

Diagnostics

gSender 1.4.3

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: 816

Y Max: 864

Z Max: 122

Spindle/Laser: false

Laser Mode Enabled: false

Connection

Available Ports:

0:

port: COM4

manufacturer: Microsoft

inuse: true

Connected Port: COM4

Baudrate: 115200

Unrecognized Ports:

0:

port: COM3

manufacturer: Intel

inuse: false

GRBL Information

Type: grblHAL

MPos:

a: 0.000

b: 0.000

c: 0.000

x: 85.116

y: 13.762

z: -2.000

WPos:

a: 0.000

b: 0.000

c: 0.000

x: 85.116

y: 13.762

z: -2.000

Sender Status:

Modal:

motion: G0

wcs: G54

plane: G17

units: G21

distance: G90

feedrate: G94

spindle: M3

coolant: M9

Tool: NULL

Workflow State: idle

Homing Flag: false

EEPROM Values

Setting	Value
\$0	10
\$1	100
\$2	1
\$3	1
\$4	1
\$5	0
\$6	0
\$10	1
\$11	0.010
\$12	0.002
\$13	0
\$20	0
\$21	0
\$22	0
\$23	3
\$24	25.000
\$25	1500.000
\$26	250
\$27	1.000
\$30	30000
\$31	10000
\$32	0
\$100	199.799
\$101	199.601
\$102	200.000
\$110	4000.000
\$111	4000.000
\$112	3000.000
\$120	750.000
\$121	750.000
\$122	500.000
\$130	816.000
\$131	864.000
\$132	122.000

Recent Alarms

None

Recent Errors

3/9/2024, 10:57:21 AM

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

Input: N/A Controller: grblHAL

3/9/2024, 11:53:45 AM

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

Input: N/A Controller: grblHAL

3/9/2024, 1:40:11 PM

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

Input: N/A Controller: grblHAL

3/9/2024, 1:46:18 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 1:46:27 PM

Motion command target is invalid.

Input: G3 X85.185 Y24.403 I0 J1.419 Controller: grblHAL

3/9/2024, 1:46:34 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 1:46:36 PM

Motion command target is invalid.

Input: G2 X-1.185 Y38.598 I0 J1.419 Controller: grblHAL

3/9/2024, 1:46:38 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 1:46:41 PM

Motion command target is invalid.

Input: G3 X85.185 Y52.792 I0 J1.419 Controller: grblHAL

3/9/2024, 1:46:43 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 1:46:45 PM

Motion command target is invalid.

Input: G2 X-1.185 Y66.986 I0 J1.419 Controller: grblHAL

3/9/2024, 1:54:10 PM

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

Input: N/A Controller: grblHAL

3/9/2024, 1:54:18 PM

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

Input: N/A Controller: grblHAL

3/9/2024, 1:54:57 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 1:55:26 PM

Motion command target is invalid.

Input: G3 X85.185 Y24.403 I0 J1.419 Controller: grblHAL

3/9/2024, 1:55:31 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 1:55:34 PM

Motion command target is invalid.

Input: G2 X-1.185 Y38.598 I0 J1.419 Controller: grblHAL

3/9/2024, 1:55:36 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 1:55:39 PM

Motion command target is invalid.

Input: G2 X-1.185 Y49.953 I0 J1.419 Controller: grblHAL

3/9/2024, 1:55:42 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 1:57:54 PM

Repeated g-code word found in block.

Input: G2 X-1.185 Y10.209 I0 J1.419 Controller: grblHAL

3/9/2024, 1:57:58 PM

Motion command target is invalid.

Input: G3 X85.185 Y24.403 I0 J1.419 Controller: grblHAL

3/9/2024, 1:58:00 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 1:58:03 PM

Motion command target is invalid.

Input: G2 X-1.185 Y38.598 I0 J1.419 Controller: grblHAL

3/9/2024, 2:04:27 PM

More than one g-code command that requires axis words found in block.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:04:31 PM

Motion command target is invalid.

