Diagnostics

gSender 1.2.2

Environment

OS: Windows NT 10.0; Win64; x64

Connection

Available Ports:
  0:
    port: COM3
    manufacturer: Carbide 3D LLC (carbide3d.com)
    inuse: false
Connected Port: COM3
Baudrate: 115200
Unrecognized Ports:
  NULL

Machine Profile

ID: 9
Company: Carbide 3D
Name: Shapeoko
Type: XXL
Version: MK1
Limits:
  X Max: 845
  Y Max: 850
  Z Max: 100
Spindle/Laser: true
Laser Mode Enabled: true

GRBL Information

Type: Grbl
MPos:
  a: 0.000
  b: 0.000
  c: 0.000
  x: -442.425
  y: -627.350
  z: -53.025
WPos:
  a: 0.000
  b: 0.000
  c: 0.000
  x: 266.692
  y: 99.522
  z: 17.325
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

EEPROM Values

Setting	Value
$0	10
$1	255
$2	0
$3	6
$4	0
$5	0
$6	0
$10	255
$11	0.020
$12	0.010
$13	0
$20	0
$21	0
$22	1
$23	0
$24	100.000
$25	2000.000
$26	25
$27	3.000
$30	255
$31	0
$32	1
$100	40.000
$101	40.000
$102	40.000
$110	10000.000
$111	10000.000
$112	5000.000
$120	500.000
$121	500.000
$122	400.000
$130	845.000
$131	850.000
$132	100.000

Recent Alarms

Recent Errors

2023-08-19 at 11:24:15
  Error 9 - G-code commands are locked out during alarm or jog state.
  On Line : "N/A"

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2023-08-19 at 11:22:51
   Error 8 - Grbl '$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.
   On Line : "G20 G91 Z0.01"

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   On Line : "G20 G91 Z0.01"

Terminal History

```
G1X0.0375
ok
G1Y3.3500
ok
G1X10.9625
ok
G1Y3.4625
ok
G1X0.0375
ok
G0Z0.9500
ok
G0X11.0000Y3.5000
ok
ok
G1Z0.5391F70.0
ok
ok
G1X10.5000Z0.5039
ok
G1X11.0000Z0.4688
ok
ok
G1X0.0000F35.0
ok
G1X0.0000Y2.0000
ok
G1X11.0000
ok
```

```
G1Y3.5000
ok
G0Z0.9500
ok
G0X10.9625Y2.0375
ok
G1Z0.4688F70.0
ok
G1X10.4625Z0.4336
ok
G1X10.9625Z0.3984
ok
G1X0.0375F35.0
ok
G1Y2.2250
ok
G1X10.9625
ok
G1Y2.4125
G1X0.0375
ok
G1Y2.6000
ok
G1X10.9625
G1Y2.7875
ok
G1X0.0375
G1Y2.9750
ok
G1X10.9625
ok
G1Y3.1625
ok
G1X0.0375
ok
G1Y3.3500
ok
G1X10.9625
ok
G1Y3.4625
ok
G1X0.0375
ok
G0Z0.9500
ok
G0X11.0000Y3.5000
ok
ok
G1Z0.4688F70.0
ok
ok
G1X10.5000Z0.4336
ok
G1X11.0000Z0.3984
ok
ok
```

```
G1X0.0000F35.0
ok
G1X0.0000Y2.0000
ok
G1X11.0000
ok
G1Y3.5000
ok
G0Z0.9500
ok
G0X10.9625Y2.0375
ok
G1Z0.3984F70.0
ok
G1X10.4625Z0.3633
ok
G1X10.9625Z0.3281
ok
G1X0.0375F35.0
ok
G1Y2.2250
ok
G1X10.9625
ok
G1Y2.4125
G1X0.0375
ok
G1Y2.6000
ok
G1X10.9625
G1Y2.7875
ok
G1X0.0375
G1Y2.9750
ok
G1X10.9625
ok
G1Y3.1625
ok
G1X0.0375
ok
G1Y3.3500
ok
G1X10.9625
ok
G1Y3.4625
ok
G1X0.0375
ok
G0Z0.9500
ok
G0X11.0000Y3.5000
ok
ok
G1Z0.3984F70.0
ok
```

```
ok
G1X10.5000Z0.3633
ok
G1X11.0000Z0.3281
ok
ok
G1X0.0000F35.0
ok
G1X0.0000Y2.0000
ok
G1X11.0000
ok
G1Y3.5000
ok
G0Z0.9500
ok
G0X10.9625Y2.0375
ok
G1Z0.3281F70.0
ok
G1X10.4625Z0.2930
ok
G1X10.9625Z0.2578
ok
G1X0.0375F35.0
ok
G1Y2.2250
ok
G1X10.9625
ok
G1Y2.4125
G1X0.0375
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G1Y2.6000
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G1X10.9625
G1Y2.7875
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G1X0.0375
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G1X10.9625
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G1Y3.1625
ok
G1X0.0375
ok
G1Y3.3500
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G1X10.9625
ok
G1Y3.4625
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G1X0.0375
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G0Z0.9500
```

```
ok
G0X11.0000Y3.5000
ok
ok
G1Z0.3281F70.0
ok
ok
G1X10.5000Z0.2930
ok
G1X11.0000Z0.2578
ok
ok
G1X0.0000F35.0
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G1X0.0000Y2.0000
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G1X11.0000
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G1Y3.5000
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G0Z0.9500
ok
G0X10.9625Y2.0375
ok
G1Z0.2578F70.0
ok
G1X10.4625Z0.2227
ok
G1X10.9625Z0.1875
ok
G1X0.0375F35.0
ok
G1Y2.2250
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G1X10.9625
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G1Y2.4125
G1X0.0375
ok
G1Y2.6000
ok
G1X10.9625
G1Y2.7875
ok
G1X0.0375
G1Y2.9750
ok
G1X10.9625
ok
G1Y3.1625
ok
G1X0.0375
ok
G1Y3.3500
ok
G1X10.9625
```

```
!
~
[MSG:Restoring spindle]
ok
G1Y3.4625
G1X0.0375
ok
G0Z0.9500
!
~
[MSG:Restoring spindle]
G0X11.0000Y3.5000
!
~
[MSG:Restoring spindle]
ok
G1Z0.2578F70.0
ok
ok
G1X10.5000Z0.2227
ok
G1X11.0000Z0.1875
ok
ok
G1X0.0000F35.0
ok
G1X0.0000Y2.0000
ok
G1X11.0000
ok
G1Y3.5000
ok
G0Z0.9500
ok
G0X11.1250Y3.9182Z0.9500
ok
G1Z0.7500F70.0
ok
G1Y-0.3318Z0.7159
ok
G1Y3.9182Z0.6818
error:24 (Invalid g-code ID:24)
error:24 (Invalid g-code ID:24)
ok
error:2 (Bad number format)
ok
ok
\x18
G54
Grbl 1.1f ['$' for help]
ok
```

