RX RELEASE NOTES

Version 2.0.1

Bug Fixes:
> G81 and G82 Not working with Verify
> Fixed a rare case where Z axis would slowly creep into position on VMC7
> Offline software does not launch after recent Windows 10 update
> Delayed display of Error 263 by 1.5 seconds so that the user can identify if Spindle turned on properly
> Fixed scenario where machine would run an extra finish pass that was not defined
> Fixed issue where face mill makes too many passes
> Made change so that Circle pocket does not skip tool change for finish cut
> Fixed scenario where Z axis plunges down in between multiple passes in Profile events
> Spindle fails to turn on after Tool Change and STOP or RSG are used
> Fixed some cases where Depth per pass not calculating correctly
> Fixed scenario where spindle did not turn back on after auto tool change when STOP was used

Version 2.0.0
New Advanced Features:
> Added Pictures and Notes feature
> Added User Profiles to DEFAULTS page. Use code 600 to create & modify users, such that each user profile has its own set of defaults.

New Standard Features:
> First release to support VMC5, VMC7, and VMC10 machines
> Added Spiral Tool Path option for Circle Pocket event
> Added option to use finish / rest tool on Z finish cut for pockets and islands
> RPM and SFM are now both displayed simultaneously in DRO & RUN screens
> Added PTG file type - Save and open g code files along with tool offsets, as well as fixture offsets, pictures and notes.
> Added ENLARGE STOCK button within VERIFY – DEFINE STOCK page.
> For DPM mills, the BASE TOOL is no longer required to be set, so that the user can enter offsets using a tool measurement device
> CAPS LOCK button added to Keyboard
> Diagnostic Charting Tool available using service code 522
> Updated some EPA content for new features, as well as compressed the videos down to smaller file sizes.
> Added file validation tool for software updater.
> Added check for spindle run feedback, to ensure that that the spindle is actually running when it's commanded to.

Bug Fixes:
> Fixed screen resolution on tool room mills so that it will display in .0005" resolution. Version 1.7.5 was displaying in .0001" resolution.
> Fixed scenario where if conrad was too big for programmed geometry, it would give an exception instead of a proper warning message.

Fixed scenario where starting at an island pocket would result with the Z not retracting up to the rapid plane correctly.

Fixed scenario where pocket with no rest passes would run the finish cut at the rough feedrate.

Fixed issue with Verify not drawing repeat and tap events correctly.

Fixed intermittent issue with software crashing to desktop while user is in PROG or RUN mode.

Added SAVE TEMP files to code 1.

Fixed scenario where using Run - Start At on GCD files would plunge the Z deeper than programmed.

Added additional logging for intermittent issue where attempting to save a program results with an invalid filename error.

Fixed issue on lathe turrets where OPEN TEMP would replace the current tool # status.

Fixed issue where Verify would hang if a drill with zero diameter was used.

Fixed several issues regarding the run time estimator, including SFM / IPT and TAP times being way off. There are still some remaining bugs with this that will be addressed in a future version.

Fixed issue where ORDER OF PASSES was not being saved across programs.

Fixed issue where defining Depth Per Pass on Rectangular Profile would rapid instead of feed into part.

Fixed scenario on lathe where if programming a bore or cycle from backside of part, the axis would not retract back to rapid position correctly.

Fixed scenario where modifying a lathe's tool radius would incorrectly modify the current ABS position as well.

Fixed several cases where system would improperly detect an invalid feedrate within program, due to a finish cut, cutter comp, or other option being disabled.

Fixed scenario where starting in the middle of a program would result with a RUN OVER.

Fixed issue where after activating the AUX FUNCTION option, it would not be available until after reboot.

Fixed a very intermittent scenario where a POWER FEED, RETURN ABS ZERO, or CENTER would move the Z axis by the amount of the tool offset.

Fixed a very intermittent scenario where system would run the wrong program, such as perform a RETURN ABS ZERO instead of running the program in memory, or vice versa.

Fixed scenario where using Chip Clear and then jogging into the soft limit would result with a RUN OVER condition.

Fixed scenario where a profile with multiple passes was not rapiding up to the Z SAFETY plane correctly.

Fixed several other minor tool path related issues.

Version 1.7.5

Bug Fixes:

Bug 6139 - Fixed issue with Engrave Center tool path not centering itself correctly.

Add service code 601 to toggle splash screens. Splash screen will now default to TrakMT on all machine ID's.

Fixed issue with service code 326 not display error #'s greater than 250.

Fixed scenario where if pendant is disconnected from computer module while jogging, then motion will now stop immediately.

Fixed issue with Power Feed not running at correct feedrate when using certain SFM and IPT combinations.

