

# Diagnostics

gSender 1.4.11

## Environment

**OS:** X11; Linux x86\_64

**Homing:** Enabled

**Soft Limits:** Enabled

**Home Location:** 11 (Front Left)

**Report Inches:** Disabled

**Stepper Motors:** Unlocked

## Machine Profile

**ID:** 30

**Company:**

**Name:** Generic CNC

**Type:**

**Version:** undefined

**Limits:**

X Max: 296

Y Max: 228

Z Max: 74

**Spindle/Laser:** false

**Laser Mode Enabled:** false

## Connection

**Available Ports:**

0:

port: /dev/ttyACM0

manufacturer: STMicroelectronics

inuse: false

**Connected Port:** /dev/ttyACM0

**Baudrate:** 115200

**Unrecognized Ports:**

0:

port: /dev/ttyS0

inuse: false

1:

port: /dev/ttyS1

inuse: false

2:

port: /dev/ttyS2

inuse: false

3:

port: /dev/ttyS3

inuse: false

## GRBL Information

**Type:** grblHAL

**Firmware Version:** SuperLongBoard\_B5.0.5b

**MPos:**

a: 0.000

b: 0.000

c: 0.000

x: 0.000

y: 0.000

z: 111.000

**WPos:**

a: 0.000

b: 0.000

c: 0.000

x: -43.667

y: -32.666

z: 164.249

**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: 3000

Normal:

xyStep: 5  
zStep: 2  
aStep: 5  
xaStep: 5  
feedrate: 2000

Precise:

xyStep: 0.5  
zStep: 0.1  
aStep: 0.5  
xaStep: 0.5  
feedrate: 1000

**Workspace Units:** mm

**Laser:** Disabled

**Rotary:** Disabled

## EEPROM Values

Setting	Value
\$0	5.0
\$1	254
\$2	0
\$3	2
\$4	15
\$5	8
\$6	1
\$8	0
\$9	1
\$10	511
\$11	0.010
\$12	0.002
\$13	0
\$14	14
\$15	0
\$16	0
\$17	0
\$18	0
\$19	0
\$20	1
\$21	1
\$22	79
\$23	11
\$24	110.0
\$25	600.0
\$26	75
\$27	2.000
\$28	0.100
\$29	0.0
\$30	24000.000
\$31	7500.000
\$32	0
\$33	1000.0
\$34	0.0
\$35	0.0
\$36	100.0
\$37	0
\$39	1
\$40	1

\$41	1
\$42	2
\$43	1
\$44	4
\$45	3
\$46	0
\$47	0
\$56	5.0
\$57	100.0
\$58	-5.0
\$59	500.0
\$60	1
\$61	3
\$62	0
\$63	3
\$64	0
\$65	0
\$70	11
\$100	1600.000
\$101	1600.000
\$102	3200.000
\$103	79.012
\$110	3000.000
\$111	3000.000
\$112	700.000
\$113	8000.000
\$120	750.000
\$121	750.000
\$122	200.000
\$123	1000.000
\$130	296.000
\$131	228.000
\$132	74.000
\$133	0.000
\$140	2000
\$141	2000
\$142	1800
\$143	0
\$150	32
\$151	32
\$152	32
\$153	16
\$180	110.0

\$181	110.0
\$182	110.0
\$183	150.0
\$190	600.0
\$191	600.0
\$192	600.0
\$193	4300.0
\$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	11.0

\$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
\$478	3
\$481	0
\$484	0
\$486	0
\$511	7
\$512	5
\$513	8
\$520	0
\$521	0
\$522	0
\$650	1
\$651	1
\$652	0
\$653	2
\$654	8
\$655	0
\$656	1
\$657	22
\$658	7
\$659	3

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

## Recent Alarms

12/17/2024, 12:02:29 PM

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

Input: N/A Controller: grblHAL

11/27/2024, 4:21:34 PM

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

Input: G0 X241.100 Y121.100 Controller: grblHAL

11/27/2024, 3:59:50 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

11/27/2024, 3:58:36 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

11/27/2024, 3:46:14 PM

Homing required. Execute homing command (\$H) to continue.

Input: \$\$ Controller: grblHAL

11/2/2024, 11:22:18 PM

EStop asserted. Clear and reset

Input: \$ Controller: grblHAL

9/22/2024, 10:22:49 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

9/22/2024, 4:19:41 PM

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

Input: N/A Controller: grblHAL

9/22/2024, 4:19:41 PM

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

Input: N/A Controller: grblHAL

9/22/2024, 4:14:02 PM

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

Input: N/A Controller: grblHAL

9/22/2024, 4:12:25 PM

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

Input: N/A Controller: grblHAL

9/22/2024, 4:10:43 PM

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



Alarm may be safely unlocked.

