Diagnostics

gSender 1.4.7

Environment

OS: Windows NT 10.0; Win64; x64
Homing: Disabled
Soft Limits: Disabled
Home Location: 3 (Front Left)
Report Inches: Enabled
Stepper Motors: Unlocked

Machine Profile

ID: 53
Company: Sienci Labs
Name: SLB
Type:
Version:
Limits:
- X Max: 1273
- Y Max: 1252
- Z Max: 150

Spindle/Laser: true
Laser Mode Enabled: false

Connection

Available Ports:
- NULL

Connected Port: 192.168.5.1
Baudrate: 115200
Unrecognized Ports:
- 0:
  - port: COM4
  - manufacturer: Intel
  - inuse: false

GRBL Information

Type: grblHAL
Firmware Version: SuperLongBoard_B5.0.5
MPos:
- a: 0
- b: 0
- c: 0
- x: 76.19999999999999
- y: 76.19999999999999
- z: 0

WPos:
- a: 0
- b: 0
- c: 0
- x: 76.19999999999999
- y: 76.19999999999999
- z: 88.86698

Sender Status:
- Modal:
  - NULL
- Tool: NULL

Workflow State: idle
Homing Flag: false

Preferences

Jog Presets:

- Rapid:
  - xyStep: 25.4
  - zStep: 12.7
  - 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	5.0
$1	254
$2	0
$3	5
$4	15
$5	15
$6	1
$8	0
$9	0
$10	511
$11	0.010
$12	0.002
$13	1
$14	14
$15	0
$16	3
$17	0
$18	0
$19	0
$20	0
$21	0
$22	77
$23	3
$24	200.0
$25	3000.0
$26	250
$27	5.000
$28	0.100
$29	0.0
$30	24000.000
$31	1000.000
$32	0
$33	1000.0
$34	0.0
$35	0.0
$36	100.0
$37	0
$39	1
$40	0

$41	1
$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	160.000
$101	160.000
$102	400.000
$103	19.753
$110	5000.000
$111	5000.000
$112	3000.000
$113	8000.000
$120	150.000
$121	150.000
$122	75.000
$123	1000.000
$130	1273.000
$131	1252.000
$132	150.000
$133	0.000
$140	1950
$141	1950
$142	1950
$143	0
$150	8
$151	8
$152	8
$153	16
$180	100.0

$181	100.0
$182	100.0
$183	200.0
$190	2000.0
$191	2000.0
$192	250.0
$193	3000.0
$200	16.0
$201	16.0
$202	16.0
$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	0.0
$341	0
$342	30.0
$343	25.0
$344	200.0
$345	200.0
$346	1
$370	0
$372	0
$374	3
$375	50
$376	0
$384	0
$392	5.0

$393	1.0
$395	1
$398	128
$450	0
$451	0
$452	0
$453	G4P0
$454	G4P0
$455	G4P0
$456	3
$457	3
$458	3
$459	3
$476	2
$481	0
$484	1
$486	0
$511	8
$512	8
$513	8
$520	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	1
$666	17
$668	1
$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

7/1/2024, 4:24:03 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

7/1/2024, 1:34:12 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:56:22 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:56:04 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

7/1/2024, 12:49:21 PM
EStop asserted. Clear and reset
Input: N/A Controller: grblHAL

7/1/2024, 12:41:16 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:32:53 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:32:53 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A Controller: grblHAL

7/1/2024, 12:32:53 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:29:33 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:29:17 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:26:15 PM
Spindle at speed timeout. Clear before continuing.
Input: N/A Controller: grblHAL

7/1/2024, 12:15:58 PM
Homing required. Execute homing command ($H) to continue.
Input: N/A Controller: grblHAL

7/1/2024, 12:11:13 PM
Homing required. Execute homing command ($H) to continue.
Input: N/A Controller: grblHAL

7/1/2024, 12:09:45 PM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A Controller: grblHAL

7/1/2024, 12:05:40 PM
Homing required. Execute homing command ($H) to continue.
Input: N/A Controller: grblHAL

7/1/2024, 11:56:46 AM
Homing fail. Pull off travel failed to clear limit switch. Try increasing pull-off setting or check wiring.
Input: N/A Controller: grblHAL

Recent Errors

7/1/2024, 4:35:28 PM
Missing the expected G-code word value or numeric value format is not valid.
Input: m3 Controller: grblHAL

7/1/2024, 4:22:03 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 4:21:27 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 4:07:13 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 4:06:57 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 4:06:32 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 4:01:15 PM
G-code words consist of a letter and a value. Letter was not found.
Input: N/A Controller: grblHAL

7/1/2024, 4:01:09 PM
G-code words consist of a letter and a value. Letter was not found.
Input: N/A Controller: grblHAL

7/1/2024, 12:56:34 PM
G-code words consist of a letter and a value. Letter was not found.
Input: N/A Controller: grblHAL

7/1/2024, 12:56:30 PM
G-code words consist of a letter and a value. Letter was not found.
Input: N/A Controller: grblHAL

7/1/2024, 12:54:47 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 12:43:09 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 12:42:54 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

7/1/2024, 12:41:23 PM
G-code words consist of a letter and a value. Letter was not found.
Input: N/A Controller: grblHAL

