# Diagnostics

gSender 1.4.6

## Environment

**OS:** Macintosh; Intel Mac OS X 10_15_7
**Homing:** Disabled
**Soft Limits:** Enabled
**Home Location:** 3 (Front Left)
**Report Inches:** Disabled
**Stepper Motors:** Unlocked

## Machine Profile

**ID:** 1
**Company:** Sienci Labs
**Name:** LongMill MK2
**Type:** 48x30
**Version:** MK2
**Limits:**
  X Max: 1273
  Y Max: 855
  Z Max: 120
**Spindle/Laser:** false
**Laser Mode Enabled:** false

## Connection

**Available Ports:**
  0:
    port: /dev/tty.usbmodem204E337742301
    manufacturer: STMicroelectronics
    inuse: false
**Connected Port:** /dev/tty.usbmodem204E337742301
**Baudrate:** 115200
**Unrecognized Ports:**
  0:
    port: /dev/tty.Bluetooth-Incoming-Port
    inuse: false
  1:
    port: /dev/tty.WONDERBOOM3-SPPDev
    inuse: false

## GRBL Information

**Type:** grblHAL
**MPos:**
  a: 0.000
  b: 0.000
  c: 0.000
  x: 282.619
  y: 108.331
  z: -67.248
**WPos:**
  a: 0.000
  b: 0.000
  c: 0.000
  x: 181.019
  y: 6.731
  z: -1.398
**Sender Status:**
  Modal:
    motion: G1
    wcs: G54
    plane: G17
    units: G21
    distance: G90
    feedrate: G94
    spindle: M3
    coolant: M9
  Tool: NULL
**Workflow State:** idle
**Homing Flag:** true

# **<u>Preferences</u>**

**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 | 1 |
| $21 | 1 |
| $22 | 77 |
| $23 | 3 |
| $24 | 100.0 |
| $25 | 5000.0 |
| $26 | 250 |
| $27 | 1.500 |
| $28 | 0.100 |
| $29 | 0.0 |
| $30 | 24000.000 |
| $31 | 8500.000 |
| $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 | 2 |
| $46 | 1 |
| $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 | 750.000 |
| $121 | 750.000 |
| $122 | 750.000 |
| $123 | 1000.000 |
| $130 | 1273.000 |
| $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

4/18/2024, 11:20:48 PM
   EStop asserted. Clear and reset
   Input: g0x4y4    Controller: grblHAL

4/18/2024, 11:18:42 PM
   EStop asserted. Clear and reset
   Input: G1X154.047Y98.928    Controller: grblHAL

4/18/2024, 11:14:52 PM
   EStop asserted. Clear and reset
   Input: G1X6.831Y23.742    Controller: grblHAL

4/18/2024, 8:50:01 PM
   EStop asserted. Clear and reset
   Input: G1X6.831Y23.742    Controller: grblHAL

4/18/2024, 8:48:45 PM
   EStop asserted. Clear and reset
   Input: G1X168.662Y95.879    Controller: grblHAL

4/18/2024, 8:48:28 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: grblHAL

4/18/2024, 8:40:02 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: grblHAL

4/18/2024, 8:37:38 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/18/2024, 8:37:09 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: grblHAL

4/18/2024, 8:36:37 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/18/2024, 8:35:30 PM
   EStop asserted. Clear and reset
   Input: (VECTRIC POST REVISION)    Controller: grblHAL

4/18/2024, 8:33:01 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/18/2024, 7:49:28 PM
  EStop asserted. Clear and reset
  Input: G1X6.831Y23.742    Controller: grblHAL

4/18/2024, 7:45:27 PM
  EStop asserted. Clear and reset
  Input: T1    Controller: grblHAL

4/18/2024, 7:44:43 PM
  EStop asserted. Clear and reset
  Input: T1    Controller: grblHAL

4/18/2024, 7:41:30 PM
  EStop asserted. Clear and reset
  Input: G1X6.831Y23.742    Controller: grblHAL