Input: G2 X-1.185 Y21.564 I0 J1.419 Controller: grblHAL

3/9/2024, 2:04:33 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:04:35 PM

Motion command target is invalid.

Input: G2 X-1.185 Y38.598 I0 J1.419 Controller: grblHAL

3/9/2024, 2:04:37 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:04:37 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:04:39 PM

Motion command target is invalid.

Input: G3 X85.185 Y52.792 I0 J1.419 Controller: grblHAL

3/9/2024, 2:04:41 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:04:43 PM

Motion command target is invalid.

Input: G2 X-1.185 Y66.986 I0 J1.419 Controller: grblHAL

3/9/2024, 2:04:45 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:04:48 PM

Motion command target is invalid.

Input: G2 X-1.185 Y78.342 I0 J1.419 Controller: grblHAL

3/9/2024, 2:08:52 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:08:52 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:08:58 PM

Motion command target is invalid.

Input: G3 X85.185 Y115.247 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:01 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:09:01 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:09:01 PM
Motion command target is invalid.
Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:09:03 PM
Motion command target is invalid.
Input: G3 X85.185 Y154.991 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:03 PM
Motion command target is invalid.
Input: G2 X-1.185 Y163.508 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:05 PM
Motion command target is invalid.
Input: G2 X-1.185 Y169.186 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:07 PM
Motion command target is invalid.
Input: G2 X-1.185 Y180.541 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:11 PM
Motion command target is invalid.
Input: G3 X85.185 Y183.38 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:13 PM
Motion command target is invalid.
Input: G2 X-1.185 Y186.219 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:14 PM
Motion command target is invalid.
Input: G3 X85.185 Y189.058 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:16 PM
Motion command target is invalid.
Input: G2 X-1.185 Y191.897 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:18 PM
Motion command target is invalid.
Input: G3 X85.185 Y194.736 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:20 PM
Motion command target is invalid.
Input: G2 X-1.185 Y197.575 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:21 PM
Motion command target is invalid.
Input: G3 X85.185 Y200.413 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:23 PM
Motion command target is invalid.
Input: G2 X-1.185 Y203.252 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:25 PM
Motion command target is invalid.
Input: G3 X85.185 Y206.091 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:26 PM
Motion command target is invalid.
Input: G2 X-1.185 Y208.93 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:28 PM
Motion command target is invalid.
Input: G3 X85.185 Y211.769 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:29 PM
Motion command target is invalid.
Input: G2 X-1.185 Y214.608 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:31 PM
Motion command target is invalid.
Input: G3 X85.185 Y217.447 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:33 PM
Motion command target is invalid.
Input: G2 X-1.185 Y220.286 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:35 PM
Motion command target is invalid.
Input: G3 X85.185 Y223.124 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:36 PM
Motion command target is invalid.
Input: G2 X-1.185 Y225.963 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:39 PM
Motion command target is invalid.
Input: G3 X85.185 Y228.802 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:40 PM
Motion command target is invalid.
Input: G2 X-1.185 Y231.641 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:42 PM
Motion command target is invalid.
Input: G3 X85.185 Y234.48 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:44 PM
Motion command target is invalid.
Input: G2 X-1.185 Y237.319 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:46 PM
Motion command target is invalid.
Input: G3 X85.185 Y240.158 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:51 PM
Motion command target is invalid.
Input: G2 X-1.185 Y242.997 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:54 PM
Motion command target is invalid.
Input: G3 X85.185 Y245.835 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:56 PM
Motion command target is invalid.
Input: G2 X-1.185 Y248.674 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:57 PM
Motion command target is invalid.
Input: G3 X85.185 Y251.513 I0 J1.419 Controller: grblHAL

3/9/2024, 2:09:59 PM
Motion command target is invalid.
Input: G2 X-1.185 Y254.352 I0 J1.419 Controller: grblHAL

