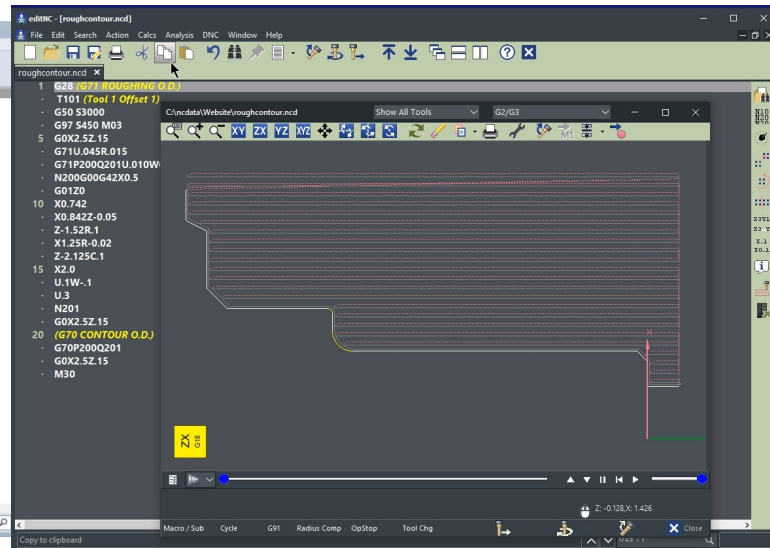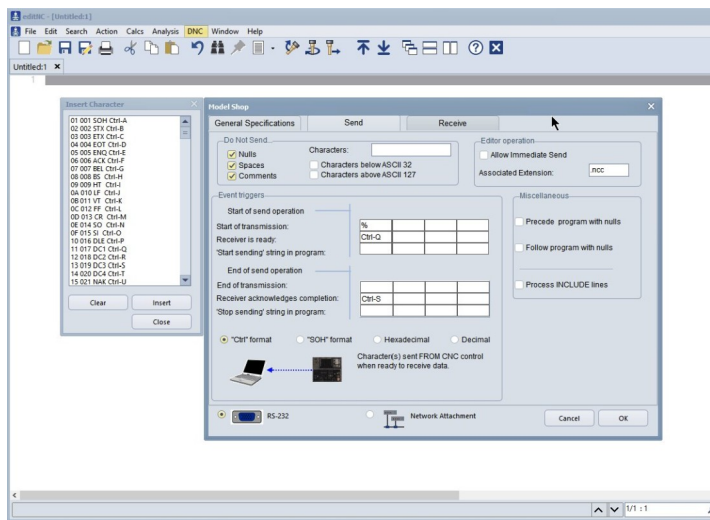# EditNC Release 12.0.0
(1 March 2021)

New:

- Editor converted to native 64 bit program
- New color "styles" simplify tailoring to user taste
- Backplotter improvements
    - Arrow keys can now be used for panning
    - CL file tool axis can be hidden
    - New print options (Create bitmap, copy to clipboard)
    - Improved interface showing more information
    - Better replay slow-speed control
    - More warnings on questionable program blocks
    - Better STL overlay sectioning for lathe programs
- New auxiliary toolbar buttons
- Better Fanuc macro handling of missing brackets
- General Analysis
    - Now supports many Okuma lathe cycles
    - More warnings on questionable program blocks
- File Open, Save, SaveAs, Insert, and DNC operations can be logged to a central file
- DNC provides options for networked controls
- Heidenhain→Fanuc conversion retains comments
- Minor interface improvements and changes
    - Note: Graphical file preview has been removed from Search for Files
- Bug fixes
-

EditNC Update 11.6.1
(27 May 2020)

Fixes:

- Some cycles not displayed shown in backplotter in incremental mode

EditNC Update 11.6.0
(14 February 2020)

Enhanced:

- G10 L2 and G10 L20 WCS set command is now supported
- Added Okuma and Fadal work coordinate systems (Fixture offsets) G15Hnnn and Ennn
- Backplotter Select Element dialog shows more detail about moves and cycles
- General Analysis now shows Fanuc variables with crossreference (where-used) list
- STL and DXF overlay functions improved and moved to main backplotter menu
- Analysis - Cycle time estimates improved for lathe cycles
- Okuma lathe suppport for backplotter

Fixes:

- Fix: Backplot and Analysis can loop if G75 peck distance is zero
- Fix: Editor crashes if closed when backplot is being prepared but not yet displayed
- Fix: Analysis-Time Estimate was incorrect if tool went below X0.0
- Fix: G71-G71 pair preceded by a G1 move may fail due to "no depth parm" error.

