

Version 1.5.15

- Fixed scenario where starting a program may have slowly fed towards the part instead of rapid.
- Fixed issue where 8 tool turret would not home itself correctly on all lathe machine ID's.

Version 1.5.14

- Fixed issue where running a Cycle event with an 8 tool turret may have resulted with the axis feeding to an unknown position.
- Fixed issue with service code 122 not accepting calibration values.
- Fixed issue with Drill event displaying Feed Per Tooth instead of Feed Per Rev.

Version 1.5.13

Fixes:

- Updated EPA content on both mill and lathes
- Added functionality to Service Code 535 for backlash limits and negative home offsets for 8 tool turret.
- Added support to emulate 8 tool turret for offline software.
- Added "Please Wait" message for 8 tool turret homing routine

Known Issues:

- GCD option is not available yet.
- Run Time Estimator has some known issues.
- Threading away from the chuck is not supported in this build yet.
- Very intermittently, one or more of the axis in DRO screen may either freeze or not draw correctly. Note that when this happens, the machine will still run properly and keep track of its position, it is simply not displaying it properly. This has been fixed and will be released in a future version.
- If the turret generates a fault, the error message displayed will refer to it as the "Y" axis.
- Running a thread on offline or demo box may fault out at times. Not an issue on the machine.

Version 1.5.12

- Merged a few minor fixes to calibration service codes.
- Fixed scenario where changing tool type in tool table would incorrectly update the DRO to the tool that was being changed.
- Message log entries has new line character when logging update runtime and gdi hide popup messages. This causes log viewer to popup a confirmation window for each entry.

Version 1.5.11

- (For mill offline and demo) Put the missing BASE label back in second row of tool table
- Fixed conrad/chamfer default setting, was not working correctly in prior versions
- Fixed issue where turret homing is waiting for spindle to come up to speed (after e-stopping while the turret had motion).
- Fixed scenario where losing air pressure with turret on DRO aborts out and gives wrong error message.
- Added new Power Reset logic. User will be prompted what to do when attempting to enable servos.
- Fixed issue with starting at finish pass of CSS groove event did not run at the correct RPM.

Version 1.5.10

- Updated door open logic for all USA and Euro lathes.
- Fixed scenario where user would see Y limit alarm when dual input limit switches were enabled.
- Fixed scenario where inserting a cutoff event from clipboard did not offset event correctly.
- (offline and demo) fixed issue with XY arcs not being drawn on the proper plane.
- Fixed scenario where the flashing warning button on the info tool bar does not go away if the ESTOP button is released.

Version 1.5.9

- Fixed some cases that caused service code 316 to not update correctly.
- Updated Tool Setup screen, when using turret user will be prompted to move to turret position.
- Fixed scenario where turret fault message was not visible to user.
- Turret is now not able to run until it is properly homed.
- Fixed scenario where soft keys did not work if aborted out of service code 510.

Version 1.5.8

- Fixed scenario where if air is lost during run, spindle will be disabled but motion will continue.

Version 1.5.7

- Added support for machine ID's 108 and 109.
- Fixed issue where electronic handwheels did work while in Do One Thread Repair
- Fixed issue with tapping algorithm ignored latheDecelTime config parameter
- Fixed so that Traking will work regardless of what options are available on options key.

Version 1.5.6

- Updated the layout of status bar fields.
- Fixed issue where Run Start At Event with large GCD times out. Changed how time out works and now sending communication between slave and master when processing.
- Fixed issue where EHWs did not work during chip clear.

- Fixed issue with vestigial small handwheel motion after Do One.
- Fixed scenario where switching between CSS and RPM and CSS again will not run at the program CSS speed for the last event. This happens onreference program for this issue.

Version 1.5.5

- Original Release