4/18/2024, 7:34:04 PM
  Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check
wiring.
  Input: (VECTRIC POST REVISION)    Controller: grblHAL

4/18/2024, 7:33:48 PM
  Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing
is highly recommended.
  Input: N/A    Controller: grblHAL

4/18/2024, 7:25:06 PM
  EStop asserted. Clear and reset
  Input: G1X6.831Y23.742    Controller: grblHAL

4/18/2024, 6:59:33 PM
  EStop asserted. Clear and reset
  Input: T1    Controller: grblHAL

4/18/2024, 6:58:25 PM
  EStop asserted. Clear and reset
  Input: N/A    Controller: grblHAL

4/18/2024, 6:52:59 PM
  EStop asserted. Clear and reset
  Input: T1    Controller: grblHAL

4/18/2024, 6:50:20 PM
  EStop asserted. Clear and reset
  Input: N/A    Controller: grblHAL

4/18/2024, 5:04:04 PM
  EStop asserted. Clear and reset
  Input: g0x30    Controller: grblHAL

4/17/2024, 10:52:53 PM
  Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check
wiring.
  Input: N/A    Controller: grblHAL

4/17/2024, 10:49:10 PM
  Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check

wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:47:32 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:46:06 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:45:46 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:44:54 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:44:02 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:43:15 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:42:18 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:41:00 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:40:18 PM
    EStop asserted. Clear and reset
    Input: N/A    Controller: grblHAL

4/17/2024, 10:38:34 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:37:17 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 10:34:38 PM
   Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: N/A    Controller: grblHAL

4/17/2024, 10:27:58 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 10:27:46 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: N/A    Controller: grblHAL

4/17/2024, 10:26:09 PM
   Homing fail. The active homing cycle was reset.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:41:01 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:39:58 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:35:47 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:35:23 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:35:12 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:30:59 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:28:19 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/17/2024, 9:27:44 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check

wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:25:58 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:24:51 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:17:26 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:16:31 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:13:09 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:12:00 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:10:28 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:08:30 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:07:56 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:06:39 PM
    EStop asserted. Clear and reset
    Input: N/A    Controller: grblHAL

4/17/2024, 9:06:04 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 9:05:17 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 9:04:26 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 9:01:50 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 9:01:10 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 8:58:36 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 8:57:39 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 8:57:15 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 8:57:07 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 8:57:00 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A    Controller: grblHAL

4/17/2024, 8:56:36 PM
Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
Input: N/A    Controller: grblHAL

4/17/2024, 8:46:05 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A    Controller: grblHAL

4/17/2024, 8:44:46 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check

wiring.
    Input: N/A    Controller: grblHAL

4/17/2024, 8:38:34 PM
    Homing required. Execute homing command ($H) to continue.
    Input: N/A    Controller: grblHAL

4/17/2024, 8:35:13 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/16/2024, 9:15:06 PM
    EStop asserted. Clear and reset
    Input: N/A    Controller: grblHAL

4/16/2024, 9:14:30 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/16/2024, 9:13:53 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/16/2024, 9:13:27 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/16/2024, 9:11:28 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/16/2024, 9:10:19 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: g0y3    Controller: grblHAL

4/16/2024, 9:07:44 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

4/16/2024, 9:05:28 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/16/2024, 9:03:24 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A    Controller: grblHAL

4/16/2024, 9:02:01 PM
    Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
    Input: N/A     Controller: grblHAL

4/16/2024, 9:01:24 PM
    EStop asserted. Clear and reset
    Input: N/A     Controller: grblHAL

4/16/2024, 9:01:23 PM
    Homing fail. The active homing cycle was reset.
    Input: N/A     Controller: grblHAL

4/16/2024, 8:59:55 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

4/16/2024, 8:58:17 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

4/16/2024, 8:58:02 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

4/16/2024, 8:57:00 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A     Controller: grblHAL

4/16/2024, 8:56:34 PM
    Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
    Input: N/A     Controller: grblHAL

4/16/2024, 8:52:19 PM
    Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
    Input: N/A     Controller: grblHAL

