

# Diagnostics Report

gSender v1.5.7 • Generated on 2/9/2026

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## Environment

**Operating System:**

X11; Linux x86\_64

**Homing:**

Enabled

**Soft Limits:**

Enabled

**Home Location:**

3 (Front Left)

**Report Inches:**

Disabled

**Stepper Motors:**

Unlocked

## Machine Profile

**ID:**

30

**Company:**

**Name:**

Generic CNC

**Type:**

**Version:**

**Work Area:**

X: 1252mm

Y: 2502mm

Z: 287mm

**Spindle/Laser:**

Not Available

**Laser Mode:**

Disabled

## Connection

**Connected Port:**

/dev/ttyACM0

**Baudrate:**

115200

**Manufacturer:**

Unknown

## Controller Status

**Type:**

Grbl

**Firmware:**

N/A

**Workflow State:**

running

**In Use:****No****Available Ports:**

None detected

**Unrecognized Ports:**

- /dev/ttyACM0
- /dev/ttyS1
- /dev/ttyS2
- /dev/ttyS3
- /dev/ttyS4
- /dev/ttyS5
- /dev/ttyS0

**Homing Status:****Not Homed****Machine Position:**

X: -1247.000mm  
Y: -2497.000mm  
Z: -5.000mm  
A: 0°  
B: 0°  
C: 0°

**Work Position:**

X: -407.473mm  
Y: -675.675mm  
Z: 66.000mm  
A: 0°  
B: 0°  
C: 0°

## Preferences & Settings

**Workspace Units:****Metric (mm)****Laser Mode:****Disabled****Rotary Mode:****Disabled****Jog Presets:****Rapid:**

XY Step: 20 mm  
Z Step: 10 mm  
Feedrate: 5000 mm/min  
A Step: 20°

**Normal:**

XY Step: 5 mm  
Z Step: 2 mm  
Feedrate: 3000 mm/min  
A Step: 5°

**Precise:**

XY Step: 0.5 mm  
Z Step: 0.1 mm  
Feedrate: 1000 mm/min  
A Step: 0.5°

# Firmware Settings

Setting	Current Value	Default Value
\$0	10.0	10
\$1	25	100
\$2	0	1
\$3	0	1
\$4	0	1
\$5	0	0
\$6	0	0
\$10	3	1
\$11	0.010	0.010
\$12	0.002	0.002
\$13	0	0
\$20	1	0
\$21	1	0
\$22	1	0
\$23	3	3
\$24	500.0	25.000
\$25	2000.0	1500.000
\$26	250	250
\$27	5.000	1.000
\$30	90000.000	30000
\$31	0.000	10000
\$32	0	0

<b>\$100</b>	<b>640.000</b>	<b>200.000</b>
<b>\$101</b>	<b>480.000</b>	<b>200.000</b>
<b>\$102</b>	<b>768.000</b>	<b>200.000</b>
<b>\$110</b>	<b>7000.000</b>	<b>4000.000</b>
<b>\$111</b>	<b>7000.000</b>	<b>4000.000</b>
<b>\$112</b>	<b>2000.000</b>	<b>3000.000</b>
<b>\$120</b>	<b>150.000</b>	<b>750.000</b>
<b>\$121</b>	<b>150.000</b>	<b>750.000</b>
<b>\$122</b>	<b>150.000</b>	<b>500.000</b>
<b>\$130</b>	<b>1252.000</b>	<b>810.000</b>
<b>\$131</b>	<b>2502.000</b>	<b>855.000</b>
<b>\$132</b>	<b>287.000</b>	<b>120.000</b>

## Errors and Alarms

### All Alarms (15)

**2/9/2026, 3:41:20 PM**

Homing must be run if limit switches and homing cycle is enabled in EEPROM  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:08:25 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

**2/6/2026, 5:08:09 PM**

Homing must be run if limit switches and homing cycle is enabled in EEPROM  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:05:09 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

**2/6/2026, 5:04:53 PM**

Homing must be run if limit switches and homing cycle is enabled in EEPROM  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:02:55 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

### All Errors (126)

**2/6/2026, 5:08:39 PM**

Jog target exceeds machine travel. Jog command has been ignored.  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:08:39 PM**

Jog target exceeds machine travel. Jog command has been ignored.  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:08:37 PM**

