

//GCode for Drawing Pancakes

//01 Header

G21; Set Units to MM
G1 F7600; Set Speed to 7600 mm per minute
M107; Turn Batter Dispenser off to stop batter flow
G28; Home All Axis

//02 Drawing Code

G00 X30 Y30; Move bottle to coordinates (30,30)
M106; Start Dispensing Batter
G00 X130 Y30; Move bottle to coordinates (130,30)
G00 X130 Y130; Move bottle to coordinates (130,130)
G00 X30 Y130; Move bottle to coordinates (30,130)
G00 X30 Y30; Move bottle to coordinates (30,30)
M107; Stop Dispensing Batter

//03 Footer

G28 X0 Y0; Home all axis
M84; Turn Movement Motors Off

//04 Complete Square

G21; Set Units to MM
G1 F7600; Set Speed to 7600 mm per minute
M107; Turn Batter Dispenser off to stop batter flow
G28; Home All Axis
G00 X30 Y30; Move bottle to coordinates (30,30)
M106; Start Dispensing Batter
G4 P750; Pause the machine for 750 milliseconds ($\frac{3}{4}$ of a second). This allows the batter to drop down to the griddle.
G00 X130 Y30; Move bottle to coordinates (130,30)
G00 X130 Y130; Move bottle to coordinates (130,130)
G00 X30 Y130; Move bottle to coordinates (30,130)
G00 X30 Y30; Move bottle to coordinates (30,30)
M107; Stop Dispensing Batter
G28 X0 Y0; Home all axis
M84; Turn Movement Motors Off

//05 The Gap

G21; Set Units to MM
G1 F7600; Set Speed to 7600 mm per minute
M107; Turn Batter Dispenser off to stop batter flow
G28; Home All Axis
G00 X30 Y30; Move bottle to coordinates (30,30)
M106; Start Dispensing Batter
G4 P750; Pause the machine for 750 milliseconds ($\frac{3}{4}$ of a second). This allows the batter to drop down to the griddle.
G00 X130 Y30; Move bottle to coordinates (130,30)

G00 X130 Y130; Move bottle to coordinates (130,130)
G00 X30 Y130; Move bottle to coordinates (30,130)
G00 X30 Y30; Move bottle to coordinates (30,30)
M107; Stop Dispensing Batter
G4 P750; Pause the machine for 750 milliseconds ($\frac{3}{4}$ of a second)
G28 X0 Y0; Home all axis
M84; Turn Movement Motors Off

//06 The Blob

G21; Set Units to MM
G1 F7600; Set Speed to 7600 mm per minute
M107; Turn Batter Dispenser off to stop batter flow
G28; Home All Axis
G00 X30 Y30; Move bottle to coordinates (30,30)
M106; Start Dispensing Batter
G4 P750; Pause the machine for 750 milliseconds ($\frac{3}{4}$ of a second). This allows the batter to drop down to the griddle.
G00 X130 Y30; Move bottle to coordinates (130,30)
G00 X130 Y130; Move bottle to coordinates (130,130)
G00 X30 Y130; Move bottle to coordinates (30,130)
G00 X30 Y40; Move bottle to coordinates (30,40)
M107; Stop Dispensing Batter
G00 X30 Y30; Move bottle to coordinates (30,30)
G4 P750; Pause the machine for 750 milliseconds ($\frac{3}{4}$ of a second)
G28 X0 Y0; Home all axis
M84; Turn Movement Motors Off

//07 Final

G21; Set Units to MM
G1 F7600; Set Speed to 7600 mm per minute
M107; Turn Batter Dispenser off to stop batter flow
G28; Home All Axis
G00 X30 Y30; Move bottle to coordinates (30,30)
M106; Start Dispensing Batter
G4 P750; Pause the machine for 750 milliseconds ($\frac{3}{4}$ of a second). This allows the batter to drop down to the griddle.
G00 X130 Y30; Move bottle to coordinates (130,30)
G00 X130 Y130; Move bottle to coordinates (130,130)
G00 X30 Y130; Move bottle to coordinates (30,130)
G00 X30 Y40; Move bottle to coordinates (30,40)
M107; Stop Dispensing Batter
G00 X30 Y30; Move bottle to coordinates (30,30)
G4 P750; Pause the machine for 750 milliseconds ($\frac{3}{4}$ of a second)
G28 X0 Y0; Home all axis
M84; Turn Movement Motors Off