

**Postby cncdrive » Sat Oct 08, 2016 10:46 am**  
**UCCNC version 1.2026 is ready for testing.**  
**The download link:**  
**[http://www.cncdrive.com/UCCNC/setup\\_1.2026.exe](http://www.cncdrive.com/UCCNC/setup_1.2026.exe)**

**The changes/bug fixes list:**

- On startup first time if MDI was entered with the Enter key it did not accept the typed in command, fixed.**
- If the Toolpath view was in focus then the Enter key did not access the MDI, fixed.**
- Softlimits issue after homing fixed.**
- Screeneditor was missing the Add Codeview button, button was added.**
- Adding new Toolpath view in screen editor had a bug and caused an exception, fixed.**
- The M10/M11 commands had a problem when in some cases the commands were optimised out and accidentally removed in CV mode, fixed.**
- The exec.Wait function was not precise, had a problem, fixed.**

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**Postby cncdrive » Wed Oct 26, 2016 1:04 pm**

**UCCNC version 1.2027 ready for testing**

**Postby cncdrive » Wed Oct 26, 2016 1:04 pm**

**UCCNC version 1.2027 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2027.exe](http://www.cncdrive.com/UCCNC/setup_1.2027.exe)**

**Bug fixes and changes:**

- Current selected g-code line highlighted with selectable color on the toolpath.**
- Jog screen did not resize on Window resize event, only when state change, bug fixed.**
- Appearance tab page items were reorganised.**
- On no screenset text found in the screenset file (zero text) the startup frozen, bug fixed.**
- Textentered and Texfield click events were added to the plugin interface.**
- Chargepump2. pin configuration was added (except the UC100 which has low pin count).**
- Jog safe probe mode was made switchable with off by default. Button JSP to enable/disable it was added to the screenset.**
- THC enabled, THC anti dive and THC anti down configurable outputs were added.**
- Control keyboard key fixed shortcut was added to override the cont.jog mode to step-jog mode.**
- Step mode jogging was converted to DRO based. Textfield for jog step distance was added to the jog screen.**
- Laser outputs M10 still had a bug where the**

**command was optimised out and removed after null sized motion commands, bug fixed.**  
**- UC300ETH and UC400ETH DHCP acknowledge timeout was changed from 500msec to 3000msec to support routers with slow response to this command.**

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**Postby cncdrive » Tue Nov 01, 2016 4:06 pm**  
**UCCNC version 1.2028 is ready for testing.**  
**The download link:**  
**[http://www.cncdrive.com/UCCNC/setup\\_1.2028.exe](http://www.cncdrive.com/UCCNC/setup_1.2028.exe)**

**Bug fixes and changes:**

- Getvar and Setvar functions were moved to the exec object, so are now callable from macros also.**
- M44 motherboard firmware was changed with pullups/downs disabled which caused problem for the inputs voltage range for this motherboard, so the inputs did not work.**
- Virtual mouse function was added to emulate mouse move and click with keyboard, enable it with the Tab keyboard key.**
- Screeneditor was missing the Add fill button and delete fills was also not working, added and fixed.**
- UC300ETH\_hi and UC300ETH\_low motherboards configurations had an issue and the software did not startup in these modes, fixed.**

**cncdrive**  
**Site Admin**

**Posts: 1583**

**Joined: Tue Aug 12, 2014 7:17 pm**

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**Postby cncdrive » Wed Nov 09, 2016 11:41 am**  
**UCCNC version 1.2029 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2029.exe](http://www.cncdrive.com/UCCNC/setup_1.2029.exe)**

**Bug fixes and changes:**

- Issue fixed with virtual mouse function leaving the DROs when clicked with the pointer above the DRO fixed.**
- Focusoutoffields function was added to the plugininterface and macro interface. The function can be called to deselect the DRO (blinking cursor leave) which was selected for input.**
- Issue fixed with the g-code line pointer stepped over with one line the M3 function if there was a feedrate change code in the next line, when the THC was enabled and the system was waiting for the ArcOK signal which did not come on. Now the g-code line pointer stops on the M3 line properly.**
- Laserengrave plugin was updated with min. and max. pixel brightness offsets settings.**

- Screen editor issue was fixed with Combobox Font size selection and save to screenset file caused a screenset error. Furthermore the Font size is now casted to integer to show as integer value in the Screen editor Font property field.
- The Utility tool in the /Util folder was updated with a bug fix which allowed to select the ethernet controllers even if the device was unpowered and had no connection anymore.
- Xbox360 plugin bug was fixed which did not allow the plugin to run in the background when the window was closed and in some cases caused the plugin to crash on closing.

