

```
{
  "macros_list": [],
  "gcode_list": [],
  "settings": {
    "max-deviation": 0.05,
    "junction-accel": 200000,
    "units": "IMPERIAL",
    "probing-prompts": true
  },
  "probe": {
    "probe-ydim": 54.05,
    "probe-zdim": 15.52,
    "probe-diameter": 6.35,
    "probe-slow-seek": 25,
    "probe-fast-seek": 75,
    "probe-xdim": 54.05
  },
  "wifiName": "US-FL-CLW-DRACON",
  "selected-tool-settings": {
    "laser": {
      "tool": {
        "tool-enable-mode": "lo-hi",
        "min-spin": 0,
        "selected-tool": "laser",
        "tool-direction-mode": "disabled",
        "tool-reversed": false,
        "max-spin": 1000
      },
      "pwm-spindle": {
        "dynamic-power": true,
        "pwm-inverted": false,
        "pwm-min-duty": 1,
        "pwm-freq": 1000,
        "rapid-auto-off": true,
        "pwm-max-duty": 99.99
      }
    },
    "pwm": {
      "tool": {
        "tool-enable-mode": "disabled",
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    "min-spin": 6000,
    "selected-tool": "pwm",
    "tool-direction-mode": "disabled",
    "tool-reversed": false,
    "max-spin": 24000
  },
  "pwm-spindle": {
    "dynamic-power": true,
    "pwm-inverted": false,
    "pwm-min-duty": 1,
    "pwm-freq": 1000,
    "rapid-auto-off": true,
    "pwm-max-duty": 99.99
  }
},
"router": {
  "tool": {
    "tool-enable-mode": "lo-hi",
    "min-spin": 0,
    "selected-tool": "router",
    "tool-direction-mode": "disabled",
    "tool-reversed": false,
    "max-spin": 255
  },
  "pwm-spindle": {
    "dynamic-power": false,
    "pwm-inverted": false,
    "pwm-min-duty": 1,
    "pwm-freq": 1000,
    "rapid-auto-off": false,
    "pwm-max-duty": 99.99
  }
},
"custom-modbus-vfd": {
  "modbus-spindle": {
    "parity": "None",
    "bus-id": "1",
    "multi-write": false,
    "regs": [
      {
```

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    "reg-type": "max-freq-read",
    "reg-value": 0,
    "reg-addr": 7
  },
  {
    "reg-type": "freq-scaled-set",
    "reg-value": 10000,
    "reg-addr": 40961
  },
  {
    "reg-type": "freq-read",
    "reg-value": 0,
    "reg-addr": 36864
  },
  {
    "reg-type": "forward-write",
    "reg-value": 1,
    "reg-addr": 40960
  },
  {
    "reg-type": "reverse-write",
    "reg-value": 2,
    "reg-addr": 40960
  },
  {
    "reg-type": "stop-write",
    "reg-value": 6,
    "reg-addr": 40960
  },
  {
    "reg-type": "disconnect-write",
    "reg-value": 5,
    "reg-addr": 40960
  },
  {
    "reg-type": "status-read",
    "reg-value": 0,
    "reg-addr": 45056
  },
  {
```



```
    "baud": "9600"
  },
  "tool": {
    "tool-enable-mode": "lo-hi",
    "min-spin": 0,
    "selected-tool": "custom-modbus-vfd",
    "tool-direction-mode": "lo-hi",
    "tool-reversed": false,
    "max-spin": 24000
  },
  "pwm-spindle": {
    "dynamic-power": true,
    "pwm-inverted": false,
    "pwm-min-duty": 1,
    "pwm-freq": 1000,
    "rapid-auto-off": true,
    "pwm-max-duty": 99.99
  }
},
"pwn-cnc-vfd": {
  "modbus-spindle": {
    "parity": "None",
    "bus-id": "1",
    "multi-write": false,
    "regs": [
      {
        "reg-type": "freq-read",
        "reg-value": 0,
        "reg-addr": 38864
      },
      {
        "reg-type": "max-freq-read",
        "reg-value": 0,
        "reg-addr": 7
      },
      {
        "reg-type": "freq-set",
        "reg-value": 0,
        "reg-addr": 40961
      }
    ]
  }
},
```

