

# Diagnostics

gSender 1.4.11

## Environment

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

**Homing:** Enabled

**Soft Limits:** Disabled

**Home Location:** 3 (Front Left)

**Report Inches:** Enabled

**Stepper Motors:** Locked

## Machine Profile

**ID:** 30

**Company:**

**Name:** Generic CNC

**Type:**

**Version:** undefined

**Limits:**

X Max: 400

Y Max: 400

Z Max: 55

**Spindle/Laser:** false

**Laser Mode Enabled:** false

## Connection

**Available Ports:**

0:

port: COM3

manufacturer: wch.cn

inuse: false

**Connected Port:** COM3

**Baudrate:** 115200

**Unrecognized Ports:**

NULL

## GRBL Information

**Type:** Grbl

**Firmware Version:** N/A

**MPos:**

a: 0.000

b: 0.000

c: 0.000

x: -42.45102

y: -60.23864

z: 36.2331

**WPos:**

a: 0.000

b: 0.000

c: 0.000

x: 19.98726

y: 19.99234

z: 0

**Sender Status:**

Modal:

motion: G1

wcs: G54

plane: G17

units: G20

distance: G90

feedrate: G94

spindle: M3

coolant: M9

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:** in

**Laser:** Disabled

**Rotary:** Disabled

## EEPROM Values

Setting	Value
\$0	10
\$1	255
\$2	0
\$3	0
\$4	0
\$5	0
\$6	0
\$10	1
\$11	0.010
\$12	0.002
\$13	1
\$20	0
\$21	1
\$22	1
\$23	3
\$24	25.000
\$25	1000.000
\$26	250
\$27	1.000
\$30	10000
\$31	1
\$32	0
\$100	80.000
\$101	80.000
\$102	400.000
\$110	2000.000
\$111	2000.000
\$112	1200.000
\$120	300.000
\$121	300.000
\$122	30.000
\$130	400.000
\$131	400.000
\$132	55.000

