

Error Code

Error code

The error codes of recent 4 errors are recorded under [ERROR LOG.] in the system report.

Error Code	Error messages	Contents	Cause	Action (You do not have to perform everything listed below. Sometimes performing just one or some of the following can solve the problem.)	Status light	Error log in system report
1000-0001	ERROR: 1000-0001 The X limit switch was not found.	<ul style="list-style-type: none"> The X-axis limit sensor is not pressed. The X-axis limit sensor does not respond. The main board does not receive signals from the X-axis limit sensor. 	<ul style="list-style-type: none"> The operation is impeded by cutting waste or obstacles. The X-axis limit sensor is in a wrong position. The wiring of the X-axis limit sensor is defective. The X-axis limit sensor is defective. The wiring between the X-axis limit sensor and the main board is defective. The wiring between the X-axis motor and the main board is defective. The X-axis motor is defective. There is a problem in the X-axis operation due to the defective X-axis driver IC. 	<ul style="list-style-type: none"> Remove the obstacles. Adjust the position of the X-axis limit sensor. Check the connectivity of the X-axis limit sensor. Replace the X-axis limit sensor. Check the connectivity between the X-axis limit sensor and the main board. Check the connectivity between the X-axis motor and main board. Replace the X-axis motor. Replace the main board. 	RED (Blinking)	Yes
1000-0002	ERROR: 1000-0002 The Y limit switch was not found.	<ul style="list-style-type: none"> The Y-axis limit sensor is not pressed. The Y-axis limit sensor does not respond. The main board does not receive signals from the Y-axis limit sensor. 	<ul style="list-style-type: none"> The operation is impeded by cutting waste or obstacles. The Y-axis limit sensor is in a wrong position. The wiring of the Y-axis limit sensor is defective. The Y-axis limit sensor is defective. The wiring between the Y-axis limit sensor and the main board is defective. The wiring between the Y-axis motor and the main board is defective. The Y-axis motor is defective. There is a problem in the X-axis operation due to the defective Y-axis driver IC. 	<ul style="list-style-type: none"> Remove the obstacles. Adjust the position of the Y-axis limit sensor. Check the connectivity of the Y-axis limit sensor. Replace the Y-axis limit sensor. Check the connectivity between the Y-axis limit sensor and the main board. Check the connectivity between the Y-axis motor and the main board. Replace the Y-axis motor. Replace the main board. 	RED (Blinking)	Yes
1000-0004	ERROR: 1000-0004 The Z limit switch was not found.	<ul style="list-style-type: none"> The Z-axis limit sensor is not pressed. The Z-axis limit sensor does not respond. The main board does not receive signals from the Z-axis limit sensor. 	<ul style="list-style-type: none"> The operation is impeded by cutting waste or obstacles. The Z-axis limit sensor is in a wrong position. The wiring of the Z-axis limit sensor is defective. The Z-axis limit sensor is defective. The wiring between the Z-axis limit sensor and the main board is defective. The wiring between the Z-axis motor and the main board is defective. The Z-axis motor is defective. There is a problem in the X-axis operation due to the defective Z-axis driver IC. 	<ul style="list-style-type: none"> Remove the obstacles. Adjust the position of the Z-axis limit sensor. Check the connectivity of the Z-axis limit sensor. Replace the Z-axis limit sensor. Check the connectivity between the Z-axis limit sensor and the main board. Check the connectivity between the Z-axis motor and the main board. Replace the Z-axis motor. Replace the main board. 	RED (Blinking)	Yes
1000-0008	ERROR: 1000-0008 The A limit switch was not found.	<ul style="list-style-type: none"> The A-axis limit sensor does not respond. The main board does not receive signals from the A-axis limit sensor. 	<ul style="list-style-type: none"> The operation is impeded by cutting waste or obstacles. The A-axis limit sensor is in a wrong position. The wiring of the A-axis limit sensor is defective. The wiring of the A-axis motor is defective. The A-axis motor is defective. 	<ul style="list-style-type: none"> Remove the obstacles. Adjust the position of the A-axis limit sensor. Check the connectivity of the A-axis limit sensor. Check the connectivity of the A-axis motor. Replace the A-axis motor. Replace the main board. 	RED (Blinking)	Yes
