

Diagnostics

gSender 1.4.6

Environment

OS: Windows NT 10.0; Win64; x64

Homing: Disabled

Soft Limits: Disabled

Home Location: 3 (Front Left)

Report Inches: Enabled

Stepper Motors: Unlocked

Machine Profile

ID: 0

Company: Sienci Labs

Name: LongMill MK2

Type: 30x30

Version: MK2

Limits:

X Max: 816

Y Max: 864

Z Max: 122

Spindle/Laser: false

Laser Mode Enabled: false

Connection

Available Ports:

NULL

Connected Port: COM3

Baudrate: 115200

Unrecognized Ports:

NULL

GRBL Information

Type: Grbl

MPos:

a: 0

b: 0

c: 0

x: 0

y: 0

z: 0

WPos:

a: 0

b: 0

c: 0

x: -245.2243

y: -2.3621999999999996

z: 23.985219999999998

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: in

Laser: Disabled

Rotary: Disabled

EEPROM Values

Setting	Value
\$0	10
\$1	100
\$2	1
\$3	1
\$4	1
\$5	0
\$6	0
\$10	1
\$11	0.010
\$12	0.002
\$13	1
\$20	0
\$21	0
\$22	0
\$23	3
\$24	25.000
\$25	1500.000
\$26	250
\$27	1.000
\$30	30000
\$31	10000
\$32	0
\$100	200.000
\$101	200.000
\$102	200.000
\$110	4000.000
\$111	4000.000
\$112	3000.000
\$120	750.000
\$121	750.000
\$122	500.000
\$130	816.000
\$131	864.000
\$132	122.000

Recent Alarms

4/26/2024, 6:14:59 PM

Probe fail. Probe is not in the expected initial state before starting probe cycle when G38.2 and G38.3 is not triggered and G38.4 and G38.5 is triggered.

Input: N/A Controller: Grbl

4/25/2024, 8:06:05 PM

Probe fail. Probe is not in the expected initial state before starting probe cycle when G38.2 and G38.3 is not triggered and G38.4 and G38.5 is triggered.

Input: N/A Controller: Grbl

4/25/2024, 8:03:59 PM

Probe fail. Probe is not in the expected initial state before starting probe cycle when G38.2 and G38.3 is not triggered and G38.4 and G38.5 is triggered.

Input: N/A Controller: Grbl

4/25/2024, 8:01:39 PM

Probe fail. Probe is not in the expected initial state before starting probe cycle when G38.2 and G38.3 is not triggered and G38.4 and G38.5 is triggered.

Input: N/A Controller: Grbl

Recent Errors

4/29/2024, 1:37:33 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X3.4896Y1.8754 Controller: Grbl

4/29/2024, 1:36:59 PM

More than one g-code command that requires axis words found in block.

Input: G1X2.1472Y3.2742 Controller: Grbl

4/28/2024, 3:38:23 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X2.1846Y3.3414 Controller: Grbl

4/28/2024, 11:37:21 AM

More than one g-code command that requires axis words found in block.

Input: G1X5.0723Y3.5562 Controller: Grbl

4/28/2024, 11:37:09 AM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X3.0554Y2.8252 Controller: Grbl

4/28/2024, 11:12:33 AM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X12.6401Y2.0095 Controller: Grbl

4/28/2024, 11:12:19 AM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X6.6498Y3.4900 Controller: Grbl

4/28/2024, 11:12:12 AM

More than one g-code command that requires axis words found in block.

Input: G1X7.8350Y3.3289 Controller: Grbl

4/28/2024, 11:11:41 AM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X3.2627Y2.6578Z-0.3950 Controller: Grbl

4/27/2024, 6:01:22 PM

More than one g-code command that requires axis words found in block.

Input: G0Z0.2000 Controller: Grbl

4/27/2024, 6:00:55 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X2.1204Y3.3148 Controller: Grbl

4/27/2024, 6:00:30 PM

More than one g-code command that requires axis words found in block.

Input: G1X3.2072Y2.4164 Controller: Grbl

4/27/2024, 5:28:12 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X178.518Y48.555Z-4.789 Controller: Grbl

4/27/2024, 5:27:33 PM

More than one g-code command that requires axis words found in block.

