

Diagnostics

gSender 1.4.6

Environment

OS: Windows NT 10.0; Win64; x64

Homing: Disabled

Soft Limits: Disabled

Home Location: 11 (Back Right)

Report Inches: Disabled

Stepper Motors: Unlocked

Machine Profile

ID: 1

Company: Sienci Labs

Name: LongMill MK2

Type: 48x30

Version: MK2

Limits:

X Max: 1270

Y Max: 855

Z Max: 120

Spindle/Laser: false

Laser Mode Enabled: false

Connection

Available Ports:

0:

port: COM4

manufacturer: Microsoft

inuse: false

Connected Port: COM4

Baudrate: 115200

Unrecognized Ports:

0:

port: COM1

manufacturer: (Standard port types)

inuse: false

GRBL Information

Type: grblHAL

MPos:

a: 0.000

b: 0.000

c: 0.000

x: 48.768

y: 48.768

z: 0.000

WPos:

a: 0.000

b: 0.000

c: 0.000

x: 0.000

y: 0.000

z: 0.000

Sender Status:

Modal:

NULL

Tool: NULL

Workflow State: idle

Homing Flag: true

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	5.0
\$1	254
\$2	0
\$3	6
\$4	15
\$5	15
\$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	0
\$21	0
\$22	77
\$23	11
\$24	100.0
\$25	3000.0
\$26	25
\$27	1.500
\$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	0

\$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	800.000
\$101	800.000
\$102	800.000
\$103	19.753
\$110	5500.000
\$111	5500.000
\$112	4500.000
\$113	8000.000
\$120	1000.000
\$121	1000.000
\$122	750.000
\$123	1000.000
\$130	1270.000
\$131	855.000
\$132	120.000
\$133	0.000
\$140	2800
\$141	2800
\$142	2800
\$143	0
\$150	32
\$151	32
\$152	32
\$153	16
\$180	100.0

\$181	100.0
\$182	100.0
\$183	100.0
\$190	5000.0
\$191	5000.0
\$192	5000.0
\$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	0
\$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	1
\$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

4/13/2024, 1:50:11 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: N/A Controller: grbIHAL

4/13/2024, 1:17:35 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: grbIHAL

4/13/2024, 1:11:26 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: N/A Controller: grbIHAL

4/13/2024, 1:07:42 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: grbIHAL

4/13/2024, 1:06:01 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: T1 Controller: grbIHAL

4/13/2024, 1:02:01 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: T1 Controller: grbIHAL

4/13/2024, 12:59:50 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: T1 Controller: grbIHAL

4/13/2024, 9:53:55 AM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: grbIHAL

4/13/2024, 9:47:28 AM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: grbIHAL

4/13/2024, 9:42:58 AM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: T1 Controller: grbIHAL

4/13/2024, 9:42:51 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing

is highly recommended.

Input: T1 Controller: grbIHAL

4/13/2024, 9:41:35 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: G0X0.8975Y0.9068Z0.2000 Controller: grbIHAL

4/13/2024, 9:40:04 AM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: grbIHAL

4/12/2024, 11:10:32 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: grbIHAL

4/12/2024, 11:06:49 AM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: N/A Controller: grbIHAL

4/11/2024, 7:48:27 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: grbIHAL

4/11/2024, 7:46:28 PM

EStop asserted. Clear and reset

Input: N/A Controller: grbIHAL

4/11/2024, 7:46:28 PM

Homing fail. The active homing cycle was reset.

Input: N/A Controller: grbIHAL

4/11/2024, 6:32:22 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: grbIHAL

4/11/2024, 6:30:20 PM

EStop asserted. Clear and reset

Input: N/A Controller: grbIHAL

4/11/2024, 6:30:19 PM

Homing fail. The active homing cycle was reset.

Input: N/A Controller: grbIHAL

4/11/2024, 6:28:57 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: grbIHAL

4/11/2024, 6:28:48 PM

EStop asserted. Clear and reset

Input: N/A Controller: grbIHAL

4/11/2024, 6:28:47 PM

Homing fail. The active homing cycle was reset.

Input: N/A Controller: grblHAL

4/11/2024, 6:28:27 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: grblHAL

4/11/2024, 6:28:18 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

4/11/2024, 6:28:17 PM

Homing fail. The active homing cycle was reset.

