

Diagnostics

gSender 1.4.10

Environment

OS: Windows NT 10.0; Win64; x64

Homing: Disabled

Soft Limits: Disabled

Home Location: 11 (Front Left)

Report Inches: Disabled

Stepper Motors: Unlocked

Machine Profile

ID: 12

Company: Sienci Labs

Name: LongMill MK1

Type: 30x30

Version: MK1

Limits:

X Max: 810

Y Max: 855

Z Max: 120

Spindle/Laser: false

Laser Mode Enabled: true

Connection

Available Ports:

NULL

Connected Port: 192.168.5.1

Baudrate: 115200

Unrecognized Ports:

0:

port: COM1

manufacturer: (Standard port types)

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: 0.000

WPos:

a: 0.000

b: 0.000

c: 0.000

x: 48.550

y: 444.179

z: 94.838

Sender Status:

Modal:

NULL

Tool: NULL

Workflow State: idle

Homing Flag: false

Preferences

Jog Presets:

Rapid:

xyStep: 20

zStep: 10

aStep: 20

xaStep: 20

feedrate: 5000

Normal:

xyStep: 5

zStep: 2

aStep: 5

xaStep: 5

feedrate: 3000

Precise:

xyStep: 0.5

zStep: 0.1

aStep: 0.5

xaStep: 0.5

feedrate: 1000

Workspace Units: mm

Laser: Enabled

Rotary: Disabled

EEPROM Values

Setting	Value
\$0	5.0
\$1	254
\$2	0
\$3	2
\$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	0
\$23	11
\$24	150.0
\$25	4300.0
\$26	25
\$27	1.500
\$28	0.100
\$29	0.0
\$30	3000.000
\$31	0.000
\$32	0
\$33	500.0
\$34	0.0
\$35	0.0
\$36	100.0
\$37	8
\$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	800.000
\$101	800.000
\$102	800.000
\$103	79.012
\$110	4000.000
\$111	4000.000
\$112	4000.000
\$113	8000.000
\$120	750.000
\$121	750.000
\$122	750.000
\$123	1000.000
\$130	810.000
\$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	150.0

\$181	150.0
\$182	150.0
\$183	150.0
\$190	4300.0
\$191	4300.0
\$192	4300.0
\$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	1
\$730	1000.000
\$731	0.000
\$733	500.0
\$734	0.0
\$735	0.0
\$736	100.0
\$741	0.000
\$742	0.000
\$743	0

Recent Alarms

12/12/2024, 4:47:35 PM

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

Input: N/A Controller: grblHAL

12/12/2024, 4:45:05 PM

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

Input: \$103=79.012345679 Controller: grblHAL

12/8/2024, 4:07:23 PM

EStop asserted. Clear and reset

Input: gggggg Controller: grblHAL

12/8/2024, 3:27:10 PM

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

Input: N/A Controller: grblHAL

12/7/2024, 2:55:43 PM

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

Input: g0 x50 Controller: grblHAL

Recent Errors

12/12/2024, 2:33:24 PM

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

Input: \$103=79.012345679 Controller: grblHAL

12/10/2024, 10:54:43 AM

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

Input: \$511=0 Controller: grblHAL

12/10/2024, 10:52:56 AM

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

Input: ggg Controller: grblHAL

12/10/2024, 10:51:15 AM

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

Input: N/A Controller: grblHAL

12/10/2024, 10:50:13 AM

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

Input: N/A Controller: grblHAL

12/10/2024, 10:49:29 AM

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

Input: N/A Controller: grblHAL

12/10/2024, 10:43:34 AM

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

Input: \$\$ Controller: grblHAL

12/10/2024, 10:33:21 AM

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

Input: ggg Controller: grblHAL

12/10/2024, 10:33:03 AM

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

Input: \$rst=\$ Controller: grblHAL

12/9/2024, 8:11:22 PM

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

Input: \$rst=\$ Controller: grblHAL

12/9/2024, 4:54:17 PM

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

Input: \$rst=\$ Controller: grblHAL

12/8/2024, 4:46:16 PM

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

Input: \$dfu Controller: grblHAL

12/8/2024, 4:09:15 PM

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

Input: \$dfu Controller: grblHAL

12/8/2024, 4:08:57 PM

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

Input: N/A Controller: grblHAL

12/8/2024, 3:59:47 PM

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

Input: N/A Controller: grblHAL

12/8/2024, 3:59:20 PM

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

Input: N/A Controller: grblHAL

12/8/2024, 3:55:04 PM

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

Input: N/A Controller: grblHAL

12/8/2024, 3:54:58 PM

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

Input: N/A Controller: grblHAL

Terminal History

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

\$X

[MSG:Caution: Unlocked]

