RELEASE NOTES

Release Notes for PathPilot® v2.0.2

March 2018

New Features

For more information on added features, refer to the machine's operator manual at tormach.com/documents.

All

- Added suggestions for feeds and speeds in conversational routines (PP-1090)

Mill

- In the **Conversational** tab, there's a **DXF** tab to import a .dxf file and generate G-code from it (PP-1930)

Enhancements

All

- To make it easier to understand the order of error messages, there's a time stamp added to the beginning of each message on the **Status** tab (PP-1794)
- When loading a .jpg, .jpeg, or .png file, the image viewer opens to make sure that you're loading the right file (PP-1823)
- When adjusting the override or jog speed sliders, you can use the scroll wheel on the mouse to make adjustments in 2-percent increments (PP-1900)
- If a conversational DRO field is highlighted red because of an error in the value entered, we added a context-sensitive tool tip to help you troubleshoot it (PP-1935)
- To reduce confusion, we moved the light that indicates the currently selected axis on the Jog Shuttle to the right of the **Axis** DRO field (PP-1959)
- To make it easier to read error messages, the **Error Message** window in the **Status** tab is automatically maximized based on your machine's configuration (PP-1960)
- If the text in a comment after M00 or M01 doesn't match an image file name, the comment now displays over the toolpath preview (PP-1983)
- If the **Feedrate Override** slider or the **Spindle Override** slider is set to over 100 percent, it's now reset to 100 percent when loading a G-code file (PP-2020)
- The percentage set on the **Jog Speed** slider is remembered through power cycles (PP-2021)

Mill

- In the **Probe** tab, there's a button to change the corner on which to probe a part (PP-1742)
- To improve usability, we expanded the size of the font selection list in the **Engrave** tab by removing the **Font Preview** window (now, the font preview applies to the text entered in the **Text** field); also, we fixed a bug in the Bebas font name (PP-1832)
- When an Automatic Tool Changer (ATC) is doing **Go to Tray Load** and **Remove** operations, ATC reliability is improved; also, we improved the interface's responsiveness (PP-1940)
- In the **ATC** tab, when deleting all tool assignments, there's an alert message to confirm the deletion (PP-2018)

Lathe

- In conversational, there's a tag in the G-code comments to indicate from which **X** side the tool is cutting (PP-1596)
- In conversational profiling:
  - In the lathe profiling points table, there's an alert message that displays after you click **CLR** to confirm the deletion (PP-1833)
  - There's an option to use only **Roughing** or only **Finishing** (PP-1865)
- In the **Settings** tab, there's support for the Automatic Collet Closer Kit for 15L Slant-PRO (PN 38690) (PP-1918)
- In the **Tool Table** window, editing table cells auto-advances to the next column (PP-2044)

Fixed Issues

All

- We clarified this error message: "Circular move on line 40 would exceed joint 0's negative limit" (PP-1767)
- We fixed an issue where, when editing G-code, the **Save As** dialog box was missing a field for the file name — which made it difficult to save a new version of a G-code file, or to create a new G-code file to save on the PathPilot® controller (PP-1809)
- In the **Status** tab, when a limit switch is pushed in, the axes limit switch lights are now yellow to indicate an unusual status (previously, they were green); also, we added a context-sensitive tool tip to indicate if the limit switch is disabled (PP-1847)
- When in conversational editing, we fixed an issue where using **Save As** in some path and file name situations produced an unexpected exception (PP-1878)
- In conversational job assignment editing, we fixed an issue where **Insert Step** inserted below the current **File** tree row only (PP-1880)
- We fixed an issue where the spindle tip drawing was outside of the work envelope box by the tool offset value (PP-1882)
- We fixed an issue where using the **Spindle Speed Range** button during a programmed M00 or M01 break was prevented (PP-1883)
- When using the override and jog speed sliders, we fixed an issue where percentages were changed when **HOME** or **END** was pressed on the keyboard (PP-1901)
- We fixed an issue where changing the network name was only saved if **ENTER** was pressed on the keyboard (to view the new network name, you still must power cycle the PathPilot® controller) (PP-1903)
- In the **Tool Table** window, we fixed an issue where using **LEFT ARROW** or **RIGHT ARROW** on the keyboard jogged the machine instead of moving the cursor between cells (PP-1939)
- If the custom metric or SAE threads files are deleted, the template for custom files is now automatically restored, which has helpful examples as comments (PP-2048)

Mill

- We clarified this ATC message that displays when removing a tool from the spindle: "Insert T0 in spindle" (PP-1851)
- In conversational external thread milling, we fixed an issue where entering values in DRO fields required a certain order (PP-1808)
- In conversational engraving, we fixed an issue where serial number engraving failed at a small height (PP-2015)

Lathe

- In conversational profiling, we fixed issues where:
  - An exception error was sometimes received when the profile was first loaded (PP-1724)
  - The **RPM** and **Feed** DRO fields were grayed out after selecting **Drill** or **Thread** tabs (PP-1796)
  - Arcs that continued from arcs with a different radii could cause errors (PP-1849)
  - Loading some G-code files caused errors (PP-1860)
  - The generated tool path could, in some circumstances, gouge the part (PP-1863)
  - A rapid occurred from **-X** to the far **+X** side of a part before cutting started (PP-1871)
  - A math overflow error, in some situations, caused a duplication of steps (PP-1872)
  - Editing a profiling step, and then posting the same profile, could produce slightly different G-code (PP-1873)
  - A finish pass could result in a part gouge for some series of lines and arcs (PP-1874)
  - A very small radius could fail before the finish pass (PP-1875)
  - Entering **0** in a DRO field in the radius column caused an error (PP-1931)
- We also fixed issues where:
  - After switching between conversational editing and loading G-code files, the tool path sometimes displayed in the wrong orientation (PP-1932)
  - PathPilot® wouldn't exit if all three of the following conditions happened (PP-1951):
    1. A USB M-Code I/O Interface Kit was enabled
    2. The **Status** tab was active
    3. The **Emergency Stop** button was pushed