3/9/2024, 2:10:01 PM
Motion command target is invalid.
Input: G3 X85.185 Y257.191 I0 J1.419 Controller: grblHAL

3/9/2024, 2:10:03 PM
Motion command target is invalid.
Input: G2 X-1.185 Y260.03 I0 J1.419 Controller: grblHAL

3/9/2024, 2:10:04 PM
Motion command target is invalid.
Input: G3 X85.185 Y262.869 I0 J1.419 Controller: grblHAL

3/9/2024, 2:10:06 PM
Motion command target is invalid.
Input: G2 X-1.185 Y265.707 I0 J1.419 Controller: grblHAL

3/9/2024, 2:10:08 PM
Motion command target is invalid.
Input: G3 X85.185 Y268.546 I0 J1.419 Controller: grblHAL

3/9/2024, 2:10:09 PM
Motion command target is invalid.
Input: G2 X-1.185 Y271.385 I0 J1.419 Controller: grblHAL

3/9/2024, 2:11:12 PM
G-code words consist of a letter and a value. Letter was not found.
Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:11:12 PM
Motion command target is invalid.
Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:11:15 PM
Motion command target is invalid.
Input: G3 X85.185 Y152.706 I0 J2.481 Controller: grblHAL

3/9/2024, 2:11:15 PM
Motion command target is invalid.
Input: G3 X85.185 Y192.404 I0 J2.481 Controller: grblHAL

3/9/2024, 2:11:16 PM
Motion command target is invalid.
Input: G3 X85.185 Y202.329 I0 J2.481 Controller: grblHAL

3/9/2024, 2:11:18 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:11:20 PM

Motion command target is invalid.

Input: G2 X-1.185 Y246.989 I0 J2.481 Controller: grblHAL

3/9/2024, 2:11:22 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:11:48 PM

More than one g-code command that requires axis words found in block.

Input: G2 X-1.185 Y28.649 I0 J2.481 Controller: grblHAL

3/9/2024, 2:11:55 PM

Motion command target is invalid.

Input: G2 X-1.185 Y38.573 I0 J2.481 Controller: grblHAL

3/9/2024, 2:11:58 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:12:00 PM

Motion command target is invalid.

Input: G3 X85.185 Y63.385 I0 J2.481 Controller: grblHAL

3/9/2024, 2:12:02 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:12:04 PM

Motion command target is invalid.

Input: G2 X-1.185 Y88.196 I0 J2.481 Controller: grblHAL

3/9/2024, 2:12:06 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:12:08 PM

Motion command target is invalid.

Input: G3 X85.185 Y113.007 I0 J2.481 Controller: grblHAL

3/9/2024, 2:12:11 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:12:13 PM

Motion command target is invalid.

Input: G2 X-1.185 Y137.819 I0 J2.481 Controller: grblHAL

3/9/2024, 2:12:15 PM

Motion command target is invalid.

Input: G1 X-1.185 Controller: grblHAL

3/9/2024, 2:12:17 PM

Motion command target is invalid.

Input: G1 X85.185 Controller: grblHAL

3/9/2024, 2:12:20 PM

Motion command target is invalid.

Input: G2 X-1.185 Y157.668 I0 J2.481 Controller: grblHAL

Terminal History

```
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G2 X-1.185 Y217.215 I0 J2.481
G1 X85.185
G3 X85.185 Y222.178 I0 J2.481
G1 X-1.185
G2 X-1.185 Y227.14 I0 J2.481
G1 X85.185
G3 X85.185 Y232.102 I0 J2.481
G1 X-1.185
G2 X-1.185 Y237.064 I0 J2.481
G1 X85.185
G3 X85.185 Y242.027 I0 J2.481
G1 X-1.185
G2 X-1.185 Y246.989 I0 J2.481
G1 X85.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G3 X85.185 Y251.951 I0 J2.481
G1 X-1.185
```