EditNC Update 11.5.0
(1 September 2019)

Enhanced:

- New option to set English/Metric units defaults
- New "Auto Determine" option to specify tool change commands
- "Visualization Plane" added to backplotter – easier to see orientation
- Several improvements to General Analysis
- Minor improvement configuring DNC connection
- STL and DXF files can overlay backplot – contact us for usage info
- Various interface improvements

Fixes:
- Fix: "Save As" did not always honor file type correctly
- Fix: Some arcs with radius < .0091" were not plotted correctly
- Fix: Analysis could fail on some programs with CSS option checked
- Fix: Compare options not saved between sessions
- Fix: Analysis output of some metric lathe programs was incorrect

EditNC Update 11.4.1

- Fix: M6 is always processed at end of a block (so e.g. M6T1 will load, not preselect tool 1).
- Fix G72 facing was incorrect in some left-to-right cases

EditNC Update 11.4.0
(8 April 2019)

Enhanced:

- New user option to keep multiple generations of backup files
- Heidenhain<->Fanuc conversion improved (e.g. Cycles defined in main pgm but used in subprograms are allowed)
- Heidenhain backplotting - Sections involving cycles and subprogram calls were completely rewritten
- Heidenhain general analysis - Sections involving cycles and subprogram calls were completely rewritten
- G52 backplotter and analysis support added
- Better cancel method for looping CNC programs in Analysis-General and backplotter
- Analysis-General now shows a warning if decimal point is used on G83/G87 Q-word (These are not valid on all controls)
- Analysis-General and backplotter issue warning if G83/G87 value is negative

Fixes:
- Fix: G83 and G87 may show incorrectly in mill-turn programs if no R-word is present
- Fix: Several Heidenhain backplot errors and omissions fixed
- Fix: Several Heidenhain->Fanuc conversion errors involving cycles fixed
- Fix: At init install,read-only background and current line bg drop downs on Options dialog are blank
- Fix: Default folder (File-Open) not consistent
- Fix: Arc problems when using work coordinate systems
- Fix: Arcs may not be rendered correctly when printing a backplot
- Fix: Minor interface issue with Calcs-Programmer hole circle was fixed

EditNC Update 11.3.1
(17 October 2018)

Enhanced:

- Backplotted element being interrogated via select+shift is highlighted
- APT GOTO/ statements with 9 parameters are now accepted
- Backplotter performance improved for most programs
- Network license check improved

Fixes:
- Fix: G72 facing will not face in +Z direction
- Fix: G75 grooving did not return to correct position
- Fix: Replaying 2-line G7x step-by-step jumps to end of program right after line 1
- Fix: Geometry calc ploygon - starts at 6, goes up to ?, back down stops at 7 but click up once for 6 again
- Fix: "This software does not accept more hardware changes..." message removed
- Fix: APTCL backplot : Incorrect error issued an MOVARC commands
- Fix: APTCL backplot - $$ comments not handled correctly
- Fix: Backplotter: Other commands may cause G71 failure

EditNC Update – Release 11.3
(2 April 2018)

Enhanced

- Add support for Select Tool separate from Load Tool

- Add support for Fanuc M98Qnnn -> N-word (Fanuc parm 6005 bit 0 controls this)
- Improvements to Editor Options screen (*Files and Editing* tab)
- "Key Folders" replace a single "Default Folder" for File Open and Save As
- Backplotter interface improvements for start-stop at cursor, "show selected", show tool, and others
- Added "Select tool" to right-click drop down
- General Analysis now reports if % at start but not end and vice versa
- General Analysis min/max improvements (Lathe cycles, high/low isn)
- Re_Post added to Convert menu
- Floating License Server
  - IP based license server replaces basic network licensing
  - Added option to automatically restart after failure
  - Reliability and logging mprovements

Fixes
- Fix: APTCL backplot failed on some fields with decimals with European decimal char set in Windows
- Fix: Potential error when saving file with no extension
- Fix: Editors occasionally incorrectly terminated by server (Network licenses)
- Fix: Heidenhain Gen Analysis axis limit output click on grid cell jumps to wrong block
- Fix: Abend if user spins mouse wheel after selecting General Analysis min/max grid
- Fix "Winlicense trial has been manipulated" message eliminated - now reports as error code
- Fix: Long RPX run causes network license timeout
- Fix: Missing NLS entries in backplotter
- Fix: DNC download did not process *INCLUDE files

