

Diagnostics

gSender 1.4.12

Environment

OS: Windows NT 10.0; Win64; x64

Homing: Enabled

Soft Limits: Enabled

Home Location: 0 (Back Right)

Report Inches: Disabled

Stepper Motors: Locked

Machine Profile

ID: 30

Company:

Name: Generic CNC

Type:

Version: undefined

Limits:

X Max: 1260

Y Max: 648

Z Max: 170

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: grblHAL

Firmware Version: SuperLongBoard_B5.0.5b

MPos:

a: 0.000

b: 0.000

c: 0.000

x: 0.000

y: 0.000

z: 255.000

WPos:

a: 0.000

b: 0.000

c: 0.000

x: 0.000

y: 0.000

z: 0.000

Sender Status:

Modal:

NULL

Tool: NULL

Workflow State: idle

Homing Flag: true

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: mm

Laser: Disabled

Rotary: Disabled

EEPROM Values

Setting	Value
\$0	5.0
\$1	255
\$2	0
\$3	6
\$4	0
\$5	15
\$6	1
\$8	0
\$9	1
\$10	511
\$11	0.010
\$12	0.002
\$13	0
\$14	14
\$15	0
\$16	0
\$17	0
\$18	0
\$19	0
\$20	1
\$21	0
\$22	77
\$23	0
\$24	150.0
\$25	4300.0
\$26	25
\$27	1.500
\$28	0.100
\$29	0.0
\$30	24000.000
\$31	7500.000
\$32	0
\$33	1000.0
\$34	0.0
\$35	0.0
\$36	100.0
\$37	0
\$39	1
\$40	1

\$41	0
\$42	2
\$43	1
\$44	4
\$45	3
\$46	0
\$47	0
\$56	5.0
\$57	100.0
\$58	-5.0
\$59	500.0
\$60	1
\$61	3
\$62	0
\$63	3
\$64	0
\$65	0
\$70	11
\$100	320.000
\$101	320.000
\$102	200.000
\$103	79.012
\$110	15000.000
\$111	15000.000
\$112	6000.000
\$113	8000.000
\$120	1500.000
\$121	1500.000
\$122	1500.000
\$123	1000.000
\$130	1260.000
\$131	648.000
\$132	170.000
\$133	0.000
\$140	2800
\$141	2800
\$142	2800
\$143	0
\$150	32
\$151	32
\$152	16
\$153	16
\$170	0.000

\$171	0.000
\$172	0.000
\$173	0.000
\$180	200.0
\$181	200.0
\$182	200.0
\$183	200.0
\$190	3000.0
\$191	3000.0
\$192	3000.0
\$193	3000.0
\$200	22.0
\$201	22.0
\$202	22.0
\$203	22.0
\$210	35
\$211	35
\$212	35
\$213	50
\$220	22.0
\$221	22.0
\$222	22.0
\$223	22.0
\$300	grblHAL
\$301	0
\$302	192.168.5.1
\$303	192.168.5.1
\$304	255.255.255.0
\$305	23
\$307	80
\$308	21
\$338	7
\$339	0
\$340	5.0
\$341	0
\$342	30.0
\$343	25.0
\$344	200.0
\$345	200.0
\$346	1
\$347	5.0
\$348	2.500
\$349	25.000

\$370	0
\$372	0
\$374	3
\$375	50
\$376	1
\$384	0
\$392	11.0
\$393	1.0
\$395	6
\$398	128
\$450	1
\$451	2
\$452	4
\$453	G4P0
\$454	G4P0
\$455	G4P0
\$456	0
\$457	2
\$458	0
\$459	2
\$476	2
\$481	0
\$484	1
\$486	0
\$511	6
\$512	8
\$513	8
\$520	0
\$521	0
\$534	0
\$650	1
\$651	1
\$652	0
\$653	2
\$654	8
\$655	0
\$656	1
\$657	22
\$658	7
\$659	3
\$660	0
\$661	3
\$662	0