4/16/2024, 8:52:11 PM
    EStop asserted. Clear and reset
    Input: N/A     Controller: grblHAL

4/16/2024, 8:52:11 PM
    Homing fail. The active homing cycle was reset.
    Input: N/A     Controller: grblHAL

4/16/2024, 8:43:23 PM
    Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
    Input: N/A     Controller: grblHAL

4/16/2024, 8:43:14 PM
 EStop asserted. Clear and reset
 Input: N/A    Controller: grblHAL

4/16/2024, 8:43:14 PM
 Homing fail. The active homing cycle was reset.
 Input: N/A    Controller: grblHAL

4/16/2024, 8:42:01 PM
 Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
 Input: g0x3    Controller: grblHAL

4/16/2024, 8:40:53 PM
 Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
 Input: N/A    Controller: grblHAL

4/16/2024, 8:39:48 PM
 Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
 Input: N/A    Controller: grblHAL

4/16/2024, 8:33:23 PM
 Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
 Input: N/A    Controller: grblHAL

4/16/2024, 8:32:37 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

4/16/2024, 8:31:03 PM
 Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
 Input: N/A    Controller: grblHAL

4/16/2024, 8:29:12 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

4/16/2024, 8:28:56 PM
 Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
 Input: N/A    Controller: grblHAL

4/16/2024, 8:28:48 PM
 EStop asserted. Clear and reset
 Input: N/A    Controller: grblHAL

4/16/2024, 8:28:47 PM
 Homing fail. The active homing cycle was reset.
 Input: N/A    Controller: grblHAL

4/16/2024, 8:27:55 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/16/2024, 8:17:37 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/16/2024, 8:16:57 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/16/2024, 8:16:41 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/16/2024, 8:06:14 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/16/2024, 7:41:49 PM
   Spindle at speed timeout. Clear before continuing.
   Input: N/A    Controller: grblHAL

4/16/2024, 7:37:46 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: N/A    Controller: grblHAL

4/16/2024, 7:36:14 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: g0x3y3    Controller: grblHAL

4/16/2024, 7:34:12 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/16/2024, 7:31:12 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/16/2024, 7:28:22 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
   Input: N/A    Controller: grblHAL

4/16/2024, 7:25:27 PM
   Homing required. Execute homing command ($H) to continue.
   Input: N/A    Controller: grblHAL

4/16/2024, 7:21:31 PM
   EStop asserted. Clear and reset
   Input: N/A    Controller: grblHAL

4/16/2024, 7:16:43 PM
　EStop asserted. Clear and reset
　Input: N/A　　Controller: grblHAL

4/8/2024, 2:19:49 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

4/8/2024, 2:19:24 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

4/6/2024, 8:37:11 PM
　Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
　Input: g0z-.04　　Controller: Grbl

4/2/2024, 7:55:16 PM
　Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
　Input: N/A　　Controller: Grbl

4/2/2024, 7:54:53 PM
　Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
　Input: N/A　　Controller: Grbl

4/2/2024, 7:54:29 PM
　Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.
　Input: N/A　　Controller: Grbl

4/2/2024, 7:53:58 PM
　Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
　Input: N/A　　Controller: Grbl

4/2/2024, 7:53:36 PM
　Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
　Input: N/A　　Controller: Grbl

4/1/2024, 7:44:46 PM
　Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
　Input: g0x1y1　　Controller: Grbl

4/1/2024, 7:32:19 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

3/25/2024, 8:32:41 PM
　Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.

Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

3/25/2024, 8:09:09 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

3/18/2024, 9:41:08 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

3/16/2024, 7:52:02 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: G1X753.882F1524.0    Controller: Grbl

3/16/2024, 7:51:50 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: G1X722.132Z-11.430    Controller: Grbl

3/16/2024, 7:51:26 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: G1X722.132Z-11.430    Controller: Grbl

3/16/2024, 7:49:49 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

3/16/2024, 5:41:06 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: g0x4y.5    Controller: Grbl

3/16/2024, 5:05:51 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

3/16/2024, 5:05:37 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

3/16/2024, 5:05:35 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

3/16/2024, 5:05:33 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

3/16/2024, 5:05:31 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

3/16/2024, 5:05:29 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

3/16/2024, 5:05:28 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

3/16/2024, 5:05:26 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

3/16/2024, 5:05:23 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

3/16/2024, 5:05:21 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

3/16/2024, 5:05:16 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

3/15/2024, 7:00:41 PM
   Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: (VECTRIC POST REVISION)     Controller: Grbl

3/14/2024, 8:49:39 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
   Input: N/A     Controller: Grbl

3/14/2024, 8:20:43 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
   Input: N/A     Controller: Grbl

3/14/2024, 8:05:16 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
   Input: N/A     Controller: Grbl

3/14/2024, 7:34:40 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:34:13 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:32:05 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:31:19 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:24:16 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:22:46 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:19:38 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: N/A    Controller: Grbl

3/14/2024, 7:19:10 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:19:03 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: G1X28.016Z1.270F2032.0    Controller: Grbl

3/14/2024, 7:14:39 PM
Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.
Input: N/A    Controller: Grbl

3/14/2024, 7:13:50 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
Input: N/A    Controller: Grbl

3/14/2024, 7:13:10 PM
Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.

Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

3/14/2024, 7:12:57 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

3/14/2024, 7:12:30 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

2/25/2024, 11:45:36 AM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained.
Alarm may be safely unlocked.
   Input: N/A    Controller: Grbl

2/10/2024, 10:53:27 AM
   Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and
G38.4.
   Input: g0x3y3    Controller: Grbl

2/7/2024, 6:16:11 PM
   Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly
recommended.
   Input: (Header)    Controller: Grbl

2/7/2024, 6:08:24 PM
   Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly
recommended.
   Input: (Header)    Controller: Grbl

2/7/2024, 6:07:00 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check
wiring.
   Input: $H    Controller: Grbl

2/7/2024, 6:06:18 PM
   Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly
recommended.
   Input: (Header)    Controller: Grbl

2/7/2024, 6:03:38 PM
   Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check
wiring.
   Input: $H    Controller: Grbl

2/7/2024, 6:03:21 PM
   Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly
recommended.
   Input: g0x42.5    Controller: Grbl

2/6/2024, 8:38:23 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing
is highly recommended.
   Input: g0x-25    Controller: Grbl

2/4/2024, 4:49:28 PM
   Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: g0x-24.9    Controller: Grbl

2/4/2024, 4:41:09 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
   Input: g0x24.9    Controller: Grbl

2/4/2024, 3:29:42 PM
   Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.
   Input: g0x24.9    Controller: Grbl

2/4/2024, 3:21:05 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: (VECTRIC POST REVISION)    Controller: Grbl

2/4/2024, 3:21:03 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: (VECTRIC POST REVISION)    Controller: Grbl

2/4/2024, 3:20:59 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: (VECTRIC POST REVISION)    Controller: Grbl

2/4/2024, 3:20:30 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: (VECTRIC POST REVISION)    Controller: Grbl

2/4/2024, 3:19:44 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: (VECTRIC POST REVISION)    Controller: Grbl

2/4/2024, 3:19:33 PM
   Hard limit has been triggered. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.
   Input: (VECTRIC POST REVISION)    Controller: Grbl

2/4/2024, 3:15:27 PM
   Probe fail. Probe did not contact the workpiece within the programmed travel for G38.2 and G38.4.
   Input: g0x-24.2    Controller: Grbl


# Recent Errors

4/1/2024, 9:41:37 PM
G-code words consist of a letter and a value. Letter was not found.
Input: g0x3y3    Controller: Grbl

4/1/2024, 8:36:06 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

4/1/2024, 8:36:05 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: g0x.625y.625    Controller: Grbl

