
Okuma America Corporation

**THINC-API
Release Notes for Lathe**

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Release Notes For Lathe	Date: 10/08/2014

Revision History

Date	Version	Description	Author
5/21/2007	S5015-008-00	Public release for Lathe THINC-API version 1.0.0.0	LHuynh
6/04/2007	S5015-008-01	Public release for Lathe THINC-API version 1.1.0.0	Lhuynh
08/15/2007	S5015-008-02	Public release for Lathe THINC-API version 1.2.0.0	Lhuynh
2/22/2008	S5015-008-03	Public Release 1.6.0.0 for Lathe THINC-API	Lhuynh
4/11/2008	S5015-008-04	Public Release 1.6.0.0 for Lathe THINC-API	Lhuynh
06/27/2008	S5015-008-05	Public Release 1.6.3.0 for Lathe THINC-API	Lhuynh
07/25/2008	S5015-008-06	Public Release 1.6.4.0 for Lathe THINC-API	Lhuynh
10/27/2008	S5015-008-07	Public Release 1.7.0.0 for Lathe THINC-API	Lhuynh
12/18/2008	S5015-008-08	Public Release 1.8.0.0 for Lathe THINC-API	Lhuynh
04/30/2009	S5015-008-09	Public Release 1.9.1.0 for Lathe THINC-API	Lhuynh
10/12/2009	S5015-008-10	Public Release 1.10.0.0 for Lathe THINC-API	Lhuynh
04/28/2010	S5015-008-11	Public Release 1.11.0.0 for Lathe THINC-API	Lhuynh
09/14/2010	S5015-008-12	Public Release 1.11.1.0 for Lathe THINC-API	Lhuynh
01/04/2011	S5015-008-13	Public Release 1.12.0.0 for Lathe THINC-API	Lhuynh
02/02/2011	S5015-008-14	Public Release 1.12.1.0 for Lathe THINC-API	Lhuynh
11/14/2011	S5015-008-15	Beta Release 1.14.0.0 for Lathe THINC-API	Lhuynh
01/15/2012	S5015-008-16	Beta Release 1.14.1.0 for Lathe THINC-API	Lhuynh
09/21/2012	S5015-008-17	Beta Release 1.14.2.0 for Lathe THINC-API	Lhuynh
12/04/2012	S5015-008-18	Public Release 1.15.0.0 for Lathe THINC-API	Lhuynh

THINC-API	Version: S5015-008-24
Release Notes For Lathe	Date: 10/08/2014

03/06/2013	S5015-008-19	Beta Release 1.15.1.0 for Lathe THINC-API	Lhuynh
03/18/2013	S5015-008-20	Beta Release 1.15.2.0 for Lathe THINC-API	Lhuynh
09/25/2013	S5015-008-21	Public Release 1.16.0.0 for Lathe THINC-API	Lhuynh
01/15/2014	S5015-008-22	Public Release 1.17.0.0 for Lathe THINC-API	Lhuynh
04/01/2014	S5015-008-23	Public Release 1.17.1.0 for Lathe THINC-API	Lhuynh
10/08/2014	S5015-008-24	Public Release 1.17.2.0 for Lathe THINC-API	Lhuynh

THINC-API	Version: S5015-008-24
Release Notes For Lathe	Date: 10/08/2014

Table of Contents

1.	Introduction	5
1.1	Disclaimer of Warranty	5
1.2	Purpose	5
1.3	Scope	5
1.4	Definitions, Acronyms, and Abbreviations	5
1.5	References	5
2.	About This Release	5
3.	New Features	7
4.	Known Bugs and Limitations	7
4.1	Defect	7
4.2	General Defect	7
4.2.1	Data-API	8
4.3	Defects Fixed in this Release	8
4.3.1	API Notifier Status	8
4.3.2	CATC class	8

THINC-API	Version: S5015-008-24
Release Notes For Lathe	Date: 10/08/2014

Release Notes for Lathe

1. Introduction

1.1 Disclaimer of Warranty

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1.2 Purpose

The purpose of the **Release Notes** document is to communicate major new features and changes in this release of the THINC-API for Lathe libraries. It also documents known problems and workarounds.

1.3 Scope

This document describes Public Release 1.17.2.0 of THINC-API for Lathe.

1.4 Definitions, Acronyms, and Abbreviations

GAC – Global Assembly Cache Windows folder located in 'C:\WINDOWS\assembly'

1.5 References

None.

