

## RELEASE NOTES FOR PATHPILOT V2.8.3

September 2021

### ENHANCEMENTS

#### Mills and Routers

- For some setups (depending on the machine configuration and the model of the tool setter), we reduced the Z traverse feed rate in the G37 / G37.1 tool touchoff sequence. This reduces the risk of damage due to an incorrectly set G37 Z position. (PP-3291)

#### Mills

- We improved collision avoidance when using long tools in Automatic Tool Changers (ATCs). Previously, after a tool change, the final Z position was set to whichever was higher between G30 Z and tool change Z. Now, the Z position is saved at the beginning of a tool change, and later restored after the tool change is complete (if it's above the tool change height position). (PP-3286)

**Note:** To toggle this behavior on or off, use the following commands in the MDI Line DRO field:



```
ADMIN ATC M6_EPILOG_RETRACT ON  
ADMIN ATC M6_EPILOG_RETRACT OFF
```

#### xsTECH

- The noise made by the axis motors on xsTECH routers is now quieter. (PP-3256)

### FIXED ISSUES

#### All

- We added updated graphics drivers for improved OpenGL performance on newer PathPilot controllers (Rev C). (PP-3279)
- We fixed an issue with very small G02 and G03 arcs and cutter compensation where, in some situations, the compensated arc used the wrong number of full turns. (PP-3278)
- The jog mode button's LED now reflects the current keyboard jogging mode. Previously, using the jog shuttle or console pendant could have side effects such that selecting the jog mode button appeared to have no effect in toggling the LED. (PP-3300)

## Mills

- We fixed an issue with M98 subroutines/looping where the loop count was intermittently wrong after a program abort. (PP-1969)
- G30 now accepts an intermediate axis position in incremental (G91) coordinates. This makes it easier to retract individual axes. Previously, intermediate Z moves had to be to an absolute position. (PP-3273)

### EXAMPLE



```
G91 G30 Z0  
G90
```

**Code breakdown:** Move incrementally zero units in Z (no motion), then rapid in Z to the position specified in parameter 5183 (no other axes move).

## Lathes

- We fixed an issue where, in some situations while using a console, cycling through jog axes from X to Z on the pendant reported a false error message that the maximum jog speed for the (non-existent) Y-axis was missing. (PP-3288)



**Note:** This issue didn't affect keyboard jogging on the console.

## 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**.

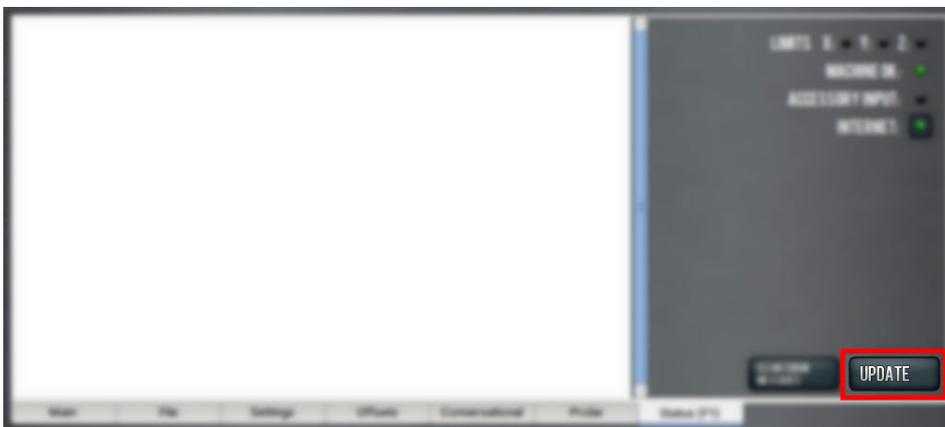


Figure 1: Update button on the Status tab.

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

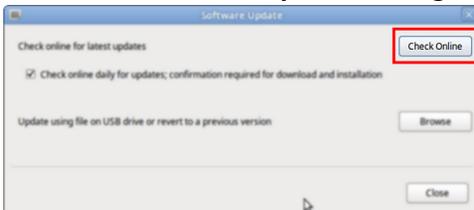


Figure 2: Software Update dialog box.

4. Select **Install**.

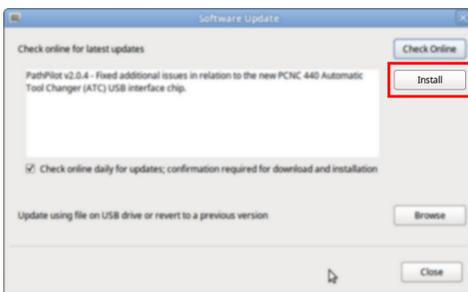


Figure 3: Install button on the Software Update dialog box.

