Diagnostics

gSender 1.4.7

Environment

OS: X11; Linux x86_64
Homing: Disabled
Soft Limits: Enabled
Home Location: 11 (Front Left)
Report Inches: Disabled
Stepper Motors: Unlocked

Machine Profile

ID: 53
Company: Sienci Labs
Name: SLB
Type:
Version:
Limits:
- X Max: 296
- Y Max: 228
- Z Max: 74

Spindle/Laser: false
Laser Mode Enabled: false

Connection

Available Ports:
- 0:
  - port: /dev/ttyACM0
  - manufacturer: STMicroelectronics
  - inuse: false

Connected Port: /dev/ttyACM0
Baudrate: 115200
Unrecognized Ports:
- 0:
  - port: /dev/ttyS0
  - inuse: false
- 1:
  - port: /dev/ttyS1
  - inuse: false
- 2:
  - port: /dev/ttyS2
  - inuse: false
- 3:
  - port: /dev/ttyS3
  - inuse: false

GRBL Information

Type: grblHAL
Firmware Version: SuperLongBoard_B5.0.3
MPos:
- a: 0.000
- b: 0.000
- c: 0.000
- x: 0.000
- y: 0.000
- z: 0.000

WPos:
- a: 0.000
- b: 0.000
- c: 0.000
- x: -44.334
- y: -20.666
- z: 52.382

Sender Status:
- Modal:
  - NULL
- Tool: NULL

Workflow State: idle
Homing Flag: false

Preferences

Jog Presets:

- Rapid:
  - xyStep: 20
  - zStep: 10
  - aStep: 20
  - xaStep: 20
  - feedrate: 5000
- Normal:
  - xyStep: 5
  - zStep: 2
  - aStep: 5
  - xaStep: 5
  - feedrate: 3000
- Precise:
  - xyStep: 0.5
  - zStep: 0.1
  - aStep: 0.5
  - xaStep: 0.5
  - feedrate: 1000

Workspace Units: mm
Laser: Disabled
Rotary: Disabled

EEPROM Values

Setting	Value
$0	5.0
$1	254
$2	0
$3	2
$4	15
$5	8
$6	1
$8	0
$9	1
$10	511
$11	0.010
$12	0.002
$13	0
$14	14
$15	0
$16	0
$17	0
$18	0
$19	0
$20	1
$21	1
$22	79
$23	11
$24	100.0
$25	500.0
$26	125
$27	2.000
$28	0.100
$29	0.0
$30	24000.000
$31	7200.000
$32	0
$33	1000.0
$34	0.0
$35	0.0
$36	100.0
$37	0
$39	1
$40	1

$41	1
$42	2
$43	1
$44	4
$45	3
$46	0
$47	0
$56	5.0
$57	100.0
$58	-5.0
$59	500.0
$60	1
$61	3
$62	0
$63	3
$64	0
$65	0
$70	11
$100	1600.000
$101	1600.000
$102	3200.000
$103	19.753
$110	3600.000
$111	3600.000
$112	700.000
$113	8000.000
$120	750.000
$121	750.000
$122	200.000
$123	1000.000
$130	296.000
$131	228.000
$132	74.000
$133	0.000
$140	1900
$141	1900
$142	1700
$143	0
$150	32
$151	32
$152	32
$153	16
$180	150.0

$181	150.0
$182	150.0
$183	150.0
$190	2500.0
$191	2500.0
$192	500.0
$193	5000.0
$200	22.0
$201	22.0
$202	22.0
$203	22.0
$210	35
$211	35
$212	35
$213	50
$220	22.0
$221	22.0
$222	22.0
$223	22.0
$300	grblHAL
$301	0
$302	192.168.5.1
$303	192.168.5.1
$304	255.255.255.0
$305	23
$307	80
$308	21
$338	7
$339	0
$340	0.0
$341	0
$342	30.0
$343	25.0
$344	200.0
$345	200.0
$346	1
$370	0
$372	0
$374	3
$375	50
$376	1
$384	0
$392	4.0

