Centroid CNC12 v5.22 Mill, Lathe, Router, Plasma Release Notes:

CNC software is now available for use with Acorn, AcornSix, Hickory, Allin1DC, Oak and MPU11. Please Follow the installation instructions. Do not use "restore report" using a report from an earlier version.

Download CNC12 v5.22 here.
https://www.centroidcnc.com/centroid_diy/centroid_cnc_software_downloads.html

This is a free CNC software update! All previous license files file work with this new version of CNC12 software (in their respective categories: Acorn mill licenses work with Acorn mill, Oak lathe licenses work with Oak lathe CNC12, etc.)

- Fixed the CNC12 installer overwriting the WCS file and other files from an existing installation for Oak/Allin1DC/Mpu11 updates.

- Fixed bug caused by a rounding error that made slaved axes momentarily change direction that only revealed itself when trying to send a signal to Teknic Clearpaths to hard stop home all three axes at a time.

- Fixed Pages in the wizard too long to fit on a single page when printing will now be scaled down rather than cut off

- Fixed bug where G10 PXXX RYYY would write an incorrect value if a G20/21 command was issued contrary to the default units of measure for cnc12.
This is evident in the series of commands:
G21
G10 P700 R4
G65 "C:\cncm\ncfiles\tool#9700.cnc"
which would result in tool3.cnc being called rather than the requested tool4.cnc

- Fixed bug where Plasma Intercon wouldn't launch due to missing files

- Fixed bug where Single Blocks would not set correctly out of the run menu. Also fixed functionality to match that of v5.10 when interacting between CNC12 and PLC in regards to the run menu removing F5 as an option when single block mode activated via the plc

- Fixed bug where API call Tool.GetHeightOffsetAmount would always return H1 rather than the active H value if no H value was specified

- Added API calls State.GetConsoleType and State.SetConsoleType

- Added the ability to collapse the navigation pane of the wizard. Also fixed related minimum size of the wizard to scale to a 4:3 operators LCD screen better

- Fixed bug where Lathe would not save or load smoothing presets.

- Fixed bug where jogging beyond travel limits after homing via M26 in MDI was possible

- Added some protection for startupOptions.ini to ignore blank lines and lines containing excess null terminators and other 'garbage'

- Fixed run menu resetting the part count upon entry. Part count will change upon interaction with the part count input box

- Acorn Lathe C-Axis will now require an Ultimate license. Existing Acorn C axis users are grandfathered in. email diysales@centroidcnc.com for details.

- Fixed bug where cycle start wouldn't work in the run-resume menu if P400 was set to 0

- Fixed bug where homing the THC axis (Z-Axis) via switches before homing any other axis, canceling out of the homing program, and rerunning the homing program resulted in an immediate axis travel limit exceeded error

- Added diagonal buttons to the keyboard jogging legend

- Fixed bug where park.mac would install over a custom park.mac (and other similar problems)

- Added classes VB_[class] to the CentroidAPI to resolve ambiguity between the class and class instance that Visual Basic can't overcome.

- Added bit 4 (add 16) to parameter 113 to hide the Wizard button from the Utility menu (and all other buttons that may launch the wizard)

- Fixed bug where Z Clearance Height in Router Touch Plate menu would not convert between imperial and metric when changing units

- Updated Keyboard Jog Panel legend for Lathe

- Fixed bug where keyboard jogging is enabled, a command is entered and run in MDI, MDI is exited, and the keyboard jog panel is moved resulting in keyboard jogging no longer functioning

- Fixed bug where 410 Scale error would appear upon restart of software

- Lathe G99 moves without an encoder setup will no issue a warning message. To reduce tech support related to user trying to command lathe moves without an encoder installed and configured.

- Lathe parameter 48 is defaulted to 1 to make G98 the default mode. To reduce tech support related to user trying to command lathe moves without an encoder installed and configured.

- Fixed some interactions between Keyboard Jogging and the MDI menu so keyboard jogging works better.

- Fixed omission of the Plasma Scribe menu in the wizard

- Fixed bug where the API call Job.CancelExecution would not cancel a job while using the emulator/offline intercon. This call will issue the "Escape" key for the emulator/offline intercon install.

- Fixed bug where M221 timer would end other M2XX messages if the timer expired after the message elapsed

- Fixed a Touch Plate dialog box message bug.

- Added "Laser Deploy" as an output selection in the Wizard.