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

# INSTALL AN UPDATE FILE FROM A USB DRIVE

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**.

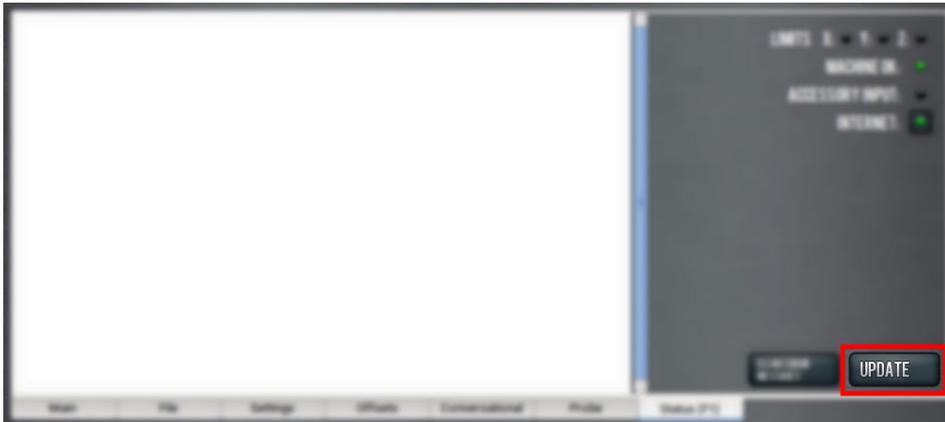


Figure 4: Update button on the Status tab.

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

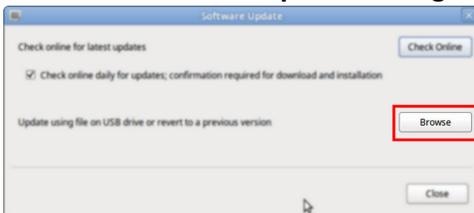


Figure 5: Software Update dialog box.

# INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

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



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**.

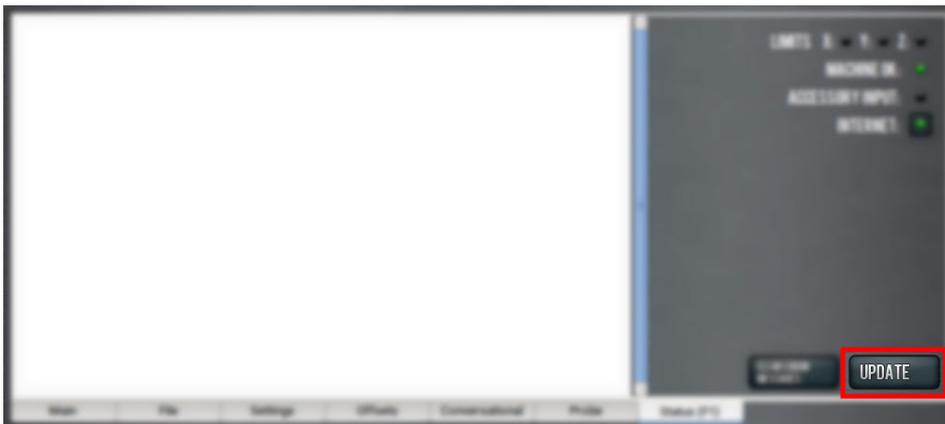


Figure 7: Update button on the Status tab.

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

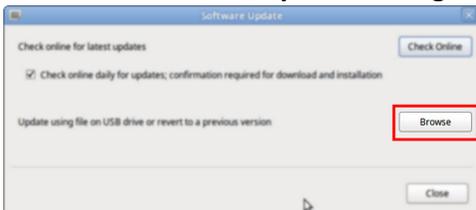
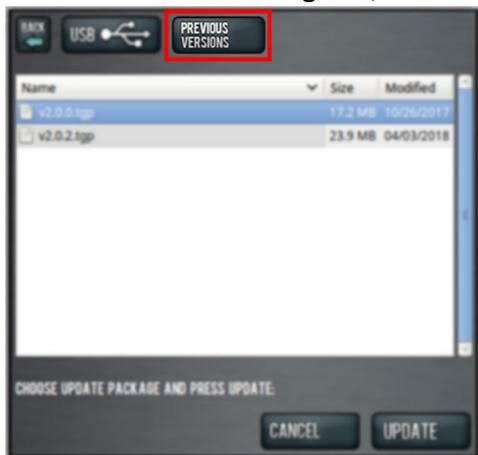


Figure 8: Software Update dialog box.

# INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

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.