RELEASE NOTES FOR PATHPILOT V2.8.0

June 2021

ENHANCEMENTS

All

- We improved the behavior of the set start line function in two ways (PP-3090):
  1. If the correct tool is already in the spindle, skip the retract to tool change height.
  2. Retract to the `G30` position rather than `G53 Z0`. This saves time and allows for better control of retract position, like on lathes with a turret.
- We added a new, read-only parameter `# <_tool_offset_number>` to get the currently applied tool offset number at the interpreter read-ahead location for use in G-code programs. (PP-3249)

Mills

- We improved collision avoidance when using long tools in Automatic Tool Changers (ATCs). Now, after a tool change involving the ATC, the final Z position is set to whichever is higher between G30 Z and tool change Z. (PP-3254)

Plasma

- We added mild steel cut charts for the Powermax 85 plasma source. (PP-2941)
- We added a parametric conversational shape library. It includes things like common shapes, flanges, and brackets — along with conversational parameters — for quick and easy cutting. (PP-3193)

FIXED ISSUES

All

- We fixed issues where:
  - While using the pendant on the PathPilot operator console, the jog speed wasn't limited before the axes were referenced. (PP-3037)
  - The View Options tab (in the G-Code window) wouldn't refresh when a file modification was detected. (PP-3102)
  - Some G-code program errors would appear to leave the Tool Path display blank. (PP-3114)

  - When exiting a `G37` move, the machine moved to the initial Z position before moving to the Z clear position. (PP-3132)
  - While using the pendant on the PathPilot operator console, the axis motion stuttered when jogging at high speeds. (PP-3188)
  - After unplugging and re-connecting the touch screen monitor's USB cable, the calibration settings were removed. (PP-3245)
  - Attempting to assign a value to a read-only parameter correctly raised an error, but failed to clear that error. This caused any future MDI or program runs to fail, and required a restart of PathPilot to resume normal operation. (PP-3252)

Mills

- We added rapid jogging support for rotary axes. (PP-2901)
- We fixed an issue where, if an ATC had low air pressure, selecting ATC FWD or ATC REV caused the PathPilot interface to freeze. This required a restart of PathPilot to resume normal operation. (PP-3253)

Lathes

- We fixed an issue where, after a spindle stop was commanded, a user command to unclamp the collet was allowed before the spindle had fully stopped. (PP-3219)

Plasma

- We fixed an issue where some AutoFS presets for mild steel used the incorrect amperage. (PP-3111)

MANAGE PATHPILOT VERSIONS

You don't need to install updates sequentially. You can update from any previous version to the current version of PathPilot. Depending on what you want to do, refer to the following sections:

- "Download and Install an Update File from the Controller" (below)
- "Install an Update File from a USB Drive" (on the next page)
- "Install a Previous Version of an Update File" (page 5)

DOWNLOAD AND INSTALL AN UPDATE FILE FROM THE CONTROLLER

1. Confirm that the PathPilot controller is powered on and out of **Reset** mode.
2. Downloading and installing an update file requires an Internet connection. From the **Status** tab, confirm that the **Internet** button LED light is on. Then, select **Update**.

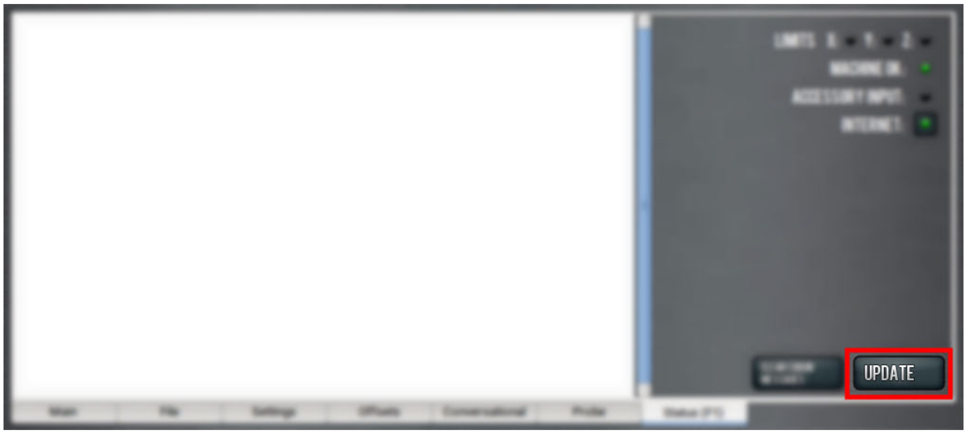
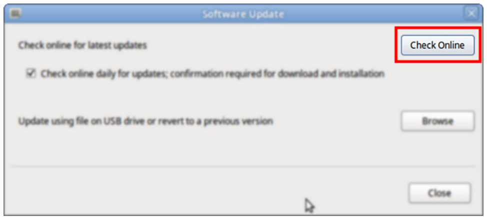


Figure 1: Update button on the Status tab.