```
{
  "reg-type": "forward-write",
  "reg-value": 1,
  "reg-addr": 40960
},
{
  "reg-type": "stop-write",
  "reg-value": 5,
  "reg-addr": 40960
},
{
  "reg-type": "stop-write",
  "reg-value": 6,
  "reg-addr": 40960
},
{
  "reg-type": "reverse-write",
  "reg-value": 2,
  "reg-addr": 40960
},
{
  "reg-type": "disconnect-write",
  "reg-value": 5,
  "reg-addr": 40960
},
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
},
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
},
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
},
},
```



```
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
},
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
},
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
},
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
},
{
  "reg-type": "disabled",
  "reg-value": 0,
  "reg-addr": 0
}
],
"baud": "9600"
},
"tool": {
  "tool-enable-mode": "lo-hi",
  "min-spin": 0,
  "selected-tool": "pwnncnc-vfd",
  "tool-direction-mode": "lo-hi",
  "tool-reversed": false,
  "max-spin": 24000
},
"pwm-spindle": {
  "dynamic-power": true,
  "pwm-inverted": false,
  "pwm-min-duty": 1,
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    "pwm-freq": 1000,  
    "rapid-auto-off": true,  
    "pwm-max-duty": 99.99  
  }  
}  
,  
"modbus-spindle": {  
  "parity": "None",  
  "bus-id": "1",  
  "multi-write": false,  
  "regs": [  
    {  
      "reg-type": "freq-read",  
      "reg-value": 0,  
      "reg-addr": 38864  
    },  
    {  
      "reg-type": "max-freq-read",  
      "reg-value": 0,  
      "reg-addr": 7  
    },  
    {  
      "reg-type": "freq-set",  
      "reg-value": 0,  
      "reg-addr": 40961  
    },  
    {  
      "reg-type": "forward-write",  
      "reg-value": 1,  
      "reg-addr": 40960  
    },  
    {  
      "reg-type": "stop-write",  
      "reg-value": 5,  
      "reg-addr": 40960  
    },  
    {  
      "reg-type": "stop-write",  
      "reg-value": 6,  
      "reg-addr": 40960  
    }  
  ]  
}
```



```
    },
    {
      "reg-type": "disabled",
      "reg-value": 0,
      "reg-addr": 0
    },
    {
      "reg-type": "disabled",
      "reg-value": 0,
      "reg-addr": 0
    }
  ],
  "baud": "9600"
},
"full_version": "1.4.0",
"motors": [
  {
    "reverse": false,
    "search-velocity": 1.688,
    "homing-mode": "stall-min",
    "drive-current": 2.8,
    "max-switch": "disabled",
    "max-accel": 750.002,
    "step-angle": 1.8,
    "latch-backoff": 5,
    "idle-current": 1,
    "axis": "X",
    "microsteps": 16,
    "latch-velocity": 0.1,
    "enabled": true,
    "stall-sample-time": 200,
    "stall-microstep": 8,
    "travel-per-rev": 15.999,
    "max-jerk": 1000,
    "max-soft-limit": 816,
    "min-switch": "disabled",
    "zero-backoff": 1.501,
    "stall-volts": 2,
    "stall-current": 1,
    "min-soft-limit": 0,
```

```
    "max-velocity": 10
  },
  {
    "reverse": false,
    "search-velocity": 1.688,
    "homing-mode": "stall-min",
    "drive-current": 2.8,
    "max-switch": "disabled",
    "max-accel": 750,
    "step-angle": 1.8,
    "latch-backoff": 5,
    "idle-current": 1,
    "axis": "Y",
    "microsteps": 16,
    "latch-velocity": 0.1,
    "enabled": true,
    "stall-sample-time": 200,
    "stall-microstep": 8,
    "travel-per-rev": 10,
    "max-jerk": 1000,
    "max-soft-limit": 816,
    "min-switch": "disabled",
    "zero-backoff": 1.5,
    "stall-volts": 2,
    "stall-current": 1,
    "min-soft-limit": 0,
    "max-velocity": 10
  },
  {
    "reverse": false,
    "search-velocity": 1.688,
    "homing-mode": "stall-min",
    "drive-current": 2.8,
    "max-switch": "disabled",
    "max-accel": 750,
    "step-angle": 1.8,
    "latch-backoff": 5,
    "idle-current": 1,
    "axis": "Y",
    "microsteps": 16,
```

