GRBL configuration parameter settings
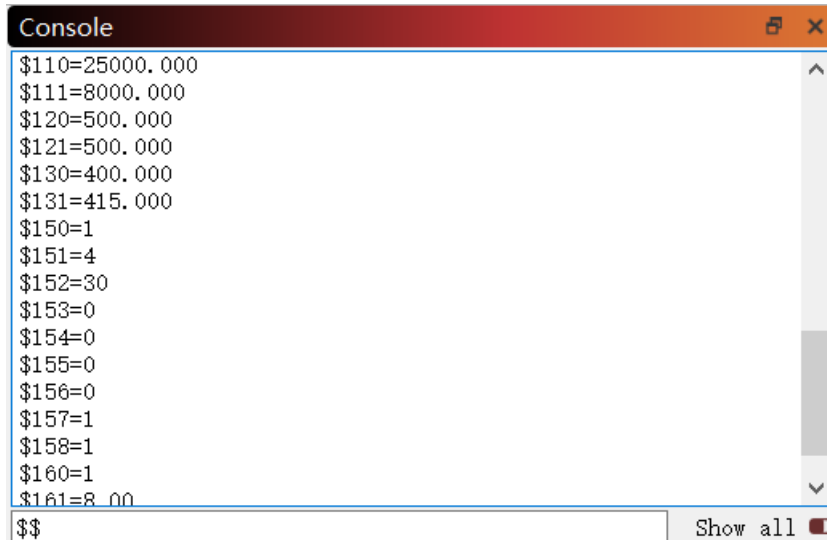
After connecting the machine and software successfully, you can enter $$ in "Console" and press Enter to check or modify some GRBL configuration parameters. Please refer to "User Manual for Air-Assist.pdf" for $150 and $151, and "Laser Module Alarm Function.pdf" for $153, $154, $155.

$152: The time waiting to enter standby mode after finishing working. You can set it from 0 to 100, and it is 30 by default (Waiting for 30 seconds and enter standby mode automatically after finishing working); if you set $152 to 100, the air pump and the laser module will not be powered off.

Notes: In standby mode, the air pump and laser module will be powered off after finishing working.

$156: To control whether the working mode of the 40W laser module is associated with "Air" in LightBurn. It can be set to 0 or 1, and it is 0 by default (the working mode of the laser module is not associated with AIR). If you set $156 to 1, the laser module is in "Normal" mode when the Air is enabled and you should refer to "40W Recommended Parameters". When the Air is disabled, the laser module is in "Precise" mode and you should refer to "22W Recommended Parameters ".
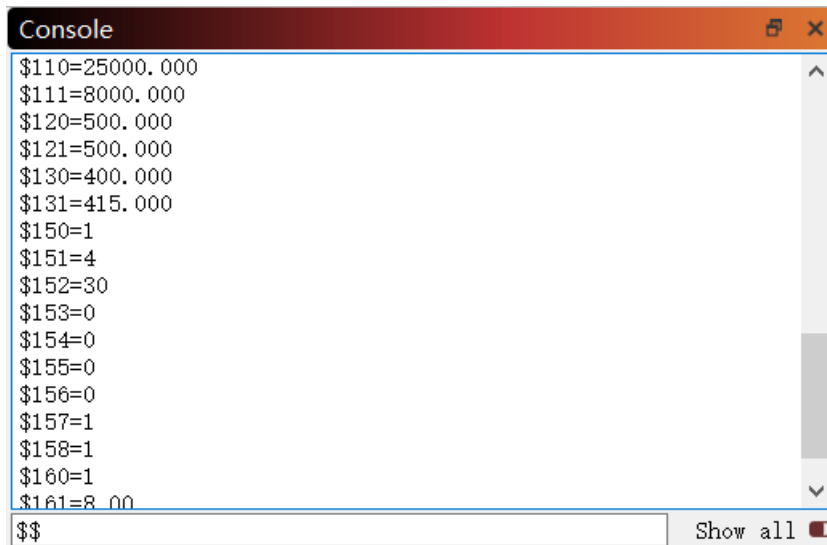
$157: The laser power when frame-previewing during working with TF card. You can set it to 1, 2 or 3, and it is 1 by default (The laser power is 1%).

Notes: The power can be set as needed when frame-previewing during working with TF card because the absorption and reflection of different colors of materials for laser are different.

Do not modify other configuration parameters except $150, $151, $152, $153, $154, $155, $156, $157 because it may cause the machine to work abnormally.

GRBL 配置参数设置

成功连接机器和软件后，在控制台输入$$并回车，可查看或修改部分 GRBL 配置参数。其中，$150、$151 相关说明请参考"气流调节用户手册.pdf"，$153、$154、$155 相关说明请参考"激光模组报警功能.pdf"。

```
Console                                              ⊡  ✕
$110=25000.000                                        ∧
$111=8000.000
$120=500.000
$121=500.000
$130=400.000
$131=415.000
$150=1
$151=4
$152=30
$153=0
$154=0
$155=0
$156=0
$157=1
$158=1
$160=1
$161=8.00                                             ∨
$$                                          Show all ▣
```

$152：工作结束后，进入待机状态的等待时间，可设置为 0~100，默认为 30（即工作结束后，等待 30 秒自动进入待机状态）；如果设置为 100，则不会关闭气泵与激光模组电源。

备注：待机状态时，气泵与激光模组电源会被关闭。

$156：控制 40W 激光模组的工作模式是否与 LightBurn 中的 Air 相关联，可设置为 0，1，默认为 0（此时激光模组的工作模式与 AIR 不关联）。如果设置为 1，则当启用 Air 选项时，激光模组处于 Normal 模式，此时请参考"40W 推荐参数"；当禁用 Air 选项时，激光模组处于 Precise 模式，此时请参考"22W 推荐参数"。

$157：离线工作时边框预览的激光功率大小，可设置为 1，2，3；默认为 1（即激光功率大小为 1%）

备注：由于不同颜色的材料对激光的吸收和反射不一样，在进行离线工作边框预览时可根据实际需要设置激光功率大小；

除了$150、$151、$152、$153、$154、$155、$156、$157 以外，其它配置参数切勿随意更改，否则可能导致机器工作异常。