## Recent Alarms

3/11/2025, 12:40:43 PM

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

Input: \$\$ Controller: Grbl

3/11/2025, 12:40:43 PM

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

Input: \$\$ Controller: Grbl

3/10/2025, 8:50:33 PM

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

Input: \$H Controller: Grbl

3/10/2025, 8:50:32 PM

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

Input: \$H Controller: Grbl

3/10/2025, 8:50:23 PM

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

Input: \$\$ Controller: Grbl

3/10/2025, 8:50:23 PM

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

Input: \$\$ Controller: Grbl

3/10/2025, 1:03:55 PM

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

Input: \$\$ Controller: Grbl

3/10/2025, 1:03:55 PM

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

Input: \$\$ Controller: Grbl

3/8/2025, 12:45:20 PM

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

Input: \$H Controller: Grbl

3/6/2025, 1:07:46 PM

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

Input: \$H Controller: Grbl

3/6/2025, 1:05:06 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

3/6/2025, 1:03:54 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: Grbl

3/6/2025, 1:03:47 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: Grbl

3/6/2025, 1:03:18 PM

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

Input: \$H Controller: Grbl

3/6/2025, 1:03:00 PM

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

Input: \$\$ Controller: Grbl

3/6/2025, 1:03:00 PM

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

Input: \$\$ Controller: Grbl

## Recent Errors

3/10/2025, 1:03:02 PM

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

Input: \$131=380 Controller: Grbl

3/10/2025, 1:02:33 PM

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

Input: \$112=1200 Controller: Grbl

3/10/2025, 1:02:33 PM

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

Input: \$112=1200 Controller: Grbl

3/9/2025, 7:07:19 PM

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

Input: \$2=0 Controller: Grbl

## Terminal History

ok

G1X2.8905Y2.7649Z-0.0748

ok

G1X2.8658Y2.7906Z-0.0753

ok  
G1X2.8408Y2.8160Z-0.0759  
ok  
G1X2.8155Y2.8413Z-0.0765  
ok  
G1X2.7900Y2.8664Z-0.0770  
ok  
G1X2.7642Y2.8912Z-0.0776  
ok  
G1X2.7381Y2.9159Z-0.0781  
ok  
G1X2.7119Y2.9404Z-0.0787  
ok  
G1X2.6853Y2.9646Z-0.0792  
ok  
G1X2.6585Y2.9887Z-0.0798  
ok  
G1X2.6315Y3.0125Z-0.0804  
ok  
G1X2.6042Y3.0361Z-0.0809  
!  
\x18  
ok  
Grbl 1.1h ['\$' for help]  
G10 L20 P1 Z0  
ok  
G10 L20 P1 Z0  
ok  
\$\$  
\$0=10 (Step pulse time, \$)  
\$1=255 (Step idle delay, ms)  
\$2=0 (Step pulse invert, mask)  
\$3=0 (Step direction invert, mask)  
\$4=0 (Invert step enable pin, boolean)  
\$5=0 (Invert limit pins, boolean)  
\$6=1 (Invert probe pin, boolean)  
\$10=1 (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=1 (Hard limits enable, boolean)  
\$22=1 (Homing cycle enable, boolean)  
\$23=3 (Homing direction invert, mask)  
\$24=25.000 (Homing locate feed rate, mm/min)  
\$25=1000.000 (Homing search seek rate, mm/min)  
\$26=250 (Homing switch debounce delay, ms)  
\$27=1.000 (Homing switch pull-off distance, mm)  
\$30=10000 (Maximum spindle speed, rpm)  
\$31=1 (Minimum spindle speed, rpm)  
\$32=0 (Laser-mode enabled as spindle, boolean)  
\$100=80.000 (X-axis travel resolution, step/mm)  
\$101=80.000 (Y-axis travel resolution, step/mm)  
\$102=400.000 (Z-axis travel resolution, step/mm)  
\$110=2000.000 (X-axis maximum rate, mm/min)  
\$111=2000.000 (Y-axis maximum rate, mm/min)

\$112=1200.000 (Z-axis maximum rate, mm/min)  
\$120=300.000 (X-axis acceleration, mm/sec^2)  
\$121=300.000 (Y-axis acceleration, mm/sec^2)  
\$122=30.000 (Z-axis acceleration, mm/sec^2)  
\$130=400.000 (X-axis maximum travel, mm)  
\$131=400.000 (Y-axis maximum travel, mm)  
\$132=55.000 (Z-axis maximum travel, mm)  
ok  
\$6=0  
ok  
\$\$  
\$0=10 (Step pulse time, ~~\$~~)  
\$1=255 (Step idle delay, ms)  
\$2=0 (Step pulse invert, mask)  
\$3=0 (Step direction invert, mask)  
\$4=0 (Invert step enable pin, boolean)  
\$5=0 (Invert limit pins, boolean)  
\$6=0 (Invert probe pin, boolean)  
\$10=1 (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=1 (Hard limits enable, boolean)  
\$22=1 (Homing cycle enable, boolean)  
\$23=3 (Homing direction invert, mask)  
\$24=25.000 (Homing locate feed rate, mm/min)  
\$25=1000.000 (Homing search seek rate, mm/min)  
\$26=250 (Homing switch debounce delay, ms)  
\$27=1.000 (Homing switch pull-off distance, mm)  
\$30=10000 (Maximum spindle speed, rpm)  
\$31=1 (Minimum spindle speed, rpm)  
\$32=0 (Laser-mode enabled as spindle, boolean)  
\$100=80.000 (X-axis travel resolution, step/mm)  
\$101=80.000 (Y-axis travel resolution, step/mm)  
\$102=400.000 (Z-axis travel resolution, step/mm)  
\$110=2000.000 (X-axis maximum rate, mm/min)  
\$111=2000.000 (Y-axis maximum rate, mm/min)  
\$112=1200.000 (Z-axis maximum rate, mm/min)  
\$120=300.000 (X-axis acceleration, mm/sec^2)  
\$121=300.000 (Y-axis acceleration, mm/sec^2)  
\$122=30.000 (Z-axis acceleration, mm/sec^2)  
\$130=400.000 (X-axis maximum travel, mm)  
\$131=400.000 (Y-axis maximum travel, mm)  
\$132=55.000 (Z-axis maximum travel, mm)  
ok  
G90  
G0 X0 Y0  
ok  
ok  
\$J=G20G91 Z0.394 F197  
ok  
\$J=G20G91 Z0.394 F197  
ok  
G10 L20 P0 Z0  
ok