G-Code File

Status	Value
Name	DishSoap_Bottom_Pocket Cutout EMDC-250 C563.gcode
Sent	0
Received	251753.01556420233
Total	328

```
(VECTRIC POST REVISION)
(B7D73AB80401207B5F86E427EB6AE0D2)
T1
G17
G20
G90
G0Z1.5500
G0X0.0000Y0.0000
S10000M3
G0X10.9625Y2.0375Z0.9500
G1Z0.7500F70.0
G1X10.4625Z0.7148
G1X10.9625Z0.6797
G1X0.0375F35.0
G1Y2.2250
G1X10.9625
G1Y2.4125
G1X0.0375
G1Y2.6000
G1X10.9625
G1Y2.7875
G1X0.0375
G1Y2.9750
G1X10.9625
G1Y3.1625
G1X0.0375
G1Y3.3500
G1X10.9625
G1Y3.4625
G1X0.0375
G0Z0.9500
G0X11.0000Y3.5000
G1Z0.7500F70.0
G1X10.5000Z0.7148
G1X11.0000Z0.6797
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
G1Y3.5000
G0Z0.9500
G0X10.9625Y2.0375
G1Z0.6797F70.0
G1X10.4625Z0.6445
G1X10.9625Z0.6094
G1X0.0375F35.0
G1Y2.2250
G1X10.9625
```

```
G1Y2.4125
G1X0.0375
G1Y2.6000
G1X10.9625
G1Y2.7875
G1X0.0375
G1Y2.9750
G1X10.9625
G1Y3.1625
G1X0.0375
G1Y3.3500
G1X10.9625
G1Y3.4625
G1X0.0375
G0Z0.9500
G0X11.0000Y3.5000
G1Z0.6797F70.0
G1X10.5000Z0.6445
G1X11.0000Z0.6094
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
G1Y3.5000
G0Z0.9500
G0X10.9625Y2.0375
G1Z0.6094F70.0
G1X10.4625Z0.5742
G1X10.9625Z0.5391
G1X0.0375F35.0
G1Y2.2250
G1X10.9625
G1Y2.4125
G1X0.0375
G1Y2.6000
G1X10.9625
G1Y2.7875
G1X0.0375
G1Y2.9750
G1X10.9625
G1Y3.1625
G1X0.0375
G1Y3.3500
G1X10.9625
G1Y3.4625
G1X0.0375
G0Z0.9500
G0X11.0000Y3.5000
G1Z0.6094F70.0
G1X10.5000Z0.5742
G1X11.0000Z0.5391
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
G1Y3.5000
G0Z0.9500
G0X10.9625Y2.0375
```

```
G1Z0.5391F70.0
G1X10.4625Z0.5039
G1X10.9625Z0.4688
G1X0.0375F35.0
G1Y2.2250
G1X10.9625
G1Y2.4125
G1X0.0375
G1Y2.6000
G1X10.9625
G1Y2.7875
G1X0.0375
G1Y2.9750
G1X10.9625
G1Y3.1625
G1X0.0375
G1Y3.3500
G1X10.9625
G1Y3.4625
G1X0.0375
G0Z0.9500
G0X11.0000Y3.5000
G1Z0.5391F70.0
G1X10.5000Z0.5039
G1X11.0000Z0.4688
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
G1Y3.5000
G0Z0.9500
G0X10.9625Y2.0375
G1Z0.4688F70.0
G1X10.4625Z0.4336
G1X10.9625Z0.3984
G1X0.0375F35.0
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G1X10.9625
G1Y2.4125
G1X0.0375
G1Y2.6000
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G1Y2.7875
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G1Y2.9750
G1X10.9625
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G1X0.0375
G1Y3.3500
G1X10.9625
G1Y3.4625
G1X0.0375
G0Z0.9500
G0X11.0000Y3.5000
G1Z0.4688F70.0
G1X10.5000Z0.4336
G1X11.0000Z0.3984