Input: N/A Controller: grblHAL

4/11/2024, 6:02:49 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

4/11/2024, 3:37:14 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

4/10/2024, 11:32:08 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

4/10/2024, 11:29:25 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

4/8/2024, 5:03:51 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 5:03:46 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 5:02:09 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 4:02:22 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 4:00:32 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 3:55:59 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

4/8/2024, 3:54:48 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

4/8/2024, 3:53:56 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 3:50:43 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

4/8/2024, 3:34:26 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 3:33:25 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

4/8/2024, 3:24:32 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

4/8/2024, 3:23:58 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/8/2024, 3:23:21 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

4/8/2024, 1:09:14 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

4/8/2024, 1:07:43 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing

is highly recommended.

Input: X13.8961Y7.9672 Controller: Grbl

4/8/2024, 1:03:29 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

4/6/2024, 2:10:27 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

4/6/2024, 2:09:56 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

3/22/2024, 2:55:05 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

3/22/2024, 2:53:49 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

3/21/2024, 3:28:32 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:28:21 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:20:40 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

3/21/2024, 3:19:01 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

3/21/2024, 3:16:31 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

3/21/2024, 3:15:15 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

3/21/2024, 3:12:49 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:11:59 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

3/21/2024, 3:10:10 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:10:00 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:09:48 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:03:19 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:03:10 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/21/2024, 3:03:05 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/17/2024, 2:07:43 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: G1 X-1.327 Controller: Grbl

3/17/2024, 2:06:52 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

3/17/2024, 2:06:36 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

3/3/2024, 2:28:28 PM

Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.

Input: N/A Controller: Grbl

3/3/2024, 2:24:39 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 4:58:53 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

3/2/2024, 4:58:28 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

3/2/2024, 3:52:50 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 3:52:21 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 3:44:57 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

3/2/2024, 3:43:56 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 3:43:19 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

3/2/2024, 3:43:13 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 3:18:59 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

3/2/2024, 3:18:23 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.

Alarm may be safely unlocked.

Input: N/A Controller: Grbl

3/2/2024, 2:42:51 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 2:42:34 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 2:33:24 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 2:33:09 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 2:32:04 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

3/2/2024, 2:31:49 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

2/23/2024, 5:28:10 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: G1Z0.0400F145.0 Controller: Grbl

2/21/2024, 1:00:15 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

2/18/2024, 12:33:27 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/18/2024, 11:17:57 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/18/2024, 11:15:05 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: G1X0.9595Y0.7696Z-0.1117 Controller: Grbl

2/18/2024, 11:14:31 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/18/2024, 11:09:12 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 1:33:46 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

2/17/2024, 1:33:15 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 1:29:01 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 1:28:03 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 1:14:09 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/17/2024, 12:58:46 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

2/17/2024, 12:58:29 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 12:55:12 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 12:55:04 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

2/17/2024, 12:54:25 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 12:54:14 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 12:53:48 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 12:53:36 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

2/17/2024, 12:52:43 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/17/2024, 12:52:26 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: G0X0.0000Y0.0000 Controller: Grbl

2/17/2024, 12:50:50 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/17/2024, 12:50:23 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/17/2024, 12:48:25 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/17/2024, 12:42:59 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

2/17/2024, 12:42:49 PM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/14/2024, 12:06:11 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.

Alarm may be safely unlocked.

Input: \$\$ Controller: Grbl

2/14/2024, 12:02:13 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/14/2024, 12:01:49 PM

Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.

Input: N/A Controller: Grbl

2/14/2024, 12:01:29 PM

Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.

Input: N/A Controller: Grbl

2/14/2024, 11:57:42 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

2/14/2024, 11:56:41 AM

Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: N/A Controller: Grbl

2/14/2024, 11:55:47 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/14/2024, 11:52:24 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/14/2024, 11:50:32 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/14/2024, 11:48:30 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/14/2024, 11:47:18 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/14/2024, 11:46:45 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/14/2024, 11:45:30 AM

Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.

Input: N/A Controller: Grbl

2/14/2024, 11:44:17 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/9/2024, 11:39:37 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/9/2024, 11:38:23 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/9/2024, 11:36:47 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/9/2024, 11:35:38 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/9/2024, 11:35:04 AM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/5/2024, 10:37:03 PM

Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.

