# How to change configurations

for XE-PRO 8040 extension kit

### I. For LaserGRBL

- 1. Connect the machine to computer.
- 2. Open the LaserGRBL, connect the machine. Click path: Grbl -> Grbl Configuration
- 3. Click "Import", select the XE-PRO 8040 configuration document, it will be imported to laserGrbl. Message will show as picture-3. Changing configurations finished.

0.11		- 1	Grbl	\$\$ CO	nfiguration			
Grbl File	Colors Lang	juage Tools		\$	Parameter	Value	Unit	Description
le 🙀 Disconne	ct	- 💫	•	\$0	Step pulse time	10	microseconds	Sets time length per step. Minimum 3usec.
Recet				\$1	Step idle delay	25	milliseconds	Sets a short hold delay when stopping to
Keset				\$2	Step pulse invert	0	mask	Inverts the step signal. Set axis bit to
Homing				\$3	Step direction invert	1	mask	Inverts the direction signal. Set axis bi
🔒 Unlock				\$4	Invert step enable pin	0	boolean	Inverts the stepper driver enable pin sig
Grbl Configuration			\$5	Invert limit pins	0	boolean	Inverts the all of the limit input pins.	
			\$6	Invert probe pin	0	boolean	Inverts the probe input pin signal.	
Settings				\$10	Status report options	3	mask	Alters data included in status reports.
Material	DB			\$11	Junction deviation	0.010	millimeters	Sets how fast Grbl travels through consec
💔 🛛 Laser Life	espan			\$12	Arc tolerance	0.002	millimeters	Sets the G2 and G3 arc tracing accuracy b
Hotkeys				\$13	Report in inches	0	boolean	Enables inch units when returning any pos
- Hotkeys				\$20	Soft limits enable	0	boolean	Enables soft limits checks within machine
💥 Exit				\$21	Hard limits enable	1	boolean	Enables hard limits. Immediately halts mo
		-		\$22	Homing cycle enable	1	boolean	Enables homing cycle. Requires limit swit
				\$2.3	Homing direction invert	3	mask	Homing searches for a switch in the posit

#### \rm 🐇 Grbl

Ŧ	Parameter	Value	Unit	Description	^
\$31	Minimum spindle speed	0	RPM	Minimum spindle speed. Sets PWM to 0.4% o	
\$32	Laser-mode enable	0	boolean	Enables laser mode. Consecutive G1/2/3 co	
\$100	X-axis travel resolution	160.000	step/mm	X-axis travel resolution in steps per mil	
\$101	Y-axis travel resolution	400.000	step/mm	Y-axis travel resolution in steps per mil	
\$102	Z-axis travel resolution	400.000	step/mm	Z-axis travel resolution in steps per mil	
\$110	X-axis maximum rate	5000.000	mm/min	X-axis maximum rate. Used as GO rapid rate.	
\$111	Y-axis maximum rate	5000.000	mm/min	Y-axis maximum rate. Used as GO rapid rate.	
\$112	Z-axis maximum rate	5000.000	mm/min	Z-axis maximum rate. Used as GO rapid rate.	
\$120	X-axis acceleration	300.000	mm/sec^2	X-axis acceleration. Used for motion plan	
\$121	Y-axis acceleration	300.000	mm/sec^2	Y-axis acceleration. Used for motion plan	
\$122	Z-axis acceleration	300.000	mm/sec^2	Z-axis acceleration. Used for motion plan	
\$130	X-axis maximum travel	800.000	millimeters	Maximum X-axis travel distance from homin	
\$131	Y-axis maximum travel	400.000	millimeters	Maximum Y-axis travel distance from homin	
\$132	Z-axis maximum travel	90.000	millimeters	Maximum Z-axis travel distance from homin	
Config	imported successfully! 2				- V

#### II. For Lightburn

- Connect the machine to Lightburn. Open Console. Make sure the COM is correct. 1.
- 2. Enter command \$100=160, and send. When console shows "ok", the configuration is changed successfully.
- 3. Enter command \$130=800, and send. When console shows "ok", the configuration is changed successfully.



