

## RELEASE NOTES FOR PATHPILOT V2.5.1

May 2020

### ENHANCEMENTS

- We optimized the tools used to draw the tool path preview to reduce the loading time for G-code programs. (PP-2583)
- You can now keep subroutines in the same folder as the .nc file. Previously, they had to be in a **subroutines** folder. (PP-2697)
- On M+ and MX mills and the 24R router, you no longer have to set the Electronic Tool Setter (ETS) nose reference after each time you reference the Z-axis. (PP-2742)
- We rearranged the contents of the **ETS Setup** tab (on the **Probe** tab) to improve the user experience. (PP-2768)
- A G30 command now moves the Z-axis before moving the X- and Y-axes . Previously, it did a single, coordinated move of the X-, Y-, and Z-axes. (PP-2778)
- To measure tool lengths using an Electronic Tool Setter (ETS), we added a **Z only** checkbox to the **ATC** tab. (PP-2807)
- Selecting a line in the **G-Code** tab now highlights the corresponding section of the part's geometry in the **Tool Path** display (and vice versa). (PP-2833)
- When you open a .txt file, it now opens in the text editor. Previously, it tried to load as a G-code program. (PP-2835)
- We installed the Realtek 8812AU driver, which is required for certain WiFi adapters. (PP-2839)
- The Electronic Tool Setter (ETS) Z minus speed is now limited so that, in the case of an unexpected ETS trip, it travels a maximum of 4 mm before coming to a controlled stop. (PP-2864)
- When you reload a G-code file, it now retains your previously set G-code view options. Loading a new G-code file still resets the default options. (PP-2854)
- We reworked the **Rect/Circ** tab (on the **Probe** tab):
  - We changed the buttons from **Find Center and Set Origin** to **Find Center**, and we added radio buttons to control when to set the origin and when to just display the results. This means that you now can find the center without also changing the origin. (PP-2856)

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- We added a DRO field that displays the dimensions of the most recently used probe function, like the diameter of a circular boss or the distance between two X positions. (PP-2580)

## Mills

- We added support for CE-marked M and MX mills.
- To adjust the operator console's touch screen sensitivity in humid environments, we added the command **Admin Touchscreen Sensitivity**. (PP-2855)

## Router

- You can no longer use an M4 (spindle reverse) command in a G-code program, which could cause premature wear on certain machine components. (PP-2838)

## FIXED ISSUES


- We fixed an issue where probes retracted from the effective probe coordinate (with tip radius compensation) rather than the actual probe tip coordinate. (PP-2792)
- If the probe input changed during a probing move, PathPilot incorrectly displayed a message attributing the error to a tool setter input change. We edited this message. (PP-2800)
- We fixed an issue where Fusion 360 probe subroutines didn't correctly apply extended work offsets in G21. (PP-2885)
- When using a CNC scanner, the **Post to File** button on the **Scope** tab (within the **Scanner** tab) didn't work. This has been fixed. (PP-2867)

## Mills

- Previously, when the spindle stopped on a PCNC 440, there was a long delay before it restarted. We shortened the pause. (PP-2777)
- On the **Settings** tab, in the **Accessory Input** section, we edited the text on the **Active Probe** selection to include the Electronic Tool Setter (ETS). (PP-2804)
- Previously, conversational pocketing routines had a divide by zero exception. This has been fixed. (PP-2878)
- We fixed an issue where the 4th axis selection (on the **Settings** tab) persisted through power cycles, but the 4th axis scale settings didn't correctly apply when the machine powered on. (PP-2861)
- On machines with a microARC 4 installed, adjusting the **Maxvel Override** slider changed the speed values to those used with the 6 in. and 8 in. 4th axes. The values for the correct 4th axes are now retained. (PP-2891)

