

PC Apps, Libraries, and most examples are now built for both 32-bit and 64-bit Configurations. There are now 4 binary folders: Debug, Release, Debug64, and Release64 for the respective Configurations. This allows 64-bit Apps and Languages that interface to KMotion Libraries via .NET or C++ to be used. See wiki [here](#).

GCodeInterpreter

Don't flag errors saving tool offsets if no Tool Table file specified.

Exposed GCode Parameter Variables to the .NET Interface with GetParameter/SetParameter functions.

KMotionCNC

Added Feed Time and Feed Distance to Tool Table. These accumulate Time and Distance for the tool while GCode is feeding (G1, G2, G3). Used for determining Tool wear. Use Reset buttons to clear when Tool is replaced. Tool Table backup file with a .bak extension is saved whenever the Tool Table changes after an initial launch of KMotionCNC or 24 hours since last being backed up.

GCode files with very long file names may not fit in the KMotionCNC Title Bar and pushes the Job Time off the screen. Long file names now abbreviate the path by replacing folders near the middle with '...' A "tool tip" was added where hovering the mouse over the title bar (for 1.5 seconds) shows the full path potentially in multiple lines and also includes the Job Time.

Help Files

Internal Help Files displayed within KMotionCNC or KMotion flagged a Java Script warning. This has been corrected.

Help Files Updated for Feed Times In KMotionCNC Tool Table

Several broken links were fixed.

KMotion

Kogna Flash COM error message fixed

If no Board Present Compile for board selected in Options rather than showing error

Python Examples

Add Python examples OnOffTK and GCodeWithCallbacks and changed Folder and build settings of IronPython OnOffWPF example. GCodeWithCallbacks and OnOffTK run with standard Python and do not require IronPython. These use pythonnet for .NET access to the KMotionLibraries. OnOffTK uses Python's tkinter to create a simple GUI of a window with two buttons.

Jogger.NET/KMViaVB Visual Basic Example/Interface

Updated to interface with 32/64-bit handles.

Fixed issue Marshalling Compiler Error Messages as UNICODE wide characters.

KMotionDLL

When using the TI Compiler a bug existed where the Max Thread Space was always being compared to KFLOP's max allowed total Thread Space. When using Kogna and Thread #7 the default Thread space size (0x100000) is larger than KFLOP's total Thread space (0xb0000) which causes an error. This has been corrected to compare to Kogna's Max allowed Thread Space when using Kogna.

KFLOP

Made Firmware global variables 'bb', 'ilen', and 'src' static so as not to conflict with User Program Names

Kogna

Made Firmware global variables 'bb', 'ilen', and 'src' static so as not to conflict with User Program Names