4/1/2024, 7:33:52 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

4/1/2024, 7:33:52 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

4/1/2024, 7:33:52 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

4/1/2024, 7:33:51 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

4/1/2024, 7:33:51 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

3/17/2024, 1:02:15 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

3/17/2024, 1:02:11 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

3/17/2024, 1:02:10 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

3/17/2024, 1:02:10 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

3/17/2024, 1:02:10 PM
Jog target exceeds machine travel. Jog command has been ignored.
Input: N/A    Controller: Grbl

3/17/2024, 1:02:08 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/17/2024, 1:02:03 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/17/2024, 1:02:03 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/17/2024, 1:02:02 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/17/2024, 1:01:58 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/17/2024, 1:01:56 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/16/2024, 5:05:10 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/16/2024, 5:05:10 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/16/2024, 5:05:10 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: g0y.5    Controller: Grbl

3/14/2024, 7:34:30 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/14/2024, 7:34:29 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/14/2024, 7:34:29 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/14/2024, 7:34:29 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/14/2024, 7:34:29 PM
   Jog target exceeds machine travel. Jog command has been ignored.
   Input: N/A    Controller: Grbl

3/14/2024, 7:34:29 PM
  Jog target exceeds machine travel. Jog command has been ignored.
  Input: N/A    Controller: Grbl

3/14/2024, 7:34:28 PM
  Jog target exceeds machine travel. Jog command has been ignored.
  Input: N/A    Controller: Grbl

3/14/2024, 7:34:28 PM
  Jog target exceeds machine travel. Jog command has been ignored.
  Input: N/A    Controller: Grbl

3/14/2024, 7:15:10 PM
  Jog target exceeds machine travel. Jog command has been ignored.
  Input: N/A    Controller: Grbl

2/10/2024, 10:53:49 AM
  Grbl $' system command was not recognized or supported.
  Input: N/A    Controller: Grbl

2/4/2024, 3:20:56 PM
  Jog target exceeds machine travel. Jog command has been ignored.
  Input: N/A    Controller: Grbl

2/4/2024, 3:20:56 PM
  Jog target exceeds machine travel. Jog command has been ignored.
  Input: N/A    Controller: Grbl

2/4/2024, 3:20:56 PM
  Jog target exceeds machine travel. Jog command has been ignored.
  Input: N/A    Controller: Grbl