S LightBurn - LightBurn 1.1.04 <u>File</u> <u>Edit</u> Tools <u>Arrange</u> Laser Tools Window Language Help |♦ nn ▲ Width 0.000 ♦ nn ▲ Height 0.000 400

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## IIII. For UGS

- 1. Connect the machine to UGS. Open console.
- 2. Enter command \$100=160, and send. When console shows "ok", the configuration is changed successfully.
- 3. Enter command \$130=800, and send. When console shows "ok", the configuration is changed successfully.



universal Gcode Platfo	rm (Version 2.0.14)		
<u>File</u> <u>Edit</u> Machine Pro	ogram <u>T</u> ools Visualizer	Window Help	
🖸 📂 🗔 💉		D 0	
Controller State (DRO) >	< _	Welcome Page ×	- 0
	E 0.000	WirtCODE Getting Started Recent Work Features Show Next Time	2
Yo	000.0 0 <b>P3.5-</b> 000.0		
Z <sub>0</sub> FEED RA	0.000 0.000		Ì
SPINE	DLE 0		
G0 G21 G94 G	90 G54 G17	,	
ALAR	IM III	Getting started	
Toolbox x Macros	Jog Controller –		
101 Reset Zero	Keturn to Zero	Welcome to Universal Gcode Sender - If this is your first time using UGS thanks for giving it a try. This window is here to help you get started, once you are comfortable with the basic sending functionality please explore the other tabs to learn about the other features that this software has to offer.	
			-
Soft Reset	Home Machine	Console x Probe Module \$120 = 300.000 (X-axis acceleration, mm/sec <sup>2</sup> 2)	-
🔒 Unlock	Q Get State	\$121 = 300.000       (Y-aris acceleration, ms/sec <sup>2</sup> )         \$122 = 300.000       (Z-aris acceleration, ms/sec <sup>2</sup> )         \$130 = 400.000       (X-aris maximum travel, millimeters)         \$131 = 400.000       (Y-aris maximum travel, millimeters)         \$131 = 400.000       (Y-aris maximum travel, millimeters)	
✔ Check Mode		>>>> \$100=160 ok \$130=800	
		Step size: 15.0mm   Idle	No

# IV. For Candle

- 1. Connect the machine to Candle. Open settings. Make sure the COM is correct.
- 2. Enter command \$100=160, and send. When console shows "ok", the configuration is changed successfully.
- 3. Enter command \$130=800, and send. When console shows "ok", the configuration is changed successfully.

G Grblcontrol (Candle)	🚯 Settings		? ×	
Grblcontrol (Candle) File Service Help G-(1 Settings) [GC:GO G54 G17 G21 G90 G94 M5 M9 7 F/S: 0 / 0	Connection Sender Machine information Control User commands Heightmap Parser Visualizer Tool model Console Panels Colors Font	<pre>? × Connection Port: CON4 Sender Ignore error responses Automatically set parser state before sending from selected line Eachine information Status query period: 30 Units: nm  Rapid speed: 2500 Acceleration: 100 Spindle speed nin.: 0 max.: 1000 Lacor preser pin.: 0 max.: 1000</pre>		
		Control Probe commands: C21091G38.2Z-50F100,C92 Z15;00 Safe position commands: C90C21;C0Z10 C9CC21;C0Z10 C9CC21;C0Z10 Vser commands	Z5 v OK Cancel	

e Service Help			
G-code program			State
[GC:GO G54 G17 G21 G90 G94 M5 M9 TO FO S100 F/S: 0 / 0			Work coordinates:         0.000       -2.890       0.000         Machine coordinates:       0.000       0.000         Status:       Idle       Idle         Control       (12)       12       12         Image:
X: 0.000 0.000 Y: 0.000 0.000 Z: 0.000 0.000 0.000 / 0.000 / 0.000		00:00:00 / 00:00:0 Buffer: 0 / 0 / Vertices: 14 FPS: 6	\$31=0 \$32=0 \$100=40.000 \$101=40.000 \$102=200.000 \$110=500.000 \$111=5000.000
# Command	000 State	Perponse	\$112=5000.000
* Command	State	кезропее	\$122=300.000 \$122=300.000 \$132=300.000 \$131=400.000 \$131=400.000 \$132=70.000 \$100=160 < ok
Check mode Autoscroll	(men R	eset Send Pause Abort	8130-800