1001-0000	ERROR: 1001-0000 The NVRAM cannot be accessed.	<ul style="list-style-type: none"> The NVRAM (non-volatile memory) cannot be accessed. 	<ul style="list-style-type: none"> The main board is defective. 	<ul style="list-style-type: none"> Replace the main board. 	RED (Blinking)	Yes
1006-0201	ERROR: 1006-0201 The X axis position has been shifted.	<ul style="list-style-type: none"> The X-axis position has been shifted. 	<ul style="list-style-type: none"> The cutting condition is too hard. The X-axis belt is dirty./The X-axis belt has cutting waste. The X-axis belt is defective. The X-axis drive pulley has cutting waste. Bad fixation of the X-axis motor. The X-axis motor is defective. 	<ul style="list-style-type: none"> Revise the cutting condition. Clean the X-axis belt. Replace the X-axis belt. Clean the X-axis drive pulley. Reattach the X-axis motor. Replace the X-axis motor. 	RED (Lighting)	No
1006-0202	ERROR: 1006-0202 The Y axis position has been shifted.	<ul style="list-style-type: none"> The Y-axis position has been shifted. 	<ul style="list-style-type: none"> The cutting condition is too hard. The Y-axis belt is dirty./The Y-axis belt has cutting waste. The Y-axis belt is defective. The Y-axis drive pulley has cutting waste. Bad fixation of the Y-axis motor. The Y-axis motor is defective. 	<ul style="list-style-type: none"> Revise the cutting condition. Clean the Y-axis belt. Replace the Y-axis belt. Clean the Y-axis drive pulley. Reattach the Y-axis motor. Replace the Y-axis motor. 	RED (Lighting)	No

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1006-0204	ERROR: 1006-0204 The Z axis position has been shifted.	<ul style="list-style-type: none"> The Z-axis position has been shifted. 	<ul style="list-style-type: none"> The cutting condition is too hard. The Z-axis belt is dirty./The Z-axis belt has cutting waste. The Z-axis belt is defective. The Z-axis drive pulley has cutting waste. Bad fixation of Z-axis motor. The Z-axis motor is defective. 	<ul style="list-style-type: none"> Revise the cutting condition. Clean the Z-axis belt. Replace the Z-axis belt. Clean the Z-axis drive pulley. Reattach the Z-axis motor. Replace the Z-axis motor. 	RED (Lighting)	No
1006-0208	ERROR: 1006-0208 The A axis position has been shifted.	<ul style="list-style-type: none"> The A-axis position has been shifted. 	<ul style="list-style-type: none"> Foreign substances get stuck in the A-axis. Step-out of the A-axis occurred by incorrect cutting conditions. The rotary axis unit is defective. 	<ul style="list-style-type: none"> Remove foreign substances. Revise the cutting condition. Replace the rotary axis unit. 	RED (Lighting)	No
1006-0008	ERROR: 1006-0008 The A axis unit was plugged or unplugged while the power was on.	<ul style="list-style-type: none"> The A-axis unit was plugged or unplugged while the power was on. 	<ul style="list-style-type: none"> The A-axis unit was plugged or unplugged while the power was on. 	<ul style="list-style-type: none"> Restart the power. 	RED (Blinking)	Yes
1017-0000	ERROR: 1017-0000 The cover was opened during the spindle rotating.	<ul style="list-style-type: none"> The cover was opened during the spindle rotating. 	<ul style="list-style-type: none"> The top cover sensor or the dust cover sensor is detected during the spindle rotation. 	<ul style="list-style-type: none"> Select [Continue] to restart cutting when continuing cutting. (Cutting quality is not guaranteed.) Select [CancelJob] when cancelling cutting. 	YELLOW (Lighting)	No
1018-0000	ERROR: 1018-0000 The chucking sensor was not found.	<ul style="list-style-type: none"> The chucking sensor was not found. 	<ul style="list-style-type: none"> The ATC limit sensor (Top/Bottom) is in a wrong position. The wiring of the ATC limit sensor (Top/Bottom) is defective. The ATC limit sensor (Top/Bottom) is defective. The wiring between the ATC limit sensor (Top/Bottom) and the main board is defective. The ATC unit is defective. 	<ul style="list-style-type: none"> Adjust the position of the ATC limit sensor (Top/Bottom). Check the connectivity of the ATC limit sensor (Top/Bottom). Replace the ATC limit sensor (Top/Bottom). Check the connectivity between the ATC limit sensor (Top/Bottom) and the main board. Replace the ATC unit. 	RED (Blinking)	Yes
