

Version 2.0.5

- Added support for alpha characters in program name.

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Enhancements:

- Added ability to retain tool offsets between programs, new rules are as follows:
 - 1) When opening a GCD program, we will now always prompt the user if he wishes to keep his existing tool table with offsets and modifiers.
 - 2) When opening a PT4 program, we will now compare the tools in the tool table to the tools saved in the program. Here are the different scenarios possible:
 - a) If a tool # exists in the tool table, but not in the program, we will now keep the one in the table as is, with offset and modifier.
 - b) If the tool diameter and description from the tool table match what is in the program, we will keep the existing offset and modifier.
 - c) If the tool diameter and description from the tool table do not match what is in the program, we will wipe out the offset and modifier, and prompt a new warning message stating that we've done so.
 - 3) Regarding Open / Save TEMP, it should work mostly the same as before.
 - a) If a tool entry exists in the TEMP file, it will always replace whatever is in current tool table, offset and all. In the event that we are replacing a tool with the same diameter and description, but a different offset, we will warn the user that we are replacing the offset.
 - b) If a tool entry exists in the current tool table, but not in the temp, we will leave the one in the current table intact.
 - 4) We will no longer erase the tool table when the user erases the current program in memory.
- Implemented MULTI PART, FIXTURE OFFSETS, and WORK COORD screens. (See use case doc for how this works).
- Fixed various labeling errors regarding our MULTI PART / SHIFT scheme:
 - The shift numbers in the MULTI PART screen now start with 0 as the base part. Shift #1 should represent the first instance of a shift occurring, much like a repeat.
 - When starting in the middle of a program, it will now prompt for Shift #, as opposed to Fixture #.
 - The top of the RUN screen now displays SHIFT # as opposed to Fixture #.
- Added the ability to program the spindle in reverse for all events. Press the ? soft key while highlighting the RPM prompt.
- Reworked service code 1 and 319, to make it more like the M11 version.
- Added service code 444, as well as crash report software. This will generate a log and be saved within code 1 in the event that the software crashes unexpectedly.
- Code 128 now allows user to switch between inch and metric.
- Code 123 now allows user to load default calibration values for each axis individually.
- Added ability to start at pass # or finish cut for Thread Mill event.

Fixes:

- Fixed Run mode and Tool Loading mode so that the green tool unclamp button will always work when the door is open.
- Fixed intermittent issue where code 503 would not have the correct default of 500ipm max feedrate.
- Fixed an issue where after tool changes, the Z would not rapid to the correct safety height. Was noticeable when the Z safety was set close to the Z abs 0.
- Fixed an issue where tapping at higher rpm's would intermittently tap at a much smaller depth than what was programmed.
- Fixed Tool Table page such that tool types ≥ 10 can now be entered.
- Fixed problem with lube pump logic, if running a program that is longer than the cycle time set within code 300, the pump will keep discharging every few seconds after the first discharge.
- Fixed issue with the Load Tools screen flickering if the spindle was turned.

- Fixed offline software to now emulate tool changes when run.
- Fixed offline software where previous versions would always give soft limit errors when attempting to draw a Tool Path.
- Fixed issue where opening a file of the same name would cause the DRO to lose its ABS 0.
- Fixed a scenario where code 300 would remain drawn on top of the screen when user would MODE out.
- Fixed scenario where starting in the middle of a GCD program would cause the Z axis to rapid up to the top limit.
- Fixed a couple of scenarios where if a tool change was interrupted due to some other fault, it would only display a Y axis soft limit error.
- Fixed issue with Repeat counter was not displaying the correct # that the machine was currently running.
- Changed behavior such that if door is opened during a Tap event, the tap will continue to run until it is complete, and then stop. User must press E-STOP if he wishes to stop in the middle of a Tap.
- Fixed issue with SAVE TEMP not saving the offsets for a GCD file.
- Fixed a scenario where the Z axis would be rounding corners while rapiding up and over in between moves. Was found while running an engraving GCD program.
- Fixed issue within Tool Table where scrolling through the tool type would be very slow to draw.
- Fixed issue where user was not able to use handwheel to scroll forward from event 0.
- Added a limitation to the size of GCD files that can be opened to 20MB.
- Fixed issue where a program brought in from a PT7 was applying a diameter modifier to the tool. Diameter modifiers will now be ignored.
- Fixed issue where a Tap event saved on the 2op was not able to be opened properly on other ProtoTRAK controls.
- Fixed issue where END AGE and ABORT AGE were missing when editing an Irregular pocket or profile.