Input: G1X135.719Y72.154Z-6.372 Controller: Grbl

4/27/2024, 3:18:33 PM

Missing the expected G-code word value or numeric value format is not valid.

Input: G1X85.127Y293.933 Controller: Grbl

4/27/2024, 3:10:41 PM

Grbl '\$' system command was not recognized or supported.

Input: N/A Controller: Grbl

4/27/2024, 3:08:01 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X88.580Y55.388Z-3.685 Controller: Grbl

4/27/2024, 3:07:36 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X63.086Y519.017 Controller: Grbl

4/27/2024, 3:06:37 PM

Missing the expected G-code word value or numeric value format is not valid.

Input: G1X95.752Y127.203 Controller: Grbl

4/27/2024, 2:39:08 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X135.561Y550.934 Controller: Grbl

4/27/2024, 2:38:03 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X63.641Y467.063 Controller: Grbl

4/27/2024, 2:37:45 PM

More than one g-code command that requires axis words found in block.

Input: G1X92.765Y94.670 Controller: Grbl

4/27/2024, 2:37:18 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X159.135Y96.071 Controller: Grbl

4/27/2024, 2:36:06 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X212.938Y53.367Z0.000 Controller: Grbl

4/27/2024, 2:35:55 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X165.509Y96.809Z-5.554 Controller: Grbl

4/27/2024, 2:34:21 PM

Motion command target is invalid.

Input: G1Z-10.160F254.0 Controller: Grbl

4/27/2024, 2:33:45 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X65.213Y72.224 Controller: Grbl

4/27/2024, 2:33:26 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G2X103.115Y71.989I-0.656J-0.328 Controller: Grbl

4/27/2024, 2:33:06 PM

More than one g-code command that requires axis words found in block.

Input: G1X110.786Y61.927 Controller: Grbl

4/27/2024, 2:26:44 PM

More than one g-code command that requires axis words found in block.

Input: G2X108.264Y79.100I1.627J2.811 Controller: Grbl

4/27/2024, 2:24:35 PM

Motion command target is invalid.

Input: G1X182.410Y61.250 Controller: Grbl

4/27/2024, 2:20:58 PM

More than one g-code command that requires axis words found in block.

Input: G1X89.370Y79.266 Controller: Grbl

4/27/2024, 2:20:08 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X164.561Y95.832 Controller: Grbl

4/27/2024, 2:15:46 PM

More than one g-code command that requires axis words found in block.

Input: G3X12.700Y32.752I-9.550J-17.632 Controller: Grbl

4/27/2024, 2:15:01 PM

More than one g-code command that requires axis words found in block.

Input: G1X271.318Y54.345 Controller: Grbl

4/27/2024, 2:13:51 PM

More than one g-code command that requires axis words found in block.

Input: G1X95.358 Controller: Grbl

4/26/2024, 6:17:55 PM

More than one g-code command that requires axis words found in block.

Input: G1Z-2.444F254.0 Controller: Grbl

4/26/2024, 6:17:55 PM

More than one g-code command that requires axis words found in block.

Input: G1X53.756Y71.940 Controller: Grbl

4/26/2024, 6:15:00 PM

G-code commands are locked out during alarm or jog state.

Input: (VECTRIC POST REVISION) Controller: Grbl

4/26/2024, 6:14:56 PM

No axis words found in block for g-code command or current modal state which requires them.

Input: N/A Controller: Grbl

4/26/2024, 4:27:19 PM

More than one g-code command that requires axis words found in block.

Input: G1X57.178Y75.283Z15.836 Controller: Grbl

4/26/2024, 4:18:46 PM

G-code words consist of a letter and a value. Letter was not found.

Input: G1X136.955Y79.850Z13.161 Controller: Grbl

4/26/2024, 4:17:35 PM

More than one g-code command that requires axis words found in block.

Input: G1X33.293Y83.322 Controller: Grbl

4/26/2024, 4:17:14 PM

More than one g-code command that requires axis words found in block.

Input: G1X45.065Y72.705 Controller: Grbl

4/25/2024, 8:13:15 PM

More than one g-code command that requires axis words found in block.

Input: G1X239.957Y75.767Z14.197 Controller: Grbl

4/25/2024, 8:13:11 PM

More than one g-code command that requires axis words found in block.

Input: G1X239.778Y54.293 Controller: Grbl

4/25/2024, 8:12:55 PM

More than one g-code command that requires axis words found in block.

