



Please note the following:

- ?? M50 must be the first M code entered in the list, and M51 must be the second.
- ?? FlashCut will execute these M codes automatically. M50 and M51 should NOT be in the G-Code file except for one situation: If the G-Code file ends with a feedrate move (instead of a rapid move), add an M51 at the end of the file to turn off the cutting device.

#### Baud Rate Settings

Since Version 1.61 supports the Lightning Chip, it can also handle larger baud rates up to 115200 baud. These are found in the Setup...System Options Menu.

If you have any questions concerning these new features, please don't hesitate to call FlashCut for assistance. Thank you for using FlashCut CNC.