Centroid CNC12 v5.26 RC3 Mill, Lathe, Router, Plasma Release Notes: 2-19-25

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.

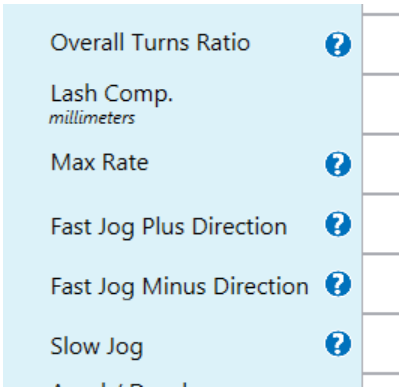
Download CNC12 v5.26 here.
https://www.centroidcnc.com/centroid_diy/centroid_cnc_software_downloads.html

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.)

1. Fixed a bug in v5.24 CNC12 causing the new M297 (defeat soft travel limits) to remain active even after terminating a job and/or exiting MDI.

2. The Wizard now accepts “degrees/rev” as units for the Overall Turns Ratio for rotary axes in both imperial and metric.

3. Added information buttons to the Axis Configuration menu in the Wizard to help explain the units of certain axis parameters.



4. Removed Skip Macro if searching line in M50/M51 macros for Acorn, Acornsix, and Hickory. This allows Run Search to find the M51 command for C-Axis Moves, if the macro was skipped this would have resulted in an invalid axis error for C-Axis.

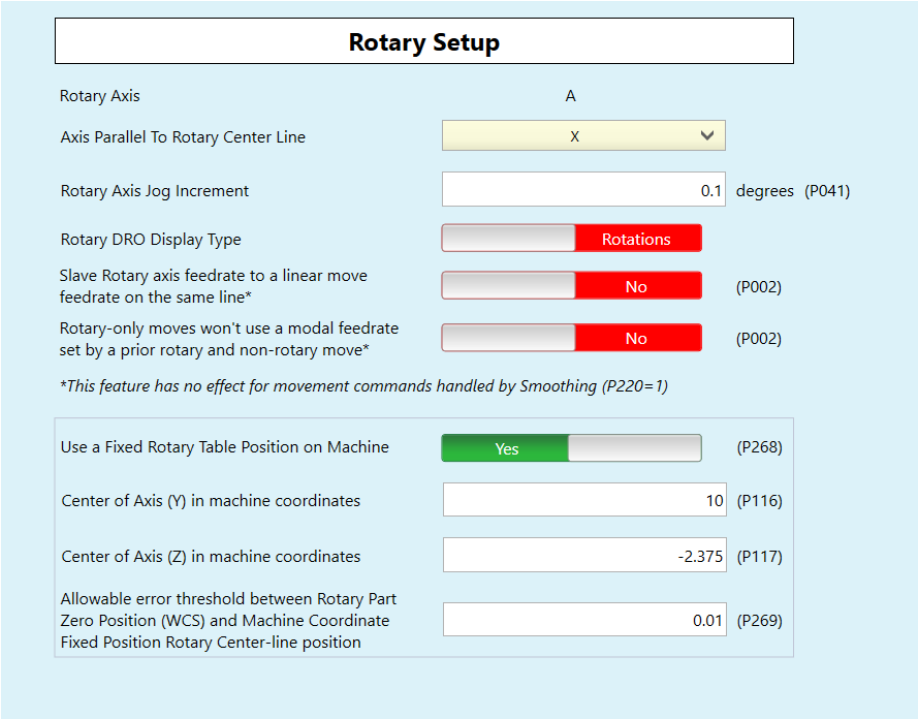
5. Fixed faulty Smart Search options parsing for Lathe

6. Wizard i/o: Renamed ChipPumpOut to “WashDownOut” for Hickory.
PWMOutput was also hidden for AcornSix as it applies to Acorn only, AcornSix has two deadicated PWM outputs so no need to have this output in the i/o assignment drop down.

7. Fixed any Wizard Tooltips that didn’t have text or had vague text

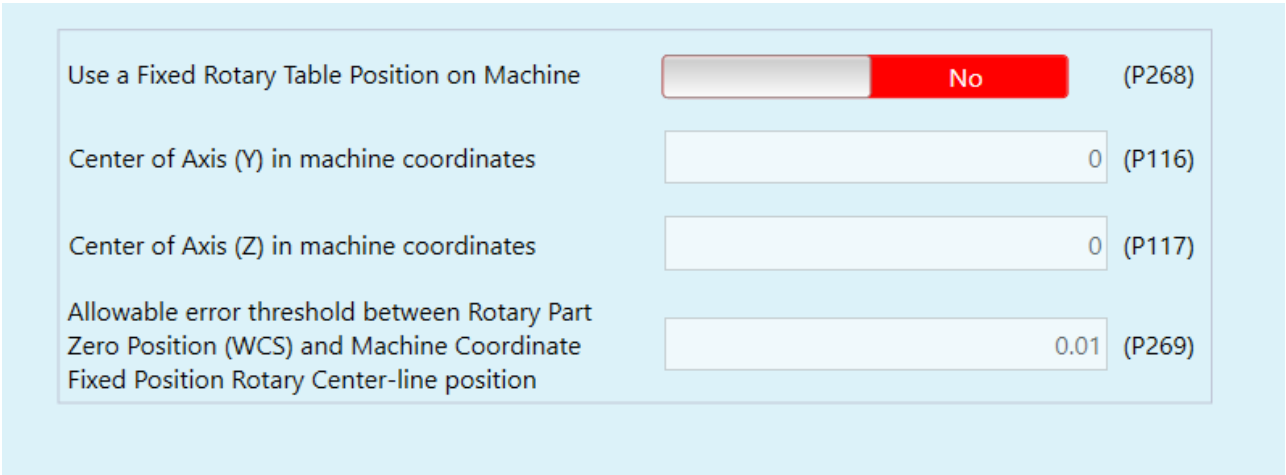
8. Fixed a bug where rotary feedrates below a certain threshold would not display on the DRO.

9. Added Slider in the Wizard Rotary Setup Menu to choose whether or not to use a Fixed Position (in machine coordinates) for a Rotary Table or just display and run the Rotary Job at the current (any) WCS location.



Added P268 (Fixed Rotary Table Position) and P269 (Rotary Center-line Threshold) to CNC12. P268 determines whether the software should account for the center-line coordinate parameters (P116-119) when graphing a rotary job, and P269 sets the maximum allowable difference between the current rotary WCS and the center-line coordinates. If the users current WCS is not set within the P269 value of the Rotary Table Center then CNC12 issues a warning message stating this.

If the Slider is set to NO there is no warning message and the G code job will simply graph and run where ever the WCS is set.



10. Fixed bug where the CNC12 installer for Oak and Allin1DC Lathe would also harmlessly install CNC12 Router version of CNC12.

11. Parameters 571-578 (Max Scale Difference for each axis that is using a scale for positioning) are now applied to each individual axis instead of only using the value from P571 for all.

12. Fixed a bug where the probe indicator graphic would not display NC probes correctly when P18 (Probe Detect) was set below -50,000.