$393	1.0
$395	0
$398	128
$450	1
$451	2
$452	4
$453	G4P0
$454	G4P0
$455	G4P0
$456	0
$457	2
$458	0
$459	2
$462	8192
$463	8193
$464	8451
$465	18
$466	34
$467	1
$468	50.0
$469	60.0
$470	60.0
$471	100.0
$479	4
$481	0
$484	1
$486	0
$511	7
$512	8
$513	5
$520	0
$521	0
$523	0
$650	1
$651	1
$652	0
$653	2
$654	8
$655	0
$656	1
$657	22
$658	7
$659	3

$660	0
$661	3
$662	0
$663	41759
$664	0
$665	1
$666	0
$668	0
$730	255.000
$731	0.000
$733	1000.0
$734	0.0
$735	0.0
$736	100.0
$741	0.000
$742	0.000
$743	0

Recent Alarms

6/16/2024, 6:43:02 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: (JuneFusionTest-v2) Controller: grblHAL

6/9/2024, 4:17:02 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

6/7/2024, 4:15:17 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

6/3/2024, 3:37:52 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

6/3/2024, 2:49:31 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

6/3/2024, 2:48:28 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

6/1/2024, 4:10:34 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

6/1/2024, 4:08:30 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: $hz Controller: grblHAL

6/1/2024, 4:07:21 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

6/1/2024, 4:05:22 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

6/1/2024, 3:57:17 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/31/2024, 4:07:36 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/31/2024, 3:49:56 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/31/2024, 3:49:02 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/31/2024, 3:47:36 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/31/2024, 3:46:52 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/31/2024, 3:46:23 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 7:35:48 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 7:34:15 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 7:16:39 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 7:13:51 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 7:13:23 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 7:13:01 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel,

decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 2:12:06 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/29/2024, 1:31:12 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

5/29/2024, 1:30:55 PM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/28/2024, 11:58:00 AM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A Controller: grblHAL

5/28/2024, 11:57:32 AM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A Controller: grblHAL

5/28/2024, 11:56:27 AM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/28/2024, 11:55:56 AM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: g1 y100 f5000 Controller: grblHAL

5/28/2024, 11:49:57 AM
Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.
Input: N/A Controller: grblHAL

5/28/2024, 11:33:46 AM
Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: G1 X200 f5 Controller: grblHAL

5/26/2024, 7:48:22 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z-100 f5000 Controller: grblHAL

5/26/2024, 7:33:37 PM
EStop asserted. Clear and reset
Input: M8 Controller: grblHAL

5/26/2024, 7:27:25 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z10 f5000 Controller: grblHAL

5/26/2024, 7:27:06 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z49 f5000 Controller: grblHAL

5/26/2024, 7:26:46 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z50 f5000 Controller: grblHAL

5/26/2024, 7:26:32 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z60 f5000 Controller: grblHAL

5/26/2024, 7:25:51 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z50 f5000 Controller: grblHAL

5/26/2024, 5:14:22 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

5/26/2024, 5:11:55 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 X-30 F2500 Controller: grblHAL

5/26/2024, 5:11:32 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 X-60 F2500 Controller: grblHAL

5/26/2024, 5:11:07 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 X-70 F2500 Controller: grblHAL

5/26/2024, 5:10:09 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A Controller: grblHAL

5/26/2024, 5:09:39 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A Controller: grblHAL

5/26/2024, 5:08:59 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing

is highly recommended.
Input: N/A Controller: grblHAL

5/26/2024, 5:08:45 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A Controller: grblHAL

5/26/2024, 5:07:50 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A Controller: grblHAL

5/26/2024, 5:07:21 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: G1 Y-100 F5000 Controller: grblHAL

5/26/2024, 4:58:14 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A Controller: grblHAL

5/26/2024, 4:57:56 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A Controller: grblHAL

5/26/2024, 4:57:45 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A Controller: grblHAL

5/26/2024, 4:56:58 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: $$ Controller: grblHAL

5/25/2024, 3:12:49 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

5/19/2024, 6:27:55 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

5/18/2024, 1:12:08 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z70 F5000 Controller: Grbl