2. About This Release

Public Release 1.17.2.0 of the THINC-API library for Lathe supports the following:

From this release, THINC-API libraries will check dependency libraries during installation and at run-time. THINC-API will fail to install or load if version of dependency libraries cannot support current version of THINC-API.

From this release and forward, API Notifier will delay the checking of API for an approximately of 1 minutes or so after NC is running.

All applications compiled with Beta Release from version 1.15.X.X must be compiled with Public Release version 1.17.0.0 or higher when it is available.

In current version of THINC-API, some of the existing functions related to ATC, Tool, TailStock, and Chuck Data from DATA-API or Command API might not function correctly on OSP-P300S (SLP) and OSP-P300L control unless they have been revised as listed in the Change section 3.2.

***Please refer to the help file for detail usage and compatibility information of each function.
This version requires latest OSP system disk.***

THINC-API Release notes	©Okuma America Corporation, 2014	Page 5 of 8
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THINC-API	Version: S5015-008-24
Release Notes For Lathe	Date: 10/08/2014

Version of Okuma.CLDATAPI.dll in this release is 2.6.1.0

Version of Okuma.CLCMDAPI.dll in this release is 2.0.0.0

Version of APINotifierService.exe in this release is 1.17.4.0

Version of APINotifierStatus.exe in this release is 1.1.2.0

Version of Okuma.Flexnet.dll in this release is 1.3.0.0

Version of Okuma.Apilog.dll in this release is 1.4.0.0

This release requires OCJ API version 003Q

The following functions of Okuma.CLDATAPI.dll library will not be available in OSP-P100II control machines:

Classes	Interfaces
CMachine	OnOffStateEnum GetNCStatus(NCStatusEnum enNCStatus)
CMachine	CCurrentAlarm* GetCurrentAlarm()
CIO	OnOffStateEnum GetUserTaskIOVariable(IOTypeEnum enIO, Int32 intIndex) ;
CIO	void SetUserTaskOutputVariable(Int32 intIndex, OnOffStateEnum enValue) ;
CIO	OnOffStateEnum GetProtectedUserTaskOutputVariable(Int32 intIndex) ;
CIO	void SetProtectedUserTaskOutputVariable(Int32 intIndex, OnOffStateEnum enValue) ;

The following functions of Okuma.CLCMDAPI.dll library will not be available in OSP-P100II control machines:

Classes	Interfaces
CATC	Sub RegisterToolPot(ByVal intPotNo As Integer, ByVal intToolNo As Integer, ByVal enSettingToolKind As SettingToolKindEnum, ByVal enSettingToolSize As SettingToolSizeEnum, ByVal enReturnMagazine As ReturnMagazineEnum)
CATC	Sub SetNextTool(ByVal intToolNo As Integer, ByVal enSettingToolKind As SettingToolKindEnum, ByVal enSettingToolSize As SettingToolSizeEnum, ByVal enReturnMagazine As ReturnMagazineEnum)
CATC	Sub SetToolInStation(ByVal intToolNo As Integer, ByVal enSettingToolKind As SettingToolKindEnum, ByVal enSettingToolSize As SettingToolSizeEnum, ByVal enReturnMagazine As ReturnMagazineEnum, ByVal enTurretStation As TurretStationEnum)
CATC	Sub UnRegisterToolPot(ByVal intPotNo As Integer)
CProgram	CancelMainProgram()
CProgram	SelectMainProgramRSide(ByVal strMainProgramFileName As String, Optional ByVal strSubProgramFileName As String = "", Optional ByVal strSystemSubstituteProgramFileName As String = "", Optional ByVal strProgramName As String = "")
CProgram	SelectMainProgramLSide(ByVal strMainProgramFileName As String, Optional ByVal strSubProgramFileName As String = "", Optional ByVal strSystemSubstituteProgramFileName As String = "", Optional ByVal strProgramName As String = "")