1019-0000	ERROR: 1019-0000 The chucking sensor is in an incorrect status.	<ul style="list-style-type: none"> The chucking sensor is in an incorrect status. Both top and bottom sensors are on. 	<ul style="list-style-type: none"> The ATC limit sensor (Top/Bottom) is in a wrong position. The wiring of the ATC limit sensor (Top/Bottom) is defective. The ATC limit sensor (Top/Bottom) is defective. The wiring between the ATC limit sensor (Top/Bottom) and the main board is defective. The ATC unit is defective. 	<ul style="list-style-type: none"> Adjust the position of the ATC limit sensor (Top/Bottom). Check the connectivity of the ATC limit sensor (Top/Bottom). Replace the ATC limit sensor (Top/Bottom). Check the connectivity between the ATC limit sensor (Top/Bottom) and the main board. Replace the ATC unit. 	RED (Blinking)	Yes
101A-0000	ERROR: 101A-0000 The chucking motor experienced excessive current.	<ul style="list-style-type: none"> The chucking sensor is in an incorrect status. 	<ul style="list-style-type: none"> The ATC limit sensor (Top/Bottom) is in a wrong position. The wiring of the ATC limit sensor (Top/Bottom) is defective. The ATC limit sensor (Top/Bottom) is defective. The wiring between the ATC limit sensor (Top/Bottom) and the main board is defective. The ATC unit is defective. 	<ul style="list-style-type: none"> Adjust the position of the ATC limit sensor (Top/Bottom). Check the connectivity of the ATC limit sensor (Top/Bottom). Replace the ATC limit sensor (Top/Bottom). Check the connectivity between the ATC limit sensor (Top/Bottom) and the main board. Replace the ATC unit. 	RED (Blinking)	Yes
101B-0000	ERROR: 101B-0000 The chucking motor control circuit experienced excessive current.	<ul style="list-style-type: none"> The chucking sensor is in an incorrect status. 	<ul style="list-style-type: none"> The ATC limit sensor (Top/Bottom) is in a wrong position. The wiring of the ATC limit sensor (Top/Bottom) is defective. The ATC limit sensor (Top/Bottom) is defective. The wiring between the ATC limit sensor (Top/Bottom) and the main board is defective. The ATC unit is defective. The main board is defective. 	<ul style="list-style-type: none"> Adjust the position of the ATC limit sensor (Top/Bottom). Check the connectivity of the ATC limit sensor (Top/Bottom). Replace the ATC limit sensor (Top/Bottom). Check the connectivity between the ATC limit sensor (Top/Bottom) and the main board. Replace the ATC unit. Replace the main board. 	RED (Blinking)	Yes
101C-0000	ERROR: 101C-0000 The tool sensor was not found.		<ul style="list-style-type: none"> The tool sensor is being pressed. The wiring of tool sensor is defective. The wiring between the tool sensor and the main board is defective. The tool sensor is defective. 	<ul style="list-style-type: none"> Check the operation of the tool sensor. Check the connectivity of the tool sensor. Check the connectivity between the tool sensor and the main board. Replace the tool sensor. 	RED (Blinking)	Yes
101D-000X	ERROR: 101D-000X The #X cutter cannot be released.		<ul style="list-style-type: none"> Another tool is placed at the original position in stocker. Inner portion of the ATC stocker is dirty. The ATC stocker is defective. The collet is worn/deformed. The cutter is locked in the collet. 	<ul style="list-style-type: none"> Remove the cutter in the stocker. Clean the stocker. Replace the stocker. Replace the collet. 	RED (Lighting)	No

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101E-000X	ERROR: 101E-000X The #X cutter might be broken.		<ul style="list-style-type: none"> The cutter is broken. The cutter is misaligned by cutting load. Ability of the collet to retain the cutter decreases. The cutting condition is too hard. 	<ul style="list-style-type: none"> Replace the cutter. Revise the cutting condition. Retighten the collet. Revise the cutting condition. 	RED (Lighting)	No
101F-000X	ERROR: 101F-000X The #X cutter chucking has slipped out.		<ul style="list-style-type: none"> The cutter is not found. Non-blade part of the cutter touches the material wall. (The cutter moves down by big friction.) The cutter is worn. (It makes big friction) The cutter is welded. The cutting condition is too hard. 	<ul style="list-style-type: none"> Automatic correction (VPanel) Use the cutter with longer blade./Keep enough distance to the wall./Ramp the wall. Replace the cutter. Use the air blow properly. Revise the cutting condition. 	RED (Lighting)	No
