



Fondo Sociale Europeo



Ministero dello Sviluppo Economico



REGIONE PUGLIA
Assessorato alle Politiche Giovanili

a.r.t.i.
Agenzia regionale per la tecnologia e l'innovazione



Iniziativa finanziata con risorse del FSE - PO Puglia 2014/2020 Azione 8.4 e del Fondo per lo Sviluppo e la Coesione

Allegato C – G-Code



3DilBio S.r.l.s. | Via Mercede 11, 72019 San Vito dei Normanni (BR) | 3DilBiosrls@pec.it – 3DilBio@gmail.com

+39 3462441302 - +39 349687367 | C.F./P.iva 02631760747 | n. REA BR-160184

G0 X0 Y0 Z0 "home position"

G91 "use relative coordinates"

G21 "set units to millimeters"

F200

"First block layer"

G0 X0 Y0 Z100

G1 X0 Y4640 Z0 E4640

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-4080 Z0 E4080

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50

G1 X0 Y4640 Z0 E4640

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-4080 Z0 E4080

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50

G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50
G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50
G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080

G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50

G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50

G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50

G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640



G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50

G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y0 Z50

G1 X0 Y4640 Z0 E4640
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-4080 Z0 E4080
G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

"Second block layer"

G0 X0 Y0 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
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G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
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G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
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G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
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G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
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G1 X3640 Y0 Z0 E3640
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G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
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G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
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G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
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G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
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G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
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G1 X0 Y-550 Z0 E550
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G0 X0 Y-3810 Z50
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G0 X0 Y3810 Z0
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G0 X0 Y-3810 Z50
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G0 X0 Y3810 Z0
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G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
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G0 X0 Y-3810 Z50
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G0 X0 Y-3810 Z50
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G0 X0 Y-3810 Z50
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G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

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G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

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G1 X0 Y4080 Z0 E4080
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G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
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G1 X750 Y0 Z0 E750
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G0 X0 Y3810 Z0
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G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
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G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
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G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
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G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
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G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
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G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G1 X0 Y280 Z0 E280

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280

G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

G0 X0 Y-3810 Z50
G1 X0 Y830 Z0 E830
G1 X280 Y0 Z0 E280
G1 X0 Y-550 Z0 E550
G1 X750 Y0 Z0 E750
G1 X0 Y-280 Z0 E280
G1 X-1030 Y0 Z0 E1030
G0 X0 Y3810 Z0
G1 X0 Y830 Z0 E830
G1 X3640 Y0 Z0 E3640
G1 X0 Y-4640 Z0 E4640
G1 X-1530 Y0 Z0 E1530
G1 X0 Y280 Z0 E280
G1 X1250 Y0 Z0 E1250
G1 X0 Y4080 Z0 E4080
G1 X-3080 Y0 Z0 E3080
G1 X0 Y-550 Z0 E550
G1 X-280 Y0 Z0 E280

"Third block layer"

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G0 X280 Y0 Z0 E0

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G0 X0 Y-280 Z0 E0

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G0 X0 Y280 Z0 E0

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G0 X-280 Y0 Z0 E0

G0 X0 Y-3810 Z50

G1 X0 Y830 Z0 E830

G0 X280 Y0 Z0 E0

G1 X0 Y-550 Z0 E550

G1 X750 Y0 Z0 E750

G0 X0 Y-280 Z0 E0

G1 X-1030 Y0 Z0 E1030

G0 X0 Y3810 Z0

G1 X0 Y830 Z0 E830

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-1530 Y0 Z0 E1530

G0 X0 Y280 Z0 E0

G1 X1250 Y0 Z0 E1250

G1 X0 Y4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G1 X0 Y-550 Z0 E550

G0 X-280 Y0 Z0 E0

G0 X0 Y-3810 Z50

"Fourth block, first group, layer after application of Multizinc mesh"

G1 X0 Y4640 Z0 E4640

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-3640 Y0 Z0 E3640

G0 X280 Y280 Z0

G1 X0 Y4080 Z0 E4080

G1 X3080 Y0 Z0 E3080

G1 X0 Y-4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G0 X0 Y0 Z50

G1 X0 Y4080 Z0 E4080

G1 X3080 Y0 Z0 E3080

G1 X0 Y-4080 Z0 E4080

G1 X-3080 Y0 Z0 E3080

G0 X-280 Y-280 Z0

G1 X0 Y4640 Z0 E4640

G1 X3640 Y0 Z0 E3640

G1 X0 Y-4640 Z0 E4640

G1 X-3640 Y0 Z0 E3640

"Fourth block, second group, layer as filler"

G0 X90 Y280 Z0

G0 X0 Y0 Z-50

G1 X0 Y4080 Z0 E4080

G0 X100 Y0 Z0 E0

G1 X0 Y-4080 Z0 E4080

G0 X-100 Y0 Z50 E0

G1 X0 Y4080 Z0 E4080

G0 X100 Y0 Z0 E0

G1 X0 Y-4080 Z0 E4080

G0 X90 Y0 Z0

G0 X0 Y-90 Z0

G0 X0 Y0 Z-50

G1 X3080 Y0 Z0 E3080

G0 X0 Y-100 Z0 E0

G1 X-3080 Y0 Z0 E3080

G0 X0 Y100 Z50 E0

G1 X3080 Y0 Z0 E3080

G0 X0 Y-100 Z0 E0

G1 X-3080 Y0 Z0 E3080

G0 X0 Y100 Z0 E0

G0 X3080 Y4260 Z0

G0 X0 Y0 Z-50

G1 X-3080 Y0 Z0 E3080

G0 X0 Y100 Z0 E0

G1 X3080 Y0 Z0 E3080

G0 X0 Y-100 Z50 E0

G1 X-3080 Y0 Z0 E3080

G0 X0 Y100 Z0 E0

G1 X3080 Y0 Z0 E3080

G0 X0 Y-100 Z0 E0

G0 X0 Y-90 Z0

G0 X90 Y0 Z0

G0 X0 Y0 Z-50

G1 X0 Y-4080 Z0 E4080

G0 X100 Y0 Z0 E0

G1 X0 Y4080 Z0 E4080

G0 X-100 Y0 Z50 E0

G1 X0 Y-4080 Z0 E4080

G0 X100 Y0 Z0 E0

G1 X0 Y4080 Z0 E4080

G0 X-100 Y0 Z0 E0

"End Procedure"

G0 Z500

G90

G0 X1500 Y0

G0 X0 Y0