Input: G2X140.702Y72.944I2.537J0.000 Controller: Grbl

4/25/2024, 8:12:55 PM

More than one g-code command that requires axis words found in block.

Input: G2X140.702Y72.944I2.537J0.000 Controller: Grbl

4/25/2024, 8:12:51 PM

More than one g-code command that requires axis words found in block.

Input: G1X88.213Y88.955Z15.685 Controller: Grbl

4/25/2024, 8:12:36 PM

More than one g-code command that requires axis words found in block.

Input: G1X47.021Y99.100Z16.214 Controller: Grbl

Terminal History

G1X2.8146Y2.5685

ok

G1X2.8967Y2.5455

ok

G1X2.9532Y2.5278

ok

G1X2.9836Y2.5163

ok

G1X3.0118Y2.5043

ok

G1X3.0378Y2.4917

ok

G1X3.0617Y2.4784

ok

G1X3.0835Y2.4644

ok

G1X3.1031Y2.4497

ok

G1X3.1206Y2.4342

ok

G1X3.1357Y2.4179

ok

G1X3.1487Y2.4008

ok

G1X3.1599Y2.3830

ok

G1X3.1695Y2.3642

ok

G1X3.1773Y2.3445

ok

G1X3.1833Y2.3241

ok

G1X3.1876Y2.3029

ok

G1X3.1901Y2.2810

ok

G1X3.1910Y2.2586

ok

G1X3.1905Y2.2408

ok

G1X3.1890Y2.2234

ok

G1X3.1865Y2.2062

ok

G1X3.1830Y2.1893

ok

G1X3.1784Y2.1727

ok

G1X3.1729Y2.1563
ok
G1X3.1664Y2.1402
ok
G1X3.1589Y2.1245
ok
G1X3.1505Y2.1091
ok
G1X3.1410Y2.0940
ok
G1X3.1306Y2.0793
ok
G1X3.1193Y2.0649
ok
G1X3.1071Y2.0508
ok
G1X3.0940Y2.0372
ok
G1X3.0799Y2.0238
ok
G1X3.0649Y2.0107
ok
G1X3.0487Y1.9980
ok
G1X3.0316Y1.9862
ok
G1X3.0135Y1.9751
ok
G1X2.9946Y1.9650
ok
G1X2.9748Y1.9556
ok
G1X2.9542Y1.9472
ok
G1X2.9327Y1.9396
ok
G1X2.9104Y1.9328
ok
G1X2.8873Y1.9268
ok
G1X2.8633Y1.9216
ok
G1X2.8385Y1.9173
ok
G1X2.8129Y1.9138
ok
G1X2.7864Y1.9110
ok
G1X2.7591Y1.9091
ok
G1X2.7310Y1.9079
ok
G1X2.7020Y1.9075
ok
G1X2.6745Y1.9079
ok

G1X2.6475Y1.9093
ok
G1X2.6212Y1.9115
ok
G1X2.5956Y1.9146
ok
G1X2.5706Y1.9186
ok
G1X2.5463Y1.9235
ok
G1X2.5226Y1.9293
ok
G1X2.4996Y1.9360
ok
G1X2.4773Y1.9437
ok
G1X2.4556Y1.9522
ok
G1X2.4347Y1.9617
ok
G1X2.4144Y1.9721
ok
G1X2.3948Y1.9835
ok
G1X2.3760Y1.9958
ok
G1X2.3579Y2.0089
ok
G1X2.3405Y2.0231
ok
G1X2.3238Y2.0382
ok
G1X2.3078Y2.0543
ok
G1X2.2926Y2.0714
ok
G1X2.2781Y2.0895
ok
G1X2.2644Y2.1086
ok
G1X2.2514Y2.1286
ok
G1X2.2392Y2.1496
ok
G1X2.2278Y2.1715
ok
G1X2.2171Y2.1944
ok
G1X2.2071Y2.2182
ok
G1X2.1978Y2.2429
ok
G1X2.1893Y2.2685
ok
G1X2.1814Y2.2951
ok