G2 X-1.185 Y256.914 I0 J2.481
G1 X85.185
G3 X85.185 Y261.876 I0 J2.481
G1 X-1.185
G2 X-1.185 Y266.838 I0 J2.481
G1 X85.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G3 X85.185 Y271.8 I0 J2.481
G1 X-1.185
G2 X-1.185 Y276.763 I0 J2.481
G1 X85.185
G3 X85.185 Y281.725 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
\$C
[MSG:Disabled]
ok
Grbl 1.1h ['\$' for help] LongMill MK2 build Feb 7, 2022
\x18
Grbl 1.1h ['\$' for help] LongMill MK2 build Feb 7, 2022
G90 G94
G17
G21
G28 G91 Z0
G90
G4 P0.5
(M0)
ok
ok
ok
ok
ok
ok
ok
ok
G4 P0.5
ok
~
S12000 M3
G17 G90 G94

G54
G0 X86.128 Y3.837
Z15
G1 Z5 F2190
Z-1.365 F1100
G18 G3 X85.493 Z-2 I-0.635 K0 F2190
G1 X85.185
X-1.185
G17 G2 X-1.185 Y8.8 I0 J2.481
G1 X85.185
G3 X85.185 Y13.762 I0 J2.481
G1 X-1.185
G2 X-1.185 Y18.724 I0 J2.481
G1 X85.185
G3 X85.185 Y23.686 I0 J2.481
G1 X-1.185
G2 X-1.185 Y28.649 I0 J2.481
G1 X85.185
G3 X85.185 Y33.611 I0 J2.481
G1 X-1.185
G2 X-1.185 Y38.573 I0 J2.481
G1 X85.185
G3 X85.185 Y43.536 I0 J2.481
G1 X-1.185
G2 X-1.185 Y48.498 I0 J2.481
G1 X85.185
G3 X85.185 Y53.46 I0 J2.481
G1 X-1.185
G2 X-1.185 Y58.422 I0 J2.481
G1 X85.185
G3 X85.185 Y63.385 I0 J2.481
G1 X-1.185
G2 X-1.185 Y68.347 I0 J2.481
G1 X85.185
G3 X85.185 Y73.309 I0 J2.481
G1 X-1.185
G2 X-1.185 Y78.271 I0 J2.481
G1 X85.185
G3 X85.185 Y83.234 I0 J2.481
G1 X-1.185
G2 X-1.185 Y88.196 I0 J2.481
G1 X85.185
G3 X85.185 Y93.158 I0 J2.481
G1 X-1.185
G2 X-1.185 Y98.121 I0 J2.481
G1 X85.185
G3 X85.185 Y103.083 I0 J2.481
G1 X-1.185
G2 X-1.185 Y108.045 I0 J2.481
G1 X85.185
ok
G3 X85.185 Y113.007 I0 J2.481
ok
G1 X-1.185
ok
ok

ok
G2 X-1.185 Y117.97 I0 J2.481
ok
G1 X85.185
ok
ok
G3 X85.185 Y122.932 I0 J2.481
G1 X-1.185
ok
ok
G2 X-1.185 Y127.894 I0 J2.481
ok
G1 X85.185
ok
G3 X85.185 Y132.857 I0 J2.481
ok
G1 X-1.185
ok
G2 X-1.185 Y137.819 I0 J2.481
!
error:25 (Invalid gcode ID:25)
error:2 (Bad number format)
ok
error:2 (Bad number format)
error:24 (Invalid gcode ID:24)
error:33 (Invalid gcode ID:33)
ok
~
G1 X85.185
G3 X85.185 Y142.781 I0 J2.481
G1 X-1.185
ok
!
error:33 (Invalid gcode ID:33)
ok
ok
~
G2 X-1.185 Y147.743 I0 J2.481
G1 X85.185
G3 X85.185 Y152.706 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G2 X-1.185 Y157.668 I0 J2.481
G1 X85.185
G3 X85.185 Y162.63 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)