5/18/2024, 1:11:06 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Z70 F5000 Controller: Grbl

5/18/2024, 12:58:45 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1 Y225 F5000 Controller: Grbl

3/23/2024, 2:14:44 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: S18400 M3 Controller: Grbl

Recent Errors

6/3/2024, 3:36:09 PM
Missing the expected G-code word value or numeric value format is not valid.
Input: N/A Controller: Grbl

6/1/2024, 4:08:11 PM
Missing the expected G-code word value or numeric value format is not valid.
Input: HZ Controller: grblHAL

6/1/2024, 4:08:11 PM
Missing the expected G-code word value or numeric value format is not valid.
Input: HZ Controller: grblHAL

5/26/2024, 4:58:38 PM
Feed rate has not yet been set or is undefined.
Input: G1 X100 Controller: grblHAL

5/19/2024, 7:04:41 PM
Missing the expected G-code word value or numeric value format is not valid.
Input: $$ Controller: Grbl

5/18/2024, 12:44:40 PM
Feed rate has not yet been set or is undefined.
Input: G1 X1 Controller: Grbl

Terminal History

gSender - [grblHAL]
Connected to /dev/ttyACM0 with a baud rate of 115200
[VER:1.1f.20230917:]
$$
[OPT:VNMPZHS+2,128,1024,4,0]
[NEWOPT:ENUMS,RT+,HOME,ES,SED,ETH,FTP,TMC=7,SD,YM]
[FIRMWARE:grblHAL]
[NVS STORAGE:*EEPROM]
[FREE MEMORY:133K]
[DRIVER:STM32F412]
[DRIVER VERSION:230828]
[BOARD:SuperLongBoard_B5.0.3]
[AUX IO:3,4,0,0]
[WIZCHIP:W5500]

[IP:192.168.5.1]
[PLUGIN:Trinamic v0.12]
[PLUGIN:MODBUS v0.14]
[PLUGIN:HUANYANG VFD v0.11]
[PLUGIN:HUANYANG P2A VFD v0.10]
[PLUGIN:Durapulse VFD GS20 v0.05]
[PLUGIN:Yalang VFD YL620A v0.02]
[PLUGIN:MODVFD v0.03]
[PLUGIN:H-100 VFD v0.03]
[PLUGIN:SLB Laser PWM switch v0.01]
[SPINDLE:SLB_SPINDLE]
[PLUGIN:SIENCI Indicator Lights v1.0]
[PLUGIN:Bootloader Entry v0.01]
[PLUGIN:Macro plugin v0.03]
[PLUGIN:SLB Probing v0.01]
[PLUGIN:SwitchBank plugin v0.02]
[PLUGIN:SDCARD v1.10]
[PLUGIN:FS macro plugin v0.05]
ok
$0=5.0 (Step pulse time, µs)
$1=254 (Step idle delay, ms)
$2=0 (Step pulse invert, mask)
$3=2 (Step direction invert, mask)
$4=15 (Invert step enable pin, boolean)
$5=8 (Invert limit pins, boolean)
$6=1 (Invert probe pin, boolean)
$8=0
$9=1
$10=511 (Status report options, mask)
$11=0.010 (Junction deviation, mm)
$12=0.002 (Arc tolerance, mm)
$13=0 (Report in inches, boolean)
$14=14
$15=0
$16=0
$17=0
$18=0
$19=0
$20=1 (Soft limits enable, boolean)
$21=1 (Hard limits enable, mask)
$22=79 (Homing cycle enable, mask)
$23=11 (Homing direction invert, mask)
$24=100.0 (Homing locate feed rate, mm/min)
$25=500.0 (Homing search seek rate, mm/min)
$26=125 (Homing switch debounce delay, ms)
$27=2.000 (Homing switch pull-off distance, mm)
$28=0.100 (G73 pull-off distance, mm)
$29=0.0 (Step Pulse Delay, µs)
$30=24000.000 (Maximum spindle speed, rpm)
$31=7200.000 (Spindle Mode,)
$32=0 (Laser-mode enabled as spindle, boolean)
$33=1000.0 (Spindle Frequency, Hz)
$34=0.0 (Spindle Duty Cycle, %)
$35=0.0 (Minimum spindle speed, %)
$36=100.0 (Maximum spindle speed, %)
$37=0 (Deenergized Steppers, %)

