

# **TB000 (Rev4) - Software Update Highlights**

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See release notes for more detailed and minor changes.

\* Optional Feature

## **Windows CNC 11**

### **v3.04, 05-20-2011**

Live PID tuning for 3rd Party drives

Added PLC Detective (WinPcap) for PLC diagnostics and trouble shooting

Improved loading speed of files in file menu's

\*Removed Radial & Contour digitizing and replaced with Wall Following digitizing

\*Implemented DP7 probe support

### **v3.02, 09-09-2010**

Support velocity mode drives

## **LINUX CNC 10**

### **v2.70, 09-08-2010**

Implemented "Classic" Cutter Comp to correct some issues with Cutter Comp.

New AD2 smoothing implemented to allow high speed routers to run faster and more smoothly

Rotary increment feature added to Intercon

Software unlocks are now entered from F8-Options screen instead of the Parameters menu

### **v2.68, 04-01-2010**

Standard program file size increased from 1MB to 4MB

Work Coordinate Systems now comes with 6 work coordinates instead of only 1 (Extended WCS can still be purchased to get the full 18 WCS)

The following options have become standard features (no unlock required): Cutter compensation, Drilling Cycles, Compression Tapping, Multi-range Spindle, Spindle Speed, Laser Compensaion, 4th Axis, and Subs & Macros

Expired Demo mode no longer completely locks you out of the software, now you can navigate the software, but you cannot run a program

### **v2.66, 12-15-2009**

Graphics acceleration added to g-code back plot as well as mouse support

P123 added for lathe software to smooth handwheel movement

Simultaneous contouring (unlock feature) added

### **v2.64, 01-20-2009**

Added F-key shortcuts to Nedit screen to make editor easier to use

**v2.63,11-05-2008**

Remote Access and Diagnostics for remote viewing and file transfer.

Angle probing cycle to automatically calculate an angle from 2 probed points.

Added 3 new foreign languages. German, Swedish, and Finnish.

**v2.61h,4-29-2008**

Hex file change to remove dynamic braking and reset over current messages

Reset PLC whenever CNC10 is started

**v2.61,3-4-2008**

Remove debug output to prevent using up disk space

Changed Advanced Load Menu Rename prompt

**v2.60,2-22-2008**

New Linux Kernel version 2.6.x requiring new Flash Card

DosBox/Millwrite support for online engraving

DSP Probe

Improved Laser Compensation

**v2.38,5-27-2008**

Hex file update for 2.4.x Linux Kernel to change overcurrent handling on AC systems

**v2.36,9-12-2007**

Inverse Time Parsing for CNC10 mill

Command line history for MDI

"318 \_axis too close to switch" Error removed

**v2.32,2-06-2007**

Simplified File Operations

On-Screen Help System

Graphing Intercon files from Load Menu

**v2.30,7-28-2006**

Changed File Operations

Paired axis resynchronization

**v1.51,12-22-2005**

CPU10b Support

Enabled multi-axis, protected-move probing functions

New CNC editor (NEdit)

**v1.27,9-21-2005**

Added location chooser for Updates & Reports in Start Menu

**v1.25,8-03-2005**

Spiral cleanout replaces Zig Zag cleanout in Intercon

Island avoidance added to cleanout cycle in Intercon

Z axis MPG mode during job run

Added wait for Spindle At Speed

Added M150 to zero spindle encoder at index pulse

Updates, reports, and backup/restore in Util Menu use the location chooser

WCS 7-18 viewable and editable in WCS menu\*

**v1.21,2-10-2005**

Added P148 for fast jogging before home is set

**v1.20,1-06-2005**

USB Support

Linux Serial Communication

DXF Engraving\*

**v1.15,9-30-2004**

High Resolution Display

Lathe one shots

Improved Lathe Intercon Thread menu

Chinese Translations

**v1.11,7-20-2004**

New French Translations

**v1.10,7-16-2004**

DXF Import\*

System Test

Improved Keyboard Jogging

Joystick jogging support

Probe detection while jogging

Dwell time added to groove and turning cycles

Drag plot improvements

5th axis pairing

G22/G23 work envelope soft limits

21 day demo

**v1.02,05-13-2004**

Background Editing

**v1.00,03-25-2004**

First release of Linux CNC10

CPU10 (PCI Card) Support

New G-code editor

Multi-tasking operating system

Shutdown Menu

**DOS CNC 7**

**v8.23,6-25-2004**

System Test

Improved Keyboard Jogging

Probe Detection while jogging

Dwell time added to groove and turning cycles

Joystick jogging support

Drag plot improvements

5th Axis Pairing

Last Dos CNC7 Release

**v8.22,2-24-2004**

G68, G69 Rotate G-codes Added

Aux Key M-Function Execution Added

New Custom PLC Messages (See TB164)

