Title: PCNC 1100 Series 3 Machine Control Software Installation and Revision Information

Date: August 2013

Current Software Install Release: Rel 1.1

Product Identification: PCNC 1100 Series 3 Mills and pre-Series 3 mills with Series 3 upgrade kit installed

Subject: Specification: This document is to track rev changes to Mach 3 for PCNC1100 Series 3 machines. This document covers both Series 3 machines and older models with the Series 3 upgrade kit installed.

General Instructions:

1. Download from http://www.tormach.com/downloads.html, page down to the "PCNC 1100 Machine Control Software" section, and select **PCNC-1100M3-3 Relx.xx.exe**.
2. Run the executable.
3. Reboot the computer after installation.
4. Attention Duality Lathe owners. Updating your mill software will require you to update your lathe software as well. The download for lathe can be found listed with the mill downloads on our website.

Upgrade Instructions:

1. The new installation will delete the contents of the C:\PCNC3 folder. If you have files that you want to preserve in this folder, save them to a different directory before installing the new software. For example, if you have saved G Code files in the C:\PCNC3\GCode folder make sure to save them to a different location if you want to access them after the install.
2. The installation will also overwrite any fine tuning you have done with spindle speed calibration, touch probe polarity, or jog shuttle configuration. This is detailed in chapter 9 of the owner's manual.
3. Copy the new downloaded installation file to the desk top.
4. Double click the new icon and follow the instructions.
5. Re-boot. THIS IS MANDATORY!
6. If you have a Tormach Machine controller, the machine control software (Mach 3) should come up automatically when the computer powers on. Otherwise, to launch the new version of Mach3, click on the PCNC icon with the name "PCNC1100M3 – 3". Icons associated with previous versions of Mach 3 will not function properly and should be deleted.

7. If the Mach 3 software was not launched at computer power up, then you may wish to update the "Startup" folder with this newest version. On most systems the "Startup" folder can be found here: c:\Documents and Settings\user (… or mill operator)\Start Menu\Programs\Startup\. If the Startup folder is not found at this location, do a search on the hard drive for this folder.

Changes made to Mach 3 with PCNC1100-M3-3 Rel 1.1

- DROs on offsets screen will now accept negative numbers
- Newfangled wizards updated to current version (2.86)
- Added support for Procunier tapping head to settings screen
- Changed M990 initialization macro to better handle starting in metric mode (G21)

Changes made to Mach 3 with PCNC1100-M3-3 Rel 1.0

- You no longer need tool zero to be active before editing the tool table
- Updated version of Notepad++ will work with Windows 7
- Updated version of PCNC config with options to change probe logic (active high versus active low) and configure 4th axis homing
- Reset now takes system out of feedhold
- Fixed bug in probing routines that may have caused unwanted Z movement if users forgot to select tool 99 (probe) before running probing routines
- Reset button now fixes apparent jog shuttle freeze caused by inadvertent pause or spacebar press
- Support for Windows Vista added
- Updated Jog Shuttle dll respects Jog Status LED
- Removed Stop button from screenset, replaced with Program Reset button so that stopping a program during a rapid move no longer results in position loss.

Prior Changes: Refer to Technical Document TD31108

SPECIAL ITEMS TO NOTE:

- Users with a Duality Lathe: You must install companion release PCNCDualityRel2.2b.exe for the lathe. VB changes in Mach3 require an update in the lathe application to avoid errors in the threading Visicycles.
- Any non-Tormach plugins you use must be updated. The internal interface to Mach3 has changed and your plugin author must recompile to be compliant to Mach3 V 3.042.xxx.