[illegible]



ok

[illegible]

\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
\$J=G20G91 Z-0.004 F39  
ok  
G90 G0 Z0  
ok

## G-Code File

Status	Value
Name	.754 thk Profile ramp no tabs.gcode
Sent	0
Received	209.2917
Total	930

(VECTRIC POST REVISION)  
(D6636633856CDF96EB5CCA1E1D47044A)  
T1  
G17  
G20  
G90  
G0Z0.8000  
G0X0.0000Y0.0000  
S1300M3  
G0X0.0000Y4.0000  
G0Z0.2000  
G1Z0.0000F30.0  
G1X0.0343Y3.9999Z-0.0006  
G1X0.0686Y3.9994Z-0.0011  
G1X0.1031Y3.9987Z-0.0017  
G1X0.1375Y3.9976Z-0.0022  
G1X0.1721Y3.9963Z-0.0028  
G1X0.2067Y3.9947Z-0.0033  
G1X0.2413Y3.9927Z-0.0039  
G1X0.2760Y3.9905Z-0.0045  
G1X0.3108Y3.9879Z-0.0050  
G1X0.3456Y3.9850Z-0.0056  
G1X0.3804Y3.9819Z-0.0061  
G1X0.4153Y3.9784Z-0.0067

G1X0.4502Y3.9746Z-0.0073  
G1X0.4851Y3.9705Z-0.0078  
G1X0.5200Y3.9661Z-0.0084  
G1X0.5550Y3.9613Z-0.0089  
G1X0.5899Y3.9563Z-0.0095  
G1X0.6249Y3.9509Z-0.0100  
G1X0.6599Y3.9452Z-0.0106  
G1X0.6949Y3.9392Z-0.0112  
G1X0.7299Y3.9329Z-0.0117  
G1X0.7648Y3.9262Z-0.0123  
G1X0.7998Y3.9192Z-0.0128  
G1X0.8347Y3.9119Z-0.0134  
G1X0.8696Y3.9043Z-0.0140  
G1X0.9045Y3.8964Z-0.0145  
G1X0.9394Y3.8881Z-0.0151  
G1X0.9742Y3.8795Z-0.0156  
G1X1.0090Y3.8706Z-0.0162  
G1X1.0438Y3.8614Z-0.0167  
G1X1.0785Y3.8519Z-0.0173  
G1X1.1131Y3.8420Z-0.0179  
G1X1.1477Y3.8318Z-0.0184  
G1X1.1822Y3.8213Z-0.0190  
G1X1.2167Y3.8105Z-0.0195  
G1X1.2511Y3.7993Z-0.0201  
G1X1.2854Y3.7878Z-0.0206  
G1X1.3197Y3.7760Z-0.0212  
G1X1.3538Y3.7639Z-0.0218  
G1X1.3879Y3.7515Z-0.0223  
G1X1.4219Y3.7387Z-0.0229  
G1X1.4558Y3.7257Z-0.0234  
G1X1.4896Y3.7123Z-0.0240  
G1X1.5233Y3.6986Z-0.0246  
G1X1.5568Y3.6846Z-0.0251  
G1X1.5903Y3.6703Z-0.0257  
G1X1.6236Y3.6557Z-0.0262  
G1X1.6569Y3.6407Z-0.0268  
G1X1.6899Y3.6255Z-0.0273  
G1X1.7229Y3.6099Z-0.0279  
G1X1.7557Y3.5941Z-0.0285  
G1X1.7884Y3.5779Z-0.0290  
G1X1.8210Y3.5615Z-0.0296  
G1X1.8534Y3.5447Z-0.0301  
G1X1.8856Y3.5277Z-0.0307  
G1X1.9177Y3.5103Z-0.0312  
G1X1.9496Y3.4927Z-0.0318  
G1X1.9814Y3.4748Z-0.0324  
G1X2.0130Y3.4566Z-0.0329  
G1X2.0444Y3.4381Z-0.0335  
G1X2.0757Y3.4193Z-0.0340  
G1X2.1068Y3.4002Z-0.0346  
G1X2.1377Y3.3809Z-0.0352  
G1X2.1684Y3.3613Z-0.0357  
G1X2.1989Y3.3414Z-0.0363  
G1X2.2292Y3.3212Z-0.0368  
G1X2.2593Y3.3008Z-0.0374  
G1X2.2893Y3.2801Z-0.0379