Input: N/A Controller: grblHAL

9/22/2024, 4:09:51 PM

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

Input: N/A Controller: grblHAL

9/22/2024, 4:09:12 PM

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

Input: N/A Controller: grblHAL

9/22/2024, 4:08:02 PM

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

Input: N/A Controller: grblHAL

9/18/2024, 3:51:50 PM

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

Input: G0 Z36.000 Controller: grblHAL

9/18/2024, 3:50:27 PM

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

Input: G0 Z18.000 Controller: grblHAL

9/5/2024, 3:30:57 PM

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

Input: N/A Controller: grblHAL

9/3/2024, 5:45:41 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

9/2/2024, 4:33:06 PM

EStop asserted. Clear and reset

Input: \$# Controller: grblHAL

9/2/2024, 3:02:04 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:47:02 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:36:20 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:35:10 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:27:12 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:25:45 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 11:55:22 AM

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

Input: N/A Controller: grblHAL

9/1/2024, 4:36:28 PM

EStop asserted. Clear and reset

Input: g0 y-46.87 Controller: grblHAL

9/1/2024, 3:11:54 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: grblHAL

9/1/2024, 2:32:23 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

9/1/2024, 2:24:34 PM

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

Input: N/A Controller: grblHAL

9/1/2024, 2:22:21 PM

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

Input: N/A Controller: grblHAL

9/1/2024, 2:06:19 PM

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

Input: N/A Controller: grblHAL

9/1/2024, 1:53:49 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 3:35:31 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

8/31/2024, 2:33:03 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: grblHAL

8/31/2024, 2:31:01 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: grblHAL

8/31/2024, 2:31:01 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: grblHAL

8/31/2024, 1:12:52 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 12:41:11 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 12:39:38 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 12:38:10 PM

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

Input: N/A Controller: grblHAL

8/11/2024, 10:19:16 AM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

8/11/2024, 10:05:59 AM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

8/6/2024, 9:21:24 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

8/6/2024, 2:20:45 PM

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

Input: G0 X241.100 Y121.100 Controller: grblHAL

8/6/2024, 2:20:08 PM

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

Input: G0 X241.100 Y121.100 Controller: grblHAL

8/6/2024, 2:19:42 PM

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

Input: G0 X241.100 Y121.100 Controller: grblHAL

7/22/2024, 4:20:44 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/22/2024, 3:37:20 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/22/2024, 3:31:39 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/22/2024, 3:29:41 PM

EStop asserted. Clear and reset

Input: \$i Controller: grblHAL

7/19/2024, 2:30:51 PM

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

Input: N/A Controller: grblHAL

7/19/2024, 2:29:31 PM

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

Input: N/A Controller: grblHAL

7/15/2024, 3:02:40 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/7/2024, 5:15:33 PM

EStop asserted. Clear and reset

Input: (AlumJuly) Controller: grblHAL

7/7/2024, 5:10:50 PM

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

Input: (AlumJuly) Controller: grblHAL

7/7/2024, 4:53:54 PM

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

Input: (AlumJuly) Controller: grblHAL

7/7/2024, 4:51:40 PM

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

Input: M5 Controller: grblHAL

7/7/2024, 4:35:59 PM

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

is highly recommended.

Input: M5 Controller: grblHAL

7/5/2024, 1:48:37 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/4/2024, 2:38:51 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/4/2024, 2:16:12 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/4/2024, 2:00:12 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/4/2024, 12:46:55 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

7/4/2024, 12:22:07 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

6/29/2024, 3:30:20 PM

EStop asserted. Clear and reset

Input: M5 Controller: grblHAL

6/29/2024, 11:20:19 AM

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

Input: G0 X250 Controller: grblHAL

6/29/2024, 11:18:42 AM

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

Input: N/A Controller: grblHAL

6/29/2024, 10:44:35 AM

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

Input: N/A Controller: grblHAL

6/16/2024, 6:43:02 PM

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

Input: (JuneFusionTest-v2) Controller: grblHAL

6/9/2024, 4:17:02 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

6/7/2024, 4:15:17 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

6/3/2024, 3:37:52 PM

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

Input: N/A Controller: grblHAL

6/3/2024, 2:49:31 PM

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

Input: N/A Controller: grblHAL

6/3/2024, 2:48:28 PM

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

Input: N/A Controller: grblHAL

6/1/2024, 4:10:34 PM

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

Input: N/A Controller: grblHAL

6/1/2024, 4:08:30 PM

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

Input: \$hz Controller: grblHAL

6/1/2024, 4:07:21 PM

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

Input: N/A Controller: grblHAL

6/1/2024, 4:05:22 PM

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

Input: N/A Controller: grblHAL

6/1/2024, 3:57:17 PM

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

Input: N/A Controller: grblHAL

5/31/2024, 4:07:36 PM

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

Input: N/A Controller: grblHAL

5/31/2024, 3:49:56 PM

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

Input: N/A Controller: grblHAL

5/31/2024, 3:49:02 PM

Homing fail. Could not find limit switch within search distances. Try increasing max travel,