G1X2.1743Y2.3226
ok
G1X2.1670Y2.3559
ok
G1X1.7576Y2.3161
ok
G1X1.7604Y2.2958
ok
G1X1.7683Y2.2497
ok
G1X1.7776Y2.2050
ok
G1X1.7885Y2.1619
ok
G1X1.8007Y2.1203
ok
G1X1.8144Y2.0802
ok
G1X1.8296Y2.0416
ok
G1X1.8461Y2.0045
ok
G1X1.8641Y1.9689
ok
G1X1.8835Y1.9348
ok
G1X1.9044Y1.9021
ok
G1X1.9267Y1.8708
ok
G1X1.9504Y1.8411
ok
G1X1.9755Y1.8127
ok
G1X2.0021Y1.7858
ok
G1X2.0302Y1.7603
ok
G1X2.0597Y1.7363
ok
G1X2.0907Y1.7138
ok
G1X2.1234Y1.6929
ok
G1X2.1576Y1.6735
ok
G1X2.1935Y1.6556
ok
G1X2.2310Y1.6392
ok
G1X2.2702Y1.6244
ok
G1X2.3110Y1.6111
ok
G1X2.3534Y1.5994
ok

G1X2.3975Y1.5891
ok
G1X2.4433Y1.5805
ok
G1X2.4908Y1.5734
ok
G1X2.5399Y1.5679
ok
G1X2.5907Y1.5639
ok
G1X2.6431Y1.5615
ok
G1X2.6973Y1.5607
ok
G1X2.7712Y1.5621
ok
G1X2.8420Y1.5660
ok
G1X2.9095Y1.5726
ok
G1X2.9738Y1.5818
ok
G1X3.0047Y1.5874
ok
G1X3.0348Y1.5936
ok
G1X3.0641Y1.6005
ok
G1X3.0926Y1.6080
ok
G1X3.1202Y1.6162
ok
G1X3.1471Y1.6250
ok
G1X3.1731Y1.6344
ok
G1X3.1983Y1.6444
ok
G1X3.2228Y1.6552
ok
G1X3.2465Y1.6665
ok
G1X3.2695Y1.6786
ok
G1X3.2917Y1.6913
ok
G1X3.3133Y1.7047
ok
G1X3.3341Y1.7187
ok
G1X3.3542Y1.7334
ok
G1X3.3735Y1.7488
ok
G1X3.3922Y1.7648
ok

G1X3.4102Y1.7816

ok

G1X3.4275Y1.7989

ok

G1X3.4440Y1.8170

ok

G1X3.4599Y1.8358

ok

G1X3.4751Y1.8552

ok

G1X3.4896Y1.8754

ok

G1X3.5035Y1.8962

ok

G1X3.5166Y1.9176

ok

G1X3.5288Y1.9391

ok

G1X3.5403Y1.9609

error:1 (Expected command letter)

ok

ok

ok

ok

ok

ok

gSender - [Grbl]

Connected to COM3 with a baud rate of 115200

Grbl 1.1h ['\$' for help] LongMill MK2 build Feb 7, 2022

\$\$

\$0=10 (Step pulse time, ~~\$~~)

\$1=100 (Step idle delay, ms)

\$2=1 (Step pulse invert, mask)

\$3=1 (Step direction invert, mask)

\$4=1 (Invert step enable pin, boolean)

\$5=0 (Invert limit pins, boolean)

\$6=0 (Invert probe pin, boolean)

\$10=1 (Status report options, mask)

\$11=0.010 (Junction deviation, mm)

\$12=0.002 (Arc tolerance, mm)

\$13=1 (Report in inches, boolean)

\$20=0 (Soft limits enable, boolean)

\$21=0 (Hard limits enable, boolean)

\$22=0 (Homing cycle enable, boolean)

\$23=3 (Homing direction invert, mask)

\$24=25.000 (Homing locate feed rate, mm/min)

\$25=1500.000 (Homing search seek rate, mm/min)

\$26=250 (Homing switch debounce delay, ms)

\$27=1.000 (Homing switch pull-off distance, mm)

\$30=30000 (Maximum spindle speed, rpm)

\$31=10000 (Minimum spindle speed, rpm)

\$32=0 (Laser-mode enabled as spindle, boolean)

\$100=200.000 (X-axis travel resolution, step/mm)

\$101=200.000 (Y-axis travel resolution, step/mm)

\$102=200.000 (Z-axis travel resolution, step/mm)

\$110=4000.000 (X-axis maximum rate, mm/min)