G1X2.3190Y3.2592Z-0.0385  
G1X2.3485Y3.2380Z-0.0391  
G1X2.3778Y3.2165Z-0.0396  
G1X2.4069Y3.1948Z-0.0402  
G1X2.4357Y3.1729Z-0.0407  
G1X2.4644Y3.1507Z-0.0413  
G1X2.4928Y3.1282Z-0.0419  
G1X2.5210Y3.1055Z-0.0424  
G1X2.5490Y3.0826Z-0.0430  
G1X2.5767Y3.0595Z-0.0435  
G1X2.6042Y3.0361Z-0.0441  
G1X2.6315Y3.0125Z-0.0446  
G1X2.6585Y2.9887Z-0.0452  
G1X2.6853Y2.9646Z-0.0458  
G1X2.7119Y2.9404Z-0.0463  
G1X2.7381Y2.9159Z-0.0469  
G1X2.7642Y2.8912Z-0.0474  
G1X2.7900Y2.8664Z-0.0480  
G1X2.8155Y2.8413Z-0.0485  
G1X2.8408Y2.8160Z-0.0491  
G1X2.8658Y2.7906Z-0.0497  
G1X2.8905Y2.7649Z-0.0502  
G1X2.9150Y2.7391Z-0.0508  
G1X2.9393Y2.7131Z-0.0513  
G1X2.9632Y2.6869Z-0.0519  
G1X2.9869Y2.6605Z-0.0525  
G1X3.0103Y2.6340Z-0.0530  
G1X3.0335Y2.6073Z-0.0536  
G1X3.0564Y2.5804Z-0.0541  
G1X3.0790Y2.5534Z-0.0547  
G1X3.1013Y2.5263Z-0.0552  
G1X3.1233Y2.4990Z-0.0558  
G1X3.1451Y2.4715Z-0.0564  
G1X3.1666Y2.4439Z-0.0569  
G1X3.1878Y2.4162Z-0.0575  
G1X3.2087Y2.3883Z-0.0580  
G1X3.2294Y2.3604Z-0.0586  
G1X3.2497Y2.3322Z-0.0592  
G1X3.2698Y2.3040Z-0.0597  
G1X3.2896Y2.2757Z-0.0603  
G1X3.3091Y2.2472Z-0.0608  
G1X3.3283Y2.2186Z-0.0614  
G1X3.3472Y2.1900Z-0.0619  
G1X3.3659Y2.1612Z-0.0625  
G1X3.3472Y2.1900Z-0.0631  
G1X3.3283Y2.2186Z-0.0636  
G1X3.3091Y2.2472Z-0.0642  
G1X3.2896Y2.2757Z-0.0647  
G1X3.2698Y2.3040Z-0.0653  
G1X3.2497Y2.3322Z-0.0658  
G1X3.2294Y2.3604Z-0.0664  
G1X3.2087Y2.3883Z-0.0670  
G1X3.1878Y2.4162Z-0.0675  
G1X3.1666Y2.4439Z-0.0681  
G1X3.1451Y2.4715Z-0.0686  
G1X3.1233Y2.4990Z-0.0692