decreasing pull-off distance, or check wiring.

Input: N/A Controller: grblHAL

5/31/2024, 3:47:36 PM

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

Input: N/A Controller: grblHAL

5/31/2024, 3:46:52 PM

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

Input: N/A Controller: grblHAL

5/31/2024, 3:46:23 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 7:35:48 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 7:34:15 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 7:16:39 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 7:13:51 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 7:13:23 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 7:13:01 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 2:12:06 PM

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

Input: N/A Controller: grblHAL

5/29/2024, 1:31:12 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

5/29/2024, 1:30:55 PM

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

Input: N/A Controller: grblHAL

5/28/2024, 11:58:00 AM

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

Input: N/A Controller: grblHAL

5/28/2024, 11:57:32 AM

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

Input: N/A Controller: grblHAL

5/28/2024, 11:56:27 AM

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

Input: N/A Controller: grblHAL

5/28/2024, 11:55:56 AM

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

Input: g1 y100 f5000 Controller: grblHAL

5/28/2024, 11:49:57 AM

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

Input: N/A Controller: grblHAL

5/28/2024, 11:33:46 AM

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

Input: G1 X200 f5 Controller: grblHAL

5/26/2024, 7:48:22 PM

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

Input: G1 Z-100 f5000 Controller: grblHAL

5/26/2024, 7:33:37 PM

EStop asserted. Clear and reset

Input: M8 Controller: grblHAL

5/26/2024, 7:27:25 PM

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

Input: G1 Z10 f5000 Controller: grblHAL

5/26/2024, 7:27:06 PM

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

Input: G1 Z49 f5000 Controller: grblHAL

5/26/2024, 7:26:46 PM

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



Alarm may be safely unlocked.

Input: G1 Z50 f5000 Controller: grblHAL

5/26/2024, 7:26:32 PM

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

Input: G1 Z60 f5000 Controller: grblHAL

5/26/2024, 7:25:51 PM

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

Input: G1 Z50 f5000 Controller: grblHAL

5/26/2024, 5:14:22 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

5/26/2024, 5:11:55 PM

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

Input: G1 X-30 F2500 Controller: grblHAL

5/26/2024, 5:11:32 PM

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

Input: G1 X-60 F2500 Controller: grblHAL

5/26/2024, 5:11:07 PM

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

Input: G1 X-70 F2500 Controller: grblHAL

5/26/2024, 5:10:09 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 5:09:39 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 5:08:59 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 5:08:45 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 5:07:50 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 5:07:21 PM

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

Input: G1 Y-100 F5000 Controller: grblHAL

5/26/2024, 4:58:14 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 4:57:56 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 4:57:45 PM

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

Input: N/A Controller: grblHAL

5/26/2024, 4:56:58 PM

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

Input: \$\$ Controller: grblHAL

5/25/2024, 3:12:49 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

5/19/2024, 6:27:55 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

5/18/2024, 1:12:08 PM

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

Input: G1 Z70 F5000 Controller: Grbl

5/18/2024, 1:11:06 PM

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

Input: G1 Z70 F5000 Controller: Grbl

5/18/2024, 12:58:45 PM

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

Input: G1 Y225 F5000 Controller: Grbl

3/23/2024, 2:14:44 PM

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

Input: S18400 M3 Controller: Grbl

## **Recent Errors**

11/27/2024, 4:00:40 PM

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

Input: N/A Controller: grblHAL

11/27/2024, 3:56:47 PM

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

Input: N/A Controller: grblHAL

11/24/2024, 9:20:37 PM

Setting is not available, possibly due to limited driver support.