ok
ok
~
G2 X-1.185 Y167.593 I0 J2.481
G1 X85.185
G3 X85.185 Y172.555 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G2 X-1.185 Y177.517 I0 J2.481
G1 X85.185
G3 X85.185 Y182.479 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G2 X-1.185 Y187.442 I0 J2.481
G1 X85.185
G3 X85.185 Y192.404 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G2 X-1.185 Y197.366 I0 J2.481
G1 X85.185
G3 X85.185 Y202.329 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok
ok
~
G2 X-1.185 Y207.291 I0 J2.481
G1 X85.185
G3 X85.185 Y212.253 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
ok

```

ok
~
G2 X-1.185 Y217.215 I0 J2.481
G1 X85.185
G3 X85.185 Y222.178 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
ok
error:33 (Invalid gcode ID:33)
~
ok
ok
G2 X-1.185 Y227.14 I0 J2.481
G1 X85.185
G3 X85.185 Y232.102 I0 J2.481
G1 X-1.185
!
error:33 (Invalid gcode ID:33)
~
ok
G2 X-1.185 Y237.064 I0 J2.481
G1 X85.185
!
error:33 (Invalid gcode ID:33)
~
ok
G3 X85.185 Y242.027 I0 J2.481
G1 X-1.185
ok
!
error:33 (Invalid gcode ID:33)
\x18
ok
Grbl 1.1h ['$' for help] LongMill MK2 build Feb 7, 2022

```

G-Code File

Status	Value
Name	dgfadfgsgf.nc
Sent	0
Received	920.6315
Total	557

```

(dgfadfgsgf)
(Machine)
( vendor: Sienci)
( model: 30x30 LongMill)
( description: 3-axis Mill)
(T5 D=6.35 CR=0 - ZMIN=-27.4 - flat end mill)
G90 G94
G17

```

G21
(When using Fusion for Personal Use, the feedrate of rapid)
(moves is reduced to match the feedrate of cutting moves,)
(which can increase machining time. Unrestricted rapid moves)
(are available with a Fusion Subscription.)
G28 G91 Z0
G90

(Face1)
M0
(MANUAL TOOL CHANGE TO T5)
S12000 M3
G17 G90 G94
G54
G0 X86.128 Y3.837
Z15
G1 Z5 F2190
Z-1.365 F1100
G18 G3 X85.493 Z-2 I-0.635 K0 F2190
G1 X85.185
X-1.185
G17 G2 X-1.185 Y8.8 I0 J2.481
G1 X85.185
G3 X85.185 Y13.762 I0 J2.481
G1 X-1.185
G2 X-1.185 Y18.724 I0 J2.481
G1 X85.185
G3 X85.185 Y23.686 I0 J2.481
G1 X-1.185
G2 X-1.185 Y28.649 I0 J2.481
G1 X85.185
G3 X85.185 Y33.611 I0 J2.481
G1 X-1.185
G2 X-1.185 Y38.573 I0 J2.481
G1 X85.185
G3 X85.185 Y43.536 I0 J2.481
G1 X-1.185
G2 X-1.185 Y48.498 I0 J2.481
G1 X85.185
G3 X85.185 Y53.46 I0 J2.481
G1 X-1.185
G2 X-1.185 Y58.422 I0 J2.481
G1 X85.185
G3 X85.185 Y63.385 I0 J2.481
G1 X-1.185
G2 X-1.185 Y68.347 I0 J2.481
G1 X85.185
G3 X85.185 Y73.309 I0 J2.481
G1 X-1.185
G2 X-1.185 Y78.271 I0 J2.481
G1 X85.185
G3 X85.185 Y83.234 I0 J2.481
G1 X-1.185
G2 X-1.185 Y88.196 I0 J2.481
G1 X85.185
G3 X85.185 Y93.158 I0 J2.481

