000

62 G92 E0 RESET EXTRUSION BACK TO "0"

63 G0 X150 E30 F1200 IS THE "30" HERE MILIMETERS? IS THE RATE (F1200) IN WHICH THE HEAD MOVES OR THE RATE OF EXT

64 G92 E0 RESET EXTRUSION BACK TO "0"

65 G1 Z5 F6000 GO TO Z5 AT A RATE OF F6000

66 ;--- Start G-code End ---

67 G92 E0
68 G92 E0 WHY DOES IT APPARENTLY RESET THE EXTRUSION COUNTER TWICE HERE?

69 G1 F2100 E-1

70 ;LAYER_COUNT:199

71 ;LAYER:0

72 M107

73 M204 S1000

74 G1 F600 Z1.28

75 G0 F3600 X166.349 Y229.328 Z1.28

76 ;TYPE:SKIRT

77 G1 F600 Z0.28

78 G1 F2100 E0

79 G1 F1500 X166.788 Y229.061 E0.03589

80 G1 X167.263 Y228.867 F0.07173