7/1/2024, 12:28:30 PM
Grbl $' system command was not recognized or supported.
Input: N/A Controller: grblHAL

Terminal History

$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=0.0 (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
$370=0
$372=0
$374=3
$375=50
$376=0
$384=0
$392=5.0
$393=1.0
$395=1

$398=128
$450=0
$451=0
$452=0
$453=G4P0
$454=G4P0
$455=G4P0
$456=3
$457=3
$458=3
$459=3
$476=2
$481=0
$484=1
$486=0
$511=8
$512=8
$513=8
$520=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=1
$666=17
$668=1
$730=255.000
$731=0.000
$733=1000.0
$734=0.0
$735=0.0
$736=100.0
$741=0.000
$742=0.000
$743=0
ok
GrblHAL 1.1f ['$' or '$HELP' for help]
$$
$0=5.0 (Step pulse time, µs)
$1=254 (Step idle delay, ms)
$2=0 (Step pulse invert, mask)
$3=5 (Step direction invert, mask)
$4=15 (Invert step enable pin, boolean)
$5=15 (Invert limit pins, boolean)
$6=1 (Invert probe pin, boolean)

$8=0
$9=0
$10=511 (Status report options, mask)
$11=0.010 (Junction deviation, mm)
$12=0.002 (Arc tolerance, mm)
$13=1 (Report in inches, boolean)
$14=14
$15=0
$16=3
$17=0
$18=0
$19=0
$20=0 (Soft limits enable, boolean)
$21=0 (Hard limits enable, mask)
$22=77 (Homing cycle enable, mask)
$23=3 (Homing direction invert, mask)
$24=200.0 (Homing locate feed rate, mm/min)
$25=3000.0 (Homing search seek rate, mm/min)
$26=250 (Homing switch debounce delay, ms)
$27=5.000 (Homing switch pull-off distance, mm)
$28=0.100 (G73 pull-off distance, mm)
$29=0.0 (Step Pulse Delay, µs)
$30=24000.000 (Maximum spindle speed, rpm)
$31=1000.000 (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=0 (Soft Limits Jogging, boolean)
$41=1
$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=160.000 (X-axis travel resolution, step/mm)
$101=160.000 (Y-axis travel resolution, step/mm)
gSender - [grblHAL]
Connected to 192.168.5.1 with a baud rate of 115200
$102=400.000 (Z-axis travel resolution, step/mm)
$103=19.753

$110=5000.000 (X-axis maximum rate, mm/min)
$111=5000.000 (Y-axis maximum rate, mm/min)
$112=3000.000 (Z-axis maximum rate, mm/min)
$113=8000.000
$120=150.000 (X-axis acceleration, mm/sec^2)
$121=150.000 (Y-axis acceleration, mm/sec^2)
$122=75.000 (Z-axis acceleration, mm/sec^2)
$123=1000.000
$130=1273.000 (X-axis maximum travel, mm)
$131=1252.000 (Y-axis maximum travel, mm)
$132=150.000 (Z-axis maximum travel, mm)
$133=0.000
$140=1950
$141=1950
$142=1950
$143=0
$150=8
$151=8
$152=8
$153=16
$180=100.0
$181=100.0
$182=100.0
$183=200.0
$190=2000.0
$191=2000.0
$192=250.0
$193=3000.0
$200=16.0
$201=16.0
$202=16.0
$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=0.0 (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
$370=0
$372=0
$374=3
$375=50
$376=0
$384=0
$392=5.0
$393=1.0
$395=1
$398=128
$450=0
$451=0
$452=0
$453=G4P0
$454=G4P0
$455=G4P0
$456=3
$457=3
$458=3
$459=3
$476=2
$481=0
$484=1
$486=0
$511=8
$512=8
$513=8
$520=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=1
$666=17
$668=1
$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
[VER:1.1f.20230917:]
[OPT:VNMPZS+2,128,1024,4,0]
[NEWOPT:ENUMS,RT+,HOME,ES,SED,ETH,FTP,TMC=7,SD,YM]
[FIRMWARE:grblHAL]
[NVS STORAGE:*EEPROM]
[FREE MEMORY:133K]
[DRIVER:STM32F412]
[DRIVER VERSION:230828]
[BOARD:SuperLongBoard_B5.0.5]
[AUX IO:3,4,0,0]
[WIZCHIP:W5500]
[IP:192.168.5.1]
[NETCON:Telnet]
[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:SLB_SPINDLE]
[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
ok
ok
ok
ok
0 - SLB_SPINDLE
1 - Huanyang v1, enabled as spindle 0, SDV
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100
7 - SLB_LASER
ok
?
<Idle|MPos:3.0000,3.0000,0.0000,0.0000|Bf:128,1023|FS:0,0|WCO:0.0000,0.0000,-3.4987,0.0000|H:1>
???
ok
$
[HLP:$$ $# $G $I $N $x=val $Nx=line $J=line $SLP $C $X $H $B ~ ! ? ctrl-x]
ok
M104 Q0
ok
$spindles
0 - SLB_SPINDLE

1 - Huanyang v1, enabled as spindle 0, SDV
2 - Huanyang P2A
3 - Durapulse GS20
4 - Yalang YS620
5 - MODVFD
6 - H-100
7 - SLB_LASER
ok

G-Code File

Status	Value

No File Loaded