```
; **** Replicator 2X start.gcode ****

M73 P0 ; enable build progress

G162 X Y F3000 ; home XY maximum

G161 Z F1200 ; home Z minimum

G92 Z-5 ; set Z to -5

G1 Z0 ; move Z to 0

G161 Z F100 ; home Z slowly

M132 X Y Z A B ; recall home offsets

M135 T0 ; load right extruder offsets

G1 X-130 Y-75 Z30 F9000 ; move to wait position off table

G130 X20 Y20 Z20 A20 B20 ; lower stepper Vrefs while heating

M126 S[fan_speed_pwm]

M140 S[bed0_temperature] T0

M134 T0 ; stabilize bed temperature

M104 S[extruder0_temperature] T0

M133 T0 ; stabilize extruder temperature

G130 X127 Y127 Z40 A127 B127 ; default stepper Vrefs

G92 A0 B0 ; zero extruders

G1 Z0.4 ; position nozzle

G1 E25 F300 ; purge nozzle

G1 X-125 Y-70 Z0.15 F1200 ; slow wipe

G1 X-120 Y-65 Z0.5 F1200 ; lift

G92 A0 B0 ; zero extruders

M73 P1 ;@body (notify GPX body has started)

; **** end of start.gcode ****
```

```
; **** Replicator 2X end.gcode ****

M73 P100 ; end build progress

G1 Z155 F1000 ; send Z axis to bottom of machine

M140 S0 T0 ; cool down HBP

M104 S0 T0 ; cool down right extruder

M104 S0 T1 ; cool down left extruder

M127 ; stop blower fan

G162 X Y F3000 ; home XY maximum

M18 ; disable stepper

M72 P1 ; play Ta-Da song

; **** end of end.gcode ****
```