3. From the **Software Update** dialog box, select **Check Online**.



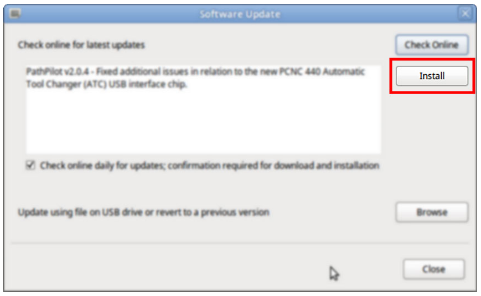
Check online for latest updates

☑ Check online daily for updates; confirmation required for download and installation

Update using file on USB drive or revert to a previous version

Figure 2: Software Update dialog box.

4. Select **Install**.



Check online for latest updates

PathPilot v2.0.4 - Fixed additional issues in relation to the new PCNC 440 Automatic Tool Changer (ATC) USB interface chip.

☑ Check online daily for updates; confirmation required for download and installation

Update using file on USB drive or revert to a previous version

Figure 3: Install button on the Software Update dialog box.

The update file is downloaded, and a notification dialog box displays.

5. From the dialog box, select **OK**.
   The update file is installed on the PathPilot controller.
6. Follow the on-screen instructions to restart the PathPilot controller.

INSTALL AN UPDATE FILE FROM A USB DRIVE

1. From the PathPilot support center, download the most recent PathPilot update file.
2. Transfer the PathPilot update file to a USB drive.
3. Put the USB drive into the PathPilot controller.
4. Confirm that the PathPilot controller is powered on and out of **Reset** mode.
5. From the **Status** tab, select **Update**.

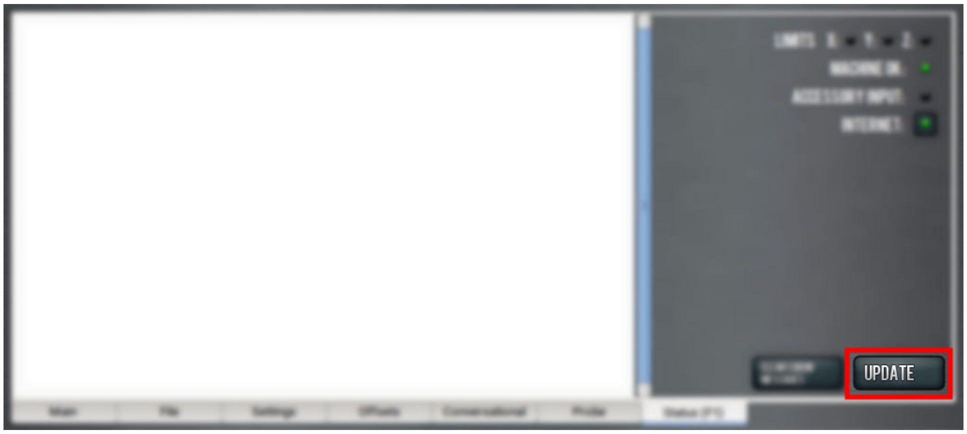
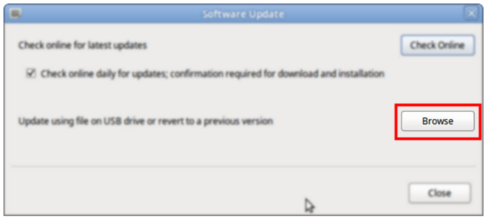

LIMITS X Y Z
MACHINE OK
ACCESSORY INPUT
INTERNET
UPDATE
Main
File
Settings
Offsets
Conversational
Probe
Status (F1)

Figure 4: Update button on the Status tab.

6. From the **Software Update** dialog box, select **Browse**.


Software Update
Check Online
Browse
Close

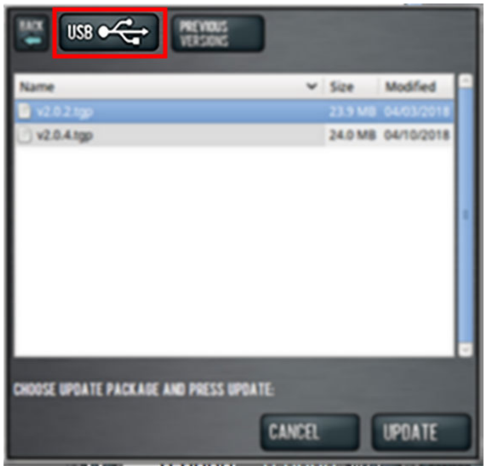
Check online for latest updates

☑ Check online daily for updates; confirmation required for download and installation

Update using file on USB drive or revert to a previous version

Figure 5: Software Update dialog box.

