RX RELEASE NOTES

Version 2.6.1

Bug Fixes:

Software does not work when using START AT on any event after an irregular pocket. This problem also happens when using an irregular pocket within our island and new clear off event.

Version 2.6.0

New Features:

RMX:

Tool Table sorting
Ability to mode out from middle of toolpath calculation
Clear Off

RLX:

Retain angle in Do One taper

Other:

VMC2 merged
Code 1 - Added functionality by using the * button
Floating License for group training

Bug Fixes:

Fix issue where Lathe Cycle Event with IPR causes motion to stop unexpectedly.
Fixed issue with Thread Repair, LH thread starting point and cross-threading.
Bug 18771 - Fix issue with message log becoming disabled after reboot.
In Status, the heading changes from status to different options for different machine ID's
Updated tapping parameters for TMC12, TMC14, TMC12-12k, and TMC14-12k. Note: AC drive parameters must be updated along with software for these machine types!
Fixed issue where treadmill event was incorrectly showing RPM instead of FIN RPM
Bug 18576 - TMC - FP EHW intermittently moves 2 axis at once
Bug 18643 - Touch user interface crashes when Run Start at is used with sub rotate event
Bug 18528 - Log Marker - pressing the asterisk button will abort a program run
Disable real time messages with double to ascii to improve real-time ISR spikes.
Fix thumping by removing logging (once again) from the CmdBuf code. This logging should not be enabled for WinCe.
Bug 18332 - TMC - Code 318 - E HANDWHEELS and 4TH AXIS are missing from list of options
Bug 18334 - TMC - AUX event does not do anything when AUX FUNCTIONS is missing
Bug 18304 - VMC2 - In 2 axis mode, cannot move the Z at all with the FP EHW
Bug 18269 – When you leave out the finish cut for rect pocket, get 0 spindle speed
Change ColdTurkey defaults to output all 100 parameters
Bug 18120 - OPEN TEMP is not restoring DRO position properly on Lathe

Bug 18104 - Sub Rotate of Irreg Pocket results with unnecessary tool changes
Bug 18123 - TMC EHW Problem - Z EHW's does not work in 2 axis mode after running a program
Bug 18130 - RMX - Choosing to start at circle pocket finish skips Z finish cut
Bug 18019 - Sub Part Verify Not Working Correctly
Bug 17375 - RLX - Tool Offset not applying correctly during Power Feed
Bug 18010 - TMC - WARM UP gives error "Not enough travel"
Bug 18019 - Sub Part Verify Not Working Correctly
Bug 17556 - GCD - Run Program and Then Stop. Now Run From an Event - Crash in Z
Bug 17711 - 0.090" Threadmill Crashes Offline and Gives Motion Control Error on TMC
Bug 17474 - EHW toggle switch missing from STATUS screen Move MessageLog.Init to earlier to get boot up messages.
Bug 17872 - Threadmill With No Fin Cut specified still asks for Fin Feed and Fin Speed
Bug 17720 - VMC2 - If not Aux, still allow cool, air, and part change. Just gray out pulse and aux output
Bug 17719 - VMC2 - AUX options not displayed correctly
Bug 17646 - Start at Fin Cut on Rectangle Pocket Causes Z Crash (TMC only)
Bug 17252 - Z Finish Cut Tool Drop down is sometimes empty in Defaults and Options
Bug 17259 - Z Finish Floor Cut Uses Roughing Feedrate and not Finish Feedrate
Bug 17407 - Stepover Amount is Wrong for Circle Pocket Offset
Bug 17443 - Stepover % for Adaptive Toolpath with Z Finish is incorrectly maxing out at 70 percent
PT10 - fix issue with message pump for WinCe
Retain values previously set in DRO DO ONE
Bug 17184 - do not reset motor encoder counts during Open Temp
Bug 17034 - For attached dxf when using manual chaining, cannot undo selected geometry and rechain.
PT10 Bug - Big lathe times out while tapping at slow speed.
Bug 12104 - XYZ Spindle Speed check Error 256 Fix Also Update to Version B131
ServiceCodes - Issue with SC523 not being able to edit F5 parameter.
PT10 - Copy Rotate Z Axis does not copy over Z Finish Cut and does not use the correct toolpath
Bug 17052 - 4th Axis shows up 2 times in status screen
Bug 16767 - TMC sim won't orient. Remove new Spindle "sanity check" when running offline because it doesn't like the jump in velocity when the spindle sim orients. The average spindle speed never goes to zero.
PT10 - fix issue where a random little blank window would show up on the desktop. This would happen when you change screen resolution. It only happened after starting master the first time
Bug 11902 - RLX not erroring out when more than one gear active
Bug 13015 - engrave event with radial option does not display properly on LOOK screen
Bug 16764 - TMC - unable to open program unless 4th axis is enabled
Bug 16700 - In Lathe, Cycle turn event does extra passes when using depth per pass
Bug 16004 - Sub Rotate Z Axis does not have Z Finish Cut
Bug 16005 - Copy Rotate Z Axis does not copy over Z Finish Cut and does not use the correct toolpath
Bug 13724 - ignore CTS button press if CTS system is not enabled on the machine
Bug 1386 - depth per pass is missing from Search Edit
Bug 16400 - Put up appropriate error message when unsupported geometry is selected
Bug 5520 - don't update index angle windows in service code 505 if any flyout windows are out
Bug 16009 - Look screen and toolpath don't match