# RELEASE NOTES

## MANAGE PATHPILOT VERSIONS

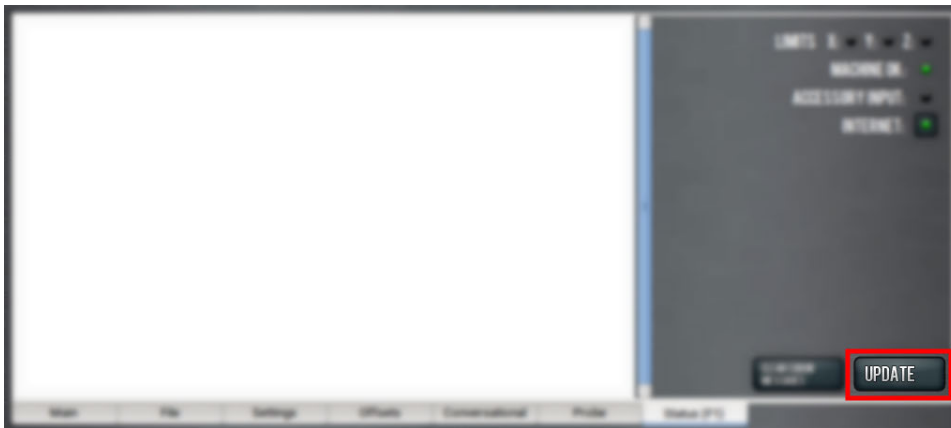
 **Note:** To update PathPilot on a CE machine, you must first confirm that the machine is in setup mode.

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)

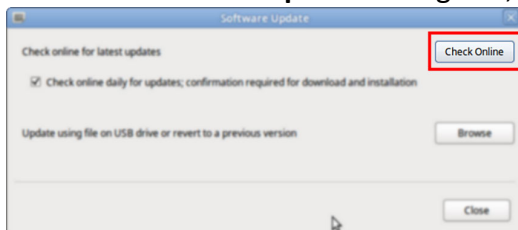
### DOWNLOAD AND INSTALL AN UPDATE FILE FROM THE CONTROLLER

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**.



*Figure 2: Software Update dialog box.*

4. Select **Install**.

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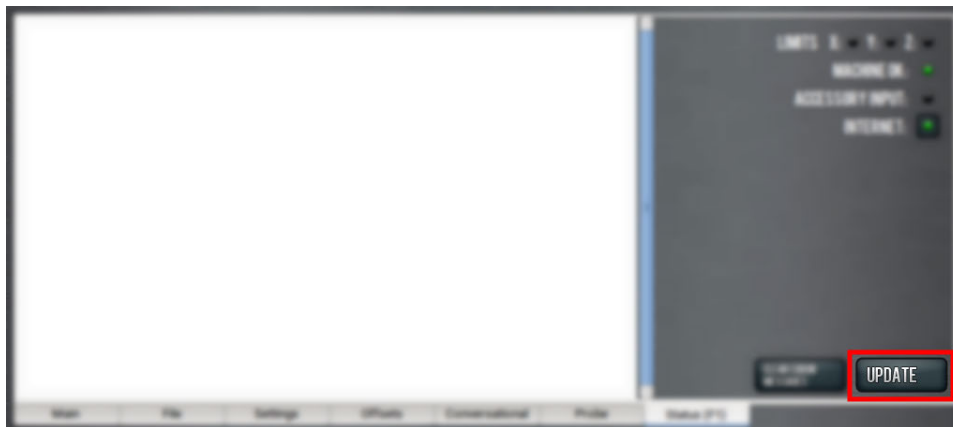
**Figure 3: Install button on the Software Update dialog box.**

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.

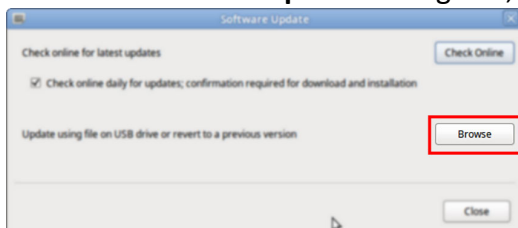
## INSTALL AN UPDATE FILE FROM A USB DRIVE

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**.