Input: N/A Controller: grblHAL

11/24/2024, 9:18:52 PM

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

Input: N/A Controller: grblHAL

10/23/2024, 8:39:57 PM

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

Input: N/A Controller: grblHAL

9/22/2024, 4:23:38 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:23:28 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:23:22 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:23:19 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:17:17 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:17:08 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:17:05 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:16:59 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:13:06 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:11:43 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:09:36 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/22/2024, 4:08:55 PM

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

Input: (SeptemberTest1) Controller: grblHAL

9/18/2024, 3:49:12 PM

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

Input: N/A Controller: grblHAL

9/3/2024, 9:23:04 AM

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

Input: N/A Controller: grblHAL

9/2/2024, 3:26:49 PM

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

Input: # Controller: grblHAL

9/2/2024, 3:26:49 PM

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

Input: # Controller: grblHAL

9/2/2024, 3:02:35 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:47:01 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:36:19 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:35:33 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:35:10 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:35:09 PM

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

Input: G0 X49 Controller: grblHAL

9/2/2024, 2:27:37 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:27:11 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:27:11 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:26:22 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 2:25:44 PM

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

Input: N/A Controller: grblHAL

9/2/2024, 11:50:28 AM

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

Input: N/A Controller: grblHAL

9/1/2024, 4:25:23 PM

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

Input: g0 -y46.87 Controller: grblHAL

9/1/2024, 4:25:08 PM

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

Input: g0 -y46.87 Controller: grblHAL

9/1/2024, 3:12:06 PM

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

Input: N/A Controller: grblHAL

9/1/2024, 2:32:52 PM

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

Input: N/A Controller: grblHAL

9/1/2024, 2:06:32 PM

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

Input: N/A Controller: grblHAL

9/1/2024, 1:54:06 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 2:33:20 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 1:13:44 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 12:41:27 PM

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

Input: N/A Controller: grblHAL

8/31/2024, 12:30:55 PM

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

Input: N/A Controller: grblHAL

8/11/2024, 10:06:39 AM

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

Input: N/A Controller: grblHAL

8/11/2024, 10:04:15 AM

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

Input: N/A Controller: grblHAL

8/6/2024, 1:41:24 PM

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

Input: N/A Controller: grblHAL

8/5/2024, 2:14:55 PM

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

Input: N/A Controller: grblHAL

8/5/2024, 2:14:02 PM

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

Input: N/A Controller: grblHAL

8/5/2024, 1:59:08 PM

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

Input: N/A Controller: grblHAL

8/5/2024, 1:54:58 PM

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

Input: N/A Controller: grblHAL

8/5/2024, 9:04:58 AM

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

Input: N/A Controller: grblHAL

8/3/2024, 7:38:34 PM

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

Input: N/A Controller: grblHAL

7/22/2024, 4:20:16 PM

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

Input: N/A Controller: grblHAL

7/22/2024, 4:20:04 PM

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

Input: N/A Controller: grblHAL

7/22/2024, 4:19:52 PM

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

Input: N/A Controller: grblHAL

7/22/2024, 3:29:03 PM

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

Input: N/A Controller: grblHAL

7/19/2024, 3:02:32 PM

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

Input: N/A Controller: grblHAL

7/19/2024, 2:04:51 PM

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

Input: N/A Controller: grblHAL

7/19/2024, 10:28:27 AM

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

Input: N/A Controller: grblHAL

7/17/2024, 3:55:11 PM

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

Input: N/A Controller: grblHAL

7/15/2024, 2:04:19 PM

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

Input: N/A Controller: grblHAL

6/3/2024, 3:36:09 PM

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

Input: N/A Controller: Grbl

6/1/2024, 4:08:11 PM

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

Input: HZ Controller: grblHAL

6/1/2024, 4:08:11 PM

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

Input: HZ Controller: grblHAL

5/26/2024, 4:58:38 PM

Feed rate has not yet been set or is undefined.

Input: G1 X100 Controller: grblHAL

5/19/2024, 7:04:41 PM

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

Input: \$\$ Controller: Grbl

5/18/2024, 12:44:40 PM

Feed rate has not yet been set or is undefined.

