

Release Notes for PathPilot™ v1.9.4b

Release Date: January 11, 2016

NOTE: Updates do not need to be applied sequentially. Simply download the latest release file to be completely up-to-date on PathPilot operating system.

Bug Fixes:

- #1115: Mill - Homing: 440 or 770/1100 with door switch may ref x in wrong direction if x or y limit already tripped or sw circuit faulty
- #1063: Mill - Conversational: Drill routine fails to post with entries where number of pecks = zero
- #1113: Mill - Conversational Threadmill: Some entries can produce a move small enough that the G64 Q value collapses the helix into a straight line
- #1112: Mill/Lathe - Networking: If currently loaded file is changed via network share and machine is jogging, user must first cancel popup to be able to stop machine
- #1110: Mill - Toolpath Display: Toolpath, program extents, gnomon not updated after probing to set work offsets
- #1087: Mill/Lathe - Save As Dialogue: Changing folders to a folder that already contains files changes the name of the file you are about to save
- #1102: Mill/Lathe - “;Document Path:” in G-code from custom post for Fusion 360™ CAM does not load or preview
- #1106: Mill/Lathe - Save Dialog: If first item in file/folder list is a file, that item’s name will be suggested as the title for the G-code file to be saved
- #1096: Lathe - Conversational: Append to file function is broken in v1.9.3
- #1092: Mill/Lathe - G-code interpreter: File with a numeric O name (i.e., O100) fail to run or generate preview

NOTE: The original v1.9.4 release contained code that was intended to fix an issue where PathPilot would display at the incorrect screen resolution with computer monitor extension cables that were missing the EDID signal pin. Unfortunately, this fix broke the system for users with older computers. This v1.9.4b release removes this code.

Release Notes for PathPilot™ v1.9.3

Release Date: November 4, 2015

Enhancements:

- #824: Mill/Lathe - G-code interpreter enhancement: Add M98/M99 support to PathPilot
- #944: Mill - G-code interpreter: Support for G52 temp coordinate offsets

Bug Fixes:

- #1082: Strange retract behavior in canned cycles
- #1080: Mill - Probing: Divide by zero error on "Find Circ Boss Center" routine
- #1078: Mill/Lathe - File Chooser: Clicking on a file in the conversational Save As dialog should populate the file name field with the selected file name
- #1060: Mill - Door switch: Disable limit switches still leaves X-axis switch active
- #1062: Lathe - Conversational: G59.x offsets not allowed by conversational routines
- #824: Mill/Lathe - G-code interpreter enhancement: Add M98/M99 support to PathPilot
- #1041: Mill - Conversational: Spaces in text cause engraving screen to fail to post, and no error is reported
- #1029: Mill - Conversational: Engrave fails to post with some entries, no error given
- #1032: Mill - Error message upon E-stop intermittently refers to X-axis limit switch error
- #978: Mill - M8 or M9 on the same line as M30 gives error message

Release Notes for PathPilot™ v1.9.2

Release Date: September 1, 2015

Enhancements:

- #1006 Mill - Add ADMIN commands SET_X_LIMIT and SET_Y_LIMIT to set X and Y travel limits. Some machines have travel envelopes that are slightly larger than the specification, and this ADMIN command lets users set travel limits longer than the specification if their machine allows it. Example: ADMIN SET_X_LIMIT 18.25 sets max travel for X axis to 18.25 inches. Standard values for X and Y are 18.0 and -9.5. SET_Y_LIMIT must take a negative value. All values must be in inches.
- #991: Mill - Conversational enhancement: Option to use center of text as work X zero

Bug Fixes:

- #1026: Mill - Probing: Move and set A-axis center button has incorrect/misleading graphic
- #1025: Mill - Tool Table: Units revert to inches in G21 shortly after entering a value
- #1024: Mill/Lathe - ADMIN SETTINGS BACKUP fails to backup mill configuration files
- #1023: Mill/Lathe - G-code Editor: Allow editing G-code when machine is off

Software Update Instructions

NOTE: Updates do not need to be applied sequentially. Simply download latest update file to be completely up-to-date on PathPilot operating system.

1. Download the most recent PathPilot update file (vX.X) at www.tormach.com/updates
2. Transfer this file to a USB drive.
3. Put the USB drive in your PathPilot controller.
4. With the PathPilot controller on and out of *Reset* mode, go to the *Status* screen and click the *Update* button (see **Figure 1**).