1020-000X	ERROR: 1020-000X The #X cutter is too long.		<ul style="list-style-type: none"> The cutter is too long. The tool holder is not installed properly. 	<ul style="list-style-type: none"> Replace the cutter. Check the attachment of the tool holder. 	YELLOW (Lighting)	No
1021-000X	ERROR: 1021-000X The #X cutter is too short.		<ul style="list-style-type: none"> The cutter is too short. The tool holder is not installed properly. 	<ul style="list-style-type: none"> Replace the cutter. Check the attachment of the tool holder. 	YELLOW (Lighting)	No
1022-000X	ERROR: 1022-000X The #X cutter was not found.		<ul style="list-style-type: none"> The stocker has no cutters. Settings of the stocker have been incorrectly configured. The magazine position correction is wrong. 	<ul style="list-style-type: none"> Set the cutter to the stocker. Check settings of the stocker number of the cutter. Automatic correction (VPanel) 	YELLOW (Lighting)	No
1023-0000	ERROR: 1023-0000 [Milling data] Number of parameters is incorrect.		<ul style="list-style-type: none"> Parameter value of the cutting data (RML-1) is out of range. The cutting data transfer failed due to an overload on the computer. 	<ul style="list-style-type: none"> Check the cutting data. Check the settings of the computer. 	YELLOW (Lighting)	No
1024-0000	ERROR: 1024-0000 [Milling data] The parameter is out of range.		<ul style="list-style-type: none"> Parameter value of the cutting data (RML-1) is out of range. The cutting data transfer failed due to an overload on the computer. 	<ul style="list-style-type: none"> Check the cutting data. Check the settings of the computer. 	YELLOW (Lighting)	No
1025-0000	ERROR: 1025-0000 [Milling data] A wrong command is detected.		<ul style="list-style-type: none"> Unsupported command is in cutting data (RML-1). The cutting data transfer failed due to an overload on the computer. 	<ul style="list-style-type: none"> Check the cutting data. Check the settings of the computer. 	YELLOW (Lighting)	No
1026-0000	ERROR: 1026-0000 [Milling data] The address is not defined.		<ul style="list-style-type: none"> Unsupported command is in cutting data (NC code). The cutting data transfer failed due to an overload on the computer. 	<ul style="list-style-type: none"> Check the cutting data. Check the settings of the computer. 	YELLOW (Lighting)	No
1027-0000	ERROR: 1027-0000 [Milling data] The parameter is not defined.		<ul style="list-style-type: none"> Parameter value of the cutting data (NC code) is out of range. The cutting data transfer failed due to an overload on the computer. 	<ul style="list-style-type: none"> Check the cutting data. Check the settings of the computer. 	YELLOW (Lighting)	No
1028-0000	ERROE: 1028-0000 [Milling data] The operation cannot be executed.		<ul style="list-style-type: none"> Unsupported command is in cutting data (NC code). The cutting data transfer failed due to an overload on the computer. 	<ul style="list-style-type: none"> Check the cutting data. Check the settings of the computer. 	YELLOW (Lighting)	No
1029-0000	ERROR: 1029-0000 The spindle experienced an overload.		<ul style="list-style-type: none"> Non-blade part of the cutter touches the material wall. (The cutter moves down by big friction.) The cutter is worn. (It makes big friction). The cutter is welded. The cutting condition is too hard. Unsupported material is used. The spindle unit is defective./Replacement time The spindle motor is defective./Replacement time 	<ul style="list-style-type: none"> Use the cutter with longer blade./Keep enough distance to the wall./Ramp the wall. Replace the cutter. Use the air blow properly. Revise the cutting condition. Use the correct materials. Replace the spindle. Replace the spindle motor. 	RED (Blinking)	Yes

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102A-0000	ERROR: 102A-0000 The spindle experienced overcurrent.	<ul style="list-style-type: none"> The spindle experienced instant overcurrent. 	<ul style="list-style-type: none"> Non-blade part of the cutter touches the material wall. (The cutter moves down by big friction.) The cutter is worn. (It makes big friction) The cutter is welded. The cutting condition is too hard. Unsupported material is used. The spindle unit is defective./Replacement time The spindle motor is defective./Replacement time Grease viscosity increases in a low-temperature environment. 	<ul style="list-style-type: none"> Use the cutter with longer blade./Keep enough distance to the wall./Ramp the wall. Replace the cutter Use the air blow properly. Revise the cutting condition. Use the correct materials. Replace the spindle. Replace the spindle motor. Warm up the spindle unit. 	RED (Blinking)	Yes
