Stop CV on angles > _____Degrees – This is a really nice setting that automatically switches the machine from CV to Exact Stop mode depending on the approaching angle of the next line of code. Setting to 90 degrees is usually a good compromise because most Gcode that has a 90 degree (or ~~smaller~~ greater) turn is usually indicative of where the user wants a nice sharp corner. However, some CAM software can output some REALLY bad code which represents an arc or angular move as a giant sequence of small 90 degree stair steps such as....

G01 X0 Y0
X0.01
Y0.01
X0.02
Y0.02

This code will run TERRIBLY with any setting ~~at 90 deg or above~~ less than 90 deg. Sometimes it is VERY hard to tell if your code has this problem by just looking at the display window.

This issue has had me banging my head against the wall, so if nothing you try will get your machine flying around the curves, you may want to look at your code. Also, it may be necessary to zoom way in on the Mach-3 toolpath display to see this sort of problem.