

Centroid CNC12 v5.06 Release notes. 7-31-23
Acorn, AcornSix, Oak, Allin1DC, Hickory.
Mill, Router, Lathe, Plasma

(Download v5.06 here:

https://www.centroidcnc.com/centroid_diy/centroid_cnc_software_downloads.html)

- 1.) Plasma THC now keeps track of the Z machine coordinate home position when switching in and out of THC mode.
- 2.) Plasma THC WCS Z position drift bug fixed, (related to item #1)
- 3.) Fixed bug where CNC12 function keys would disappear after exiting Restart Mode in Plasma
- 4.) Fixed bug in Restart Mode where moving backwards on the first event would consider the starting point at (0,0) rather than where the torch head currently is at
- 5.) Plasma Intercon: When moving the start point in a dxf or svg group, the graph will remain at the scale in which it is positioned
- 6.) Plasma Intercon: Fixed bug where lead out length value was being applied to a Lead In event causing a tail on DXF imports.
- 7.) Plasma Intercon: Added DXF Gap Tolerance Upper and Lower Bounds to control the vector that is added when bridging gaps between lines, arcs, and splines
- 8.) Plasma Intercon: Removed drag\drop native feature from textboxes
- 9.) Plasma: Added Scribe support in the Wizard with supporting CNC12 Parameters. Added parameters 562, 563, and 564 for Scribe X Offset, Scribe Y Offset, and Scribe Delay respectively. Wizard page was created to setup Scribe in Plasma which writes to these parameters.
- 10.) Offline Intercon/CNC12 emulator: Fixed crash when using Emulator software and accessing motor config screen or creating a report
- 11.) Lathe VCP: Added optional diagonal jog button VCP skin.
- 12.) AcornSix (and also future Hickory Wizard) and VCP: Wizard will now automatically add 5th and 6th axes jog buttons to the VCP using the drive letters assigned in the configuration menu. Note: If a diagonal skin is being used, Lathe won't automatically add 5th and 6th axes and Mill/Router won't automatically add the 6th axis, in these cases it is up to the user to hand edit the VCP.
- 13.) Acorn,AcornSix (and also future Hickory Wizard): Increased Rackmount bin count to 100. Bin setup table automatically adjusts to bin count entered by user as well.
- 14.) Rotary Axes: Added bit 16 (+65536) to the axis property parameters to denote an axis that is a rotary but the motor revs are configured in units of revolutions (instead of degrees). (Max rate should be set in RPM). With this bit set, the rotary axis can be programmed in degrees as the conversion to revolutions is handled internally. The DRO is displayed in degrees. This is in anticipation of an upcoming Wizard Rotary Axes setup page.
- 15.) CNC12: MDI phantom character bug fix attempt to solve intermittent phantom characters from appearing in the MDI history area.

documents/cnc12_v5.06/cnc12_v5.06_release_notes.odt

16.) Plasma Intercon: Added a "MoveOrigin" feature under Edit>Move Origin that allows the user to set a new origin point

17.) Plasma Intercon: Reworked the group feature to be able to add lead-in/out to frames and dxf/svg imports easily

18.) Plasma Intercon: Added "% of Profile Feedrate" option to the grouping menu

19.) Added "Tangential Knife" option to "Linear Or Rotary" selection in the Wizard Axis Configuration Menu in anticipation of continued T-knife feature development

20.) Updated Aux 13 and 14 skin events in the button xml file to match the updated numbers. These updates were inadvertently omitted.

NOTE: In v5.04 In order to unify Skin Event numbers for the VCP buttons across all platforms and to be compatible with the hard operators control panel a few VCP button skin event numbers in the Acorn VCP were updated and aux 13 and 14 got left out. _

The instructions below are for only users that have a custom VCP.

If you are installing a fresh install of v5.06+ you don't have to do anything in this regard.

Users with custom VCP buttons that previously Modified Aux 13 and Aux14 will need to edit the button XML and update the skin number being used.

SKIN_EVENT_66 and SKIN_EVENT_67 are for VacOn and LimitDefeat.

Aux 13 and Aux14 are SKIN_EVENT_24 and 25.

User that have previously used SKIN_EVENT_66, should make it 24 and if they used 67 they should now use 25 going forward in V5.06.

This was a one time change to Acorn so that its skin_events matched up with Acornsix, OAK, ALlin1DC, Hickory, MPU11 so the VCP matches up with the physical operators control panel in those cases

We don't expect to have to swap any SKIN_EVENTS numbers again like this in the future since now the skin event numbers are the same across all platforms.

21.) Fixed Load Meter not displaying in DRO for Oak, Allin1DC, Hickory, MPU11

22.) no longer require the regional settings of the computer to be set to "English (United States)". This check has been removed from the installer.

23.) Plasma Intercon: Added extra Lead-In/Out points for DXF and SVG imports