

Power PMAC NC - Release Notes

2/4/2019 1.8a

- Crash Fix: Save NC program to thumb drive, remove thumb drive, attempt to reload file.

2/11/2019 1.8b

- New "Go Online and Run at Login (Wait)" Start Up setting will repeatedly attempt to open Power PMAC communications until success or cancel. This feature will wait for PMAC to power up.
- Data Logging M-code example added to the SDK at a customer's request.

4/20/2019 1.8c

- Fixed G98 canned cycle issue.
- Mid program start fixes for S and T codes.

5/19/2019 1.8d

- New initialization file option WorkOffsetAxisLabels allows axes to be removed from the Work Offsets table.
- Tool and Work Offsets table scrolling bug fix.

5/23/2019 1.8e

- Tool and Work Offsets tables and LaserTable SDK example upgraded to new ScrollGrid class.
- Double-click Tool Offsets descriptions to edit.
- MS Azure translator text API v2 to v3 upgrade. (Microsoft announced discontinued support for v2.)

6/19/2019 1.8f

- New initialization file options VelocityDecimalPlaces, ManualJogButtons, AxisStatusWidth, HideMidStartButton.

8/3/2019 1.9a

- Renci SSH.NET client replaces legacy Routrek Granados SSH client for compatibility with new LX86.
- New MacroLocalVariables initialization file option.
- New Tap spindle mode.
- Canned cycles block skip fix.

9/10/2019 1.9b

- New SubtractTOSFromZaxisWOS initialization file option and dialog box.

9/26/2019 1.9c

- Support for "gpascii -2" Power PMAC communications.
- Manual tab jog buttons moved to right of distance field.
- New PageNavigation SDK example and UserPageLeftEdge initialization file keyword.

9/29 - 10/13 1.9d

- "DeviceKeywords.xml" upload from PMAC when communication is opened.
- Auto-complete dropdown list for PMAC command terminal and watch window.

3/3/2020 1.9f

- New send1 keyword "SetAxisLabel1=X" allows PMAC to specify the axis labels on the main operator screen.
- NC file execution monitoring display bug fixed.

3/20/2020 1.9g

- Extended “MacroVars” page tabs #1000 through #7500.
- “Reference MacroAssignments.txt” shows how to assign PMAC variables to macro variables #1000 and above.

3/25/2020 1.9h

- Added support for the parametric programming keyword DPRNT. DPRNT writes lines of text (including macro variable values) to “DPRNT.txt”. A new DprntFile initialization file option enables the DPRNT output filename to be specified.
- New high-contrast skin file “HighContrast.xaml” added to the Skins folder.

6/21/2020 1.9i

- Parser support for #0. An expression can now be tested for NAN by comparing with #0. For example, “#0EQ(expr)” or “#0NE(expr)”

3/31/2021 1.9k

- The Cycle Start button now sends a new command code CycleStartClicked (119) on press which enables momentary-button-style functionality on the PMAC. CycleStart (120) is sent on release as always.
- New MCF property “g.theMainWindow.AlternateClosingPrompt” allows the stock “Are you sure?” confirmation prompt to be replaced with a custom prompt.
- Bug Fix: Mid Program Start on a blank line did not parse correctly.
- New MidProgramStart Run Options bit informs PMAC of a Mid Program Start.
- “Block skips prior to mid-program start line are not supported.” message and refusal to run. This error only triggers if Block Skip mode is enabled because if not then the program will run correctly.
- Crash Fix: Removing the thumb drive that contains the NC file during execution will no longer crash NC16. The execution monitor will go blank and you will get an error message but the program will run successfully.
- Work Offsets descriptions just like Tool Offsets descriptions.
- New RotaryAxisLabels and RotaryDecimalPlaces initialization file options enable axes to be flagged as rotary (degrees) instead of linear (inch/mm).

6/11/2021 1.9m

- sendgetsends Fix: Update to current Renci SSH library. KeepAliveInterval and improved listener.
- Bug Fix: Persistent macro variables #500-#999 now updated before Settings file is saved.