**Figure 4: Update button on the Status tab.**

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



**Figure 5: Software Update dialog box.**

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

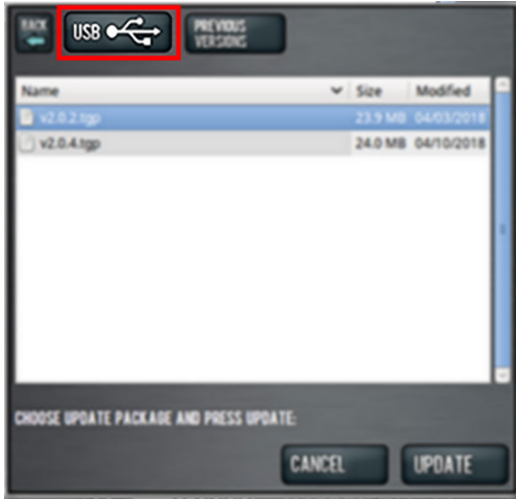


Figure 6: Browse dialog box.

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

## INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

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

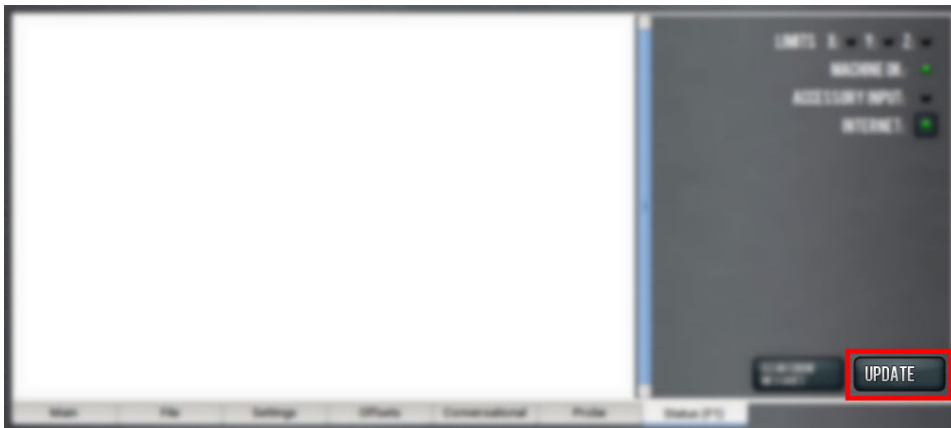


Figure 7: Update button on the Status tab.

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

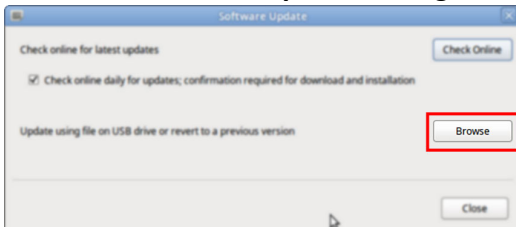
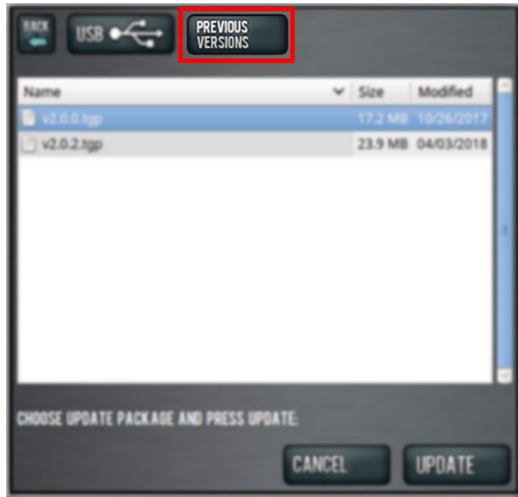


Figure 8: Software Update dialog box.

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



*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.