Bug 16266 - RLX - Copying a thread event from the clipboard results with wrong geometry

Bug 16442 - Sub and Copy Rotate not copying depth per pass correctly

Bug 16265 - For Irregular Pocket event, Z Finish Cut - Step over percentage does not take value more than 70

Bug 11902 - RLX does not error out when more than one gear is active

Bug 16010 - First Position Event does an extra move in A

Bug 15983 - RUN STRAT button does not work properly

PT10 - Z Pocket Floor Speed Incorrect

Bug 15545 - RMX - Using 0 inc on Irreg profile depths results with Z plunging to 0 ABS unexpectedly

Bug 14962 - Zig Zag Entry Not Working with Pocket

Bug 14105 - KMX - Added 100 ms to MotionAllowed and NoSpeedLimit time delay numbers for MID 109.

Bug 14103 - No Quill soft key in SC 123 for Switzerland machine 109

PBI 10787 - BBSF - VMC creeps to destination issue

Z EHW On or Off Option - Config Slave Software

Add Z EHW option for Switzerland mill

PT10 - RLX - fix bug where you cannot power-feed with the spindle in reverse. Fixed error in detection logic.

Bug 16701 - Tool Group choice is not defaulting correctly

Version 2.5.4

Bug Fixes:

Added ability to abort out of Tool Path processing.

Added software licensing for offline product.

Bug 17453 - RLX when running with 8 tool turret, some features did not work properly such as TRAKing, auto coolant, door guard and spindle safety logic.

Bug 17691 - Zig Zag entry toolpath is not being defined at the correct angle.

Fixed issue where toolpath was using plunge entry instead of zig zag.

Version 2.5.3

Bug Fixes:

Fixed Cut Tolerance Value in Default Config File

Version 2.5.2

Bug Fixes:

Fixed Lathe 8 position servo turret faults when changing positions. Changed lathe Y axis

Version 2.5.1

Bug Fixes:

Changed threading timeout from 10 to 30 seconds for sake of 30120 machines threading at low rpm's.

Fixed Low Hydraulic Fluid Pressure safety message is always flashing on 30120

Updated DEFAULTS for Euro product ID's 91, 92, 93, and 94

Fixed issue in DEFAULTS page with Rough Cut Tolerances with and without finish were swapped.
Spindle speed 0 RPM warning message that comes up for Rect Pocket

Version 2.5.0

New Features:

Added support for TMC12 and TMC14 machines, including 12K and CTS options
Added support for Hydraulic Turret on 30120 RLX
Add CANCEL button in OPEN TEMP for machining centers
Motion control errors are now being logged in the Fault Log
MTConnect - Added service code 602 to allow user to select version of MT Connect protocol. Currently we support 1.4 and 1.5

Bug Fixes:

Z axis not moving to correct Z SAFETY height when START AT is used
Fixed issue where performing a POWER FEED with an ATC tool without a library # would result with the Z moving unexpectedly
Switching between undefined tool to Library tool would result with tool offset not being applied correctly.
Fixed issue where 30120 machines would automatically default to have hydraulic turret enabled the first time it was turned on
RUN, START AT does not run part at the correct fixture location
Fixed issue where a following error fault may occur when attempting to TRAK the A axis
Added another decimal place for the Scale Feature
Fixed scenarios where Tool by Tool was not running in the correct order
Fixed scenario where DRO features such as Power Feed would cause unexpected rapid movement. This came about because it was trying to comp the previous tools offset, and so we changed the way that our system handles tools with no offsets defined for lathe
2 axis irregular profile is not prompting for CHECK Z and crashing into part
Running a circle pocket with no finish cut defined resulted with finish tool change
When Multiple fixtures is turned ON, Run Start at does not goto the correct Z height
Fixed issue with starting in the middle of a program that included SUB PART would result with starting at the beginning of the program
Starting program at a SUB PART with Z SAFETY defined results with Z plunging down to an unexpected depth.
Fixed issue where Verify software gives Tool # error when the first event is PAUSE
Improved tapping depth accuracy on some machine models.
Fixed scenario where system will run even though spindle is not running and code 311 is set to NO
Fixed scenario where during Irregular Profile the Z will go to Z safety before finish cut instead of going to Z rapid
Fixed issue with Run Time Estimate being way off when 4th axis event and FPT are both used
Fixed issue where Face Mill Z finish cut would not have the correct chosen cutting method
Fixed issue where a rotated pocket event using depth per pass would be missing passes
Fixed pocket toolpath scenario where the finish tool was not using the correct stepover amount
Fixed issue where Z finish cut was previously using the roughing RPM and feedrate
Fixed issue where TMC fails to orient before a tool change.

