CNC12 CNC12 v5.02 Release notes 5-19-23

(Download v5.02 here:
https://www.centroidcnc.com/centroid_diy/centroid_cnc_software_downloads.html)

1.) Fixed Acorn/AcornSix Wizard ATC menu bug where it would not remember settings if it wasn't an integer. Also, added selection for fixed or not fixed TT for Rack Mount "Maintain Tool Offset Library" selection in the ATC Wizard setup menu to tell the CNC12 tool library auto measure F key to used fixed TT location or not.

2.) Improved Acorn/AcornSix Rack Mount ATC macros. Improved macros automatically check to see if any of these inputs are assigned and uses them if they are.

Inputs: DrawBarReleased or ToolisUnclamped, SpindleIsOriented, VFDZeroSpeed,, PressureLowMessage or PressureLowStop or ATCAirPressureOk (recommend ATCAirPressureOK for ATC applications).

Outputs: Orient Spindle, UnclampTool and ATCAirBlowActivate

The Wizard generated v5.02 ATC macros work with any combination of these Input and outputs, and even no inputs or outputs at all!

3.) Added spindle cooling fan delta timer to the Wizard (P997). This delay timer works automatically in conjunction with the output "SpindleCoolingFan" and will keep the fan on for what ever amount of time is specified.

4.) Fixed an issue where laser ballscrew (position) compensation was only working for the first three axes.

5.) Added Plasma Cutter compatibility additions in plasma macros for support of Everlast and Primeweld cutters.

6.) Updated Plasma profiles to support Arc Ok for non-hypertherm cutters.

7.) Fixed a bug where Plasma Restart Mode would not use commanded feedrates when resuming a job.

8.) Options screen reinstated to Oak, Allin1DC and MPU11 installations which was accidentally omitted in v5.0

9.) Deprecated Skinning call Job.GetUserVolatileSystemVariable. Added Skinning calls Job.GetUserSystemVariable (#100-#159, #29000-#31999) and Job.GetUserStringSystemVariable (#300-#399) This is better because now this gives access to all user variables.

10.) Plasma Intercon graph will now zoom towards the center of the graph, rather than towards (0,0) and added option to 'flip' x y for viewing the way the user would like to see the display.

11.) Fixed Plasma screen flicker when using keyboard jogging.

12.) Improved the M44 Surface Plate macro to be more robust.

documents/cnc12-v5.02-cnc12-v5.02-release-notes.odt

13.) Added support for WMPG-6+ in the stock Oak and Allin1DC standard PLC programs. Updating the stock ATC PLC programs is still in progress and will be committed in next release. (user can always edit their own as well)

14.) Reinstated "Trail On" in Plasma in Run time graphics

Release notes for previous version v5.0
https://www.centroidcnc.com/centroid_diy/downloads/centroid_cnc12_download/centroid_cnc12_v5.0_release_notes.pdf