

Original Setting CNC 3018 ProVer

Probe Command:

G21G91G38.2Z-45F100; G0Z1; G38.2Z-2F10

G21 Programming in millimeters (mm)

G91: Relative Koordinatenangaben im aktuellen Koordinatensystem

G38.2 tastet auf ein Ziel zu und stoppt bei Kontakt und signalisiert einen Fehler, wenn es die Zielposition erreicht, ohne die Sonde auszulösen.

G00 Rapid positioning für Z1

Safe position commands:

G21G90; G53G0Z0

G21 Programming in millimeters (mm)

G90 Absolute programming

G53 Machine coordinate system

G00 Rapid positioning Z-1.5

[CTRL+X] < Grbl 1.1f ['\$' for help]

[MSG:'\$H' '\$X' to unlock]

\$\$ < \$0=10

\$1=25

\$2=0

\$3=2

\$4=0

\$5=0

\$6=0

\$10=3

\$11=0.010

\$12=0.002

\$13=0

\$20=0

\$21=1

\$22=1

\$23=3

\$24=25.000

\$25=500.000

\$26=250

\$27=1.000

\$30=10000

\$31=0

\$32=0

\$100=800.000---> X kalibriert auf 792.079 <-----X----->
\$101=800.000---> Y kalibriert auf 793.079 V - \wedge = Y
\$102=800.000---> Z kalibriert auf 792.079 Z = Spindel

\$110=2000.000
\$111=2000.000
\$112=600.000

\$120=10.000
\$121=10.000
\$122=10.000

\$130=260.000
\$131=158.000
\$132=34.000
ok

Erklärung der \$Code (nicht direkt für 3018)

Grbl 1.1f ['\$' for help]

>>> \$\$

\$0 = 10 (Step pulse time, microseconds)
\$1 = 25 (Step idle delay, milliseconds)
\$2 = 0 (Step pulse invert, mask)
\$3 = 5 (Step direction invert, mask)
\$4 = 0 (Invert step enable pin, boolean)
\$5 = 0 (Invert limit pins, boolean)
\$6 = 0 (Invert probe pin, boolean)
\$10 = 3 (Status report options, mask)
\$11 = 0.010 (Junction deviation, millimeters)
\$12 = 0.002 (Arc tolerance, millimeters)
\$13 = 0 (Report in inches, boolean)
\$20 = 0 (Soft limits enable, boolean)
\$21 = 0 (Hard limits enable, boolean)
\$22 = 0 (Homing cycle enable, boolean)
\$23 = 0 (Homing direction invert, mask)
\$24 = 25.000 (Homing locate feed rate, mm/min)
\$25 = 500.000 (Homing search seek rate, mm/min)
\$26 = 250 (Homing switch debounce delay, milliseconds)
\$27 = 1.000 (Homing switch pull-off distance, millimeters)
\$30 = 1000 (Maximum spindle speed, RPM)
\$31 = 5 (Minimum spindle speed, RPM)
\$32 = 0 (Laser-mode enable, boolean)
\$100 = 800.000 (X-axis travel resolution, step/mm)
\$101 = 800.000 (Y-axis travel resolution, step/mm)
\$102 = 800.000 (Z-axis travel resolution, step/mm)

\$110 = 2500.000 (X-axis maximum rate, mm/min)
\$111 = 2000.000 (Y-axis maximum rate, mm/min)
\$112 = 1500.000 (Z-axis maximum rate, mm/min)

\$120 = 45.000 (X-axis acceleration, mm/sec²)
\$121 = 45.000 (Y-axis acceleration, mm/sec²)
\$122 = 48.000 (Z-axis acceleration, mm/sec²)

\$130 = 300.000 (X-axis maximum travel, millimeters)
\$131 = 180.000 (Y-axis maximum travel, millimeters)
\$132 = 44.000 (Z-axis maximum travel, millimeters)

Grbl 1.1f ['\$' for help]

>>> \$\$

\$0 = 10 (Step pulse time, microseconds)
\$1 = 25 (Step idle delay, milliseconds)
\$2 = 0 (Step pulse invert, mask)
\$3 = 6 (Step direction invert, mask)
\$4 = 0 (Invert step enable pin, boolean)
\$5 = 0 (Invert limit pins, boolean)
\$6 = 0 (Invert probe pin, boolean)
\$10 = 3 (Status report options, mask)
\$11 = 0.010 (Junction deviation, millimeters)
\$12 = 0.002 (Arc tolerance, millimeters)
\$13 = 0 (Report in inches, boolean)
\$20 = 0 (Soft limits enable, boolean)
\$21 = 0 (Hard limits enable, boolean)
\$22 = 0 (Homing cycle enable, boolean)
\$23 = 0 (Homing direction invert, mask)
\$24 = 25.000 (Homing locate feed rate, mm/min)
\$25 = 500.000 (Homing search seek rate, mm/min)
\$26 = 250 (Homing switch debounce delay, milliseconds)
\$27 = 1.000 (Homing switch pull-off distance, millimeters)
\$30 = 5000 (Maximum spindle speed, RPM)
\$31 = 0 (Minimum spindle speed, RPM)
\$32 = 0 (Laser-mode enable, boolean)
\$100 = 800.000 (X-axis travel resolution, step/mm)
\$101 = 800.000 (Y-axis travel resolution, step/mm)
\$102 = 800.000 (Z-axis travel resolution, step/mm)
\$110 = 800.000 (X-axis maximum rate, mm/min)
\$111 = 800.000 (Y-axis maximum rate, mm/min)
\$112 = 800.000 (Z-axis maximum rate, mm/min)
\$120 = 10.000 (X-axis acceleration, mm/sec²)
\$121 = 10.000 (Y-axis acceleration, mm/sec²)
\$122 = 10.000 (Z-axis acceleration, mm/sec²)
\$130 = 200.000 (X-axis maximum travel, millimeters)
\$131 = 200.000 (Y-axis maximum travel, millimeters)
\$132 = 200.000 (Z-axis maximum travel, millimeters)

ok

>>> \$G

[GC:G0 G54 G17 G21 G90 G94 M5 M9 T0 F0 S0]

ok

