

Diagnostics

gSender 1.4.11

Environment

OS: Windows NT 10.0; Win64; x64

Homing: Disabled

Soft Limits: Disabled

Home Location: 3 (Front Left)

Report Inches: Disabled

Stepper Motors: Unlocked

Machine Profile

ID: 7

Company: Sienci Labs

Name: LongMill MK2

Type: 48x30

Version: MK2

Limits:

X Max: 816

Y Max: 864

Z Max: 122

Spindle/Laser: false

Laser Mode Enabled: false

Connection

Available Ports:

0:

port: COM3

manufacturer: Microsoft

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: 447.465

y: 178.290

z: -82.820

WPos:

a: 0.000

b: 0.000

c: 0.000

x: 0.000

y: 220.998

z: 20.320

Sender Status:

Modal:

motion: G1

wcs: G54

plane: G17

units: G21

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	100
\$2	1
\$3	0
\$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	200.000
\$101	199.378
\$102	200.000
\$110	3000.000
\$111	4000.000
\$112	3000.000
\$120	250.000
\$121	650.000
\$122	500.000
\$130	816.000
\$131	864.000
\$132	122.000

Recent Alarms

1/20/2025, 11:04:01 AM

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: Grbl

Recent Errors

2/22/2025, 10:27:12 AM

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

Input: N/A Controller: Grbl

2/22/2025, 10:26:40 AM

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

Input: N/A Controller: Grbl

2/22/2025, 10:26:40 AM

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

Input: N/A Controller: Grbl

2/8/2025, 10:07:51 AM

Grbl '\$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.

Input: N/A Controller: Grbl

2/8/2025, 9:45:55 AM

Grbl '\$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.

Input: N/A Controller: Grbl

2/8/2025, 9:45:38 AM

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

Input: N/A Controller: Grbl

2/8/2025, 9:45:38 AM

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

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2/8/2025, 9:45:38 AM

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

Input: N/A Controller: Grbl

1/20/2025, 11:04:02 AM

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

Input: N/A Controller: Grbl

1/20/2025, 11:04:02 AM

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

Input: N/A Controller: Grbl

1/20/2025, 11:04:02 AM

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

Input: N/A Controller: Grbl

1/19/2025, 12:05:27 PM

Grbl '\$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.

Input: N/A Controller: Grbl

12/1/2024, 2:35:52 PM

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

Input: N/A Controller: Grbl

12/1/2024, 2:35:52 PM

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

Input: N/A Controller: Grbl

12/1/2024, 2:35:51 PM

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

Input: N/A Controller: Grbl

12/1/2024, 2:35:51 PM

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

Input: N/A Controller: Grbl

12/1/2024, 2:35:51 PM

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

Input: N/A Controller: Grbl

12/1/2024, 2:35:51 PM

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

Input: N/A Controller: Grbl

12/1/2024, 11:40:20 AM

Grbl '\$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.

Input: N/A Controller: Grbl

11/23/2024, 2:11:15 PM

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

Input: N/A Controller: Grbl

11/23/2024, 10:45:55 AM

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

Input: N/A Controller: Grbl

11/23/2024, 10:45:55 AM

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Input: N/A Controller: Grbl

11/23/2024, 10:45:55 AM

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

Input: N/A Controller: Grbl

11/23/2024, 10:33:18 AM

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

Input: N/A Controller: Grbl

11/23/2024, 10:33:18 AM

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

Input: N/A Controller: Grbl

11/23/2024, 10:33:18 AM

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

Input: N/A Controller: Grbl

11/18/2024, 6:04:59 PM

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

Input: N/A Controller: Grbl

11/18/2024, 6:04:58 PM

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

Input: N/A Controller: Grbl

11/18/2024, 6:04:58 PM

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Input: N/A Controller: Grbl

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11/18/2024, 6:04:58 PM

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

Input: N/A Controller: Grbl

11/18/2024, 5:59:33 PM

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

Input: N/A Controller: Grbl

11/17/2024, 4:28:14 PM

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

Input: N/A Controller: Grbl

11/17/2024, 4:28:14 PM

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

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11/17/2024, 4:28:14 PM

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11/17/2024, 4:28:14 PM

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11/17/2024, 4:28:14 PM

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

Input: N/A Controller: Grbl

11/17/2024, 2:37:42 PM

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

Input: N/A Controller: Grbl

11/16/2024, 11:38:48 AM

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

Input: N/A Controller: Grbl

11/16/2024, 11:38:48 AM

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

Input: N/A Controller: Grbl

11/16/2024, 11:38:48 AM

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

Input: N/A Controller: Grbl

11/16/2024, 11:38:47 AM

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

Input: N/A Controller: Grbl

11/11/2024, 7:07:23 PM

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

Input: N/A Controller: Grbl

11/9/2024, 12:27:27 PM

Grbl '\$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.