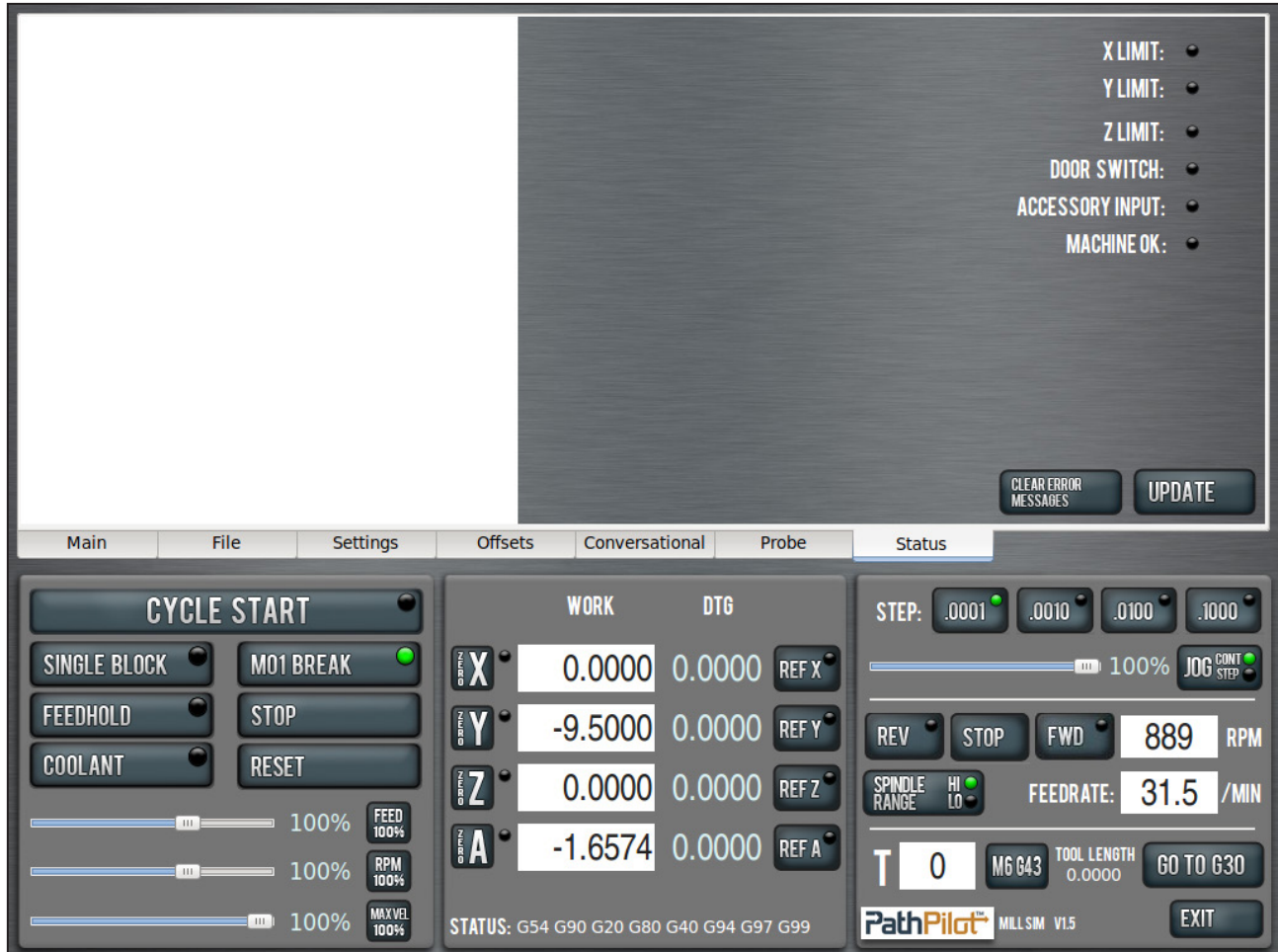


Figure 1

5. Navigate to the (vX.X) file on your USB drive and click *Update* (see **Figure 2**).



Figure 2

6. Push the E-stop button on the mill when prompted and click *OK* (see **Figure 3**).



Figure 3