Jog target exceeds machine travel. Jog command has been ignored.  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:08:36 PM**

Jog target exceeds machine travel. Jog command has been ignored.  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:08:34 PM**

Jog target exceeds machine travel. Jog command has been ignored.  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:08:25 PM**

Missing the expected G-code word value or numeric value format is not valid.  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:05:09 PM**

Missing the expected G-code word value or numeric value format is not valid.  
Input: N/A  
Controller: Grbl

**2/6/2026, 5:02:56 PM**

Missing the expected G-code word value or nu-

**2/6/2026, 5:02:06 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

**2/6/2026, 5:01:50 PM**

Homing must be run if limit switches and homing cycle is enabled in EEPROM

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:01 PM**

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: GAO

Controller: Grbl

**2/5/2026, 4:01:01 PM**

Reset while in motion. Machine position is likely lost due to sudden halt. Re-homing is highly recommended.

Input: GAO

Controller: Grbl

**2/5/2026, 3:09:53 PM**

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: (Ensure the clearance height will clear the part and or fixtures.)

Controller: Grbl

**2/5/2026, 3:09:53 PM**

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: (Ensure the clearance height will clear the part and or fixtures.)

Controller: Grbl

**2/5/2026, 3:07:26 PM**

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: G0 Z5

Controller: Grbl

meric value format is not valid.

Input: N/A

Controller: Grbl

**2/6/2026, 5:02:36 PM**

Jog target exceeds machine travel. Jog command has been ignored.

Input: N/A

Controller: Grbl

**2/6/2026, 5:02:06 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-19.579 Y-1.372 Z-4.688

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-19.081 Y-1.503 Z-4.5

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-18.579 Y-1.619 Z-4.313

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-18.579 Y-1.619 Z-4.313

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-19.081 Y-1.503 Z-4.5

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-19.579 Y-1.372 Z-4.688

Controller: Grbl

**2/5/2026, 3:07:26 PM**

Soft limit alarm. G-code motion target exceeds machine travel. Machine position retained. Alarm may be safely unlocked.

Input: G0 Z5

Controller: Grbl

**2/5/2026, 2:48:08 PM**

Homing must be run if limit switches and homing cycle is enabled in EEPROM

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-17.056 Y-1.875 Z-3.75

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-18.074 Y-1.72 Z-4.125

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-18.074 Y-1.72 Z-4.125

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-17.566 Y-1.805 Z-3.938

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-17.566 Y-1.805 Z-3.938

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-16.543 Y-1.93 Z-3.563

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-17.056 Y-1.875 Z-3.75

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-16.543 Y-1.93 Z-3.563

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-16.03 Y-1.969 Z-3.375

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: G1 X-15.515 Y-1.992 Z-3.188 F666

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-15 Y-2 I0 J-17

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-16.03 Y-1.969 Z-3.375

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: G1 X-15.515 Y-1.992 Z-3.188 F666

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-15 Y-2 Z-3

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-15 Y-2 I0 J-17

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: G2 X-15 Y32 I0 J17 F2000

Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm



or jog state.  
Input: G2 X-15 Y32 I0 J17 F2000  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-15 Y-2 Z-3  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-14.479 Y-1.992 Z-2.81  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-13.959 Y-1.968 Z-2.621  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-13.959 Y-1.968 Z-2.621  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-13.439 Y-1.928 Z-2.431  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-14.479 Y-1.992 Z-2.81  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-12.405 Y-1.801 Z-2.052  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-11.891 Y-1.713 Z-1.862  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-12.921 Y-1.872 Z-2.241

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-13.439 Y-1.928 Z-2.431

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-12.921 Y-1.872 Z-2.241

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-12.405 Y-1.801 Z-2.052

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-10.873 Y-1.491 Z-1.483

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-11.38 Y-1.61 Z-1.672

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-11.891 Y-1.713 Z-1.862

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-10.37 Y-1.357 Z-1.293

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-10.873 Y-1.491 Z-1.483

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-11.38 Y-1.61 Z-1.672

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-9.376 Y-1.043 Z-0.914

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-9.87 Y-1.208 Z-1.103

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-8.887 Y-0.863 Z-0.724

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-7.927 Y-0.459 Z-0.345

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-9.376 Y-1.043 Z-0.914

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-10.37 Y-1.357 Z-1.293

Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm

or jog state.  
Input: X-9.87 Y-1.208 Z-1.103  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-8.404 Y-0.668 Z-0.534  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-6.089 Y0.522 Z0.414  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-6.537 Y0.256 Z0.224  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-7.456 Y-0.235 Z-0.155  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-6.993 Y0.004 Z0.034  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-8.887 Y-0.863 Z-0.724  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-8.404 Y-0.668 Z-0.534  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-5.65 Y0.802 Z0.603  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-5.219 Y1.096 Z0.793