```
"latch-velocity": 0.1,  
"enabled": true,  
"stall-sample-time": 200,  
"stall-microstep": 8,  
"travel-per-rev": 10,  
"max-jerk": 1000,  
"max-soft-limit": 816,  
"min-switch": "disabled",  
"zero-backoff": 1.5,  
"stall-volts": 2,  
"stall-current": 1,  
"min-soft-limit": 0,  
"max-velocity": 10  
},  
{  
"reverse": true,  
"search-velocity": 0.67499992,  
"homing-mode": "stall-max",  
"drive-current": 2.8,  
"max-switch": "disabled",  
"max-accel": 750.0017064,  
"step-angle": 1.8,  
"latch-backoff": 5,  
"idle-current": 1,  
"axis": "Z",  
"microsteps": 16,  
"latch-velocity": 0.1,  
"enabled": true,  
"stall-sample-time": 200,  
"stall-microstep": 8,  
"travel-per-rev": 4.0005,  
"max-jerk": 999.9999216,  
"max-soft-limit": 0,  
"min-switch": "disabled",  
"zero-backoff": 1.0007599999999999,  
"stall-volts": 2,  
"stall-current": 1,  
"min-soft-limit": -132.99948,  
"max-velocity": 2.99999908  
}
```

```

],
"gcode": {
  "tool-change": "(Runs on M6, tool change)\nM70\nG21\nS0\n\n(M9
Turn off switched outlet)\nM0 M6 (MSG, Change tool and attach
probe)\n\nF100\n(probe to minimum z soft limit, which is
-10)\nG38.2 Z-10\nG92 Z15.4\nG0 Z30\nM0 (MSG, Remove probe, start
spindle)\nM72\n\n\n",
  "program-start": "(Runs at program start)\nG90 (Absolute
distance mode)\nG17 (Select XY plane)\nM7 (Turn on switched
outlet)",
  "program-end": "(Runs on M2, program end)\nM9 (Turn off
switched outlet)\nM2"
},
"non_macros_list": [],
"macros": [
  {
    "name": "Spin 20k",
    "file_name": "Spin 20k.ngc",
    "color": "#de4d4d",
    "alert": true
  },
  {
    "name": "Go Home",
    "file_name": "GoHomeXYZ.ngc",
    "color": "#0000ff",
    "alert": true
  },
  {
    "name": "Park Rgt Rear",
    "file_name": "ParkRearRightWoodworker.ngc",
    "color": "#008000",
    "alert": true
  },
  {
    "name": "Park Frt Center",
    "file_name": "ParkRearCenterWoodworker.ngc",
    "color": "#808040",
    "alert": true
  },
  {

```

```
    "name": "Laser ON 10%",
    "file_name": "FireLaser10Percent.ngc",
    "color": "#808040",
    "alert": true
  },
  {
    "name": "Park Ctr Table",
    "file_name": "Park Ctr Table.ngc",
    "color": "#408080",
    "alert": true
  }
],
"macrosList": [
  {
    "file_name": "Spin 20k.ngc"
  },
  {
    "file_name": "GoHomeXYZ.ngc"
  },
  {
    "file_name": "ParkRearRightWoodworker.ngc"
  },
  {
    "file_name": "ParkRearCenterWoodworker.ngc"
  },
  {
    "file_name": "TurnOnSpindle.ngc"
  },
  {
    "file_name": "FireLaser10Percent.ngc"
  },
  {
    "file_name": "Park Center WS.ngc"
  },
  {
    "file_name": "Park Ctr Table.ngc"
  }
],
"ip": "192.168.20.206",
"admin": {
```

```
    "auto-check-upgrade": true
  },
  "version": "1.4.0",
  "switches": {
    "switch-lockout": 250,
    "estop": "disabled",
    "probe": "normally-open",
    "switch-debounce": 5
  },
  "outputs": {
    "load-1": "lo-hi",
    "load-2": "disabled",
    "fault": "disabled"
  },
  "tool": {
    "tool-enable-mode": "lo-hi",
    "min-spin": 0,
    "selected-tool": "pwnCNC-vfd",
    "tool-direction-mode": "lo-hi",
    "tool-reversed": false,
    "max-spin": 24000,
    "tool-type": "PwnCNC VFD"
  },
  "pwm-spindle": {
    "dynamic-power": true,
    "pwm-inverted": false,
    "pwm-min-duty": 1,
    "pwm-freq": 1000,
    "rapid-auto-off": true,
    "pwm-max-duty": 99.99
  },
  "gcodeList": [
    {
      "file_name": "Bottom half_Battery Post.ngc"
    }
  ]
}
```