102A-0001	ERROR: 102A-0001 The spindle experienced overcurrent.	<ul style="list-style-type: none"> The spindle experienced overcurrent for ten seconds. 	<ul style="list-style-type: none"> Non-blade part of the cutter touches the material wall (The cutter moves down by big friction.) The cutter is worn. (It makes big friction) The cutter is welded. The cutting condition is too hard. Unsupported material is used. The spindle unit is defective./Replacement time The spindle motor is defective./Replacement time Grease viscosity increases in a low-temperature environment. 	<ul style="list-style-type: none"> Use the cutter with longer blade./Keep enough distance to the wall./Ramp the wall. Replace the cutter Use the air blow properly. Revise the cutting condition. Use the correct materials. Replace the spindle. Replace the spindle motor. Warm up the spindle unit. 	RED (Blinking)	Yes
102A-0002	ERROR: 102A-0002 The spindle experienced overcurrent.	<ul style="list-style-type: none"> The spindle experienced overcurrent for five minutes. 	<ul style="list-style-type: none"> Non-blade part of the cutter touches the material wall (The cutter moves down by big friction.) The cutter is worn. (It makes big friction) The cutter is welded. The cutting condition is too hard. Unsupported material is used. The spindle unit is defective./Replacement time The spindle motor is defective./Replacement time Grease viscosity increases in a low-temperature environment. 	<ul style="list-style-type: none"> Use the cutter with longer blade./Keep enough distance to the wall./Ramp the wall. Replace the cutter Use the air blow properly. Revise the cutting condition. Use the correct materials. Replace the spindle. Replace the spindle motor. Warm up the spindle unit. 	RED (Blinking)	Yes
102B-0000	ERROR: 102B-0000 The spindle motor temperature is too high.		<ul style="list-style-type: none"> The cutting condition is too hard. Unsupported material is used. The spindle unit is defective./Replacement time The spindle motor is defective./Replacement time The wiring of the thermistor board is defective. The thermistor board is defective. 	<ul style="list-style-type: none"> Revise the cutting condition. Use the correct materials. Replace the spindle. Replace the spindle motor. Check the connectivity of the thermistor board. Replace the thermistor board. 	RED (Blinking)	Yes
102C-0000	ERROR: 102C-0000 A communication error occurred between the spindle control circuit and the motor.		<ul style="list-style-type: none"> The wiring of the spindle motor is defective. The spindle is defective./Replacement time The spindle motor is defective./Replacement time The wiring between the spindle motor and the main board is defective. The main board is defective. 	<ul style="list-style-type: none"> Check the connectivity of the spindle motor. Replace the spindle. Replace the spindle motor. Check the connectivity between the spindle motor and the main board. Replace the main board. 	RED (Blinking)	Yes
102D-0000	ERROR: 102D-0000 The spindle can not be turned.		<ul style="list-style-type: none"> The wiring of the spindle motor is defective. The spindle is defective./Replacement time The spindle motor is defective./Replacement time The wiring between the spindle motor and the main board is defective. The main board is defective. Grease viscosity increases in a low-temperature environment. 	<ul style="list-style-type: none"> Check the connectivity of the spindle motor. Replace the spindle. Replace the spindle motor. Check the connectivity between the spindle motor and the main board. Replace the main board. Warm up the spindle unit. 	RED (Blinking)	Yes
102E-0000	ERROR: 102E-0000 The spindle crashed.		<ul style="list-style-type: none"> The cutter crashed the ATC magazine or the rotary axis unit. Metal part makes contact (electrical continuity is detected) at a wrong time during automatic correction. 	<ul style="list-style-type: none"> Check the operation procedures. Check the tool attachment. Check the fixation of each component. An incorrect fixation such as a loosened screw may cause an unexpected electrical continuity. 	RED (Blinking)	Yes
1031-XX01	ERROR: 1031-XX01 The error occurred in the control board.	<ul style="list-style-type: none"> Communication with the carriage board cannot be made. 	<ul style="list-style-type: none"> Communication with the carriage board cannot be made. The board is defective. 	<ul style="list-style-type: none"> Check the wiring between each board. Replace the board. 	RED (Blinking)	Yes