Added more message logging for Power Feed.

Improved tapping accuracy on 30120RLX.

Version 1.7.3

Bug Fixes:

      Bug 5526 - Max feedrate was being incorrectly capped at 250ipm on DPM2, DPM3, and DPM5 with EHW option.

      Bug 5525 - Updated spindle timeout amount on 30120 to allow up to 25 seconds for spindle to get up to speed. This resolves the scenario of a fault 106 when attempting to run at high rpms.

Version 1.7.2

Bug Fixes:

      Bug 4951 - In mill power feed, axis not running at correct feed with SFM and IPT defined.

      Bug 4711 - EHW do not come on after SC316.

      Bug 5483 - Powerfeed no longer works for more than one axis.

      Bug 4293 - Software freezes during RUN with Math Help

Version 1.7.1

New Features added:

1. Islands supported in DXF and Parasolid
2. Engraving - added orientation, center reference, angle, and mirror options
3. Helical Drill
4. INC SET and ABS SET for lathe conrad and chamfer
5. Keyboard and Calculator open and close with INFO buttons
6. Changed G-code editor search box

Version 1.6.20

Fixed issue introduced in 1.6.19 with "What's New" button not playing the video correctly.

Version 1.6.19

Fixed issue introduced in 1.6.17 where DEFAULTS would revert back to factory settings every time the control was restarted.

Version 1.6.17

New Features

      Consolidated mill and lathe software into one version

      Added "What's New" button

      Added support for 30120 RLX, machine ID 108.

      Added DEPTH PER PASS as an OPTION and DEFAULT for all pocket, profile, and island events

      Added support for more gcodes (see programming manual for more details):

            Mill CAM – G06, G07

            Mill GCD – G73, G84

            Lathe CAM – G73, G76, G81, G82, G92

            Lathe GCD - now available

      Added service code 522 for Diagnostic Charting Tool

      Added Z RAPID as a DEFAULT

      Added ability on lathe to thread in the Z positive direction. Note that the Z RAPID value will be on the left side of the part, and precautions should be taken accordingly.

      Added ability to collapse the Program Tools and Tool Library sections of the TOOL TABLE.

Bug Fixes

Fixed issue in lathe Power Feed where user was unable to select IPR when spindle speed is set to SFM.

Fixed issue where tool table is unable to open / close while running program in SFM or IPR.

Fixed scenario where using SHOW PATH during THREAD REPAIR would cause an OPENGL error.

Fixed issue with THREAD REPAIR not prompting user to run program again.

Fixed lathe issue with X HOME and Z HOME would sometimes revert back to default after software update.

Fixed issue found on lathe where if you were turning EHW at the same time that you set the taper amount in DO ONE, the Z would move back and forth a small amount instead of executing the specified taper amount.

Fixed issue found where if if you opened the tool table on top of a flashing safety message, and then attempted to scroll the tool table, it would result with a Windows blue screen displaying APC_INDEX_MISMATCH.

Fixed issue on bedmills where GO TO would incorrectly display Z axis as a possible target.

Fixed issue where software would not update correctly when computer name was changed.

Fixed scenario where after exiting a program RUN, and then attempting either a POWER FEED, RETURN ABS 0, or CENTER, it was possible for the Z axis to move unexpectedly by the amount of the tool offset.

Fixed several intermittent issues in DRO where an axis may disappear, freeze, or not display correctly.

Increased calibration tolerance from 1% to 2%

Fixed issues with clicking or scrolling on Tool Table would cause it to not draw on screen properly.

Fixed issue with service codes 122 and 131 not working correctly on mills.

Fixed issue with DIA MOD not having any effect when running GCD programs on mill.

Fixed issue with starting at a pass # of a profile would result with pass depths not being correct.

Fixed issue with COPY DRILL TO TAP converting INC values to ABS.

Fixed multiple scenarios found where if you start at a Pass # of a pocket, the Z would not rapid to the correct height.

Fixed intermittent scenario where attempting to go into the Verify screen would result with the software minimizing itself out of view.

Fixed service code 326 to support newer flashing messages on mill and lathe.

Fixed scenario in lathe CYCLE event where finish tool would incorrectly use the radius of the roughing tool.

Fixed specific scenario found with lathe GROOVE event where toolpath was not correct.

Euro specific bug fixes

Added support for PMER F90 RMX and 780 RLX, machine ID's 118 and 119.

Fixed scenario where error 256 Max RPM exceeded while running burn-in program.

Fixed several issues with service code 400 not working correctly on machines and offline.

Fixed issue with OPEN TEMP causing an unintended motion fault.