RELEASE NOTES

Release Notes for PathPilot v2.1.4

September 2018

ENHANCEMENTS

All

- On the File tab, added functionality to cut, copy, and paste files (PP-995)
- During program execution, added a time remaining clock (which displays above the time elapsed clock) based on the cycle's previous run time (PP-1500)
- The first time Cycle Start is selected for a program, PathPilot now provides a warning message if the program uses tool table entries that haven't been configured (PP-1673)
- Tools used by the current G-code program are now indicated in the Tool Table window — if a tool is used, its corresponding Tool column header becomes shaded (PP-2013)
- On the File tab, the USB Files window now automatically navigates down to the root folder of the USB drive (PP-2059)
- When not using a USB drive, the File tab now resizes to better use screen space (PP-2177)
- Improved logging (PP-2181):
  - After a program stops, the most recently executed G-code line number is now logged in case a program must be restarted from the middle
  - Cycle time and run time are also logged — the run time is the cycle time minus the time that the program paused at line M00 or M01
- Added two new admin commands to adjust the timing of tooltips (PP-2182):
  - `ADMIN TOOLTIP DELAYMS` sets the milliseconds prior to displaying the tooltip (and then again for the expanded tooltip). The default is 1200 milliseconds.
  - `ADMIN TOOLTIP MAXDISPLAYSEC` limits the amount of time the expanded tooltip displays. The default is 15 seconds.
- Added an `ADMIN MOUSE` command to adjust mouse preferences, like pointer speed and right- or left-hand button mapping (PP-2186)
- Added an options menu to the G-Code window so that, while using a touchscreen, you can do things like set the start line, or control the colors of line numbers and G-code (PP-2211)
- To comply with CE standards, we changed the colors of some buttons and LED lights (PP-2224)
- In the logfiles folder, there's now a log file with a history of G-code programs that have been run and their timings, called **gcode_log.txt** (PP-2237)
- Improved support for `LOGOPEN` and `LOGAPPEND` G-code commands, so that the resulting log files are now visible on the File tab (PP-2239)

> **NOTE:** For information, see the <u>LinuxCNC documentation</u>.

- If the current program file is changed and reloaded, the override sliders now maintain their set value (PP-2250)
- The Status tab is now visible while a G-code program is running, so that you can view diagnostic information (PP-2251)

TORMACH®

RELEASE NOTES

Mills

- Added Y tool offsets to the lathe interface when using a RapidTurn (PP-1519)
- Improved the response time when selecting the Conversational tab if there are many font files in the engraving_fonts folder (PP-2170)
- On the Engrave tab, added search capability to the Font list (PP-2172)
- Changed the electronic tool setter (ETS) finish touch off feed rate to 2.5 in./min, regardless of the initial feed rate (PP-2201)

FIXED ISSUES

All

- We fixed issues where:
  - A very brief limit switch trigger put the machine into reset, and didn't display an error message on the Status tab (PP-1671)
  - When using M98 for looping, the current and next highlighted lines in the G-Code window were sometimes incorrect (PP-1975)
  - The Font list didn't correctly scroll with keyboard navigation (PP-2171)
  - If a font was removed or added to PathPilot while the conversational programming's Engrave tab was visible, the currently selected font wasn't preserved (PP-2174)
  - After renaming a file or folder name, the newly named file or folder wasn't automatically selected (PP-2180)
  - If the onscreen keyboard was displayed when a file was changed, the prompt to reload the file was hidden, so it looked like the interface was locked (PP-2188)
  - When posting a file using conversational, the title wasn't used as the default file name (PP-2207)
  - Changing from G20 to G21, followed by a G30 command, could have resulted in an incorrect location used for G30 (PP-2208)
  - When frequently using the Conversational Edit dialog, PathPilot performance slowed (PP-2215)
  - G7x canned cycles didn't obey exact path mode during cycles (PP-2238)
  - When setting the work offset (by selecting a Zero button, or entering a command in a DRO field), the entry didn't immediately update the Work Offsets table (PP-2244)
  - If the work offset was changed, the display in the Tool Path window didn't immediately redraw (PP-2245)

Mills

- We fixed issues where:
  - A circular pocket less than two times the diameter of the tool couldn't be created using conversational programming (PP-1987)
  - When importing a .csv tool table, the diameter was divided by two (PP-2205)
  - When using an automatic tool changer (ATC), a tool pick up position could be set before referencing the Z-axis (PP-2221)
  - If tool parameters were changed directly by a G10 command, they didn't display correctly in the Tool Table window (PP-2240)
  - If changes were made to tools 1 through 256 in the tool table, and the controller unexpectedly restarted, the changed values weren't retained (PP-2233)
  - After selecting Start Scan, the scanner sometimes took minutes to start (PP-2219)
  - In 770M RapidTurn configurations, there were rare amplifier fault errors (PP-2223)
  - Tool number 1000 couldn't be entered into the Tool DRO field, because it was limited to three digits (PP-2209)

RELEASE NOTES

Lathe

- We fixed issues where:
    - The manual tool change message didn't clear from the Tool Path window after selecting Cycle Start (PP-2191)
    - In some conditions, the lathe G7x remap code generated exceptions and errors on load (PP-2229)
    - The command `ADMIN RESET_SOFT_LIMITS` didn't correctly function (PP-2126)
- We now consistently treat pressing **ESC** on the keyboard as a shortcut for the Stop button in lathe and RapidTurn configurations (PP-1495)

RELEASE NOTES

Manage PathPilot Versions

> **NOTE:** You don't need to install updates sequentially. Install the latest PathPilot update file to be completely up-to-date.

