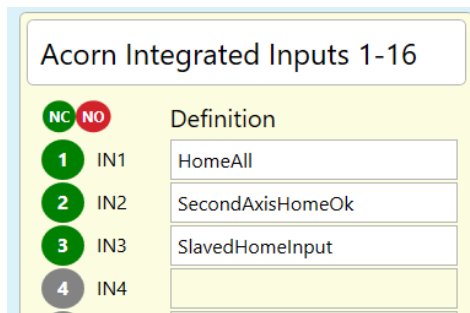


## Centroid CNC12 v5.04 Release notes 6-14-23

(Download v5.04 here:

[https://www.centroidcnc.com/centroid\\_diy/centroid\\_cnc\\_software\\_downloads.html](https://www.centroidcnc.com/centroid_diy/centroid_cnc_software_downloads.html))

- 1.) Fixed Acorn Limit Switch defeat button functionality. (skin event number in the button xml was in inadvertently not updated in previous version v5.0/v5.02)
- 2.) Fixed Oak/Allin1DC/MPU11/Hickory VCP Aux 13-16 (the controlling CNC12 parameters were off by one) which were incorrectly configured.
- 3.) Fixed Acorn VCP button Mill Vac On/Off skin event number (skin event number in the button xml was inadvertently not updated in previous versions v5.0 & v5.02 )
- 4.) Added an all new DXF import "engine" for Plasma Intercon DXF import feature. Now the new DXF import supports a wider variety of complex arcs commonly generated by graphic art programs.
- 5.) Some Color picker additions the Plasma restart graphical menu. blue, red, and purple dots which represent the pick up point, jog off point, and interrupt point
- 6.) In the Utility menu "Create Report" now copies the Wizard generated Acorn/AcornSix ATC macros to the Report.zip file.
- 7.) Updated Skin call "GetMachineType" it will now also return "emulator" for offline use.
- 8.) In Acorn and AcornSix it is now possible to mix and match HomeAll with other HomeOk inputs for example:



and the Wizard generated home program will work using all of the defined homeok inputs in addition to HomeAll.

- 9.) Added auto detection skin call so AcornSix Wizard will auto detect the AcornSix Encoder Expansion Board. "IsENCEXP12Connected"
- 10.) Fixed M1 functionality which was broken in AcornSix, Oak, Allin1DC, Hickory, MPU11.
- 11.) Fixed M0 jogging which was enabled regardless of what Parameter 10 was set to.
- 12.) Moved the TT Fixed location from the ATC menu to the Tool Touch menu in the wizard.
- 13.) Added WCS Lockout Parameter to Lathe (parameter 426). WCS Lockout was previously only available in Mill/Router/Plasma and was controlled by parameter 45

14.) Added easy control of ATC fork engage and disengage speed in the Wizard ATC setup page for Acorn and AcornSix

**ATC Setup**

ATC Type: RackMount (dropdown) \* Requires a Pro, Ultimate, or Ultimate Plus License

Custom Tool Change Macro (M6) in use: No (toggle)

Number of Pockets: 0 (input)

Machine Position Z Height Flyover: 0 (input)

Tool Rack Holding Configuration: Hole (toggle)

**Fork Engage/Disengage Speed: 50 (input)**




Choose Rack Mount Tool Length Method

- Measure Tool Length after each Tool change at a [Fixed Tool Touch Off](#) position
- Measure Tool Length after each Tool change using Surface Plate (operator will be prompted)
- Maintain Tool Length Offset Library (requires accurate homing) and do not measure tool length with every tool change

	X Position	Y Position	Distance and Direction to Clear	Clearing Axis	Z Height
Pocket 1 (Bin 1)	0	0	0	1	0
Pocket 2 (Bin 2)	0	0	0	1	0

15.) Pro Plasma License now includes unlimited block Teach/Trace mode and DXF import Blocks with Plasma Intercon.

16.) added DXF colors to the color picker

<b>VCP Background Color</b>	:		<b># a6a5a5</b>
<b>DXF Unselected Color</b>	:		<b># 7f7f7f</b>
<b>DXF Selected Color</b>	:		<b># d00000</b>
<b>DXF Highlight Color</b>	:		<b># ff0000</b>
<b>DXF Zero Reference Color</b>	:		<b># 00ff00</b>
<b>Catch All Color</b>	:		<b># fff700</b>

17.) Added Wizard ATC menu tool change “Flyover” Z height position clearance position. This is the height that the Z axis goes to in between the tool put away and the new tool (flying over the tools). This is a machine coordinates value. ( Note: Previous version used hard coded (in the macro) machine coordinate Z0. Now user can specify tool clearance Z height from one tool position to the next.) This value is set in the Wizard ATC. The Wizard writes this value to the CNC12 G30 position and the Wizard generated ATC macros use G30 to command movement to the flyover position.

### ATC Setup

ATC Type \* Requires a Pro, Ultimate, or Ultimate Plus License  
RackMount ▼

Custom Tool Change Macro (M6) in use No

Number of Pockets 0

**Machine Position Z Height Flyover** 0

Tool Rack Holding Configuration Hole

Fork Engage/Disengage Speed 50

Choose Rack Mount Tool Length Method

- Measure Tool Length after each Tool change at a [Fixed Tool Touch Off](#) position
- Measure Tool Length after each Tool change using Surface Plate (operator will be prompted)
- Maintain Tool Length Offset Library (requires accurate homing) and do not measure tool length with every tool change

	X Position	Y Position	Distance and Direction to Clear	Clearing Axis	Z Height
Pocket 1 (Bin 1)	0	0	0	1	0
Pocket 2 (Bin 2)	0	0	0	1	0

Note: the Acorn and AcornSix ATC Wizard setup page currently supports 16 pockets for Rack Mount setups, but the user can “manually” add as many additional tools to the Rack mount setup as they like. The future Wizard ATC menu will support more pockets so the user doesn’t have to copy/paste and edit files to add more than 16 pockets.

For example to add four more pockets for a total of 20, navigate to the C:/cncm/system/rackmountbins folder, ATC pocket files called: tool#position.cnc (Where # is tools 1-16). Copy anyone of these files and create a Tool 17 file from it: “tool17position.cnc”, then do the same for Tool 18 “tool18position.cnc”, etc..etc.. Ensure the naming is identical to the others so tool17position.cnc, tool18position.cnc and etc. Then edit the X, Y, Z positions and the other lines within these new tool position files for that tool. The macros are commented so it is simple to understand how they work.