

Product Update

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IMPORTANT NOTE:

This version has been tested with **Windows VISTA** operating system. Under Vista operating system if the USB communication is suddenly terminated (due to hot-unplug or PMAC power shut down), the **Windows VISTA** operating system may cause **PC Blue Screen**.

The following software has been updated in the **PMAC Executive Pro2 Suite Version 4.2.6.0**

Software Application(s)

Version Number

- **PcommServer** (Version 4.2.6.0)

New features added

1. Added functionality for SetX Diameter command for lathe.
2. Added functionality to handshake with Control Panel PLC in NC Mode Change.
3. Added 2.36 supported registry functionality in Lathe /Mill
[HKEY_LOCAL_MACHINE\SYSTEM\CurrentControlSet\Services\PMAC
C\Device0\Nc0\Code]
bTCodeTurnsOnHCode"=dword:00000000
bTCodeTurnsOnDCode"=dword:00000000
HCodeTurnOn"=dword:00000000
bHCodeTurnsOnG43"=dword:00000000

Bug Fixes

1. Handles the case with I45 (foreground reporting) set to 1.
2. Added handshaking for opening and closing the binary rotary buffer.
In our NC Server we were opening and closing the Binary rotary buffer without any handshaking from PMAC. Also when we were clearing the rotary buffer we were not clearing the indexes (PMAC and HOST) in correct order necessary for binary rotary buffer operation and this was the evil of most of our problems related to...
 - Program rewind and then sometime starts in the Middle
 - Programs jumps to some locations and start executing
 - Switch mode between Auto to MDI will show Auto program buffer in MDI modeAfter realizing this problem now in the latest server the logic is added to make sure that Rotary buffer is Open or close by checking binary rotary buffer bit from Global status (Bit 20).
3. G52 Problem is Fixed.

In the Inch or Metric mode G52 or G92 was converting the value twice. It was using NC status register for determining the current mode for conversion instead of Parsed code register.

4. The error Generated from PC like File not found in M98 or G65 call will Abort the NC motion program.
5. Fixed problem related to program line number display in RUN mode. IF G103 P1 mode is selected then line numbers display was incorrect. This fix corrects the problem.
6. Tool offset will allow 6 digits after decimal point.
7. On Program Stop and rewind (M30) Scaling and Mirroring mode as well as the offset values were reset.
In M30 (Fun: CompleteProgramEnd()) Scaling mode and Mirror mode are cancelled but did not reset the values.
8. Fixed message when tool offset is changed.
(Fun:SetNcOffsetValue()). The Offset modified change message is based on current inch/metric status bit.