Input: N/A Controller: Grbl

11/8/2024, 7:24:49 PM

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

Input: N/A Controller: Grbl

11/8/2024, 7:24:49 PM

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

Input: N/A Controller: Grbl

11/8/2024, 7:24:48 PM

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11/8/2024, 7:24:43 PM

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11/8/2024, 7:24:41 PM

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11/8/2024, 7:24:31 PM

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11/8/2024, 7:24:31 PM

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11/8/2024, 7:24:30 PM

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11/8/2024, 7:24:28 PM

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11/8/2024, 7:24:26 PM

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11/8/2024, 7:24:25 PM

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11/8/2024, 7:24:24 PM

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11/8/2024, 7:24:23 PM

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11/8/2024, 7:24:22 PM

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11/8/2024, 7:24:21 PM

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11/8/2024, 7:24:20 PM

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11/8/2024, 7:24:20 PM

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11/8/2024, 7:24:19 PM

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11/8/2024, 7:24:19 PM

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11/8/2024, 7:24:19 PM

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Input: N/A Controller: Grbl

11/8/2024, 7:24:18 PM

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11/8/2024, 7:24:16 PM

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11/8/2024, 7:24:16 PM

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11/8/2024, 7:24:16 PM

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Input: N/A Controller: Grbl

11/8/2024, 7:24:15 PM

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11/8/2024, 7:24:15 PM

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

Input: N/A Controller: Grbl

11/8/2024, 7:22:50 PM

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

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11/8/2024, 7:22:50 PM

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

Input: N/A Controller: Grbl

11/8/2024, 7:22:49 PM

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11/8/2024, 7:22:48 PM

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

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11/8/2024, 7:18:17 PM

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11/8/2024, 7:18:17 PM

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11/8/2024, 7:18:17 PM

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

Input: N/A Controller: Grbl

11/8/2024, 7:18:16 PM

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

Input: N/A Controller: Grbl

Terminal History

ok
G1X-5.582Y-2.509
ok
G1X-4.585Y-2.601
ok
G1X-3.627Y-2.655
ok
G1X-2.591Y-2.664
ok
G1X-1.489Y-2.612
ok
G1X-0.356Y-2.488
ok
G1X0.756Y-2.292
ok
G1X1.936Y-1.999
G1X2.404Y-2.175
ok
G1X3.469Y-2.514
ok
G1X3.721Y-2.581
ok
G1X3.029Y-2.770
ok
ok
G3X-1.031Y-4.928I3.330J-11.160
ok
G1X-1.125Y-5.005
ok
ok
G3X-2.722Y-6.600I7.389J-9.002
ok
G1X-2.978Y-6.910
ok
G3X-3.796Y-8.033I8.987J-7.408
ok
G1X-4.003Y-8.356
ok
G1X-4.518Y-9.242
G1X-4.904Y-9.981
ok
G1X-5.400Y-11.065
ok
G1X-5.780Y-12.013
ok
ok
G3X-6.599Y-13.590I9.895J-6.142
ok
G1X-6.683Y-13.786
ok
G1X-7.029Y-14.705
ok
G1X-7.214Y-15.265
ok
G1X-7.471Y-16.221
G1X-7.565Y-16.683

ok
G1X-9.263Y-18.323
ok
G1X-9.767Y-18.841
ok
G1X-9.994Y-18.437
ok
G1X-10.486Y-17.628
ok
G1X-11.081Y-16.747
ok
G1X-11.812Y-15.798
ok
G1X-12.356Y-15.192
ok
G1X-13.093Y-14.443
ok
G1X-13.351Y-14.203
ok
G1X-14.254Y-13.446
ok
G1X-14.527Y-13.239
ok
ok
G3X-15.559Y-12.543I-7.024J-9.290
ok
G1X-15.851Y-12.367
ok
ok
G3X-16.942Y-11.789I-5.992J-9.987
ok
G1X-17.707Y-11.446
G1X-17.744Y-11.329
ok
G1X-18.082Y-10.413
ok
G1X-18.242Y-10.030
G1X-18.665Y-9.127
ok
G1X-18.855Y-8.762
ok
G1X-19.374Y-7.867
ok
G1X-19.593Y-7.525
ok
G1X-20.223Y-6.636
ok
G1X-20.470Y-6.321
ok
G1X-21.229Y-5.443
ok
G1X-21.502Y-5.158
ok
ok
G3X-22.410Y-4.304I-8.418J-8.049
ok