\$663	41759
\$664	0
\$665	17
\$666	0
\$668	0
\$730	255.000
\$731	0.000
\$733	1000.0
\$734	0.0
\$735	0.0
\$736	100.0
\$741	0.000
\$742	0.000
\$743	0

Recent Alarms

4/2/2025, 5:33:44 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: grblHAL

4/2/2025, 5:33:29 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: grblHAL

4/2/2025, 5:32:38 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: grblHAL

4/2/2025, 5:31:06 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: grblHAL

4/2/2025, 5:30:18 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: grblHAL

4/2/2025, 5:29:46 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: grblHAL

4/2/2025, 5:28:45 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: grblHAL

4/2/2025, 5:28:45 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: grblHAL

4/2/2025, 5:22:44 PM

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

Input: \$home Controller: grblHAL

4/2/2025, 5:22:09 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: grblHAL

4/2/2025, 5:21:44 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: grblHAL

4/2/2025, 5:21:28 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

4/2/2025, 5:19:24 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: grblHAL

4/2/2025, 5:18:25 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

4/2/2025, 3:50:27 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

4/2/2025, 3:50:25 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:48:03 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:46:27 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:46:14 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

4/2/2025, 3:41:17 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

4/2/2025, 3:40:11 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:36:44 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:36:30 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:36:25 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:36:05 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:35:52 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:32:11 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:32:00 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

4/2/2025, 3:23:19 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:23:03 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 7:59:38 AM

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

Input: N/A Controller: grblHAL

4/1/2025, 8:27:49 PM

EStop asserted. Clear and reset

Input: N/A Controller: grblHAL

4/1/2025, 8:27:49 PM

Homing fail. The active homing cycle was reset.

Input: N/A Controller: grblHAL

3/31/2025, 8:01:25 PM

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

Input: N/A Controller: grblHAL

3/11/2025, 9:01:04 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

3/11/2025, 8:57:50 PM

Homing required. Execute homing command (\$H) to continue.

Input: N/A Controller: grblHAL

Recent Errors

4/2/2025, 5:29:39 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 5:13:31 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 3:23:06 PM