\$111=4000.000 (Y-axis maximum rate, mm/min)
 \$112=3000.000 (Z-axis maximum rate, mm/min)
 \$120=750.000 (X-axis acceleration, mm/sec^2)
 \$121=750.000 (Y-axis acceleration, mm/sec^2)
 \$122=500.000 (Z-axis acceleration, mm/sec^2)
 \$130=816.000 (X-axis maximum travel, mm)
 \$131=864.000 (Y-axis maximum travel, mm)
 \$132=122.000 (Z-axis maximum travel, mm)
 ok

G-Code File

Status	Value
Name	test 2_1-V-Carve 1.gcode
Sent	0
Received	0
Total	7650

(VECTRIC POST REVISION)
 (D6636633856CDF96EB5CCA1E1D47044A)
 T1
 G17
 G20
 G90
 G0Z0.8000
 G0X0.0000Y0.0000
 S14000M3
 G0X2.7425Y2.9202
 G0Z0.2000
 G1Z-0.0469F10.0
 G1X2.6585Y2.9409F30.0
 G1X2.5809Y2.9619
 G1X2.5112Y2.9828
 G1X2.4476Y3.0042
 G1X2.3912Y3.0261
 G1X2.3653Y3.0373
 G1X2.3409Y3.0490
 G1X2.3178Y3.0611
 G1X2.2959Y3.0740
 G1X2.2750Y3.0879
 G1X2.2551Y3.1033
 G1X2.2301Y3.1263
 G1X2.2074Y3.1516
 G1X2.1873Y3.1793
 G1X2.1703Y3.2092
 G1X2.1568Y3.2410
 G1X2.1472Y3.2742
 G1X2.1415Y3.3082
 G1X2.1397Y3.3408
 G1X2.1402Y3.3605
 G1X2.1417Y3.3784
 G1X2.1441Y3.3963

G1X2.1476Y3.4141
G1X2.1522Y3.4317
G1X2.1580Y3.4491
G1X2.1648Y3.4661
G1X2.1726Y3.4826
G1X2.1815Y3.4986
G1X2.1914Y3.5139
G1X2.2022Y3.5286
G1X2.2139Y3.5426
G1X2.2263Y3.5557
G1X2.2393Y3.5681
G1X2.2530Y3.5797
G1X2.2673Y3.5906
G1X2.2875Y3.6045
G1X2.3086Y3.6175
G1X2.3305Y3.6294
G1X2.3529Y3.6403
G1X2.3760Y3.6502
G1X2.3997Y3.6592
G1X2.4240Y3.6671
G1X2.4487Y3.6742
G1X2.4740Y3.6803
G1X2.4998Y3.6855
G1X2.5261Y3.6899
G1X2.5529Y3.6934
G1X2.5802Y3.6961
G1X2.6080Y3.6980
G1X2.6651Y3.6995
G1X2.7204Y3.6981
G1X2.7471Y3.6963
G1X2.7733Y3.6938
G1X2.7990Y3.6904
G1X2.8241Y3.6863
G1X2.8487Y3.6814
G1X2.8728Y3.6755
G1X2.8963Y3.6688
G1X2.9193Y3.6611
G1X2.9418Y3.6524
G1X2.9636Y3.6427
G1X2.9849Y3.6319
G1X3.0054Y3.6200
G1X3.0252Y3.6070
G1X3.0441Y3.5930
G1X3.0622Y3.5778
G1X3.0793Y3.5615
G1X3.0954Y3.5443
G1X3.1106Y3.5262
G1X3.1247Y3.5072
G1X3.1379Y3.4875
G1X3.1501Y3.4670
G1X3.1613Y3.4458
G1X3.1717Y3.4240
G1X3.1811Y3.4015
G1X3.1944Y3.3640
G1X3.4305Y3.3743
G1X3.4218Y3.4108

G1X3.4131Y3.4394
G1X3.4032Y3.4671
G1X3.3920Y3.4937
G1X3.3795Y3.5194
G1X3.3657Y3.5441
G1X3.3506Y3.5681
G1X3.3341Y3.5913
G1X3.3162Y3.6137
G1X3.2969Y3.6355
G1X3.2760Y3.6566
G1X3.2539Y3.6768
G1X3.2307Y3.6957
G1X3.2062Y3.7133
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