



Avid CNC Mach4 Release Notes

v2022Q2.1

Mach4 for Avid CNC Machines

Release Notes

- **Version 2.3.6** (4.22.2022)
 - Avid SCU v2.0.5.6
- **Version 2.3.5** (12.16.2021)
 - Avid SCU v2.0.5.5
- **Version 2.3.4** (11.1.2021)
 - Avid SCU v2.0.5.3
- **Version 2.3.3** (10.12.2021)
 - ESS plugin v277.1
 - Bugfix: Spindle fails to change speed under certain circumstances after homing
- **Version 2.3.2** (9.14.2021)
 - Mach4 v4.2.0.4612
 - ESS plugin v277
 - TMC3in1 plugin v022
 - Avid SCU v2.0.5.2
 - New: Machine must be homed prior to running G-Code or using touch plate
 - New: M300X macros for use with SheetCam post processor v1.7 and newer
 - Update: Revised default THC settings (new installs only)
 - Update: Revised default soft limit values
 - Update: Program extents can be shown in work or machine coordinates
 - Update: Improved error messages for touch plate routines
 - Update: "Home XYZ" button respects which axes are in home order
 - Update: Single cycle time screen element with persistent cycle time
 - Update: Improved performance running large G-Code programs (toolpath settings changes)
 - Update: Spindle PTC fault warning changed to generic VFD fault warning
 - Bugfix: Jog rate does not always persist across sessions
 - Bugfix: Using "Home XYZ" button dereferences A/U axis
 - Bugfix: Setting touch plate multi-axis pause to 0 sec causes error in advanced settings dialog
 - Bugfix: "Display Work Envelope" button does not toggle work envelope in toolpath preview
- **Version 2.2.2** (3.5.2021)
 - New: Support for Avid CNC 4 HP Plug and Play Spindle / VFD System
- **Version 2.2.1** (2.1.2021)



- Avid CNC SCU v2.0.4.0
- **Version 2.2.0** (12.28.2020)
 - Mach4 v4.2.0.4517
 - ESS plugin v260
 - TMC3in1 plugin v017
 - Avid CNC SCU v2.0.2.0
 - New: Enable soft limits after homing
 - New: Home X and Y axes simultaneously
 - New: Warning messages
 - New: Support for Avid CNC 8.7 HP Plug and Play Spindle / VFD
 - New: Spindle warm-up routine
 - New: Persistent cycle times
 - New: Support for dual-use routing/plasma with CRP300 electronics
 - New: Ignore tool changes option
 - Update: M6 macro for manual tool changes
 - Update: TMC3in1 plugin disabled if machine not configured for plasma use
 - Update: Torch Height Control disabled when not using plasma cutting tool
 - Update: Voltage-based THC anti-dive settings are percentage based
 - Update: Increased Z axis soft limit values to allow full travel of Z axis when soft limits enabled
 - Bugfix: Home offsets incorrectly set for dual Z axis machines
 - Bugfix: Incorrect images displayed during rotary calibration procedure
- **Version 2.0.6** (11.27.2019)
 - Mach4 v4.2.0.4322
 - ESS plugin v253
 - TMC3in1 plugin v014
 - New: Support for CRP100, CRP300, CRP500, and CRP800-revA electronics
 - New: Support for previous model revisions
 - New: Resume cut feature for plasma use
 - New: Active communications with Avid CNC control system required for configuration changes
 - New: Package profile feature specific for support of Avid CNC's Mach4 profile.
 - Update: Improved touch plate operation including error messages, numeric validation, and additional advanced settings
 - Update: Diagnostics tab displays home and limit switches separately
 - Update: G92 offsets added to fixture table on offsets tab
 - Bugfix: Not able to set spindle speed from DRO
 - Bugfix: Swap X and Y axes does not maintain right-handed coordinate system or update limit switch mappings
 - Bugfix: Changing home direction requires remapping of sensors



- Bugfix: Limit switch diagnostics don't update with axis swap or change in home direction
- Bugfix: Disable Avid configuration option overwrites setting changes under certain circumstances
- **Version 1.0.4** (8.2.2019)
 - New: Support for calibration and use of Avid PRO CNC Rotary Axis
- **Version 1.0.3** (7.15.2019)
 - Bugfix: Auto Z Touch Plate button disappears during program operation
- **Version 1.0.2** (7.9.2019)
 - Bugfix: Inconsistent machine motion
- **Version 1.0.1** (7.2.2019)
 - Initial release of Avid CNC's custom user interface and profile for Mach4
 - Mach4 v4.2.0.4162