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

Input: N/A Controller: grblHAL

4/2/2025, 7:59:39 AM

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

Input: N/A Controller: grblHAL

4/1/2025, 9:40:23 AM

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

Input: N/A Controller: grblHAL

3/31/2025, 8:06:41 PM

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

Input: N/A Controller: grblHAL

3/31/2025, 1:02:46 PM

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

Input: N/A Controller: grblHAL

3/31/2025, 1:02:03 PM

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

Input: N/A Controller: grblHAL

3/31/2025, 1:02:02 PM

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

Input: N/A Controller: grblHAL

3/11/2025, 9:00:21 PM

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

Input: N/A Controller: grblHAL

3/11/2025, 3:58:05 PM

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

Input: N/A Controller: grblHAL

3/11/2025, 3:58:03 PM

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

Input: N/A Controller: grblHAL

3/11/2025, 3:51:00 PM

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

Input: Hy Controller: grblHAL

Terminal History

1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100, enabled as spindle 1, SDV, current
7 - SLB_LASER
ok
gSender - [grblHAL]
Connected to COM3 with a baud rate of 115200
GrblHAL 1.1f ['\$' or '\$HELP' for help]
\$\$
ALARM:11
[MSG:Homing cycle required]
ok
[VER:1.1f.20230917:]
[OPT:VNMZS+2,128,1024,4,0]
[NEOPT:ENUMS,RT+,HOME,ES,EXPR,SED,ETH,FTP,TMC=7,SD,YM]
[FIRMWARE:grblHAL]
[NVS STORAGE:*EEPROM]
[FREE MEMORY:132K]
[DRIVER:STM32F412]
[DRIVER VERSION:230828]
[BOARD:SuperLongBoard_B5.0.5b]
[AUX IO:3,4,0,0]
[WIZCHIP:W5500]
[IP:192.168.5.1]
[PLUGIN:Trinamic v0.12]
[PLUGIN:MODBUS v0.14]
[PLUGIN:HUANYANG VFD v0.11]
[PLUGIN:HUANYANG P2A VFD v0.10]
[PLUGIN:Durapulse VFD GS20 v0.05]
[PLUGIN:Yalang VFD YL620A v0.02]
[PLUGIN:MODVFD v0.03]
[PLUGIN:H-100 VFD v0.03]
[PLUGIN:SLB Laser PWM switch v0.01]
[SPINDLE:H-100]
[PLUGIN:SIENCI Indicator Lights v1.0]
[PLUGIN:Bootloader Entry v0.01]
[PLUGIN:Macro plugin v0.03]
[PLUGIN:SLB Probing v0.01]
[PLUGIN:SwitchBank plugin v0.02]
[PLUGIN:SDCARD v1.10]
[PLUGIN:FS macro plugin v0.05]
ok
\$0=5.0 (Step pulse time, \$)
\$1=255 (Step idle delay, ms)
\$2=0 (Step pulse invert, mask)

\$3=6 (Step direction invert, mask)
\$4=0 (Invert step enable pin, boolean)
\$5=15 (Invert limit pins, boolean)
\$6=1 (Invert probe pin, boolean)
\$8=0
\$9=1
\$10=511 (Status report options, mask)
\$11=0.010 (Junction deviation, mm)
\$12=0.002 (Arc tolerance, mm)
\$13=0 (Report in inches, boolean)
\$14=14
\$15=0
\$16=0
\$17=0
\$18=0
\$19=0
\$20=1 (Soft limits enable, boolean)
\$21=0 (Hard limits enable, mask)
\$22=77 (Homing cycle enable, mask)
\$23=0 (Homing direction invert, mask)
\$24=150.0 (Homing locate feed rate, mm/min)
\$25=4300.0 (Homing search seek rate, mm/min)
\$26=25 (Homing switch debounce delay, ms)
\$27=1.500 (Homing switch pull-off distance, mm)
\$28=0.100 (G73 pull-off distance, mm)
\$29=0.0 (Step Pulse Delay, ~~\$~~)
\$30=24000.000 (Maximum spindle speed, rpm)
\$31=7500.000 (Spindle Mode,)
\$32=0 (Laser-mode enabled as spindle, boolean)
\$33=1000.0 (Spindle Frequency, Hz)
\$34=0.0 (Spindle Duty Cycle, %)
\$35=0.0 (Minimum spindle speed, %)
\$36=100.0 (Maximum spindle speed, %)
\$37=0 (Deenergized Steppers, %)
\$39=1 (Printable Command Characters, boolean)
\$40=1 (Soft Limits Jogging, boolean)
\$41=0
\$42=2
\$43=1 (Homing Locate Cycle,)
\$44=4 (Axis Mask,)
\$45=3 (Axis Mask,)
\$46=0 (Axis Mask,)
\$47=0 (Axis Mask,)
\$56=5.0
\$57=100.0
\$58=-5.0
\$59=500.0
\$60=1 (Restore Default Overrides, boolean)
\$61=3 (Ignore Safety Door Signal, boolean)
\$62=0 (Sleep Function, boolean)
\$63=3 (Disable Laser on Hold, boolean)
\$64=0 (Alarm on Startup, boolean)
\$65=0 (Allow Feedrate Override, boolean)
\$70=11 (Network Service,)
\$100=320.000 (X-axis travel resolution, step/mm)
\$101=320.000 (Y-axis travel resolution, step/mm)

