

# Diagnostics

gSender 1.2.0

## Environment

**OS:** Windows NT 10.0; Win64; x64

## Machine Profile

**ID:** 0

**Company:** Sienci Labs

**Name:** LongMill MK2

**Type:** 30x30

**Version:** MK2

**Limits:**

*X Max:* 812

*Y Max:* 855

*Z Max:* 114.3

**Spindle/Laser:** false

**Laser Mode Enabled:** false

## Connection

**Available Ports:**

0:

port: COM6

manufacturer: Arduino LLC ([www.arduino.cc](http://www.arduino.cc))

inuse: false

**Connected Port:** COM6

**Baudrate:** 115200

**Unrecognized Ports:**

NULL

## GRBL Information

**Type:** Grbl

**MPos:**

*a:* 0

*b:* 0

*c:* 0

*x:* 0

*y:* 0

*z:* 0

**WPos:**

*a:* 0

*b:* 0

*c:* 0

*x:* 0

*y:* 0

*z:* 0

**Sender Status:**

*Modal:*

NULL

*Tool:* NULL

**Workflow State:** idle

**Homing Flag:** false

## EEPROM Values

Setting	Value
\$0	10
\$1	25
\$2	1
\$3	5
\$4	1
\$5	0
\$6	0
\$10	3
\$11	0.010
\$12	0.002
\$13	1
\$20	0
\$21	0
\$22	0
\$23	3
\$24	400.000
\$25	1500.000
\$26	250
\$27	1.000
\$30	30000
\$31	0
\$32	1
\$100	200.000
\$101	200.000
\$102	200.000
\$110	4000.000
\$111	4000.000
\$112	3000.000
\$120	750.000
\$121	750.000
\$122	500.000
\$130	812.000
\$131	855.000
\$132	114.300

## Recent Alarms

None

## Recent Errors

None

## Terminal History

Grbl 1.1h ['\$' for help] LongMill MK1 build Feb 7, 2022

\$\$

>G20:ok

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

\$1=25 (Step idle delay, ms)

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

\$3=5 (Step direction invert, mask)

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

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

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

\$10=3 (Status report options, mask)

\$11=0.010 (Junction deviation, mm)

\$12=0.002 (Arc tolerance, mm)

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

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

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

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

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

\$24=400.000 (Homing locate feed rate, mm/min)

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

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

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

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

\$31=0 (Minimum spindle speed, rpm)

\$32=1 (Laser-mode enabled as spindle, boolean)

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

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

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

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

\$111=4000.000 (Y-axis maximum rate, mm/min)

\$112=3000.000 (Z-axis maximum rate, mm/min)

\$120=750.000 (X-axis acceleration, mm/sec<sup>2</sup>)

\$121=750.000 (Y-axis acceleration, mm/sec<sup>2</sup>)

\$122=500.000 (Z-axis acceleration, mm/sec<sup>2</sup>)

\$130=812.000 (X-axis maximum travel, mm)

\$131=855.000 (Y-axis maximum travel, mm)

\$132=114.300 (Z-axis maximum travel, mm)

ok

# G-Code File

Status	Value
Name	624 Address 1_4 DC EM.gcode
Sent	0
Received	0
Total	8052

T1  
G17  
G20  
G90  
G0Z0.8000  
G0X0.0000Y0.0000S16000M3  
G0X1.4152Y2.2453Z0.2000  
G1Z-0.1250F50.0  
G1Y8.7547F100.0  
G1X13.5848  
G1Y2.2453  
G1X1.4152  
G0Z0.2000  
G0X2.0280Y2.8570  
G1Z-0.1250F50.0  
G1X2.0405Y2.8394F100.0  
G1X2.0092  
G1Y2.8852  
G1X2.0280Y2.8570  
G1X2.1096Y2.9130  
G1X2.1359Y2.8759  
G1X2.1632Y2.8394  
G1X2.1916Y2.8036  
G1X2.2211Y2.7686  
G1X2.2465Y2.7404  
G1X1.9102  
G1Y3.2921  
G1X1.9374Y3.2269  
G1X1.9554Y3.1869  
G1X1.9742Y3.1472  
G1X1.9940Y3.1077  
G1X2.0150Y3.0679  
G1X2.0371Y3.0283  
G1X2.0603Y2.9893  
G1X2.0844Y2.9509  
G1X2.1096Y2.9130  
G1X2.1913Y2.9691  
G1X2.2160Y2.9341  
G1X2.2416Y2.8999  
G1X2.2683Y2.8663  
G1X2.2959Y2.8336  
G1X2.3245Y2.8016  
G1X2.3541Y2.7705  
G1X2.3847Y2.7403  
G1X2.4162Y2.7111

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G1Y4.2249  
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G1X1.9959Y3.3445  
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G1X2.0281Y3.2666  
G1X2.0453Y3.2284  
G1X2.0632Y3.1906  
G1X2.0820Y3.1529  
G1X2.1019Y3.1152  
G1X2.1229Y3.0778  
G1X2.1448Y3.0409  
G1X2.1675Y3.0047  
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