Release Notes for PathPilot™ v1.9.3

Release Date: November 4, 2015

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.*

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

Service Bulletin

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

Release Notes for PathPilot™ v1.9.1

Release Date: August 20, 2015

Enhancements:

- #616: Mill - Add software support for door switch (hardware kit available shortly)
- #1008: Mill - Conversational: LH option for thread mill
- #991: Mill - Conversational enhancement: Option to use center of text as work X zero
- #806: Mill/Lathe - Allow export and import of tool table, fixture offsets, fonts, thread data

Bug Fixes:

- #1002: Mill - Tool Table: When putting in tool info, hitting return/enter between cells the focus is lost after about a second when you get to the "length" cell
- #564: Mill - Interpreter: Spurious duplicate O word error message on M6 MDI command
- #1014: Mill - Conversational: Internal/External button on Thread Mill tab should clear the thread size drop down and the pitch and dia DROs
- #1015: Mill/Lathe - G-code interpreter: DROs won't zero if a program is stopped between two G5x work offset commands and the second command is followed by a tool change, probing move, or M66 read input command. Workaround: reinstate G5x offset via MDI
- #1007: Mill/Lathe - Recent File Dropdown: Clear Current Program choice removes currently applied tool offset. Workaround: click M6/G43 button (mill) or re-enter tool number (lathe) to re-apply offset after CCP
- #1010: Mill - Conversational: Thread mill with 20 TPI generates a thread with 22 threads per inch
- #982: Mill/Lathe - Tool lengths and diameters in Offsets tab display in inches units even when in G21 until tool information is changed
- #763: Mill/Lathe - ATC and USB IO: USB 3.0 blue ports do not work
- #971: Mill - Conversational Engraving: Zero RPM for use with drag engraver hangs program at first G1 move
- #977: Mill - Probing: Failure probing small diameter circular boss

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SB0046_PathPilot_Release_Notes_1115A
Page 3

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

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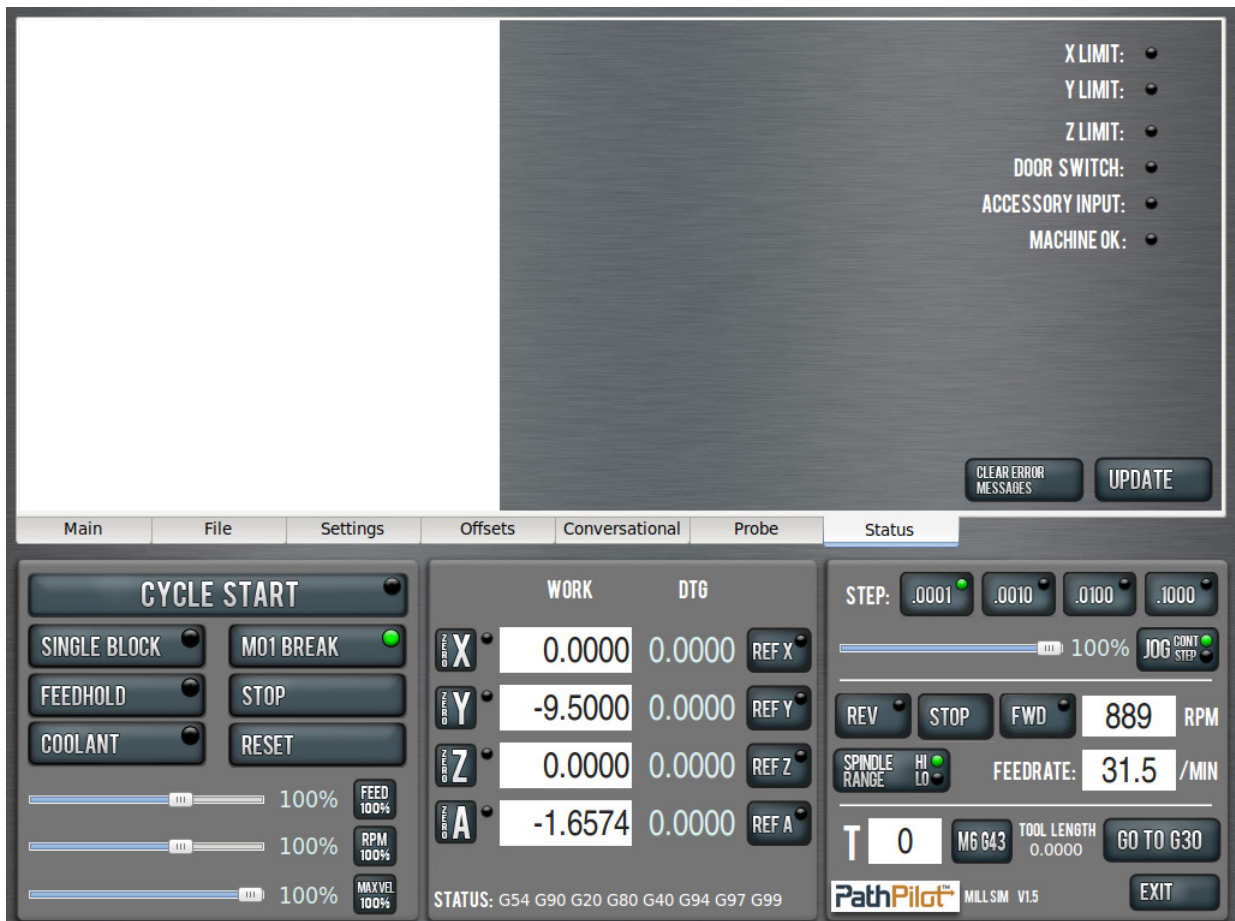SB0046_PathPilot_Release_Notes_1115A

