



RepRap GCode Cheat Sheet

Comm. Parameters	Description	Example	
G0	Axis [X/Y/Z] Position	Rapid Movement	G0 X50
G1	Axis [X/Y/Z/E] Position Feed [F]	Controlled Movement	G1 F150 X10
G4	Time in ms [P]	Dwell / Wait	G4 P500
G20	none	Set units to inch	G20
G21	none	Set units to mm	G21
G28	<Axis [X/Y/Z]>	Home	G28 X Y
G90	none	Absolute Positioning	G90
G91	none	Relative Positioning	G91
G92	Axis [X/Y/Z/E] Value	Set Position to value	G92 X5 Y10

Comm. Parameters	Description	Example	
M0	none	Stops everything after buffer is empty	M0
M17	none	Enable all stepper motors	M17
M18	none	Disable all stepper motors (move freely)	M18
M20	none	List files at the root folder of the SD Card	M20
M21	none	Initialise (mount) SD Card	M21
M22	none	Release (unmount) SD Card	M22
M23	Filename	Select File for Printing	M23 print.gco
M24	none	Start / Resume SD Card Print (see M23)	M24
M25	none	Pause SD Card Print (see M24)	M25
M26	Bytes[S]	Set SD Position in bytes	M26 S12345
M27	none	Report SD Print status	M27
M28	Filename	Write programm to SD Card	M28 print.gco
M29	Filename	Stop writing programm to SD Card	M29 print.gco
M40	none	Eject part (if possible)	M40
M41	none	Loop Programm(Stop with reset button!)	M41
M42	none	Stop if out of material (if supported)	M42
M43	none	Like M42 but leave heated bed on (if supported)	M43
M80	none	Turn on ATX Power (if necessary)	M80
M81	none	Turn off ATX Power (if necessary)	M81
M84	none	Stop idle hold (DO NOT use while printing!)	M84
M92	Steps_per_unit[X]	Programm set S steps per unit (resets)	M92 X123
M101	none	Set extruder 1 to forward (outdated)	M101
M102	none	Set extruder 1 to reverse (outdated)	M102
M103	none	Turn all extruders off (outdated)	M103
M104	Temperature[S]	Set extruder temperature (not waiting)	M104 S100
M105	none	Get extruder Temperature	M105
M106	<PWM Value[S 0-255]>	Set Fan Speed to S and start	M106 S123
M107	none	Turn Fan off	M107
M108	none	Set extruder speed (outdated)	M108
M109	Temperature[S]	Set extruder Temperature (waits till reached)	M109 S123
M110	Line Number[N]	Set current line number (next line number = line no. +1)	N123 M110
M111	Debug Level [S]	Set Debug Level	M111 S6
M112	none	Emergency Stop (Stop immediately)	M112
M113	<PWM [S]>	Set Extruder PWM to S (or onboard potent. If not given)	M113 S0.7
M114	none	Get Current Position	M114
M115	none	Get Firmware Version and Capabilities	M115
M116	none	Wait for ALL temperatures	M116
M117	none	Get Zero Position in steps	M117
M119	none	Get Endstop Status	M119
M126	Time[P]	Open extruder valve (if available) and wait for P ms	M126 P500
M127	Time[P]	Close extruder valve (if available) and wait for P ms	M127 P500
M128	PWM[S]	Set internal extruder pressure S255 eq max	M128 S123
M129	Time[P]	Turn off extruder pressure and wait for P ms	M129 P500
M140	Degrees[S]	Set heated bed temperature to S (not waiting)	M140 S55
M141	Degrees[S]	Set chamber temperature to S (not waiting)	M141 S30
M142	Pressure[S]	Set holding pressure to S bar	M142 S1
M143	Degrees[S]	Set maximum hot-end temperture	M143 S275

M160	No.[S]	Set number of materials extruder can handle	M160 S4
M203	Offset[Z]	Set Z offset (stays active even after power off)	M203 Z-0.1
M226	none	Pauses printing (like pause button)	M226
M227	Steps[P/S]	Enables Automatic Reverse and Prime	M227 P1500 S1500
M228	none	Disables Automatic Reverse and Prime	M228
M229	Rotations[P/S]	Enables Automatic Reverse and Prime	M229 P1.0 S1.0
M230	[S]	Enable / Disable wait for temp.(1 = Disable 0 = Enable)	M230 S1
M240	none	Start conveyor belt motor	M240
M241	none	Stop conveyor belt motor	M241
M245	none	Start cooler fan	M245
M246	none	Stop cooler fan	M246
M300	Freq.[S] Duration[P]	Beep with S Hz for P ms	M300 S300 P1000
T	No.	Select extruder no. (starts with 0)	T1