

Diagnostics

gSender 1.3.8-EDGE

Environment

OS: Windows NT 10.0; Win64; x64

Machine Profile

ID: 5

Company: Sienci Labs

Name: LongMill MK1

Type: 30x30

Version: MK1

Limits:

X Max: 762

Y Max: 812

Z Max: 105

Spindle/Laser: false

Laser Mode Enabled: false

Connection

Available Ports:

0:

port: COM3

manufacturer: Arduino LLC (www.arduino.cc)

inuse: false

Connected Port: COM3

Baudrate: 38400

Unrecognized Ports:

0:

port: COM1

manufacturer: (Standard port types)

inuse: false

GRBL Information

Type: grblHAL

MPos:

a: 0.000

b: 0.000

c: 0.000

x: 27.995

y: -84.995

z: 0.000

WPos:

a: 0.000

b: 0.000

c: 0.000

x: -50.165

y: -353.925

z: 2.505

Sender Status:

Modal:

NULL

Tool: NULL

Workflow State: idle

Homing Flag: false

EEPROM Values

Setting	Value
\$0	10
\$1	100
\$2	1
\$3	5
\$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	1000
\$31	0
\$32	1
\$100	200.000
\$101	200.000
\$102	200.000
\$110	4000.000
\$111	4000.000
\$112	3000.000
\$120	750.000
\$121	750.000
\$122	500.000
\$130	762.000
\$131	812.000
\$132	105.000

Recent Alarms

2023-03-11 at 16:32:22

Alarm 4 - 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.

2023-02-15 at 11:10:54

Alarm 4 - 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.

2023-02-15 at 11:09:15

Alarm 4 - 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.

Recent Errors

2023-04-30 at 15:29:54

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:54

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:53

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:53

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:48

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:37

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:19

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:18

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:17

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:17

Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:16
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:16
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:16
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:14
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:13
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:05
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:29:01
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:28:47
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:28:43
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:54
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:54
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:51
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:15
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:14
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:10
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:08
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:08
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:07
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:07
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:07
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:07
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:07
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:27:04
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:26:57
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:26:52
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:26:24
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:26:15
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : "N/A"

2023-04-30 at 15:26:13
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line : ""

2023-04-30 at 15:16:33
Error 2 - Missing the expected G-code word value or numeric value format is not valid.
On Line 1: "(VECTRIC POST REVISION)"

2023-04-22 at 16:27:25
Error 3 - Grbl '\$' system command was not recognized or supported.
On Line : ""

2023-04-08 at 14:16:57
Error 3 - Grbl '\$' system command was not recognized or supported.
On Line 1: "T1"

2023-04-08 at 14:07:48
Error 3 - Grbl '\$' system command was not recognized or supported.
On Line 1: "T1"

2023-03-31 at 14:32:52

Error 8 - Grbl '\$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.

On Line 1: "(VECTRIC POST REVISION)"

2023-03-26 at 14:29:20

Error 3 - Grbl '\$' system command was not recognized or supported.

On Line 1: "(VECTRIC POST REVISION)"

2023-03-13 at 14:20:46

Error 3 - Grbl '\$' system command was not recognized or supported.

On Line 1: "(VECTRIC POST REVISION)"

2023-03-13 at 14:20:20

Error 8 - Grbl '\$' command cannot be used unless Grbl is IDLE. Ensures smooth operation during a job.

On Line 1: "(VECTRIC POST REVISION)"

2023-02-12 at 13:13:38

Error 3 - Grbl '\$' system command was not recognized or supported.

On Line : ""

Terminal History

```
$J=G21G91 Y-1250 F3000
ok
\x85
$J=G21G91 X1250 F3000
ok
\x85
~
$J=G21G91 Z1 F1000
ok
$J=G21G91 Z1 F1000
ok
$J=G21G91 X-1250 F1000
ok
\x85
$J=G21G91 X1250 F1000
ok
\x85
$J=G21G91 X1 F1000
ok
$J=G21G91 X1 F1000
ok
$J=G21G91 X1 F1000
ok
G10 L20 P0 X0Y0Z0
ok
G91 G21
ok
G38.2 Z-30 F150
[PRB:75.495,89.995,10.810:1]
ok
G91 G0 Z4
ok
```

G38.2 Z-30 F75
[PRB:75.495,89.995,10.805:1]
ok
G4 P0.3
ok
G10 L20 P0 Z15
ok
G0 Z4
ok
G91 G0 X26.25
ok
G0 Z-15
ok
G38.2 X-50 F150
[PRB:92.495,89.995,-0.260:1]
ok
G91 G0 X4
ok
G38.2 X-50 F75
[PRB:92.365,89.995,-0.260:1]
ok
G4 P0.3
ok
G10 L20 P0 X13.125
ok
G0 X4
ok
G0 X8
ok
G0 Y-26.25
ok
G0 X-26.25
ok
G38.2 Y50 F150
[PRB:78.060,73.105,-0.260:1]
ok
G91 G0 Y-4
ok
G38.2 Y50 F75
[PRB:78.060,73.145,-0.260:1]
ok
G4 P0.3
ok
G10 L20 P0 Y-13.125
ok
G0 Y-4
ok
G0 Z19
ok
G90
ok
G91
G0 Z1
G90
G0 X0 Y0
ok

