Version 2.0.1

- Fixed scenario where Z axis may drop slightly after the servos timeout due to inactivity.

Version 2.0.0

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. Please refer to the programming manual section 9.1 for how these work now.

- 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 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 #.

- 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 interuppted 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.