Input: \$H Controller: Grbl

2/4/2024, 3:55:29 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/4/2024, 3:50:54 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/4/2024, 3:11:07 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: G0X0.0000Y0.0000 Controller: Grbl

2/4/2024, 3:10:27 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: G0X0.0000Y0.0000 Controller: Grbl

2/4/2024, 12:19:08 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/4/2024, 12:17:55 PM

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: T1 Controller: Grbl

2/4/2024, 12:16:11 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/4/2024, 12:14:42 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/4/2024, 12:14:03 PM

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.

Input: N/A Controller: Grbl

2/4/2024, 11:48:51 AM

Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.

Input: N/A Controller: Grbl

1/27/2024, 11:06:05 AM

Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.

Input: \$H Controller: Grbl

Recent Errors

4/13/2024, 10:36:42 AM

Setting value is out of range.

Input: N/A Controller: grblHAL

4/13/2024, 9:46:53 AM

Repeated g-code word found in block.

Input: X7.0872Z-0.6878 Controller: grblHAL

4/13/2024, 9:46:53 AM

Repeated g-code word found in block.

Input: X7.6791Z-0.6862 Controller: grblHAL

4/8/2024, 3:57:46 PM

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

Input: N/A Controller: Grbl

4/8/2024, 3:39:51 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

4/8/2024, 1:08:21 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

4/6/2024, 12:53:11 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

4/6/2024, 12:52:43 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

4/6/2024, 12:52:42 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

4/6/2024, 12:52:29 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

4/6/2024, 12:52:27 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 3:00:42 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 3:00:42 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 3:00:37 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 3:00:36 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 2:58:52 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 2:58:49 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 2:58:48 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 2:58:48 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 2:58:47 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/21/2024, 1:57:51 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/3/2024, 2:28:18 PM

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

Input: N/A Controller: Grbl

3/2/2024, 3:54:06 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 3:15:12 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 3:15:10 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 3:15:08 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 2:38:01 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 2:37:43 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 2:31:10 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 2:31:08 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 2:31:07 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

3/2/2024, 2:31:07 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/28/2024, 1:54:36 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/28/2024, 1:54:35 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/22/2024, 1:00:16 PM

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

Input: N/A Controller: Grbl

2/21/2024, 1:13:57 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/18/2024, 12:38:40 PM

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

Input: N/A Controller: Grbl

2/17/2024, 12:58:46 PM

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

Input: N/A Controller: Grbl

2/14/2024, 11:45:20 AM

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

Input: N/A Controller: Grbl

2/5/2024, 11:09:23 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 11:09:22 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 11:04:51 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 11:04:50 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 11:04:49 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 10:32:22 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 10:31:33 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 10:31:31 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 10:31:30 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 10:29:42 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 10:29:29 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/5/2024, 10:29:27 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:48:41 AM

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

Input: N/A Controller: Grbl

2/4/2024, 11:42:07 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:42:03 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:41:57 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:41:56 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:41:54 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:41:23 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:41:23 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:41:22 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:41:20 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:40:59 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/4/2024, 11:40:20 AM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/3/2024, 1:41:21 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/3/2024, 1:19:39 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/3/2024, 12:36:54 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/3/2024, 12:36:53 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/1/2024, 1:46:52 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:52 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:52 PM

Unsupported or invalid g-code command found in block.

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

Unsupported or invalid g-code command found in block.

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

Unsupported or invalid g-code command found in block.

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:51 PM

Jog command has no '=' or contains prohibited g-code.

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

Unsupported or invalid g-code command found in block.

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:50 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:49 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:49 PM

More than one g-code command from same modal group found in block.

Input: N/A Controller: Grbl

2/1/2024, 1:46:49 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:49 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:49 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:49 PM

Unsupported or invalid g-code command found in block.