To update and manage versions of PathPilot on the controller, you can do any of the following:

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

2.1 DOWNLOAD AND INSTALL AN UPDATE FILE

> **NOTE:** Downloading and installing an update file requires an Internet connection. From the PathPilot interface, make sure that the Internet button LED light is on.
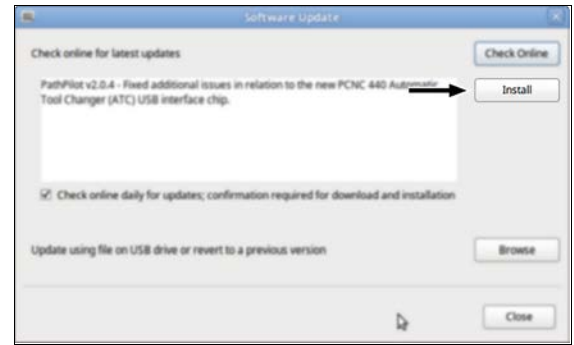
1. Make sure that the PathPilot controller is powered on and out of **Reset** mode.
2. From the PathPilot interface, on the **Status** tab, select **Update**.

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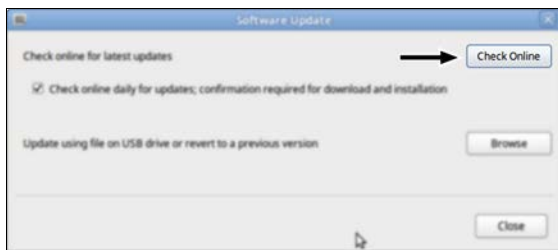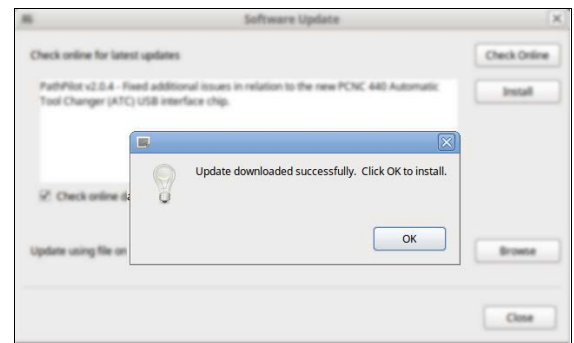

4. Select **Install**.

The update file is downloaded.

5. From the dialog box, select **OK**.

The update file is installed on the PathPilot controller.

6. Follow the instructions on the screen to restart the PathPilot controller.

2.2 INSTALL AN UPDATE FILE FROM A USB DRIVE

1. From tormach.com/pp-updates, download the most recent PathPilot update file.
2. Transfer the PathPilot update file to a USB drive.
3. Insert the USB drive into the PathPilot controller.
4. Make sure that the PathPilot controller is powered on and out of **Reset** mode.
5. From the PathPilot interface, on the **Status** tab, select **Update**.

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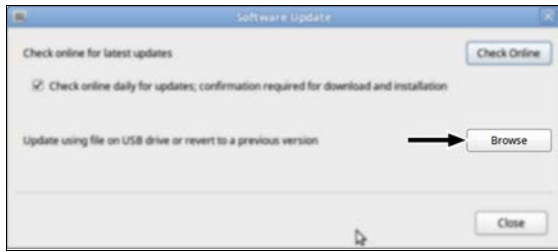
7. From the **Browse** dialog box, select **USB**.

8. Select the desired update file. Then, select **Update**.

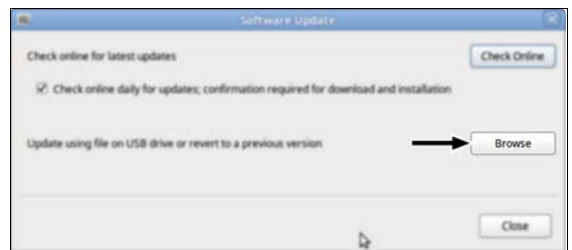The update file is installed on the PathPilot controller.

9. Follow the instructions on the screen to restart the PathPilot controller.

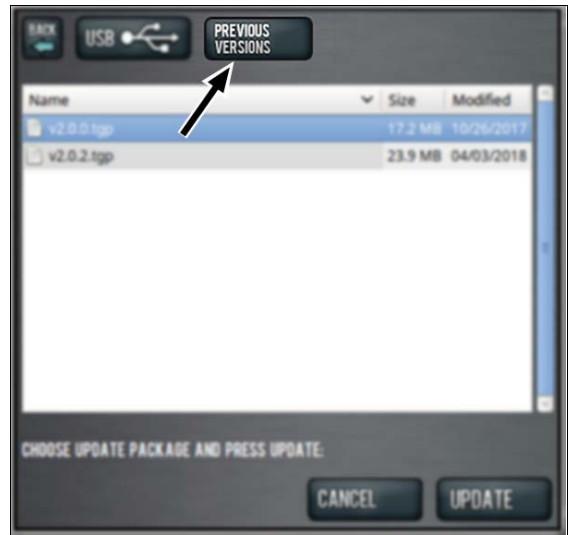## 2.3 INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

1. Make sure that the PathPilot controller is powered on and out of **Reset** mode.

2. From the PathPilot interface, on the **Status** tab, select **Update**.

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

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

5. Select the desired update file. Then, select **Update**.

The update file is installed on the PathPilot controller.

6. Follow the instructions on the screen to restart the PathPilot controller.