G1 X-1.185
G2 X-1.185 Y98.121 I0 J2.481
G1 X85.185
G3 X85.185 Y103.083 I0 J2.481
G1 X-1.185
G2 X-1.185 Y108.045 I0 J2.481
G1 X85.185
G3 X85.185 Y113.007 I0 J2.481
G1 X-1.185
G2 X-1.185 Y117.97 I0 J2.481
G1 X85.185
G3 X85.185 Y122.932 I0 J2.481
G1 X-1.185
G2 X-1.185 Y127.894 I0 J2.481
G1 X85.185
G3 X85.185 Y132.857 I0 J2.481
G1 X-1.185
G2 X-1.185 Y137.819 I0 J2.481
G1 X85.185
G3 X85.185 Y142.781 I0 J2.481
G1 X-1.185
G2 X-1.185 Y147.743 I0 J2.481
G1 X85.185
G3 X85.185 Y152.706 I0 J2.481
G1 X-1.185
G2 X-1.185 Y157.668 I0 J2.481
G1 X85.185
G3 X85.185 Y162.63 I0 J2.481
G1 X-1.185
G2 X-1.185 Y167.593 I0 J2.481
G1 X85.185
G3 X85.185 Y172.555 I0 J2.481
G1 X-1.185
G2 X-1.185 Y177.517 I0 J2.481
G1 X85.185
G3 X85.185 Y182.479 I0 J2.481
G1 X-1.185
G2 X-1.185 Y187.442 I0 J2.481
G1 X85.185
G3 X85.185 Y192.404 I0 J2.481
G1 X-1.185
G2 X-1.185 Y197.366 I0 J2.481
G1 X85.185
G3 X85.185 Y202.329 I0 J2.481
G1 X-1.185
G2 X-1.185 Y207.291 I0 J2.481
G1 X85.185
G3 X85.185 Y212.253 I0 J2.481
G1 X-1.185
G2 X-1.185 Y217.215 I0 J2.481
G1 X85.185
G3 X85.185 Y222.178 I0 J2.481
G1 X-1.185
G2 X-1.185 Y227.14 I0 J2.481
G1 X85.185
G3 X85.185 Y232.102 I0 J2.481

G1 X-1.185
G2 X-1.185 Y237.064 I0 J2.481
G1 X85.185
G3 X85.185 Y242.027 I0 J2.481
G1 X-1.185
G2 X-1.185 Y246.989 I0 J2.481
G1 X85.185
G3 X85.185 Y251.951 I0 J2.481
G1 X-1.185
G2 X-1.185 Y256.914 I0 J2.481
G1 X85.185
G3 X85.185 Y261.876 I0 J2.481
G1 X-1.185
G2 X-1.185 Y266.838 I0 J2.481
G1 X85.185
G3 X85.185 Y271.8 I0 J2.481
G1 X-1.185
G2 X-1.185 Y276.763 I0 J2.481
G1 X85.185
G3 X85.185 Y281.725 I0 J2.481
G1 X-1.185
G2 X-1.185 Y286.687 I0 J2.481
G1 X85.185
G3 X85.185 Y291.65 I0 J2.481
G1 X-1.185
G2 X-1.185 Y296.612 I0 J2.481
G1 X85.185
G3 X85.185 Y301.574 I0 J2.481
G1 X-1.185
G2 X-1.185 Y306.536 I0 J2.481
G1 X85.185
G3 X85.185 Y311.499 I0 J2.481
G1 X-1.185
G2 X-1.185 Y316.461 I0 J2.481
G1 X85.185
G3 X85.185 Y321.423 I0 J2.481
G1 X-1.185
G2 X-1.185 Y326.386 I0 J2.481
G1 X85.185
G3 X85.185 Y331.348 I0 J2.481
G1 X-1.185
G2 X-1.185 Y336.31 I0 J2.481
G1 X85.185
G3 X85.185 Y341.272 I0 J2.481
G1 X-1.185
G2 X-1.185 Y346.235 I0 J2.481
G1 X85.185
G3 X85.185 Y351.197 I0 J2.481
G1 X-1.185
G2 X-1.185 Y356.159 I0 J2.481
G1 X85.185
G3 X85.185 Y361.121 I0 J2.481
G1 X-1.185
G2 X-1.185 Y366.084 I0 J2.481
G1 X85.185
G3 X85.185 Y371.046 I0 J2.481