**v8.21,8-11-2003**

Lathe Tool Details Screen

**v8.20,6-05-2003**

5th axis support

2 axis INTERCON MILL

Aux key functions & One Shots

Enhanced keyboard jogging

Dual MPG Handwheels with improved MPG responsiveness

Distance to go DRO

INTERCON MILL Help

**v8.11, 1-24-2003**

Keyboard Jogging

Live PLC Debug

Grid Digitizing Speed Improvements\*

Teach Mode with Live DRO

File Caching

User Specified Paths

New INTERCON Translations

Input Macro

**v8.10, 12-10-2002**

Run ? Time Graphics

Parse Error Display

Conditional G Codes

Brushless Autotune

Lathe Gang tool Support

Modal Feedrate, Plunge Rate and rough Feedrates

Manual Coordinate System Rotation\*

Drill Arrays and Repeats

Distance Chamfer

**v8.03, 9-4-2002**

Random Access Tool Changer\*

**v8.01, 7-24-2002**

Automated Part Count

Block Skip

Rapid Override on F9 Key

**v8.00, 5-19-2002**

Coordinate System Rotation\*

Irregular Pocket Cleanout

Axis load meters

Intercon integration

Actual Speed Display

New Digitizing Cycle, ? Cam Copy?

**v7.53, 5-19-2002**

CAD Vector Preprocessor\*

Inch Precision on Lathe?s DRO Expanded to 5 Digits

**v7.50, 12-4-2001**

Lathe C Axis \*

Custom Probing Macros (M115, M116, M125, M126) \*

Data Logging Macros (M120, M121, M122, M123)

Error Message Logging

CAM/Wall Following Digitizing Cycles \*

Z Axis Scale Summing

Bi-Directional Laser Compensation \*

Arithmetic Functions in G-Codes and User Variables

**v7.15, 10-8-2001**

Rotary Axis? Feedrate Slaved to Non-Rotary Axis

**v7.14, 9-28-2001**

Enhanced Rigid Tapping \*

No Limit Homing

F10 - Park to Main Menu

Lathe G83, G84, and G85

Positive and Negative Travel Limits

**v7.08, 4-13-2000**

Extended Work Coordinate Systems \*

Semi-auto and Batch Tool Measurement

**v7.07, 1-28-2000**

Tool Number Search

**v7.00, 5-21-1999**

Conversational Lathe Capability

Fourth Axis Pairing Implemented

Parking Meter for Mill and Lathe

**v6.02, 11-4-1998**

Grid Digitizing Speeded Up \*

French and Chinese (ROC and PRC) Languages

Rigid Tapping (G84) Cycle \*

Lathe Clean Out Cycles G70, G71, and G72

**v6.00, 6-5-1998**

Smart Search ? Program Restart

Drag MapTM

Leadscrew Error Compensation \*

Look-Ahead Cutter Compensation

Toolpath Machining Time Estimate

Single Axis Probing Cycle Added \*

**v5.27, 9-26-1997**

3D Arcs: Pipes, Bowls, Elbows

**v5.24, 4-4-1997**

Radial and Grid Digitizing Added \*

Rotary Axis Support, degrees

**5.20, 7-1-1996**

Tool Path Graphics with Cutter Compensation Display

**v5.19, 6-26-1996**

Mirror and Scaling G-Codes \*

Multiple Patch Digitizing Added \*

**v5.18, 4-25-1996**

Engraving Software \*

**v5.14, 1-24-1996**

Multiple Languages \*

**v5.13, 1-6-1996**

Probing Cycles \*

**v5.12, 11-10-1995**

Three Point Arcs

Motor Temperature Estimation

**v5.10, 8-4-1995**

Digitizing \*

Teach Feature

Copy, Repeat, & Mirror Routines

**v5.00, 5-24-1995**

Work Coordinate Systems \*

Software Travel Limits

Lash Compensation

New User Interface

**v4.12, 4-20-1995**

Repeat-to-Depth Routine

**v4.00, 11-9-1994**

Tool Check

Tool Library Access in GGE

Canned Drilling/Boring Cycles

Part Timer

**v3.24, 8-2-1994**

Spindle High/Low Range \*

**v3.21, 7-6-1994**

Subroutines and Macros \*

**v3.20, 5-2-1994**

Tool Changer Support \*

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