G1X3.1013Y2.5263Z-0.0698  
G1X3.0790Y2.5534Z-0.0703  
G1X3.0564Y2.5804Z-0.0709  
G1X3.0335Y2.6073Z-0.0714  
G1X3.0103Y2.6340Z-0.0720  
G1X2.9869Y2.6605Z-0.0725  
G1X2.9632Y2.6869Z-0.0731  
G1X2.9393Y2.7131Z-0.0737  
G1X2.9150Y2.7391Z-0.0742  
G1X2.8905Y2.7649Z-0.0748  
G1X2.8658Y2.7906Z-0.0753  
G1X2.8408Y2.8160Z-0.0759  
G1X2.8155Y2.8413Z-0.0765  
G1X2.7900Y2.8664Z-0.0770  
G1X2.7642Y2.8912Z-0.0776  
G1X2.7381Y2.9159Z-0.0781  
G1X2.7119Y2.9404Z-0.0787  
G1X2.6853Y2.9646Z-0.0792  
G1X2.6585Y2.9887Z-0.0798  
G1X2.6315Y3.0125Z-0.0804  
G1X2.6042Y3.0361Z-0.0809  
G1X2.5767Y3.0595Z-0.0815  
G1X2.5490Y3.0826Z-0.0820  
G1X2.5210Y3.1055Z-0.0826  
G1X2.4928Y3.1282Z-0.0831  
G1X2.4644Y3.1507Z-0.0837  
G1X2.4357Y3.1729Z-0.0843  
G1X2.4069Y3.1948Z-0.0848  
G1X2.3778Y3.2165Z-0.0854  
G1X2.3485Y3.2380Z-0.0859  
G1X2.3190Y3.2592Z-0.0865  
G1X2.2893Y3.2801Z-0.0871  
G1X2.2593Y3.3008Z-0.0876  
G1X2.2292Y3.3212Z-0.0882  
G1X2.1989Y3.3414Z-0.0887  
G1X2.1684Y3.3613Z-0.0893  
G1X2.1377Y3.3809Z-0.0898  
G1X2.1068Y3.4002Z-0.0904  
G1X2.0757Y3.4193Z-0.0910  
G1X2.0444Y3.4381Z-0.0915  
G1X2.0130Y3.4566Z-0.0921  
G1X1.9814Y3.4748Z-0.0926  
G1X1.9496Y3.4927Z-0.0932  
G1X1.9177Y3.5103Z-0.0938  
G1X1.8856Y3.5277Z-0.0943  
G1X1.8534Y3.5447Z-0.0949  
G1X1.8210Y3.5615Z-0.0954  
G1X1.7884Y3.5779Z-0.0960  
G1X1.7557Y3.5941Z-0.0965  
G1X1.7229Y3.6099Z-0.0971  
G1X1.6899Y3.6255Z-0.0977  
G1X1.6569Y3.6407Z-0.0982  
G1X1.6236Y3.6557Z-0.0988  
G1X1.5903Y3.6703Z-0.0993  
G1X1.5568Y3.6846Z-0.0999  
G1X1.5233Y3.6986Z-0.1004

G1X1.4896Y3.7123Z-0.1010  
G1X1.4558Y3.7257Z-0.1016  
G1X1.4219Y3.7387Z-0.1021  
G1X1.3879Y3.7515Z-0.1027  
G1X1.3538Y3.7639Z-0.1032  
G1X1.3197Y3.7760Z-0.1038  
G1X1.2854Y3.7878Z-0.1044  
G1X1.2511Y3.7993Z-0.1049  
G1X1.2167Y3.8105Z-0.1055  
G1X1.1822Y3.8213Z-0.1060  
G1X1.1477Y3.8318Z-0.1066  
G1X1.1131Y3.8420Z-0.1071  
G1X1.0785Y3.8519Z-0.1077  
G1X1.0438Y3.8614Z-0.1083  
G1X1.0090Y3.8706Z-0.1088  
G1X0.9742Y3.8795Z-0.1094  
G1X0.9394Y3.8881Z-0.1099  
G1X0.9045Y3.8964Z-0.1105  
G1X0.8696Y3.9043Z-0.1110  
G1X0.8347Y3.9119Z-0.1116  
G1X0.7998Y3.9192Z-0.1122  
G1X0.7648Y3.9262Z-0.1127  
G1X0.7299Y3.9329Z-0.1133  
G1X0.6949Y3.9392Z-0.1138  
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