2op TMX model M11

Version 3.13 Release Notes
- Fixed issue with service code 81 where the buttons and led's would not light up correctly when pressed.

Version 3.12 Release Notes
- Fixed issue where if the hyphen were typed in program name it would insert it at the beginning.

Version 3.11 Release Notes
- Fixed intermittent scenario where in DRO the EHW axis led would not correctly match the axis that is currently in control.
- Fixed issue where in DRO one of the positional axis displayed may disappear.

Version 3.10 Release Notes
- Added ability in PROG and PROG I/O to support alpha characters in program names.

Version 3.03 Release Notes
- Updated service code 510 to support machines with 10k spindle.

Version 3.02 Release Notes
- Fixed scenario where some machines with 10K spindle were not getting up to speed when going from low RPMs to 10K RPM. Changed the time out time from 5 to 7 seconds.

Version 3.01 Release Notes
- First official release that supports 10k 2op machines.
- Added support for newer servo drives, where they may take longer to power up from a cold boot. Symptom was that the user would turn on his machine, enable servos and then see a servo fault message. Previously our software was only allowing 3 seconds to power on, but now we will wait up to 5 seconds, and display a message so the user knows what is happening.
- Fixed issue where newer front panels were not initializing the led's correctly. The symptom would be that a user booted his control, and the led's would not turn on at all until the user pressed any button.
- Fixed scenario when running GCD programs with M333 enabled, the user may sometimes see a fault 207 "The system has timed out while trying to decelerate into position".

Version 2.00 Release Notes
- 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.

- Fixed various labeling errors regarding our 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 occuring, 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 #.
- Removed previous restriction of not being able to run programs larger than 1000 events.
- Added flashing warning message if spindle or feedrate override is dropped to 0%.
- Added code 400 for foreign language support.
- Added ability to switch between inch / mm in code 123.
- Fixed multiple screen modes where the green unclamp button would not respond.
- Fixed an issue found when turning the EHW during Page Fwd / Page Back transition, it would draw the event incorrectly or jump to the beginning / end of the program.
- Fixed a scenario found in Tool Loading where the picture showing which locations had a tool were not being drawn properly.
- Fixed the scenario where if using factory defaults, the ATC would run into a limit when attempting to bring the ATC to the front.
- Fixed the tool description green message box so that all the tool descriptions are now visible.
- Added a status bar in code 319 to clearly show whether logging is on or off.
- Fixed issue where starting in the middle of the program would cause the Z axis to rapid to the top limit unexpectedly.
- Fixed a case found where defining a ramp entry on certain pocket programs would cause the tool to gouge the part outside of the pocket's defined boundary.
- Fixed issue with Repeat # counter not displaying correctly during RUN mode.
- Fixed issue with lube pump discharge time not being properly remembered across shut down.
- Code 132 was previously incorrectly displaying the EHW counts from -99 to +99, and then would roll over.
- Fixed issue with Thread Mill event would sometimes skip the finish pass.
- Fixed some cases where a steep thread mill or helix would not run at the correct feedrate.
- We will now not allow program to open if it contains mulitple fixtures.
- Fixed compatibility issues with tap event saved on the TMX would not properly open on other machines and vice versa.
- Fixed issue with not being able to define a negative value in the X or Y dimension from ball lock.
- Fixed a scenario where entering a shift offset for a program, and then going into Tool Path would cause the software to shut down unexpectedly.
- Fixed issue with tool #'s not being highlighted in the tool table page after opening a GCD program.
- Fixed scenario found where entering a negative tool diameter for some GCD programs would cause part of the program to be skipped during RUN mode.
- Fixed issue with SAVE TEMP not saving the shift offsets with a GCD program.
- Fixed issue where SAVE / OPEN TEMP would only restore the tools that were included in the program. All tools from the table are now carried over.

- Changed default lube pump settings from 7 seconds every 60 minutes to 4 seconds every 30 minutes. Updating software will revert settings to the new defaults.
- Fixed issue where opening a PT4 program that contained fixture offsets would carry over as shift offsets. They will now be ignored.
- Fixed issue with code 505 sometimes not displaying the correct Z position relative to machine Home.
- Fixed issue found where if user opened door, and pressed START and then TRAKing within the right timing sequence, the next time he would attempt to TRAK would result with the machine behaving as though it were in CNC RUN mode.
- Fixed a scenario found where running a large GCD program would skip the last several blocks of code.
- Added more message prompts to show status update when processing a large GCD file. Larger files can take longer than 30 seconds to process, and some users have believed that their systems have "locked up".
- Fixed a memory leak that was found. Was not apparent unless user was running a program over and over for several days nonstop without resetting the computer.
- Corrected the instructions in service code 520 when defining the tool change locations.
- Fixed a scenario where in TOOL LOADING, if the ABS SET button was unnecessarily pressed during the YES / NO prompt, it would cause some unexpected movement from ATC.
- Fixed a scenario where aborting a TOOL LOADING operation would cause the system to not properly recognize which tool was currently in the spindle.
- Implemented Fixture Offsets and Work Coord pages.
- Fixes issue where after adding an event to an AGE pocket or profile, the tool data would become erased for that particular tool #.
- Updated the green messages in the Tool Loading screen to remove the mention of pressing ABS SET during tool changes.
- Fixed an issue where sometimes when using the handwheel to page back, it would not display the last event of the current program, and instead skip to the second to last event.
- Fixed an intermittent issue found where adjusting the feedrate override during tool changes would result with an axis runaway scenario.
- Fixed issue where enabling M333 during tool changes would result with the axis moving very aggressively, and possibly fault.
- Starting in the middle of a gcode program will now check to see if M333 was previously enabled and run accordingly.
- Fixed issue with the SHIFT # not being displayed at the top of RUN screen while using MULTI PART feature.
- Fixed issue in PROG I/O with the bottom row of files not being fully visible.
- Changed the message prompted when a GCD program is open, to make it clearer that we are asking if they wish to keep their Tool Table Offsets.