

## **Test Release Changes KFLOP/KMotion Versions 4.35f -> 4.35g 10/30/2021**

### **KFLOP**

Independent Trip State Trajectory Planner accuracy check changed from 11 significant digits to 10 significant digits after certain special parameter sets show slightly higher errors.

### **KMotion dotNet**

Fix methods KM\_Controller.Compile() and KM\_Controller.CompileAndLoadCoff() to properly return detailed error message.

Fix KM\_Interpreter, SetupParams.SetTool() to properly set tool table diameter.

### **KMotionCNC**

Fix the SetValue Dialog (also used for InputBox in KFLOP) so any invalid entry remains in the Set Value dialog until a valid entry is entered or the Operator cancels.

Fix round off errors on GCodeViewer Setup Values ie 0.1 displayed as 0.1000000149

GCode Viewer is now more consistent with regard to panning and zooming in both Orthographic and perspective modes.

New capability added to KflopToKMotionCNCFunctions.c GetToolSlotAndID(int \*Slot, int \*ID) that allows KFLOP to request the currently selected Tool Slot and ID based on the previously selected Tool TWord. Which uses PC\_COMM\_GET\_TOOL\_SLOT\_ID in PC-DSP.h

Host Status updated in KFLOP now has a new status whether RTCP is currently active HOST\_RTCP\_ACTIVE\_BIT defined in PC\_DSP.h. RTCP\_ACTIVE defined in KMotionDef.h to access that bit.

TCP Button Screen example added which displays RTCP state and allow it to be changed with button push

Change Buttons so that whenever Text is changed it is Invalidated and re-drawn.

Screen Scripts for Dialog Controls now allow missing settings and settings in any order. This makes it easier for a C Program or SubScript to modify one attribute while leaving others unchanged.

Fixed Command line Option where Hex USB Location ID can be used to specify a specific KFLOP

### **KMotionCNC Screen Editor**

Support SubScripts through GUI with TreeView Control see related Video

Fix crash when adding a Script command to a button where the Script is to load a Screen Script File and selecting a file in the same folder as the main Screen Script which is also in the default Screens directory. The code attempted to remove the path twice.

### **KMotionCNC/GCodeInterpreter**

Fix GViewer Plot for G84 Rigid Tapping when GCode Offsets are in effect.

### **Trajectory Planner**

Improve Corner Rounding such that when adjacent segments are rounded using the entire segment for rounding a pair of segments with double "curvature" isn't created resulting in a slowdown if acceleration is limiting feedrate.

### **C Programs**

HomeMM\_V9.c added that fixes 2 bugs involved with inverted home switch polarity  
RigidTapMultiPassJogM119\_v4\_Jim.c – Rigid tap example with fix

### **GCode Programs**

Rectangle Cutout Paramatized including Angle.ngc included for cutting hole patterns and cutting pockets contributed by  
VIC