# Terminal History

G1X6.995Y24.486
ok
G1X7.203Y25.224
G1X7.452Y25.956
ok
G1X7.741Y26.681
ok
G1X8.068Y27.400
ok
G1X8.431Y28.113
ok
G1X8.829Y28.820
ok
G1X9.262Y29.521
ok
G1X9.728Y30.216
ok
G1X10.226Y30.906
ok
G1X10.755Y31.591

```
ok
G1X11.315Y32.270
ok
G1X11.906Y32.945
ok
G1X12.526Y33.614
ok
G1X13.176Y34.278
ok
G1X13.854Y34.937
ok
G1X14.560Y35.591
ok
G1X15.294Y36.239
ok
G1X16.055Y36.881
ok
G1X16.842Y37.517
ok
G1X17.656Y38.147
ok
G1X18.496Y38.771
ok
G1X19.360Y39.388
ok
G1X20.250Y39.997
ok
ok
G1X21.152Y40.591
ok
G1X27.633Y44.795
ok
G1X33.901Y48.886
ok
G1X45.881Y56.731
ok
G1X51.614Y60.472
ok
G1X57.191Y64.084
ok
G1X62.622Y67.561
ok
G1X67.916Y70.894
ok
G1X70.520Y72.508
ok
G1X73.092Y74.083
ok
G1X75.636Y75.619
ok
G1X78.153Y77.116
ok
G1X80.646Y78.573
ok
G1X83.114Y79.989
ok
```

```
G1X85.560Y81.363
ok
G1X87.985Y82.695
ok
G1X90.391Y83.984
ok
G1X92.778Y85.228
ok
G1X95.148Y86.427
ok
G1X97.504Y87.580
ok
G1X99.845Y88.686
ok
G1X102.174Y89.745
ok
ok
G1X104.491Y90.755
ok
G1X106.799Y91.716
ok
G1X109.098Y92.626
ok
G1X111.391Y93.485
ok
G1X113.677Y94.292
ok
G1X115.960Y95.045
ok
G1X118.239Y95.745
ok
G1X120.516Y96.389
ok
ok
G1X122.793Y96.976
ok
G1X125.071Y97.507
ok
G1X127.350Y97.980
ok
G1X129.632Y98.393
ok
G1X131.919Y98.746
ok
G1X134.201Y99.037
ok
G1X135.359Y99.161
ok
G1X136.509Y99.268
ok
ok
G1X137.660Y99.360
ok
G1X138.814Y99.436
ok
G1X139.970Y99.495
```

```
ok
G1X141.128Y99.539
ok
G1X142.288Y99.566
ok
G1X143.451Y99.577
ok
G1X144.616Y99.572
ok
G1X145.784Y99.550
ok
G1X146.955Y99.512
ok
G1X148.129Y99.457
ok
G1X149.306Y99.385
ok
G1X150.486Y99.296
ok
ok
G1X151.670Y99.191
ok
G1X152.857Y99.068
ok
G1X154.047Y98.928
ok
G1X155.241Y98.770
ok
G1X156.439Y98.596
ok
G1X157.641Y98.404
ok
G1X158.848Y98.194
ok
G1X160.058Y97.967
ok
G1X161.273Y97.723
ok
G1X162.492Y97.460
ok
G1X163.716Y97.180
ok
G1X164.945Y96.882
ok
G1X166.179Y96.565
ok
G1X167.418Y96.231
ok
G1X168.662Y95.879
ok
G1X169.912Y95.508
ok
G1X171.167Y95.119
ok
ok
G1X172.428Y94.712
```

```
ok
G1X173.694Y94.286
ok
G1X174.967Y93.842
ok
G1X176.246Y93.379
ok
G1X177.539Y92.895
ok
G1X180.122Y91.878
ok
G1X182.740Y90.782
ok
G1X184.577Y89.967
ok
G1X186.409Y89.105
ok
G1X188.231Y88.197
ok
G1X190.043Y87.240
ok
G1X191.839Y86.236
ok
G1X193.619Y85.184
ok
G1X195.379Y84.083
ok
G1X197.117Y82.933
ok
G1X198.829Y81.733
ok
G1X200.512Y80.483
ok
G1X202.156Y79.189
ok
G1X202.977Y78.513
ok
G1X203.781Y77.831
ok
G1X204.576Y77.136
ok
G1X205.362Y76.428
ok
G1X206.137Y75.707
ok
G1X206.902Y74.972
ok
G1X207.656Y74.225
ok
G1X208.399Y73.464
ok
G1X209.131Y72.691
ok
G1X209.850Y71.904
ok
G1X210.557Y71.103
```

```
ok
G1X211.251Y70.289
ok
G1X211.933Y69.462
ok
G1X212.601Y68.621
ok
G1X213.254Y67.767
ok
G1X213.894Y66.899
ok
G1X214.519Y66.017
ok
G1X215.129Y65.122
ok
G1X215.723Y64.214
ok
G1X216.301Y63.291
ok
G1X216.863Y62.355
ok
G1X217.409Y61.405
ok
G1X217.937Y60.441
ok
G1X218.448Y59.464
ok
G1X218.941Y58.472
ok
G1X219.415Y57.467
ok
G1X219.871Y56.449
ok
G1X220.307Y55.416
ok
G1X220.725Y54.370
ok
G1X221.122Y53.310
ok
G1X221.499Y52.236
ok
G1X221.855Y51.149
ok
G1X222.190Y50.048
ok
G1X222.504Y48.933
ok
G1X222.796Y47.805
ALARM:10 (EStop asserted. Clear and reset)
[MSG:Emergency stop - clear, then reset to continue]
\x18
$X
\x18
GrblHAL 1.1f ['$' or '$HELP' for help]
$X
```

ok
$H

# G-Code File

| Status | Value |
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| Received | 54.961099999999995 |
| Total | 588 |

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