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-7.927 Y-0.459 Z-0.345

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-7.456 Y-0.235 Z-0.155

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-3.984 Y2.052 Z1.362

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-4.386 Y1.721 Z1.172

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-3.592 Y2.396 Z1.552

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-4.798 Y1.402 Z0.983

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-3.211 Y2.752 Z1.741

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-6.537 Y0.256 Z0.224

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-5.65 Y0.802 Z0.603

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-6.993 Y0.004 Z0.034

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-2.483 Y3.497 Z2.121

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-6.089 Y0.522 Z0.414

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-2.136 Y3.886 Z2.31 F666

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-2.841 Y3.119 Z1.931

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-5.219 Y1.096 Z0.793

Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm

or jog state.  
Input: G1 Z2.5 F333.3  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: G54  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: G0 X-1.802 Y4.285  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: G0 Z5  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: Z15  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-4.798 Y1.402 Z0.983  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-4.386 Y1.721 Z1.172  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: X-3.984 Y2.052 Z1.362  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

G-code commands are locked out during alarm or jog state.  
Input: G17 G90 G94  
Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-3.592 Y2.396 Z1.552

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-3.211 Y2.752 Z1.741

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: S12000 M3

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: T4

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-2.841 Y3.119 Z1.931

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-2.483 Y3.497 Z2.121

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: G1 Z2.5 F333.3

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: X-2.136 Y3.886 Z2.31 F666

Controller: Grbl



**2/5/2026, 4:01:21 PM**

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

Input: G0 Z5

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: Z15

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: (2D Contour1)

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: G0 X-1.802 Y4.285

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: (Raise the Z-axis to a safe height before starting the program.)

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: G54

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: (Ensure the clearance height will clear the part and or fixtures.)

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: G17 G90 G94

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: S12000 M3

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: T4

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: (2D Contour1)

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: (Raise the Z-axis to a safe height before starting the program.)

Controller: Grbl

**2/5/2026, 4:01:21 PM**

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

Input: (Ensure the clearance height will clear the part and or fixtures.)

Controller: Grbl

**2/5/2026, 4:01:11 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:11 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:11 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:11 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:01 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 4:01:01 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 3:10:04 PM**

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

Input: (circle with safe retracts set to Clearance Height instead of G28)

Controller: Grbl

**2/5/2026, 3:10:04 PM**

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

Input: (circle with safe retracts set to Clearance Height instead of G28)

Controller: Grbl

**2/5/2026, 3:07:43 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 3:07:43 PM**

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

Input: N/A

Controller: Grbl

**2/5/2026, 3:06:39 PM**

G-code words consist of a letter and a value. Letter was not found.

Input: N/A

Controller: Grbl

**2/5/2026, 3:06:39 PM**

G-code words consist of a letter and a value.  
Letter was not found.  
Input: N/A  
Controller: Grbl

**2/5/2026, 3:03:26 PM**

G-code words consist of a letter and a value.  
Letter was not found.  
Input: N/A  
Controller: Grbl

**2/5/2026, 2:56:16 PM**

G-code words consist of a letter and a value.  
Letter was not found.  
Input: N/A  
Controller: Grbl

## Terminal History

```
G2 X-48.005 Y79.193 I1.744 J0.979
ok
ok
G1 X-48.906 Y81.701
ok
X-48.952 Y81.847
X-49.1 Y82.386
ok
X-49.268 Y82.971
ok
ok
X-49.294 Y83.069
ok
X-49.314 Y83.169
ok
X-49.85 Y86.148
X-49.867 Y86.259
ok
X-49.877 Y86.371
ok
X-50.067 Y89.252
X-50.071 Y89.383
ok
Y112.747
Y114.247 Z-3
ok
Y118.247
ok
Y119.747 Z-5.5 F333.3
Y135.91 F2000
```