$39=1 (Printable Command Characters, boolean)
$40=1 (Soft Limits Jogging, boolean)
$41=1
$42=2
$43=1 (Homing Locate Cycle,)
$44=4 (Axis Mask,)
$45=3 (Axis Mask,)
$46=0 (Axis Mask,)
$47=0 (Axis Mask,)
$56=5.0
$57=100.0
$58=-5.0
$59=500.0
$60=1 (Restore Default Overrides, boolean)
$61=3 (Ignore Safety Door Signal, boolean)
$62=0 (Sleep Function, boolean)
$63=3 (Disable Laser on Hold, boolean)
$64=0 (Alarm on Startup, boolean)
$65=0 (Allow Feedrate Override, boolean)
$70=11 (Network Service,)
$100=1600.000 (X-axis travel resolution, step/mm)
$101=1600.000 (Y-axis travel resolution, step/mm)
$102=3200.000 (Z-axis travel resolution, step/mm)
$103=19.753
$110=3600.000 (X-axis maximum rate, mm/min)
$111=3600.000 (Y-axis maximum rate, mm/min)
$112=700.000 (Z-axis maximum rate, mm/min)
$113=8000.000
$120=750.000 (X-axis acceleration, mm/sec^2)
$121=750.000 (Y-axis acceleration, mm/sec^2)
$122=200.000 (Z-axis acceleration, mm/sec^2)
$123=1000.000
$130=296.000 (X-axis maximum travel, mm)
$131=228.000 (Y-axis maximum travel, mm)
$132=74.000 (Z-axis maximum travel, mm)
$133=0.000
$140=1900
$141=1900
$142=1700
$143=0
$150=32
$151=32
$152=32
$153=16
$180=150.0
$181=150.0
$182=150.0
$183=150.0
$190=2500.0
$191=2500.0
$192=500.0
$193=5000.0
$200=22.0
$201=22.0
$202=22.0
$203=22.0

$210=35
$211=35
$212=35
$213=50
$220=22.0
$221=22.0
$222=22.0
$223=22.0
$300=grblHAL
$301=0
$302=192.168.5.1
$303=192.168.5.1
$304=255.255.255.0
$305=23
$307=80
$308=21
$338=7
$339=0
$340=0.0 (Spindle at speed tolerance, %)
$341=0 (Manual tool change mode,)
$342=30.0 (Probing distance, mm)
$343=25.0 (Probing slow feed rate, mm/min)
$344=200.0 (Probing seek feed rate, mm/min)
$345=200.0
$346=1
$370=0
$372=0
$374=3
$375=50
$376=1
$384=0
$392=4.0
$393=1.0
$395=0
$398=128
$450=1
$451=2
$452=4
$453=G4P0
$454=G4P0
$455=G4P0
$456=0
$457=2
$458=0
$459=2
$462=8192
$463=8193
$464=8451
$465=18
$466=34
$467=1
$468=50.0
$469=60.0
$470=60.0
$471=100.0
$479=4

$481=0
$484=1
$486=0
$511=7
$512=8
$513=5
$520=0
$521=0
$523=0
$650=1
$651=1
$652=0
$653=2
$654=8
$655=0
$656=1
$657=22
$658=7
$659=3
$660=0
$661=3
$662=0
$663=41759
$664=0
$665=1
$666=0
$668=0
$730=255.000
$731=0.000
$733=1000.0
$734=0.0
$735=0.0
$736=100.0
$741=0.000
$742=0.000
$743=0
ok
ok
ok
ok
ok
0 - SLB_SPINDLE, enabled as spindle 0, DIV, current
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD, enabled as spindle 3, SDV
6 - H-100
7 - SLB_LASER, enabled as spindle 1, DIRV
ok
$X
ok

G-Code File

Status	Value

No File Loaded