Version 2.4.0

New Features:
Added support for CTS (Coolant through Spindle) and 12K options on TMC5, TMC7, TMC10

Bug Fixes:
User not seeing appropriate error message when attempting to Sub or Copy Repeat a 4th axis event
Verify Give Language Error Message Every Time You Run It Fixed service code screen so it now lists the 4th axis codes 502 and 506 when the 4th axis is enabled
In Pockets and Islands Finish RPM runs at roughing speed
Unable to run program due to corrupt TEMP274.DAT file residing on computer module
Fixed issue with Repeat Event not opening correct on Lathe
Fixed issue with home switch failures (stuck open or closed) not generating alerts
Fixed save and open temp for GCD and PTG (GCD now gets save as PTG in save temp)
During tapping in TMC Z axis would continue to creep beyond programmed depth and spindle never reversed.
Lathe Cycle Pause Then Chip Clear at Pause Terminates Program
Tool clamp sometimes unclamps briefly
Fixed issue where ATC came out when not expected
Corrupted Slave Log file with "Performance" messages
Z motion during tool change creeps slowly into position
On Lathe, machine comes to 0ipm in middle of a Groove event
Z Fixture Offsets are not being opened properly
Fixed scenario where lathe toolpaths are completely wrong
Code 530 - Serial numbers sometimes disappearing
Toolpath Improperly Displays G2, G3 That Display & Run Correctly In Run Show Path
Lathe - Run, DRO not displaying X Movement - Show Path Displays it correctly
Lathe - PT4 File Loses Repeat Event Z Offset Value in PT10 Import
Lathe Stock Not Correct at Tailstock End in Verify
DCT - Does not work once computer name has been changed
Event not being drawn in look when it is created in program editor
Do One Changes DRO Display
Z Feed to Depth and stops on Circle Pocket
MTConnect option needs to be freely available for trial offline software
MT Connect Giving Incorrect Part Count on GCD File
Message log is constantly writing "GetCurrentUserProfileName()" to log
PK errors when Programming a Solid
Fault log appears to be logging fault messages multiple times
Intermittent timeout when starting a program. Changed "Start new program" data connection parameter to "send-always"

Version 2.3.0

New Features:
Added support for 4th axis option on all TMC machines

Bug Fixes:

Fixed save and open temp for GCD and PTG (GCD now gets save as PTG in save temp)
PK errors When Programming a Solid
Intermittent timeout when starting a program. Changed "Start new program" data connection parameter to "send-always"
Z Feed to Depth and stops on Circle Pocket
Serial number warning appears even though all serial numbers are entered
code 510 - encoder check does not display correctly for 8K VMC machines
code 510 – removed RESET button
code 510 - show text for 4096 counts for 8K VMC machines
Do One Changes DRO Display
Event not being drawn in look when it is created in program editor
DCT - Does not work once computer name has been changed
Fault log appears to be logging fault messages multiple times
Message log is constantly writing "GetCurrentUserProfileName()" to log

Version 2.2.0

Note – This update does not support the VMC2 machines or 4th axis hardware

New Features:
Added MT CONNECT as an option for all machines, and free for offline software.
Tool by Tool tool path on all RMX controls. New REPEAT PART choice in SUB REPEAT event and RUN STRATEGY button in setup mode to choose TOOL BY TOOL or PART BY PART
Option for Z finish cut tool path pattern on RMX
New Default on RMX for Z SAFETY PLANE
New Default on RLX for separate RPM vs SFM for drill and tap events
PROG IN/OUT now allows user to view all files types

Bug Fixes:
ZigZag Entry was not being saved with Circle Pockets and Spiral tool path.
Z MOD value in Program Tools table did not change when assigned to ATC # 16.
Z axis overshooting during entry moves on TMC machines
Unexpected motion occurs when performing DO ONE and opening chuck guard (Euro)
TRAKing slowly through a lathe groove event resulted with unexpected motion and errors
Tool path issues when using a finish tool larger than the roughing tool
Scenario where profile lead in/out arcs for finish cut were backwards
Run – Start At – Z finish would error out when attempting to run.
Facemill and Threadmill were not being drawn correctly in Verify screen
Erroneous tool comp error when attempting 2 axis mill / arc combinations.
Serial number warning appeared even though all serial numbers were entered. Added more logging in the event that this occurs again.
Mill Indexer would index twice when performed within a Sub Repeat.

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.