G1X-22.707Y-4.053
ok
ok
G3X-23.784Y-3.247I-7.509J-8.902
ok
G1X-24.104Y-3.035
ok
G3X-25.359Y-2.312I-6.432J-9.709
ok
G1X-26.040Y-1.973
G1X-27.387Y-1.411
ok
ok
G3X-32.926Y-0.559I-4.488J-10.747
G1X-37.618Y-0.977
ok
G1X-38.895Y-1.047
ok
G1X-39.839Y-1.042
ok
G1X-41.027Y-0.960
G1X-45.364Y-0.531
ok
G1X-47.626Y-0.343
ok
G1X-48.291Y0.117
ok
G1X-49.550Y0.871
ok
G1X-50.885Y1.551
ok
G1X-52.210Y2.134
ok
G1X-53.550Y2.648
ok
G1X-54.917Y3.106
ok
G1X-56.752Y3.644
ok
G1X-57.480Y3.911
ok
G1X-57.949Y4.157
ok
G1X-58.812Y4.557
ok
G1X-60.194Y5.125
ok
G1X-61.693Y5.674
ok
G1X-66.030Y7.057
ok
G1X-69.395Y8.161
ok
G1X-73.167Y9.425
ok
ok

G3X-75.736Y9.974I-3.701J-11.043

ok

G1X-76.629Y10.377

ok

G1X-74.879Y11.940

ok

G1X-73.606Y11.826

ok

G1X-72.144Y11.727

G1X-70.677Y11.684

ok

G1X-69.115Y11.732

ok

G1X-68.011Y11.857

ok

G1X-66.944Y12.029

ok

G1X-65.915Y12.244

ok

G1X-64.601Y12.630

ok

G1X-63.611Y12.978

ok

G1X-62.711Y13.335

ok

G1X-61.856Y13.705

ok

G1X-60.972Y14.116

ok

G1X-59.431Y14.898

ok

G1X-57.879Y15.765

ok

G1X-56.440Y16.649

ok

G1X-55.648Y17.175

ok

G1X-54.904Y17.699

ok

G1X-54.135Y18.284

ok

G1X-53.711Y18.639

ok

G1X-52.958Y18.799

ok

G1X-52.024Y19.049

ok

G1X-51.906Y19.086

ok

ok

G3X-40.300Y8.404I11.606J0.965

G1X-39.899

ok

ok

G3X-36.547Y8.897I0.000J11.646

ok

G1X-36.454Y8.925
ok
G3X-32.977Y10.645I-3.353J11.153
ok
G1X-32.867Y10.725
ok
G3X-31.381Y12.004I-6.830J9.434
ok
G1X-30.853Y12.564
ok
G3X-29.374Y12.966I-2.308J11.415
ok
ok
G3X-23.433Y11.725I5.271J10.385
G1X-23.350Y11.729
ok
G1X-22.178Y11.857
ok
G1X-21.862Y11.513
ok
G1X-21.666Y11.115
ok
G3X-20.075Y8.727I10.415J5.213
ok
G1X-19.953Y8.585
G0Z5.080
ok
G0X-54.921Y9.667
ok
G1Z-3.175F381.0
ok
G1X-55.443Y9.924F1270.0
ok
G1X-55.194Y10.063
ok
G1X-54.921Y9.667
ok
G1X-55.399Y8.499
ok
G1X-56.799Y9.167
ok
G1X-58.356Y9.804
ok
G1X-57.066Y10.458
ok
G1X-55.335Y11.425
ok
G1X-54.774Y11.770
ok
ok
G3X-50.514Y6.869I14.474J8.281
ok
G1X-51.850Y7.383
ok
G1X-53.415Y7.907
G1X-55.399Y8.499

```

ok
G0Z5.080
M5
ok
G0Z20.320
G0X0.000Y0.000
M2
G4 P0.5
ok
ok
ok
ok
ok
ok
ok
ok
[MSG:Pgm End]
ok
ok
$J=G20G91 Y1970 F118
ok
\x85

```

G-Code File

Status	Value
Name	up pocket_1-test up.gcode
Sent	0
Received	0.0049
Total	5017

```

(VECTRIC POST REVISION)
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