

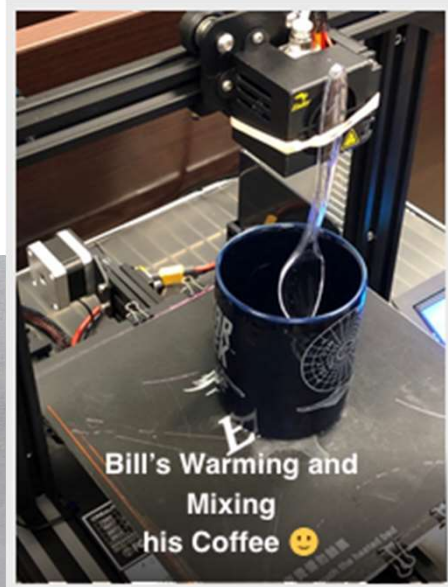


# ENDER ALUMNI WORKFLOW

Bill Mixed and Stirred

## Gcode Unplugged

April 2024



```
;FLAVOR:Marlin  
;  
; Ender-3 Tester  
G90 ;absolute positioning  
G28 ;auto home  
M140 S70 ;Heat bed to 70 degrees  
M117 Heating Bed  
G0 Z50  
M117 Attach Spoon  
G4 S30  
G0 Z212  
G0 X130 Y 140  
G0 Z135  
M117 Stirring  
G2 J10  
G3 J10  
G2 J10  
G3 J10  
G0 Z212  
G0 Y 245  
M140 S0 ; turn off heat to bed  
M117 Enjoy!  
;End of Gcode
```