\$102=200.000 (Z-axis travel resolution, step/mm)
\$103=79.012
\$110=15000.000 (X-axis maximum rate, mm/min)
\$111=15000.000 (Y-axis maximum rate, mm/min)
\$112=6000.000 (Z-axis maximum rate, mm/min)
\$113=8000.000
\$120=1500.000 (X-axis acceleration, mm/sec^2)
\$121=1500.000 (Y-axis acceleration, mm/sec^2)
\$122=1500.000 (Z-axis acceleration, mm/sec^2)
\$123=1000.000
\$130=1260.000 (X-axis maximum travel, mm)
\$131=648.000 (Y-axis maximum travel, mm)
\$132=170.000 (Z-axis maximum travel, mm)
\$133=0.000
\$140=2800
\$141=2800
\$142=2800
\$143=0
\$150=32
\$151=32
\$152=16
\$153=16
\$170=0.000
\$171=0.000
\$172=0.000
\$173=0.000
\$180=200.0
\$181=200.0
\$182=200.0
\$183=200.0
\$190=3000.0
\$191=3000.0
\$192=3000.0
\$193=3000.0
\$200=22.0
\$201=22.0
\$202=22.0
\$203=22.0
\$210=35
\$211=35
\$212=35
\$213=50
\$220=22.0
\$221=22.0
\$222=22.0
\$223=22.0
\$300=grblHAL
\$301=0
\$302=192.168.5.1
\$303=192.168.5.1
\$304=255.255.255.0
\$305=23
\$307=80
\$308=21
\$338=7
\$339=0

\$340=5.0 (Spindle at speed tolerance, %)
\$341=0 (Manual tool change mode,)
\$342=30.0 (Probing distance, mm)
\$343=25.0 (Probing slow feed rate, mm/min)
\$344=200.0 (Probing seek feed rate, mm/min)
\$345=200.0
\$346=1
\$347=5.0
\$348=2.500
\$349=25.000
\$370=0
\$372=0
\$374=3
\$375=50
\$376=1
\$384=0
\$392=11.0
\$393=1.0
\$395=6
\$398=128
\$450=1
\$451=2
\$452=4
\$453=G4P0
\$454=G4P0
\$455=G4P0
\$456=0
\$457=2
\$458=0
\$459=2
\$476=2
\$481=0
\$484=1
\$486=0
\$511=6
\$512=8
\$513=8
\$520=0
\$521=0
\$534=0
\$650=1
\$651=1
\$652=0
\$653=2
\$654=8
\$655=0
\$656=1
\$657=22
\$658=7
\$659=3
\$660=0
\$661=3
\$662=0
\$663=41759
\$664=0
\$665=17

\$666=0
\$668=0
\$730=255.000
\$731=0.000
\$733=1000.0
\$734=0.0
\$735=0.0
\$736=100.0
\$741=0.000
\$742=0.000
\$743=0
ok
ok
ok
ok
ok
0 - SLB_SPINDLE
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100, enabled as spindle 1, SDV, current
7 - SLB_LASER
ok
ok
0
ok
ok
ok
0 - SLB_SPINDLE
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100, enabled as spindle 1, SDV, current
7 - SLB_LASER
ok
\$H
ALARM:9 (Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.)
GribHAL 1.1f ['\$' or '\$HELP' for help]
[MSG:'\$H'|'\$X' to unlock]
ok
ok
ok
ok
0 - SLB_SPINDLE
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100, enabled as spindle 1, SDV, current
7 - SLB_LASER

ok
\$H
ALARM:9 (Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.)
GrbIHAL 1.1f ['\$' or '\$HELP' for help]
[MSG:'\$H'|'\$X' to unlock]
ok
ok
ok
ok
0 - SLB_SPINDLE
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100, enabled as spindle 1, SDV, current
7 - SLB_LASER
ok
\$X
[MSG:Caution: Unlocked]
ok
G10 L20 P1 X0
ok
G10 L20 P1 Z0
ok
\$H
ALARM:9 (Homing fail. Could not find limit switch within search distances. Try increasing max travel, decreasing pull-off distance, or check wiring.)
GrbIHAL 1.1f ['\$' or '\$HELP' for help]
[MSG:'\$H'|'\$X' to unlock]
ok
ok
ok
ok
0 - SLB_SPINDLE
1 - Huanyang v1
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100, enabled as spindle 1, SDV, current
7 - SLB_LASER
ok

G-Code File

Status	Value
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No File Loaded