



```
%  
G0G90X0Y0  
S1000M3T1M8  
G0Z20  
G1Z-0.2F30  
1...F...  
2...  
3...  
4...  
G0Z20  
G0 X...Y...  
G1Z-0.1F30  
1...F...  
2...  
3...  
4...  
5...  
6...  
7...  
8...|  
G0Z20  
M5  
M9  
M2  
%
```