ok  
G2 X-48.071 Y137.91 I2 J0  
ok  
G1 X-14.386  
X-12.886 Z-3  
ok  
X-8.886  
ok  
X-7.386 Z-5.5 F333.3  
X0 F2000  
ok  
ok  
G2 X2 Y135.91 I0 J-2  
G1 Y93.448  
ok  
Y91.948 Z-3  
ok  
Y87.948  
Y87.075 Z-4.456 F333.3  
ok  
X1.997 Y86.962 Z-4.643  
ok  
G0 Z5  
X-51.032 Y50.498  
ok  
G1 Z-0.25 F333.3  
ok  
Y64.904 Z-5.493 F666  
Y64.922 Z-5.5  
ok  
ok  
G2 X-49.032 Y66.904 I2 J-0.018 F2000  
ok  
G1 X-43.909  
X-42.409 Z-3  
ok  
X-38.409  
ok  
X-36.909 Z-5.5 F333.3  
ok  
X-0.961 F2000  
ok  
G2 X1.039 Y64.904 I0 J-2  
G1 Y56.674  
ok  
Y55.174 Z-3  
Y51.174  
ok  
Y49.674 Z-5.5 F333.3  
Y18.732 F2000  
ok  
X1.034 Y18.59  
ok  
X0.986 Y17.914  
ok  
X0.782 Y14.688  
ok  
X0.77 Y14.566  
X0.421 Y11.772  
ok  
ok  
G2 X0.373 Y11.521 I-1.985 J0.248  
G1 X0.253 Y11.054

ok  
X0.227 Y10.963  
ok  
X0.197 Y10.874  
X0.039 Y10.434  
ok  
X0.013 Y10.368  
ok  
X-0.854 Y8.207  
ok  
G2 X-0.966 Y7.973 I-1.856 J0.745  
ok  
G1 X-2.088 Y5.973  
ok  
G2 X-2.271 Y5.702 I-1.744 J0.979  
G1 X-2.56 Y5.341  
ok  
X-2.662 Y5.224  
ok  
X-3.016 Y4.845  
ok  
X-3.093 Y4.767  
ok  
X-3.251 Y4.616  
ok  
X-4.347 Y3.567 Z-3  
ok  
X-4.924 Y3.016  
ok  
ok  
G2 X-5.159 Y2.823 I-1.383 J1.445  
ok  
G1 X-7.228 Y1.373  
ok  
ok  
G2 X-7.518 Y1.205 I-1.147 J1.638  
ok  
G1 X-7.562 Y1.184  
ok  
ok  
ok  
X-7.995 Y0.978 Z-3.788 F333.3  
ok  
X-8.126 Y0.921 Z-4.021  
ok  
X-8.608 Y0.734 Z-4.859  
ok  
ok  
X-8.738 Y0.688 Z-5.079  
ok  
ok  
X-8.991 Y0.609 Z-5.5  
ok  
X-11.212 Y-0.085 F2000  
ok  
ok  
G2 X-11.475 Y-0.149 I-0.597 J1.909  
ok  
ok  
G1 X-13.824 Y-0.545  
ok  
ok  
G2 X-14.157 Y-0.573 I-0.333 J1.972

G1 X-14.942  
ok  
ok  
X-15.115 Y-0.566  
ok  
X-15.668 Y-0.518  
ok  
X-15.781 Y-0.505  
ok  
X-18.358 Y-0.134  
ok  
G2 X-18.664 Y-0.066 I0.285 J1.98  
ok  
G1 X-21.027 Y0.664  
ok  
ok  
ok  
G2 X-21.342 Y0.792 I0.59 J1.911  
ok  
G1 X-21.792 Y1.02  
ok  
X-21.852 Y1.052  
X-22.334 Y1.318  
ok  
X-22.422 Y1.369  
ok  
ok  
X-22.508 Y1.425  
ok  
X-24.604 Y2.877  
ok  
ok  
G2 X-24.865 Y3.093 I1.139 J1.644  
ok  
G1 X-26.671 Y4.864  
ok  
ok  
X-26.757 Y4.953  
ok  
X-26.836 Y5.047  
ok  
X-27.115 Y5.397  
X-27.231 Y5.517  
ok  
ok  
G2 X-27.399 Y5.716 I1.441 J1.387  
ok  
G1 X-28.03 Y6.571  
ok  
ok  
G2 X-28.165 Y6.782 I1.609 J1.187  
ok  
G1 X-28.621 Y7.595  
ok  
X-28.643 Y7.634  
X-28.691 Y7.695  
ok  
ok  
G2 X-28.889 Y8.006 I1.579 J1.227  
G1 X-29.345 Y8.89  
ok  
ok  
G2 X-29.461 Y9.162 I1.778 J0.916





```
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
ok
[MSG:Pgm End]
ok
ok
```