G1 X-1.185
G2 X-1.185 Y376.008 I0 J2.481
G1 X85.185
G3 X85.185 Y380.971 I0 J2.481
G1 X-1.185
G2 X-1.185 Y385.933 I0 J2.481
G1 X85.185
G3 X85.185 Y390.895 I0 J2.481
G1 X-1.185
G2 X-1.185 Y395.857 I0 J2.481
G1 X85.185
G3 X85.185 Y400.82 I0 J2.481
G1 X-1.185
G2 X-1.185 Y405.782 I0 J2.481
G1 X85.185
G3 X85.185 Y410.744 I0 J2.481
G1 X-1.185
G2 X-1.185 Y415.707 I0 J2.481
G1 X85.185
G3 X85.185 Y420.669 I0 J2.481
G1 X-1.185
G2 X-1.185 Y425.631 I0 J2.481
G1 X85.185
G3 X85.185 Y430.593 I0 J2.481
G1 X-1.185
G2 X-1.185 Y435.556 I0 J2.481
G1 X85.185
G3 X85.185 Y440.518 I0 J2.481
G1 X-1.185
G2 X-1.185 Y445.48 I0 J2.481
G1 X85.185
G3 X85.185 Y450.443 I0 J2.481
G1 X-1.185
G2 X-1.185 Y455.405 I0 J2.481
G1 X85.185
G3 X85.185 Y460.367 I0 J2.481
G1 X-1.185
G2 X-1.185 Y465.329 I0 J2.481
G1 X85.185
G3 X85.185 Y470.292 I0 J2.481
G1 X-1.185
G2 X-1.185 Y475.254 I0 J2.481
G1 X85.185
G3 X85.185 Y480.216 I0 J2.481
G1 X-1.185
G2 X-1.185 Y485.178 I0 J2.481
G1 X85.185
G3 X85.185 Y490.141 I0 J2.481
G1 X-1.185
G2 X-1.185 Y495.103 I0 J2.481
G1 X85.185
G3 X85.185 Y500.065 I0 J2.481
G1 X-1.185
G2 X-1.185 Y505.028 I0 J2.481
G1 X85.185
G3 X85.185 Y509.99 I0 J2.481

G1 X-1.185
G2 X-1.185 Y514.952 I0 J2.481
G1 X85.185
G3 X85.185 Y519.914 I0 J2.481
G1 X-1.185
G2 X-1.185 Y524.877 I0 J2.481
G1 X85.185
G3 X85.185 Y529.839 I0 J2.481
G1 X-1.185
G2 X-1.185 Y534.801 I0 J2.481
G1 X85.185
G3 X85.185 Y539.764 I0 J2.481
G1 X-1.185
G2 X-1.185 Y544.726 I0 J2.481
G1 X85.185
G3 X85.185 Y549.688 I0 J2.481
G1 X-1.185
G2 X-1.185 Y554.65 I0 J2.481
G1 X85.185
G3 X85.185 Y559.613 I0 J2.481
G1 X-1.185
G2 X-1.185 Y564.575 I0 J2.481
G1 X85.185
G3 X85.185 Y569.537 I0 J2.481
G1 X-1.185
G2 X-1.185 Y574.5 I0 J2.481
G1 X85.185
G3 X85.185 Y579.462 I0 J2.481
G1 X-1.185
G2 X-1.185 Y584.424 I0 J2.481
G1 X85.185
G3 X85.185 Y589.386 I0 J2.481
G1 X-1.185
G2 X-1.185 Y594.349 I0 J2.481
G1 X85.185
G3 X85.185 Y599.311 I0 J2.481
G1 X-1.185
G2 X-1.185 Y604.273 I0 J2.481
G1 X85.185
G3 X85.185 Y609.236 I0 J2.481
G1 X-1.185
G2 X-1.185 Y614.198 I0 J2.481
G1 X85.185
G3 X85.185 Y619.16 I0 J2.481
G1 X-1.185
G2 X-1.185 Y624.122 I0 J2.481
G1 X85.185
G3 X85.185 Y629.085 I0 J2.481
G1 X-1.185
G2 X-1.185 Y634.047 I0 J2.481
G1 X85.185
G3 X85.185 Y639.009 I0 J2.481
G1 X-1.185
G2 X-1.185 Y643.971 I0 J2.481
G1 X85.185
G3 X85.185 Y648.934 I0 J2.481