```

```
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
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G1X10.4625Z0.3633
G1X10.9625Z0.3281
G1X0.0375F35.0
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G1X10.9625
G1Y3.4625
G1X0.0375
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G1Z0.3984F70.0
G1X10.5000Z0.3633
G1X11.0000Z0.3281
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
G1Y3.5000
G0Z0.9500
G0X10.9625Y2.0375
G1Z0.3281F70.0
G1X10.4625Z0.2930
G1X10.9625Z0.2578
G1X0.0375F35.0
G1Y2.2250
G1X10.9625
G1Y2.4125
G1X0.0375
G1Y2.6000
G1X10.9625
G1Y2.7875
G1X0.0375
G1Y2.9750
G1X10.9625
G1Y3.1625
G1X0.0375
G1Y3.3500
G1X10.9625
G1Y3.4625
```

```
G1X0.0375
G0Z0.9500
G0X11.0000Y3.5000
G1Z0.3281F70.0
G1X10.5000Z0.2930
G1X11.0000Z0.2578
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
G1Y3.5000
G0Z0.9500
G0X10.9625Y2.0375
G1Z0.2578F70.0
G1X10.4625Z0.2227
G1X10.9625Z0.1875
G1X0.0375F35.0
G1Y2.2250
G1X10.9625
G1Y2.4125
G1X0.0375
G1Y2.6000
G1X10.9625
G1Y2.7875
G1X0.0375
G1Y2.9750
G1X10.9625
G1Y3.1625
G1X0.0375
G1Y3.3500
G1X10.9625
G1Y3.4625
G1X0.0375
G0Z0.9500
G0X11.0000Y3.5000
G1Z0.2578F70.0
G1X10.5000Z0.2227
G1X11.0000Z0.1875
G1X0.0000F35.0
G1X0.0000Y2.0000
G1X11.0000
G1Y3.5000
G0Z0.9500
G0X11.1250Y3.9182Z0.9500
G1Z0.7500F70.0
G1Y-0.3318Z0.7159
G1Y3.9182Z0.6818
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.6818F70.0
G1Y-0.3318Z0.6477
G1Y3.9182Z0.6136
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.6136F70.0
```

```
G1Y-0.3318Z0.5795
G1Y3.9182Z0.5455
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.5455F70.0
G1Y-0.3318Z0.5114
G1Y3.9182Z0.4773
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.4773F70.0
G1Y-0.3318Z0.4432
G1Y3.9182Z0.4091
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.4091F70.0
G1Y-0.3318Z0.3750
G1Y3.9182Z0.3409
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.3409F70.0
G1Y-0.3318Z0.3068
G1Y3.9182Z0.2727
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.2727F70.0
G1Y-0.3318Z0.2386
G1Y3.9182Z0.2045
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.2045F70.0
G1Y-0.3318Z0.1705
G1Y3.9182Z0.1364
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.1364F70.0
G1Y-0.3318Z0.1023
G1Y3.9182Z0.0682
G1Y-0.3318F35.0
G0Z0.9500
G0Y3.9182
G1Z0.0682F70.0
G1Y-0.3318Z0.0341
G1Y3.9182Z0.0000
G1Y-0.3318F35.0
G0Z0.9500
M5
G0Z1.5500
G0X0.0000Y0.0000
M2
```