NC Viewer v1.1.3



GCode File

```
1 g0 x0 y0
2 g1 x3
3 g1 y3
4 g1 x0
5 g1 y0
```

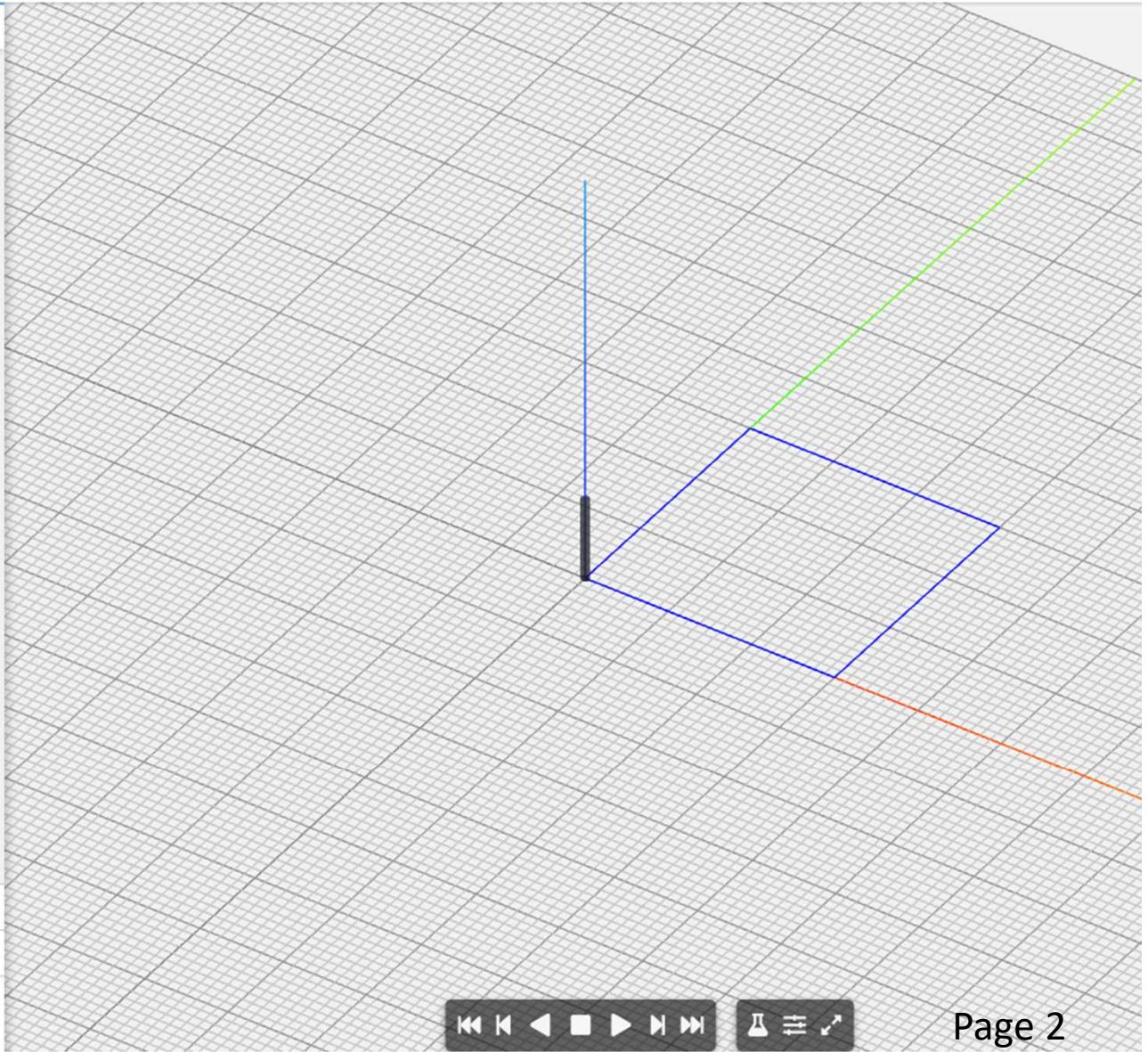


Digital Read Out

Machine Options

Plot Orientation: Vertical (Z-Up)

Diameter Mode (Lathe)







# PoorMan's Filament Dryer

```
1 ;FLAVOR:Marlin
2 ;
3 ;Filament Dryer Routine
4 ; 17APR2024 TPM comments embellished for GCode review at Alumni.
5
6 ; Set Bed temp
7 G90 ;absolute positioning
8 G28 ; Home all axis
9 ; mOVE TO MAKE CLEARANCE FOR bOX
10 G1 Z5 ; clear Z so doesn't drag on bed
11 G1 X5 Y100 ; move Y to middle, x off to the side
12 G1 Z185 ; Move Z to clear dryer box
13 M117 PLACE FILAMENT AND BOX ; put out message
14 M0 ; stop and wait for acknowledgement
15 ; HEAT UP BED
16 M140 ; SET BED TEMP
17 M190 S70 ; WAIT FOR UP TO TEMP
18 ;WAIT FOR 2 HOURS BY WAITING 120 MINUTES
19 M117 COOKING...
20 G4 S60 ; 60 SECONDS = ONE MINUTE 1
21 G4 S60 ; 60 SECONDS = ONE MINUTE 2
22 G4 S60 ; 60 SECONDS = ONE MINUTE 3
23 G4 S60 ; 60 SECONDS = ONE MINUTE 4
24 G4 S60 ; 60 SECONDS = ONE MINUTE 5
25 G4 S60 ; 60 SECONDS = ONE MINUTE 6
26 G4 S60 ; 60 SECONDS = ONE MINUTE 7
27 G4 S60 ; 60 SECONDS = ONE MINUTE 8
28 G4 S60 ; 60 SECONDS = ONE MINUTE 9
29 G4 S60 ; 60 SECONDS = ONE MINUTE 10
30 M117 10+ MINUTES
31 ;
32 G4 S600 ; 600 SECONDS = TEN MINUTES
33 M117 20+ MINUTES
34 .
```



# PoorMan's Filament Dryer

```
34 ;
35 G4 S600 ; 600 SECONDS = TEN MINUTEs
36 M117 30+ MINUTES
37 ;
38 G4 S600 ; 600 SECONDS = TEN MINUTEs
39 M117 40+ MINUTES
40 ;
41 G4 S600 ; 600 SECONDS = TEN MINUTEs
42 M117 50+ MINUTES
43 ;
44 G4 S600 ; 600 SECONDS = TEN MINUTEs
45 ;
46 M117 FIRST HOUR+ MINUTES
47 ; SECOND HOUR
48 G4 S3000 ; 3600 SECONDS = 6*TEN MINUTEs = 1 hour
49 ;
50 M117 Less than 10 minutes to go!
51 G4 S600 ; 600 SECONDS = TEN MINUTEs
52 ;
53 M140 S0 ;heated bed heater off
54 M117 FINISHED!!
55 M0 ; stop for operator to acknowledge
56 ;End of Gcode
57
```