G1 X-1.185
G18 G3 X-1.82 Z-1.365 I0 K0.635
G1 Z15
G17
(When using Fusion for Personal Use, the feedrate of rapid)
(moves is reduced to match the feedrate of cutting moves,)
(which can increase machining time. Unrestricted rapid moves)
(are available with a Fusion Subscription.)

(2D Contour1)
G0 X-3.08 Y1.365
G1 Z15 F2190
Z5
Z1 F1100
Z-1.365
G18 G2 X-2.445 Z-2 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-1.365 I0 K0.635
G1 Z5
Y1.365
Z-1 F1100
Z-3.365
G2 X-2.445 Z-4 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-3.365 I0 K0.635
G1 Z5
Y1.365
Z-3 F1100
Z-5.365
G2 X-2.445 Z-6 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0

G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-5.365 I0 K0.635
G1 Z5
Y1.365
Z-5 F1100
Z-7.365
G2 X-2.445 Z-8 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-7.365 I0 K0.635
G1 Z5
Y1.365
Z-7 F1100
Z-9.365
G2 X-2.445 Z-10 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-9.365 I0 K0.635
G1 Z5
Y1.365
Z-9 F1100
Z-11.365
G2 X-2.445 Z-12 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175

G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-11.365 I0 K0.635
G1 Z5
Y1.365
Z-11 F1100
Z-13.365
G2 X-2.445 Z-14 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-13.365 I0 K0.635
G1 Z5
Y1.365
Z-13 F1100
Z-15.365
G2 X-2.445 Z-16 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-15.365 I0 K0.635
G1 Z5
Y1.365
Z-15 F1100
Z-17.365
G2 X-2.445 Z-18 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0

G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-17.365 I0 K0.635
G1 Z5
Y1.365
Z-17 F1100
Z-19.365
G2 X-2.445 Z-20 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-19.365 I0 K0.635
G1 Z5
Y1.365
Z-19 F1100
Z-21.365
G2 X-2.445 Z-22 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-21.365 I0 K0.635
G1 Z5
Y1.365
Z-21 F1100
Z-23.365
G2 X-2.445 Z-24 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175

G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-23.365 I0 K0.635
G1 Z5
Y1.365
Z-23 F1100
Z-25.365
G2 X-2.445 Z-26 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-25.365 I0 K0.635
G1 Z5
Y1.365
Z-25 F1100
Z-26.765
G2 X-2.445 Z-27.4 I0.635 K0 F2190
G1 X-1.81
G17 G3 X-1.175 Y2 I0 J0.635
G1 Y652
G2 X2 Y655.175 I3.175 J0
G1 X82
G2 X85.175 Y652 I0 J-3.175
G1 Y2
G2 X82 Y-1.175 I-3.175 J0
G1 X2
G2 X-1.175 Y2 I0 J3.175
G3 X-1.81 Y2.635 I-0.635 J0
G1 X-2.445
G18 G3 X-3.08 Z-26.765 I0 K0.635
G1 Z15
G17

G28 G91 Z0
G90
G28 G91 X0 Y0
G90
M5
M30