Changes:
- User name no longer is included in license file

EditNC Update – Release 11.2
(19 November 2017)

Enhanced

- Action-Program Format contains new "Repair" function for Fanuc comments
- Calcs-Programming:
  - Conversion tab: Now converts between DMS, decimal degrees, and radians
  - New Arcs function
- Analysis-General now reports duplicate sequence numbers
- Improvements to printed output and backplotter appearance
- Backplot now supports use of a variable on M98 P-word
- Better performance when backplotting Fanuc programs that use macros

Fixes
Fix: G2XYR followed by XYIJ no longer flagged as error if 360 circle in 2nd line
Fix: Action-Program Format changed to not treat % and seqnos characters as comments
Fix: Analysis reported bad R-word = 0 if R defined by a variable
Fix: Analysis incorrectly reported decimal error on some commands (e.g. FUP)
Fix: Network licensing no longer requires closely coordinated clocks
Fix: Action-Rotate may not properly handle G54-G59
Fix: Action-Rotate may change HAAS G12-G13 incorrectly
Fix: Backplotter - Some 360 deg arcs failed if start/stop angles didn't subtract to exact zero
Fix: License file failed to register on some computers

EditNC Update – Release 11.1
(8 June 2017)

New

- New floating license server that runs as a Windows service program for complex networks

Enhanced

- Added rotation about part axis using keyboard XYZ keys (with Shift for reverse rotation)
- Rotation using backplotter axis rotation buttons is improved
- Improved messages when editor is registered
- Dashed arcs show indexing movement of rotary axis
- New "orientation block" improves backplot visualization

<u>Fixes</u>

Fix: Issues when decimal separator is a comma
Fix: 10165 error when using Action-Convert
Fix: Backplots may be blank if program issues "Possible loop - do you want to continue?"
Fix: G,L,P words can now be specified using variables (e.g. G#50)
Fix: Some Windows error messages contained gibberish
Fix: Action-Convert menus unavailable
Fix: Color change slider not visible in graphical compare
Fix: Linear G90<->G91 incorrect output
Fix: Heidenhain programs failed when using comma as decimal separator
Fix: Erroneous output backplotting Heidenhain arcs > 360 degrees
Fix: Possible error in cycle time estimate if G94 used in machining center program

editNC New Release - Release 11.0
(1 February 2017)

General

- New release created using new development tools (Note that Windows XP is no longer supported)
- New licensing options and activation methods including floating network licensing
- All windows and dialogs now support Unicode characters
- *Default folder* button reinstated on file Open and SaveAs dialogs
- New *Goto line number* ability added to main editor screen
- GMacro is now integrated into editor
- New *Close All* command added to File menu
- *Search For Files* improved and moved to Search menu (from File menu)
- New option to allow lower case input within comments if "Convert Keyboard Input to Upper Case" is set
- Send To is improved – up to 25 entries now available and "already running" detection of 64-bit programs added
- New reference file format (uses simple txt file)
- 10-20 small interface improvements

Backplotter

- User interface refreshed
- New slider to quickly locate operations within a backplot
- Improved performance for many programs
- Fanuc G94 lathe facing cycle added
- Option to show lathe toolpaths as front or rear turret
- Integrated support for BairTek BackplotX package (To backplot Siemens, Dynapath, Okuma, etc.)

Analysis

- Improved detection of numeric format errors (e.g. G1X5..32)

- Variable and error windows in Analysis-Macros/Vars can be resized

Compare

- Compare logic is all new
- New print function lists file differences

<u>Fixes and Changes</u>

Fix: G1XR (line-radius on lathe) may show incorrectly on backplot
Fix: Search: Error message issued if regex ends with | character
Fix: Geo Calc right angle triangle - can't enter angle < 1 degree.
Fix: Search for files - Column sort on date is not correct
Fix: File selection for compare truncates very long file specs
Fix: Line numbering option reset incorrectly after compare
Fix: Editor hangs if child window is resized during long compare
Fix: Lathe CSS time estimates are wrong
Fix: Invalid G50 can hang analysis
Fix: Analysis may hang on G76 2-line command
Fix: G76 2-line cmd does not apply default decimal positions to R-word on second line (Tapered thread)
Fix: General Analysis Misc tab may only show first work coord system

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