Laser	CNC	Default	Description
$0 = 4	4	10	Step pulse width microseconds
$1 = 25	25	25	Stepper disable delay msec 255 = keep power on
$2 = 0	0	0	Step pulse invert
$3 = 5	5	5	Axis directions invert **DO NOT CHANGE IF DIR ARE CORRECT**
$4 = 0	0	0	Step enable input pin invert 0 = pin low steppers enabled
$5 = 0	0	0	Limit switch invert 0 = switches N.O. 1 = N.C.
$6 = 0	0	0	Probe trigger invert
$10 = 1	1	1	Status report 1 = machine position 0 = work position
$11 = .500	.010	.010	Junction deviation mm
$12 = .002	.002	.002	Arc tolerance mm
$13 = 1	1	0	Report in inches 0 = mm 1 = inches
$20 = 0	0	0	Enable soft limits
$21 = 1	1	0	Enable limit switches
$22 = 1	1	0	Enable homing capability
$23 = 3	3	0	Homing direction invert for each axis
$24 = 25	25	25.000	Homing limit switch final search speed mm/min
$25 = 1000	1000	500.000	Homing limit switch first search speed mm/min
$26 = 100	100	250	Home switch electrical debounce msec
$27 = 1.000	1	1.000	Home pull off mm
$30 = 255	1000	255	Max spindle RPM or max laser power
$31 = 0	0	1	Min spindle RPM
$32 = 1	0	0	1= laser mode 0= spindle CNC
$100 = 1600	1600	800	X steps per mm
$101 = 1600	1600	800	Y steps per mm
$102 = 1600	1600	800	Z steps per mm
$110 = 1300	1300	800	X max stepper speed mm/sec
$111 = 1300	1300	800	Y max stepper speed mm/sec
$112 = 800	800	800	Z max stepper speed mm/sec
$120 = 60	60	10	X stepper acceleration mm/sec
$121 = 60	60	10	Y stepper acceleration mm/sec
$122 = 10	10	10	Z stepper acceleration mm/sec
$130 = 280	280	200	X max travel distance mm
$131 = 165	165	200	Y max travel distance mm
$132 = 30	30	200	Z max travel distance mm

Device	Material	Speed	Power
GRBL	MDF	30in/min	46%
GRBL-M3	MDF	100in/min	46%
UGS	Pine	10in/min	500RPM Step down .020 Over 30% Spiral end mill
GRBL-M3	Felt	15in/min	100%

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