7. From the **Browse** dialog box, select **USB**.


BACK
USB
PREVIOUS VERSIONS
CANCEL
UPDATE

Name	Size	Modified
v2.0.2.tgp	23.9 MB	04/03/2018
v2.0.4.tgp	24.0 MB	04/10/2018

CHOOSE UPDATE PACKAGE AND PRESS UPDATE:

Figure 6: Browse dialog box.

8. Select the desired update file, and then select **Update**.
   The update file is installed on the PathPilot controller.
9. Follow the on-screen instructions to restart the PathPilot controller.

INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

1. Confirm that the PathPilot controller is powered on and out of **Reset** mode.
2. From the **Status** tab, select **Update**.

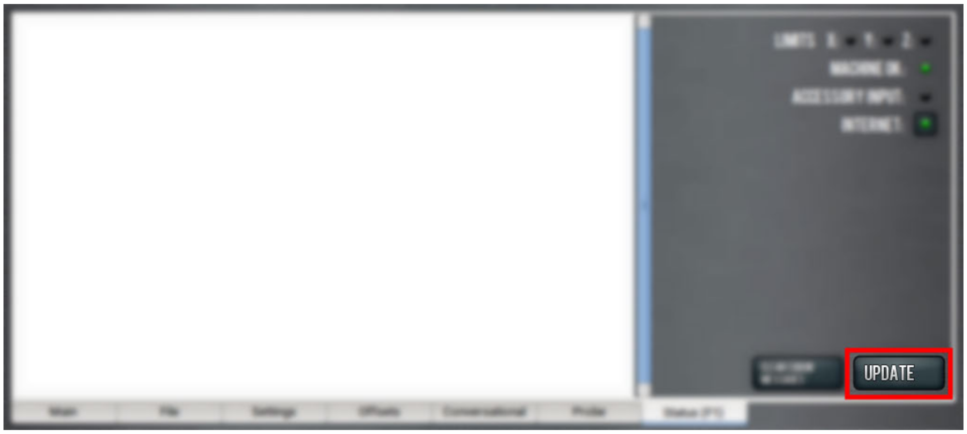
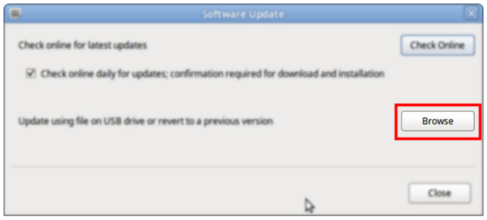

LIMITS X Y Z
MACHINE OK
ACCESSORY INPUT
INTERNET
UPDATE
Main
File
Settings
Offsets
Conversational
Probe
Status (F1)

Figure 7: Update button on the Status tab.

3. From the **Software Update** dialog box, select **Browse**.


Software Update
Check Online
Browse
Close

Check online for latest updates

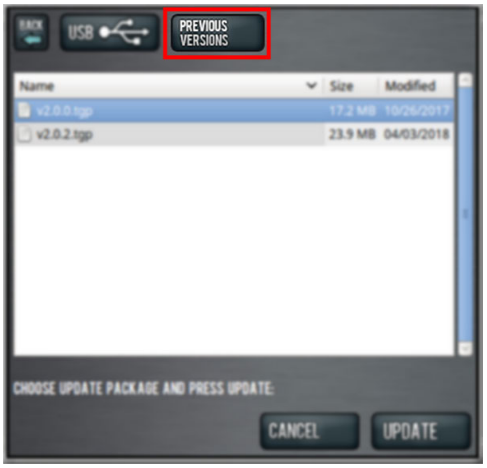
☑ Check online daily for updates; confirmation required for download and installation

Update using file on USB drive or revert to a previous version

Figure 8: Software Update dialog box.

INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

4. From the **Browse** dialog box, select **Previous Versions**.



Name	Size	Modified
v2.0.0.tgp	17.2 MB	10/26/2017
v2.0.2.tgp	23.9 MB	04/03/2018

CHOOSE UPDATE PACKAGE AND PRESS UPDATE.

Figure 9: Browse dialog box.

5. Select the desired update file, and then select **Update**.
   The update file is installed on the PathPilot controller.
6. Follow the on-screen instructions to restart the PathPilot controller.