

Test Release Changes KFLOP/KMotion Versions 4.34h -> 4.34i 5/7/2017

Trajectory Planner

Limit Break Angle to 179 degrees as full reversals shouldn't be rounded and cause errors.

Kinematics Class for 5 Axis BC Trunnion Type Table added. CKinematics5AxisTableBC.

KMotionCNC Screen Editor

Main XYZABC DRO's now support customizing Font, Size, and Background Color

GCode Edit Window now supports Font and Font Size customization

Main KMotionCNC now supports Background Bitmap

Image Buttons, Labels now do proper Alpha Blending with Background color or Bitmap

Dual Labels Type added for F (Feed Rate) and S(Spindle) bitmaps which show customizable and different bitmaps based on Feed Rate mode (Threading) or CSS mode that properly Alpha Blend with Background. 32 bit png bitmap files with alpha added (SR.png SRCSS.png FR.png FR32.png)

Better error reporting of missing bitmaps

Radio Buttons, Edit Controls, CheckBox Controls, DropDown Controls now support resizing, fonts, colors, international text.

Feed Rate Override and Spindle Rate Override background color/bitmap fixed

Test Screens Test1.scr and Test2.scr added

MomentaryToggle.scr example added

Background bitmap res/Images/tillable-metal-textures-8.jpg added

Graphical symbols within Screen Editor now displays International Text by using and requiring OpenTK.Compatibility.dll

If KMotionCNC not running when Launched then KMotionCNC from Release Folder is Launched rather than Debug Folder

C Program Examples

DoPCNoWait, DoPCIntNoWait, MsgBoxNoWait Functions added to KflopToKMotionCNCFunctions.c

CheckTripStates.c Example added for determining Independent Motion Trip States

Modulo360.c – for resetting angular axes that rotate multiple revolutions back toward zero

OutputToPWM3axisSignMag.c Added

PrintRigidTapParams.c – example for use with G84 Rigid Tapping

\\RS232\\ModBus\\DVP-PLC MODBUS-56IN-46OUT 170102.c Modbus example Added

KMotionCNC

Support for Screen Editor Changes noted above

G84 – Rigid Tapping now supported. See wiki
http://www.dynomotion.com/wiki/index.php?title=Rigid_Tapping_G84_Setup_and_Use

GCode Viewer Right/Left Mouse click sets focus so Mouse Zoom Wheel works on Split Screen under Windows XP

G95 - GCode Interpreter G95 Units per Rev Support. Allows G1 G2 G3 motion synchronized to Spindle

Trajectory Planner Negative Resolution Supported

GCode Interpreter Set Next Statement Improvements

KFLOP

KFLOP open write file using 'a' append mode