ok

G54

G21

G1 F6000

G90

M3 S17000

G0 Z31

G0 X0 A0

G0 Z28 F1200.000

G91

G1 A-360 Z-5 F2455.533

G1 A-360

G1 X150 A-21259.843 F14946.725

G1 A-360

G1 A360 Z-5 F2989.345

G1 A360

G1 X-150 A21259.843 F19098.593

G1 A360

G1 A-360 Z-0.5 F3819.719

G1 A-360

G1 X150 A-21259.843 F19644.267

G1 A-360

G90

G0 Z31

G0 X0

M5

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok

ok
ok
G54
ok
GrblHAL 1.1f ['\$' or '\$HELP' for help]
\$\$
\$0=5.0 (Step pulse time, \$)
\$1=254 (Step idle delay, ms)
\$2=0 (Step pulse invert, mask)
\$3=2 (Step direction invert, mask)
\$4=15 (Invert step enable pin, boolean)
\$5=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=0 (Homing cycle enable, mask)
\$23=11 (Homing direction invert, mask)
\$24=150.0 (Homing locate feed rate, mm/min)
\$25=4300.0 (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=3000.000 (Maximum spindle speed, rpm)
\$31=0.000 (Spindle Mode,)
\$32=0 (Laser-mode enabled as spindle, boolean)
\$33=500.0 (Spindle Frequency, Hz)
\$34=0.0 (Spindle Duty Cycle, %)
\$35=0.0 (Minimum spindle speed, %)
\$36=100.0 (Maximum spindle speed, %)
\$37=8 (Deenergized Steppers, %)
\$39=1 (Printable Command Characters, boolean)
\$40=1 (Soft Limits Jogging, boolean)
\$41=1
\$42=2
\$43=1 (Homing Locate Cycle,)
\$44=4 (Axis Mask,)
\$45=3 (Axis Mask,)
\$46=0 (Axis Mask,)
\$47=0 (Axis Mask,)
\$56=5.0
\$57=100.0
\$58=-5.0
\$59=500.0

\$60=1 (Restore Default Overrides, boolean)
\$61=3 (Ignore Safety Door Signal, boolean)
\$62=0 (Sleep Function, boolean)
\$63=3 (Disable Laser on Hold, boolean)
\$64=0 (Alarm on Startup, boolean)
\$65=0 (Allow Feedrate Override, boolean)
\$70=11 (Network Service,)
\$100=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=79.012
gSender - [grblHAL]
Connected to 192.168.5.1 with a baud rate of 115200
\$110=4000.000 (X-axis maximum rate, mm/min)
\$111=4000.000 (Y-axis maximum rate, mm/min)
\$112=4000.000 (Z-axis maximum rate, mm/min)
\$113=8000.000
\$120=750.000 (X-axis acceleration, mm/sec²)
\$121=750.000 (Y-axis acceleration, mm/sec²)
\$122=750.000 (Z-axis acceleration, mm/sec²)
\$123=1000.000
\$130=810.000 (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=150.0
\$181=150.0
\$182=150.0
\$183=150.0
\$190=4300.0
\$191=4300.0
\$192=4300.0
\$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 (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=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=1
\$730=1000.000
\$731=0.000
\$733=500.0
\$734=0.0
\$735=0.0
\$736=100.0
\$741=0.000
\$742=0.000
\$743=0
ok
ok
ok
ok
ok
0 - SLB_SPINDLE, enabled as spindle 0, DIV, current
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD, enabled as spindle 2, SDV
6 - H-100
7 - SLB_LASER, enabled as spindle 1, DIRV
ok
[VER:1.1f.20230917:]
[OPT:VNMPSL+2,128,1024,4,0]
[NEOPT:ENUMS,RT+,ES,SED,ETH,FTP,TMC=7,SD,YM]
[FIRMWARE:grblHAL]
[NVS STORAGE:*EEPROM]
[FREE MEMORY:133K]
[DRIVER:STM32F412]
[DRIVER VERSION:230828]
[BOARD:SuperLongBoard_B5.0.5b]
[AUX IO:3,4,0,0]
[WIZCHIP:W5500]
[IP:192.168.5.1]
[NETCON:Telnet]
[PLUGIN:Trinamic v0.12]
[PLUGIN:MODBUS v0.14]
[PLUGIN:HUANYANG VFD v0.11]
[PLUGIN:HUANYANG P2A VFD v0.10]

[PLUGIN:Durapulse VFD GS20 v0.05]
[PLUGIN:Yalang VFD YL620A v0.02]
[PLUGIN:MODVFD v0.03]
[PLUGIN:H-100 VFD v0.03]
[PLUGIN:SLB Laser PWM switch v0.01]
[SPINDLE:SLB_SPINDLE]
[PLUGIN:SIENCI Indicator Lights v1.0]
[PLUGIN:Bootloader Entry v0.01]
[PLUGIN:Macro plugin v0.03]
[PLUGIN:SLB Probing v0.01]
[PLUGIN:SwitchBank plugin v0.02]
[PLUGIN:SDCARD v1.10]
[PLUGIN:FS macro plugin v0.05]
ok
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