Page 4

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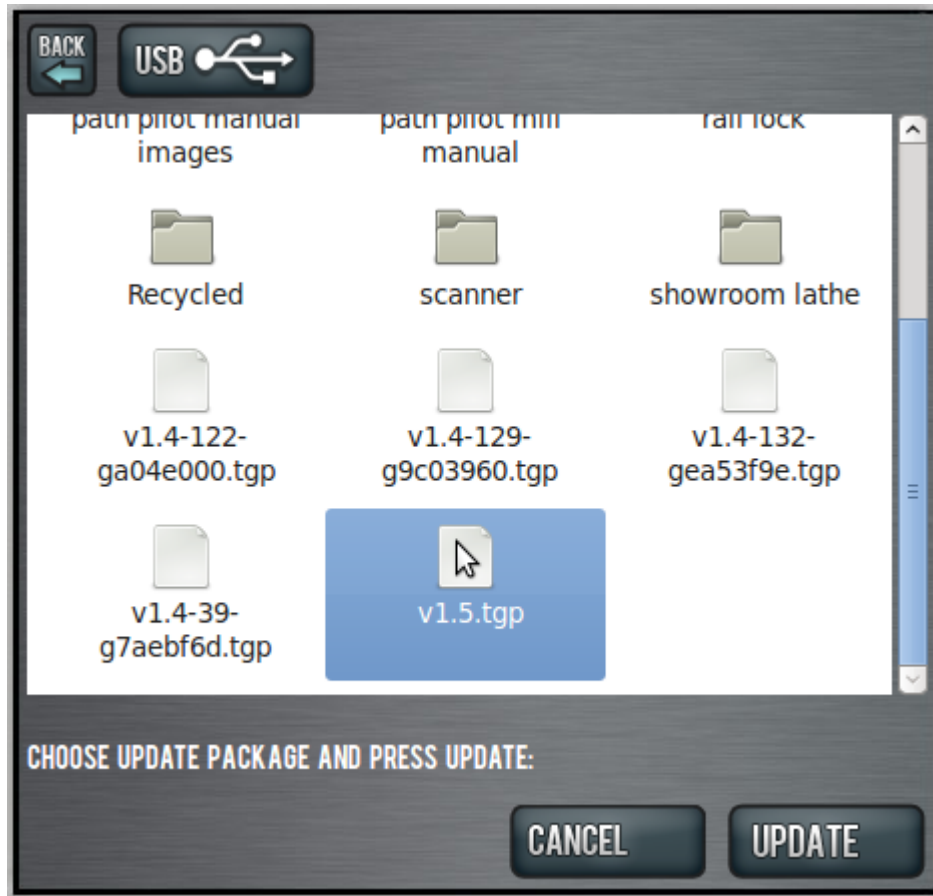

Figure 2

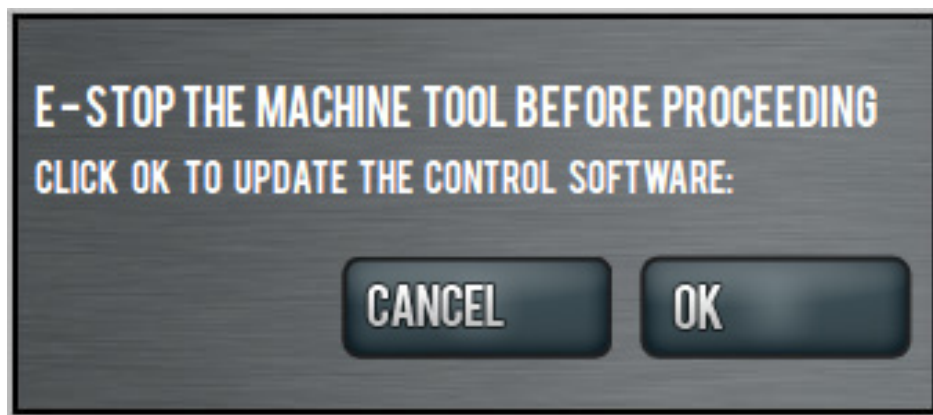6. Push the E-stop button on the mill when prompted and click *OK* (see **Figure 3**).

Figure 3

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SB0046_PathPilot_Release_Notes_1115A
Page 5