ok
ok
ok
G90 G0 Z0
ok
\$J=G21G91 Z1250 F800.000
ok
\x85
\$J=G21G91 Y1250 F3000
ok
\x85
\$J=G21G91 Y5 F3000
ok
\$J=G21G91 Y5 F3000
ok
\$J=G21G91 Y5 F3000
ok
\$J=G21G91 Z2 F3000
ok
\$J=G21G91 Z2 F3000
ok
\$J=G21G91 Z2 F3000
ok
G10 L20 P0 X0Y0Z0
ok
G91 G21
ok
G38.2 Z-30 F150
[PRB:79.185,269.325,11.620:1]
ok
G91 G0 Z4
ok
G38.2 Z-30 F75
[PRB:79.185,269.325,11.640:1]
ok
G4 P0.3
ok
G10 L20 P0 Z15
ok
G0 Z4
ok
G91 G0 X26.25
ok
G0 Z-15
ok
G38.2 X-50 F150
[PRB:96.085,269.325,0.575:1]
ok
G91 G0 X4
ok
G38.2 X-50 F75
[PRB:96.075,269.325,0.575:1]
ok
G4 P0.3
ok
G10 L20 P0 X13.125

ok
G0 X4
ok
G0 X8
ok
G0 Y26.25
ok
G0 X-26.25
ok
G38.2 Y-50 F150
[PRB:81.775,278.735,0.575:1]
ok
G91 G0 Y4
ok
G38.2 Y-50 F75
[PRB:81.775,278.700,0.575:1]
ok
G4 P0.3
ok
G10 L20 P0 Y13.125
ok
G0 Y4
ok
G0 Z19
ok
G90
ok
G91
G0 Z1
G90
G0 X0 Y0
ok
ok
ok
ok
G90 G0 Z0
ok
\$J=G21G91 Z1250 F2400.000
ok
\x85
G10 L20 P0 X0Y0Z0
ok
G91 G21
ok
G38.2 Z-30 F150
[PRB:82.900,265.515,12.585:1]
ok
G91 G0 Z4
ok
G38.2 Z-30 F75
[PRB:82.900,265.515,12.560:1]
ok
G4 P0.3
ok
G10 L20 P0 Z15
ok

```
G0 Z4
ok
G91 G0 X-26.25
ok
G0 Z-15
ok
G38.2 X50 F150
[PRB:64.930,265.515,1.495:1]
ok
G91 G0 X-4
ok
G38.2 X50 F75
[PRB:64.980,265.515,1.495:1]
ok
G4 P0.3
ok
G10 L20 P0 X-13.125
ok
G0 X-4
ok
G0 X-8
ok
G0 Y26.25
ok
G0 X26.25
ok
G38.2 Y-50 F150
[PRB:79.285,282.145,1.495:1]
ok
G91 G0 Y4
ok
G38.2 Y-50 F75
[PRB:79.285,282.115,1.495:1]
ok
G4 P0.3
ok
G10 L20 P0 Y13.125
ok
G0 Y4
ok
G0 Z19
ok
G90
ok
gSender - [grblHAL]
Connected to COM3 with a baud rate of 38400
Grbl 1.1h ['$' for help] LongMill build Sept 8, 2021
[VER:1.1h.20190830:]
$$
[OPT:VMZ,15,128]
ok
$0=10 (Step pulse time, $)
$1=100 (Step idle delay, ms)
$2=1 (Step pulse invert, mask)
$3=5 (Step direction invert, mask)
$4=1 (Invert step enable pin, boolean)
```

```

$5=0 (Invert limit pins, boolean)
$6=0 (Invert probe pin, boolean)
$10=1 (Status report options, mask)
$11=0.010 (Junction deviation, mm)
$12=0.002 (Arc tolerance, mm)
$13=0 (Report in inches, boolean)
$20=0 (Soft limits enable, boolean)
$21=0 (Hard limits enable, mask)
$22=0 (Homing cycle enable, mask)
$23=3 (Homing direction invert, mask)
$24=25.000 (Homing locate feed rate, mm/min)
$25=1500.000 (Homing search seek rate, mm/min)
$26=250 (Homing switch debounce delay, ms)
$27=1.000 (Homing switch pull-off distance, mm)
$30=1000 (Maximum spindle speed, rpm)
$31=0 (Spindle Mode, )
$32=1 (Laser-mode enabled as spindle, boolean)
$100=200.000 (X-axis travel resolution, step/mm)
$101=200.000 (Y-axis travel resolution, step/mm)
$102=200.000 (Z-axis travel resolution, step/mm)
$110=4000.000 (X-axis maximum rate, mm/min)
$111=4000.000 (Y-axis maximum rate, mm/min)
$112=3000.000 (Z-axis maximum rate, mm/min)
$120=750.000 (X-axis acceleration, mm/sec^2)
$121=750.000 (Y-axis acceleration, mm/sec^2)
$122=500.000 (Z-axis acceleration, mm/sec^2)
$130=762.000 (X-axis maximum travel, mm)
$131=812.000 (Y-axis maximum travel, mm)
$132=105.000 (Z-axis maximum travel, mm)
ok
!
error:2 (Bad number format)
!
error:2 (Bad number format)
!
error:2 (Bad number format)
!
error:2 (Bad number format)
~
$J=G21G91 X1250 F3000
ok
\x85
$J=G21G91 Y-1250 F3000
ok
\x85

```

G-Code File

Status	Value
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No File Loaded