THINC-API	Version: S5015-008-24
Release Notes For Lathe	Date: 10/08/2014

CTools	CalcualteToolOffset(ByVal intToolNo As Integer, ByVal enAxisIndex As OffsetAxisIndexEnum, ByVal enSubSystem As SubSystemEnum, ByVal dblValue As Double)
CTools	AddConstantToolOffset(ByVal intOffsetNo As Integer, ByVal enAxisIndex As OffsetAxisIndexEnum, ByVal enSubSystem As SubSystemEnum, ByVal enCuttingPosition As CuttingPositionEnum)
CTools	AddConstantNoseRadiusCompensation(ByVal intOffsetNo As Integer, ByVal enAxisIndex As OffsetAxisIndex2Enum, ByVal enSubSystem As SubSystemEnum, ByVal enCuttingPosition As CuttingPositionEnum)
CTools	AddConstantToolWear(ByVal intOffsetNo As Integer, ByVal enAxisIndex As OffsetAxisIndex2Enum, ByVal enSubSystem As SubSystemEnum, ByVal enCuttingPosition As CuttingPositionEnum)
CTools	SubtractConstantToolOffset(ByVal intOffsetNo As Integer, ByVal enAxisIndex As OffsetAxisIndexEnum, ByVal enSubSystem As SubSystemEnum, ByVal enCuttingPosition As CuttingPositionEnum)
CTools	SubtractConstantNoseRadiusCompensation(ByVal intOffsetNo As Integer, ByVal enAxisIndex As OffsetAxisIndex2Enum, ByVal enSubSystem As SubSystemEnum, ByVal enCuttingPosition As CuttingPositionEnum)
CTools	SubtractConstantToolWear(ByVal intOffsetNo As Integer, ByVal enAxisIndex As OffsetAxisIndex2Enum, ByVal enSubSystem As SubSystemEnum, ByVal enCuttingPosition As CuttingPositionEnum)
CProgram	SelectScheduleProgramLSide(ByVal strScheduleProgramFileName As String)
CProgram	SelectScheduleProgramRSide(ByVal strScheduleProgramFileName As String)
CMachine	Public Sub SetUserAlarm(ByVal enAlarm As UserAlarmEnum, Optional ByVal strAlarmMessage As String = "", Optional ByVal enUserAlarmSubSystem As UserAlarmSubSystemEnum = 0)
CMachine	Public Sub ClearUserAlarmD(ByVal enUserAlarmSubSystem As UserAlarmSubSystemEnum)

Note: User Alarm will require OKUMA.Lathe.UserAlarm license feature in order to function on OSP-P200 machine if machine can support.

3. New Features

None

4. Known Bugs and Limitations

This section identifies known problems in this release and describes any work-arounds.

4.1 Defect

4.2 General Defect

DATA-API library, Okuma.CLDATAPI.dll, cannot create directly under ASP.NET web application.

Solution/Work-arounds: Create and initialize DATA-API in a separate thread. All function calls must be called from objects created inside separated thread mentioned above.

DATA-API library can only support applications designed with single-threaded apartment of COM threading model. The underlying library, LDATAPI.dll, cannot be loaded during call to CMachine::Init function when an MTAThread attribute is applied to the application.

Solution/Work-arounds: None

THINC-API	Version: S5015-008-24
Release Notes For Lathe	Date: 10/08/2014

4.2.1 Data-API

4.2.1.1 MacMan.COperationHistory class

Function:

```
Int32 COperation* GetOperationHistory(Int32 intIndex) ;
ArrayList* GetOperationHistory(Int32 intFromIndex, Int32 intToIndex);
Int32 GetMaxCount() ;
Int32 GetCount() ;
```

Symptom: Failed to get correct data for Subsystem L and R side if MacMan screen is different than current setting of subsystem. It always gets the data from current MacMan screen.

Solution/Work around: None

4.2.1.2 CAxis class

Function:

```
Double GetActualPositionProgramCoord( AxisIndex1Enum enAxisIndex);
Double GetTargetPosition (AxisIndex1Enum enAxisIndex);
```

Symptom: The Z-axis position for sub system NC-AL and NC-AR does not return data correctly. It is based on the current selection of spindle in NC panel or command program G140/G141.

Solution/Work around: None

4.3 Defects Fixed in this Release

4.3.1 API Notifier Status

It has been revised to hide the form when it is first loaded to minimize the interference with other Windows applications running on the control.

4.3.2 CATC class

Function:

```
Public Function GetMaxPots(ByVal enMagazineType As MagazineTypeEnum) As Integer
```

Symptom: The function cannot return correct number of pots for sub magazine on OSP-P300S controls having sub magazine (second magazine) or dual magazine.

Solution/Work around: Require OSP system support custom API version 003Q.