1031-XX02	ERROR: 1031-XX02 The error occurred in the control board.	<ul style="list-style-type: none"> Communication with the panel board cannot be made. 	<ul style="list-style-type: none"> Communication with the panel board cannot be made. The board is defective. 	<ul style="list-style-type: none"> Check the wiring between each board. Replace the board. 	RED (Blinking)	Yes

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1036-0000	ERROR: 1036-0000 A communication error occurred between the spindle control circuit and the MAIN firmware.		<ul style="list-style-type: none"> The wiring of the spindle motor is defective. The spindle is defective./Replacement time The spindle motor is defective./Replacement time The wiring between the spindle motor and the main board is defective. The main board is defective. The carriage board is defective. 	<ul style="list-style-type: none"> Check the connectivity of the spindle motor. Replace the spindle. Replace the spindle motor. Check the connectivity between the spindle motor and the main board. Replace the main board. Replace the carriage board. 	RED (Blinking)	Yes
103B-0000	ERROR: 103B-0000 The automatic correction is not yet finished.		<ul style="list-style-type: none"> The cutting operation is executed before performing automatic correction. 	<ul style="list-style-type: none"> Perform automatic correction. 	RED (Lighting)	None
-	Can not setup the origin on the machine coordinate.		<ul style="list-style-type: none"> An attempt was made to set the origin by [ORIGIN] button when the machine coordinate system is displayed. 	<ul style="list-style-type: none"> Switch the display to user coordinate system. Set the origin by [ORIGIN] button. 	BLUE (Lighting) (Without rotary axis unit) GREEN (Lighting) (With rotary axis unit)	None
1044-0000	ERROR: 1044-0000 The automatic Z0 setting failed.		<ul style="list-style-type: none"> Automatic setting of Z-axis user origin was performed when Z0 sensor is not in position. 	<ul style="list-style-type: none"> Plug in the Z0 sensor cable again. Position the detection pin directly over the Z0 sensor. Use the [Z0 SENSE] button to automatically set the Z-axis user origin again. 	RED (Lighting)	None
1045-XX01	ERROR: 1045-XX01 The error occurred during synchronizing the control board.		<ul style="list-style-type: none"> Communication with the carriage board cannot be made. 	<ul style="list-style-type: none"> Check the wiring between the main board and the panel board. Replace the main board. Replace the carriage board. 	RED (Blinking)	Yes
1045-XX02	ERROR: 1045-XX02 The error occurred during synchronizing the control board.		<ul style="list-style-type: none"> Communication with the panel board cannot be made. 	<ul style="list-style-type: none"> Check the wiring between the main board and the panel board. Replace the main board. Replace the panel board. 	RED (Blinking)	Yes
1046-0001	ERROR: 1046-0001 The combination of firmware version of the main board and the sub board is invalid.		<ul style="list-style-type: none"> The combination of the firmware version between the main board and the carriage board is wrong. 	<ul style="list-style-type: none"> Upgrade the firmware of all boards to the latest version. 	RED (Lighting)	None
1046-0002	ERROR: 1046-0002 The combination of firmware version of the main board and the sub board is invalid.		<ul style="list-style-type: none"> The combination of firmware version between main board and the panel board is wrong. 	<ul style="list-style-type: none"> Upgrade the firmware of all boards to the latest version. 	RED (Lighting)	None
1047-0002	ERROR: 1047-0002 The machine's internal memory cannot be accessed.		<ul style="list-style-type: none"> Read/Write of the SD card failed. 	<ul style="list-style-type: none"> Replace the SD card. Replace the board. 	RED (Lighting)	None
1048-0000	ERROR: 1048-0000 Detected an emergency stop signal from the external input terminal.		<ul style="list-style-type: none"> Turn on EMG_STOP of EXT.2 terminal. 	<ul style="list-style-type: none"> Turn off EMG_STOP. Check the connected machine. Check/Replace the extention board. 	RED (Blinking)	Yes

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XXXX-XXXX	ERROR: XXXX-XXXX An unknown error occurred.				RED (Blinking)	Yes