

Test Release Changes KFLOP/KMotion Versions 4.34e -> 4.34f 12/05/2016

General

Change Apps/Dlls to use XP Platform so they can still run under Windows XP

KMotionCNC Screen Editor

Add Momentary Button to Activate Bit based on Var Value

Add GCode Editor Control Read Only option Var = -1 no change, 0 = read only (with right click override), 1 = read/write.
2 = read only no override

Fix initial sync of Caption/MaxBox/MinBox/ResizeFrame/maximize when Main Tab not initially selected

KMotionCNC/GCode Interpreter/Coordmotion Libraries

GCode Interpreter expanded from 6 to 8 Axes. U V words supported.

Added Trajectory Planner Settings for UV Axes

Add emc_UV.var Example to save UV variables/offsets also

Add GCode Editor syntax highlighting for GCode U V words

New "Save Always" option on Edit Fixtures Dialog. Defaults to enabled, Checks for Offsets/Variables Changes every 1 second and saves to disk on any changes.

Fix Feedrate/Spindle Speed Bar Graphic drawing out of bounds

Fix Peck Drill Cycle Pecking up to initial z plane instead of clearance plane (R)

Added GCode Interpreter Radius Compensation Mode Entry Move. EMC_COMP_ENTRY_STYLE vs FANUC_COMP_ENTRY_STYLE. See:

http://www.dynomotion.com/wiki/index.php?title=Internal/concave_Path_Tool_Radius_Compensation_Example_G41/G42

Offsets rounded to 4 decimals in mm Mode and 6 digits in Inches Mode

Screens

SetTwoValues.scr Example to set two values in KFLOP

KFLOP

Fix issue with Soft limits not being honored when MoveExp called while feedhold released

KMotion.exe

Main Window Size and Position persistence

Restore Lines Viewed in C Program Editor and any Selection when switching C Program Threads

Force KFLOP Menu Option always on

C Program Examples

Add Mark's MPGSMoother.c example