Input: N/A Controller: Grbl

2/1/2024, 1:46:49 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:48 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:47 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:47 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:47 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:47 PM

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

Input: N/A Controller: Grbl

2/1/2024, 1:46:29 PM

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

Input: \$\$ Controller: Grbl

2/1/2024, 1:16:44 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

2/1/2024, 1:16:43 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

1/26/2024, 12:51:44 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

1/26/2024, 12:49:43 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

1/26/2024, 12:49:42 PM

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A Controller: Grbl

Terminal History

```
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
$H
[MSG:]
ok
$25=3000
ok
$$
$0=5.0 (Step pulse time, $)
$1=254 (Step idle delay, ms)
$2=0 (Step pulse invert, mask)
$3=6 (Step direction invert, mask)
$4=15 (Invert step enable pin, boolean)
$5=15 (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=0 (Soft limits enable, boolean)
$21=0 (Hard limits enable, mask)
$22=77 (Homing cycle enable, mask)
$23=11 (Homing direction invert, mask)
$24=100.0 (Homing locate feed rate, mm/min)
$25=3000.0 (Homing search seek rate, mm/min)
$26=25 (Homing switch debounce delay, ms)
$27=1.500 (Homing switch pull-off distance, mm)
$28=0.100 (G73 pull-off distance, mm)
$29=0.0 (Step Pulse Delay, $)
$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=0 (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=800.000 (X-axis travel resolution, step/mm)
\$101=800.000 (Y-axis travel resolution, step/mm)
\$102=800.000 (Z-axis travel resolution, step/mm)
\$103=19.753
\$110=5500.000 (X-axis maximum rate, mm/min)
\$111=5500.000 (Y-axis maximum rate, mm/min)
\$112=4500.000 (Z-axis maximum rate, mm/min)
\$113=8000.000
\$120=1000.000 (X-axis acceleration, mm/sec²)
\$121=1000.000 (Y-axis acceleration, mm/sec²)
\$122=750.000 (Z-axis acceleration, mm/sec²)
\$123=1000.000
\$130=1270.000 (X-axis maximum travel, mm)
\$131=855.000 (Y-axis maximum travel, mm)
\$132=120.000 (Z-axis maximum travel, mm)
\$133=0.000
\$140=2800
\$141=2800
\$142=2800
\$143=0
\$150=32
\$151=32
\$152=32
\$153=16
\$180=100.0
\$181=100.0
\$182=100.0
\$183=100.0
\$190=5000.0
\$191=5000.0

\$192=5000.0
\$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=0
\$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=1
\$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
\$J=G20G91 Y1.92 F118
ok
\$J=G20G91 X1.92 F118
ok
\$J=G20G91 Z-0.079 F118
ok
\$J=G20G91 Z-0.079 F118
ok
\$J=G20G91 Z-0.079 F118
ok
\$J=G20G91 Z-0.079 F118
ok
\$H

[MSG:]

ok

G55

ok

\$J=G20G91 Y1.92 F118

ok

\$J=G20G91 X1.92 F118

ok

G10 L20 P2 X0 Y0 Z0

ok

\$J=G20G91 X1.92 Y1.92 F118

ok

\$J=G20G91 X1.92 Y1.92 F118

ok

G90

G0 X0 Y0

ok

ok

G54

ok

\$H

[MSG:]

ok

G10 L20 P1 X0 Y0 Z0

ok

\$J=G20G91 X1.92 Y1.92 F118

ok

G90

G0 X0 Y0

ok

ok

G55

ok

\$J=G20G91 X1.92 Y1.92 F118

ok

\$J=G20G91 X1.92 Y1.92 F118

ok

\$J=G20G91 X1.92 Y1.92 F118

ok

G90

G0 X0 Y0

ok

ok

G54

ok

\$H

[MSG:]

ok

G55

ok

G90

G0 X0 Y0

ok

ok

G54

ok

\$H
[MSG:]
ok
G55
ok
G90
G0 X0 Y0
ok
ok
\$H
[MSG:]
ok
G10 L20 P2 X0 Y0 Z0
ok
G54
ok
G10 L20 P1 X0 Y0 Z0
ok
G55
ok
\$J=G20G91 X1.92 Y1.92 F118
ok
G10 L20 P2 X0 Y0 Z0
ok
\$J=G20G91 X1.92 Y1.92 F118
ok
\$J=G20G91 X1.92 Y1.92 F118
ok
G90
G0 X0 Y0
ok
ok

G-Code File

Status	Value
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No File Loaded