

## RepRap Ormerod GCode Cheat Sheet (based on dc42 firmware) 1st Feb 2015 v1.10

Comm.	Parameters	Description	Example	Comment
G1	[X/Y/Z/E]	Position Feed [F]	Controlled Movement	G1 F150 X10
G4	Time in ms [P]	Dwell / Wait	G4 P500	
G10	Pn [RS]	Set Offsets	G10 P1 S100	Set standby(R) or Active(S) Temp (XYZ not done)
G20	none	Set units to inch	G20	
G21	none	Set units to mm	G21	
G28	[X/Y/Z]	Home	G28 X Y	
G30	Pn [X/Y/Z]	Z Probe set at defined position	G30 P0 X60 Y20 Z0.0	
G31	Z P	Return / set Probe at current position	G31 Z0.75 P596	Set Z home value or return current probe value
G32	none	Multiple Z Probe Auto bed compensation	G32	M557 sets up 4 compensation points
G90	none	Absolute Positioning	G90	
G91	none	Relative Positioning	G91	
G92	[X/Y/Z/E] Val	Set Position to value	G92 X5 Y10	
M0	none	Stops everything after buffer is empty	M0	
M1	none	Sleep	M1	
M18	none	Disable all stepper motors	M18	
M20	none	List files in gcodes folder of the SD Card	M20	
M23	Filename	Select File for Printing	M23 print.gco	
M24	none	Start / Resume SD Card Print	M24	
M25	none	Pause SD Card Print	M25	
M26	Sn	Set SD file position	M26 S1000	
M27	none	Report SD Print status	M27	
M28	Filename	Write program to SD Card gcodes folder	M28 print.g	
M29	Filename	Stop writing program to SD Card	M29 print.g	
M32	Filename	Select file for printing and go	M32 print.gco	
M36	Filename	Return file information	M36 print.gco	
M37	S	Simulation mode	M37 S	S toggles simulation, No S returns result
M80	none	Turn on ATX Power	M80	
M81	none	Turn off ATX Power	M81	
M82	none	Extruder absolute positioning	M82	
M83	none	Extruder relative positioning	M83	
M84	none	Stop idle hold	M84	
M85	none	Set inactive time	M85	No action
M92	XSteps_per_unit	Set steps per unit	M92 X123	
M98	PFilename	Run macro (gcode file in sys folder)	M98 Pmacro.g	
M99	none	Return result of M98 macro	M99	
M104	STemperature	Set extruder temperature (not waiting)	M104 S100	
M105	none	Get extruder Temperature	M105	
M106	Sspeed	Set Fan Speed to S and start	M106 S123	S is value 0-255
M107	none	Turn Fan off	M107	Deprecated. Use M106 S0
M109	S	Set Temp and wait	M109 S180	Deprecated. Set temp and use M116
M110	Line Number[N]	Set current line number		(next line number = line no. +1) N123 M110
M111	SDebugLevel	Set Debug Level	M111 S0	0=off,1=on,2=report
M112	none	Emergency Stop (Stop immediately)	M112	
M114	none	Get Current Position	M114	Deprecated
M115	none	Get Firmware Version and Capabilities	M115	
M116	none	Wait for ALL temperatures	M116	
M117	none	Marlin LCD message	M117	Does nothing treated as invalid M code
M119	Xn,Yn,Zn	Set End stops	M119	
M120	none	Push	M120	Saves abs/rel, feed rate and filename
M121	none	Pop	M121	Restores values from M120
M122	none	Run Diagnostics	M122	

M126	PTime	Open extruder valve / wait for P ms		No action
M127	PTime	Close extruder valve / wait for P ms		No action
M135	none	Set PID sample interval		No action
M140	STemperature	Set heated bed temperature (not waiting)	M140 S55	
M141	STemperature	Set chamber temperature (not waiting)	M141 S30	Not supported
M190	STemperature	Set extruder temperature and wait (like 109)	M190 S180	
M201	[X/Y/Z]	Set maximum accelerations	M201 X800 Y800 Z5 E250	
M203	[X/Y/Z/E]	Set maximum velocity/feed rates	M203 X12000 Y12000 Z180 E2700	
M205	none	No action		
M206	[X/Y/Z]	Offset Axes	M206 X10 Y10	
M208	[X/Y/Z] [S1]	Set maximum or minimum Axis lengths	M208 X200 Y210 Z180	Normally sets maximum, add S1 to set minimums
M210	[X/Y/Z]	Set homing feed rates	M210 X1000 Y1500	
M220	Soverride	Set Speed factor override percentage	M220 S80	
M221	Soverride	Set Extrude factor override percentage	M221 S80	
M301	[PIDWB]	Set hot end PID values	M300 S300 P1000	
M302		Allow cold extrudes	M302	No action
M304	[PIDWB]	Set heated bed PID values		
M305	P[TBRLH]	Set Heater parameters	M305 P0 H40	T(25 r), B(beta), R(SeriesR), HL( ADC high low offsets)
M500	M500	Store parameters in EEPROM	M500	
M501	M501 [Sn]	Load parameters from EEPROM	M501	If S then set Autosave
M502	M502	Revert to factory defaults	M502	
M503	none	List config set up	M503	
M540	M540 Pmac	Set report Mac address	M540 P00:01:02:03:04:05	
M550	PName	SetMachine name	M550 POrmerod	
M551	Ppassword	Set Web password	M55 Ppassword	Password not used by lamBurny web code
M552	PIPAddr	Get/Set IP address	M552 P192.168.0.42	
M553	PNetmask	Get/Set netmask	M553 P255.255.255.0	
M554	PGateway	Get/Set gateway	M554 P192.168.0.1	
M555	Pn	Emulate Firmware	M555 P2	
M556	[S/X/Y/Z]	Set Orthogonal Axis compensation	M556 S78 X-0.65 Y0.9 Z0.2	S=Length, X=XY, Y=YZ, Z= XZ
M557	P[0,1,2,3] X Y	Set Auto compensation co-ordinates	M557 P0 X60 Y0	Use in conjunction with G32
M558	P	Set Z probe type	M558 P1	1 IR, 2 Modulated IR, 3 Ultrasonic
M559	Pfilename	Upload config.g	M559 Pconfig.g	
M560	Pfilename	Upload reprep.htm	M560 Preprep.htm	
M561		Set Identity transform	M561	Cancels compensation
M562	P	Reset temperature fault	M562 P1	0=bed,1=extruder. To be used with caution
M564	Slimit	Enable/Disable axis limit checks	M564 S0	0=disable, 1=enable
M566	M566	Set / Get maximum jerk rates		
M567	M567	Set/report tool mix ratios		
M568	M568 Pn Sn	Turn on/off automatic tool mixing		
M569	M569 Pn Sn	Set/report axis direction		
M570	Sn	Set/report heater timeout		
M572	M572 Pn Sn	Set/report elastic compensation		
M574	[X/Y/Z] [S1]	Configure end stop	M574 X0 Y2 Z0 S1	
M575	M575 P B S	Configure Serial Comms		
M665	M665 L R B H	Set Delata configuration		
M666	M666 X Y Z	Set Delta endstops		
M906	[X/Y/Z/E]	Set motor currents	M906 X800 Y800 Z800 E900	
M998	P	Request resend of line	M998 P34	
M999		Reset	M999	Waits 0.5 second and resets
T	N	Select extruder no. (starts with 0)	T1	