## G-Code File Status

---

### File Information

Name: br.nc

Total Lines: 620

Lines Sent: 620

Remaining: 22.5999

Progress: **100% Complete**

### Full G-Code Content

```
(br)
(T4 D=4 CR=0 - ZMIN=-5.5 - flat end mill)
G90 G94
G17
G21
(-Attention- Property Safe Retracts is set to Clearance Height.)
(Ensure the clearance height will clear the part and or fixtures.)
(Raise the Z-axis to a safe height before starting the program.)

(2D Contour1)
T4
S12000 M3
G17 G90 G94
G54
G0 X-21.855 Y34.671
Z15
G0 Z5
G1 Z2.5 F333.3
Y32.848 Z1.836 F666
X-21.861 Y32.686 Z1.777
X-21.881 Y32.526 Z1.719
X-21.893 Y32.452 Z1.691
X-21.874 Y31.487 Z1.34
X-21.729 Y30.557 Z0.998
```

X-21.713 Y30.467 Z0.964  
X-21.26 Y29.271 Z0.499  
X-20.256 Y28.469 Z0.031  
X-18.856 Y28.073 Z-0.498  
X-18.582 Z-0.598  
X-18.396 Y28.098 Z-0.666  
X-17.042 Y28.363 Z-1.169  
X-16.469 Y28.646 Z-1.401  
X-16.125 Y29.463 Z-1.724  
X-15.901 Y30.96 Z-2.275  
Y32.266 Z-2.75  
Y38.257 F2000  
X-21.855  
Y32.848  
G2 X-21.881 Y32.526 I-2 J0  
G1 X-21.893 Y32.452  
X-21.874 Y31.487  
X-21.729 Y30.557  
X-21.713 Y30.467  
X-21.26 Y29.271  
X-20.256 Y28.469  
X-18.856 Y28.073  
X-18.582  
X-18.396 Y28.098  
X-17.042 Y28.363  
X-16.469 Y28.646  
X-16.125 Y29.463  
X-15.901 Y30.96  
Y32.266  
Y38.257 Z-4.93 F666  
X-17.466 Z-5.5  
X-21.855 F2000  
Y32.848  
G2 X-21.881 Y32.526 I-2 J0  
G1 X-21.893 Y32.452  
X-21.874 Y31.487  
X-21.729 Y30.557  
X-21.713 Y30.467  
X-21.26 Y29.271  
X-20.256 Y28.469  
X-18.856 Y28.073  
X-18.582  
X-18.396 Y28.098  
X-17.042 Y28.363  
X-16.469 Y28.646  
X-16.125 Y29.463  
X-15.901 Y30.96  
Y38.257  
X-17.466  
G0 Z5  
X-17.514 Y109.264  
G1 Z2.5 F333.3  
X-17.715 Z2.427 F666  
Y101.815 Z-0.284  
X-17.718 Y101.695 Z-0.328  
X-17.729 Y101.576 Z-0.371  
X-17.754 Y101.365 Z-0.449  
X-17.638 Y100.092 Z-0.914  
X-17.363 Y99.39 Z-1.188  
X-17.129 Y99.234 Z-1.291  
X-16.483 Y99.081 Z-1.532  
X-16.437 Y99.09 Z-1.549  
X-15.505 Y99.305 Z-1.897

```
X-15.368 Y99.385 Z-1.955
X-15.139 Y100.081 Z-2.222
X-14.94 Y101.414 Z-2.712
Y101.517 Z-2.75
Y109.264 F2000
X-17.715
Y101.815
X-17.718 Y101.695
X-17.729 Y101.576
X-17.754 Y101.365
X-17.638 Y100.092
X-17.363 Y99.39
X-17.129 Y99.234
X-16.483 Y99.081
X-16.437 Y99

... (truncated for file size)
```