Input: G1 X1 Controller: Grbl

## Terminal History

G1 Y3.5

ok

ok

G2 X69.5 Y-1.675 I-5.175 J0

G1 X3.5

ok

ok

G2 X-1.675 Y3.5 I0 J5.175

G1 Y17.5  
ok  
ok  
G2 X3.5 Y22.675 I5.175 J0  
G1 X4.452  
ok  
ok  
G3 X5.088 Y23.31 I0 J0.635  
G1 Y23.945  
ok  
ok  
G19 G3 Y24.58 Z2.535 J0 K0.635  
ok  
G1 X2.865 Y25.215  
Z1.265 F304.8  
ok  
ok  
G2 Y24.58 Z0.63 J-0.635 K0 F1320.8  
G1 Y23.945  
ok  
ok  
G17 G3 X3.5 Y23.31 I0.635 J0  
G1 X69.5  
ok  
ok  
G2 X75.31 Y17.5 I0 J-5.81  
G1 Y3.5  
ok  
ok  
G2 X69.5 Y-2.31 I-5.81 J0  
G1 X3.5  
ok  
ok  
G2 X-2.31 Y3.5 I0 J5.81  
G1 Y17.5  
ok  
G2 X3.5 Y23.31 I5.81 J0  
ok  
X3.976 Y22.993 I0 J-0.516  
ok  
ok  
G3 X4.452 Y22.675 I0.476 J0.198  
G1 X69.5  
ok  
ok  
G2 X74.675 Y17.5 I0 J-5.175  
G1 Y3.5  
ok  
ok  
G2 X69.5 Y-1.675 I-5.175 J0  
G1 X3.5  
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ok  
G2 X-1.675 Y3.5 I0 J5.175  
G1 Y17.5  
ok



ok  
G2 X3.5 Y22.675 I5.175 J0  
G1 X4.452  
ok  
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G3 X5.088 Y23.31 I0 J0.635  
G1 Y23.945  
ok  
ok  
G19 G3 Y24.58 Z1.265 J0 K0.635  
ok  
G1 X2.865 Y25.215  
Z0.635 F304.8  
ok  
ok  
G2 Y24.58 Z0 J-0.635 K0 F1320.8  
G1 Y23.945  
ok  
ok  
G17 G3 X3.5 Y23.31 I0.635 J0  
G1 X69.5  
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ok  
G2 X75.31 Y17.5 I0 J-5.81  
G1 Y3.5  
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G2 X69.5 Y-2.31 I-5.81 J0  
G1 X3.5  
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G2 X-2.31 Y3.5 I0 J5.81  
G1 Y17.5  
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G2 X3.5 Y23.31 I5.81 J0  
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X3.976 Y22.993 I0 J-0.516  
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G3 X4.452 Y22.675 I0.476 J0.198  
G1 X69.5  
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G2 X74.675 Y17.5 I0 J-5.175  
G1 Y3.5  
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G2 X69.5 Y-1.675 I-5.175 J0  
G1 X3.5  
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G2 X-1.675 Y3.5 I0 J5.175  
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G2 X3.5 Y22.675 I5.175 J0

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G4 P0.5

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S18400 M3

G17 G90 G94

G54

G0 X34.5 Y6.818

Z24.52

G0 Z14.52

G1 Z8 F304.8

Y6.5 F762

X45.5

G3 X46.5 Y7.5 I0 J1

G1 Y13.5

G3 X45.5 Y14.5 I-1 J0

G1 X31.5

G3 X30.5 Y13.5 I0 J-1

G1 Y7.5

G3 X31.5 Y6.5 I1 J0

G1 X34.5

Y6.818

G0 Z14.52

X69.5 Y0.183

G1 Z8 F304.8

Y0.5 F762

X3.5

G2 X0.5 Y3.5 I0 J3

G1 Y17.5

G2 X3.5 Y20.5 I3 J0

G1 X69.5

G2 X72.5 Y17.5 I0 J-3

G1 Y3.5

G2 X69.5 Y0.5 I-3 J0

G1 Y0.183

G0 Z14.52

X19.183 Y10.5

G1 Z8 F304.8

X19.5 F762

G3 X11.5 Y10.5 I-4 J0

X19.5 Y10.5 I4 J0

G1 X19.183

G0 Z24.52

G28 G91 Z0

G90

G28 G91 X0 Y0

G90

M5

M30

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[MSG:Pgm End]

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```

$C
[MSG:Disabled]
GrblHAL 1.1f ['$' or '$HELP' for help]
G54
28,1ok
|0|0]
0]
0]
pindle and coolant state on resume|||0|0[SETTING:152|45|Z-axis mi-
crosteps|steps|5|###0|||0|0]
]
st enable (M7),Flood enable (M8),M62-M65 only|||0|0] [SETTING:511|6|Spindle
1||3|SLB_SPINDLE,Huanyang v1,Huanyang P2A,Durapulse GS20,Yalang YS620,MOD-
VFD,H-100,SLB_LASER,Disabled|||1|0]
ok
ok
ok
ok
0 - SLB_SPINDLE, enabled as spindle 0, DIV, current
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD, enabled as spindle 2, SDV
6 - H-100
7 - SLB_LASER, enabled as spindle 1, DIRV
ok

```

## G-Code File

Status	Value
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No File Loaded