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**Postby cncdrive » Sun Nov 27, 2016 1:02 pm**  
**UCCNC version 1.2030 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2030.exe](http://www.cncdrive.com/UCCNC/setup_1.2030.exe)**

**Bug fixes and changes:**

- Virtual mouse function was further developed. Now in virtual mouse mode on Enter keyboard key press the left mouse down is emulated and on keyup the mouse left button up is emulated. The enter key can be used to drag items, e.g. the rulers on controls. And the virtual mouse is now enabled also on

**sub-windows, e.g. on the g-code open window, so it can be used to open files.**

**- The user fields and checkboxes ID $\geq$  20000 are saved in the profil on Save file button press and on software closing.**

**- The macroloops missed the EN-US cultureinfo setting, so there was a number format issue in the macros when run in the loops on non English Windows, problem fixed.**

**- The macroloops started too early, a bit earlier than the GUI finalised the initialisation, problem fixed.**

**- Mouse scrolling to move the g-code was added to the g-code viewer.**

**- HTML encoding problem for special characters was fixed.**

**- An option was added to the General settings page to precompile all macros on the software startup. If the option is set then all macros are compiled on the software startup and will run from the prebuilt assembly when the macro is called until the macro text is changed. The macros call always checks and compares the to the previous macro text and if the macro text was changed then the macro is recompiled.**

**If this option is not set then the macros are not recompiled on the software startup, but they are still stored compiled after the first macro call and until the macro text is changed. If the text is changed then the macro is recompiled. The macros executes an average of 1000 times faster if precompiled.**

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**Postby cncdrive » Sat Jan 07, 2017 11:28 am**  
**UCCNC version 1.2031 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2031.exe](http://www.cncdrive.com/UCCNC/setup_1.2031.exe)**

**Bug fixes and changes:**

- Modbus plugin packet send retry count did not set and remained on default value, fixed.**
- Jog panel auto popup disable option added with option to pop on mouse click only.**
- Macro executer bug fixed which disabled the macro runs on Stop in previous test release.(Was a serious issue and this is why the previous test release was withdrawn.)**
- Macros precompile progress window was added to macro precompile option. The window shows the progress of the macros compilation on startup and the process can be terminated pressing the onscreen Interrupt button.**
- Up/down type textfields with same ID did not update eachother, fixed.**
- Plugininterface Informplugin and Informplugins functions were added, the functions can send and return generic objects between plugins and macros. (Example in the docs.)**
- exec.Codelist function was added which function**

can execute a List of g-codes using the look-ahead (CV) buffer. (Example in the docs.)

- Feedrate<0.6 was not working with probing, fixed.
- Blink property was added to the LEDs screen objects, so the LEDs can be blinked in their on states if this property is set true.
- New screen item Slider was added to the screen editor. The slider can be used to control the value of textfields, it works like the Windows Slider control.
- Laser plugin min. and max. values were changed to show in percent instead of 0-255 and the full range of 0-100% is not allowed for both.
- Variable #5060 was added to indicate success and errors of the probing.
- Input triggers were upgraded from 48pcs to 96pcs.
- Output triggers were upgraded from 48pcs to 96pcs.
- Hotkeys were upgraded from 48pcs to 96pcs.
- Button codes to hide and show jog panel were added. Can be used to pop out and hide the jog panel with hotkeys or input triggers.
- Toolpath view mouse double click to reset the toolpath to top view and contents zoom function added.
- Unknown g-code Wait for Cycle Start option could stuck and not run in some circumstances, fixed.
- Softlimits did not work properly when using slave axis, the software still checked the slave axis's softlimits range while it should not do that, fixed.
- G10 L1 load tool table Z=null case was not handled and generated an exception, fixed.
- G10 L1 load tool table was working with 48 tools only, was now updated to 96 tools.

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**Postby cncdrive » Tue Feb 07, 2017 5:20 pm**

**UCCNC version 1.2032 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2032.exe](http://www.cncdrive.com/UCCNC/setup_1.2032.exe)**

**Bug fixes and changes:**

- Spindle pulleys ratio now scales the encoder resolution for rigid tapping operations.**
- Q peck depth parameter was added to rigid tapping G33.1 and G33.2 to support peck tapping.**
- The CV motion planner had a problem with miniature lines between 2 arcs, it slowed down the feedrate.**
- 6pcs of Auxiliary encoder counters were added. (Only the ethernet controllers has and will have this new feature.)**
- Spindle closed loop PID controller was added. (Only the ethernet controllers has and will have this new feature.)**
- Feedrate set in macro with the F keyword was not working in some cases because of a synchronisation problem.**
- OpenGL toolpath view farplane height was extended to see through extreme large objects which was a problem.**
- The digitizing filename textfield for M40 got empty and caused an error message on M41 save digitizing**

**file operation if the filename select was previously cancelled by the user.**

- The JRO analog channel input if changed when the jogging was in the slowing down state and if in the same time a new jog button was pressed still when the axis was slowing down could cause the axis to continue jogging which could be stopped with pressing jog again or stop or reset, fixed.**
- When jogged an axis to softlimits the other axes if any others were also moving and if they did not reach the softlimits then they stopped instantly, this was corrected to deceleration.**
- Problem with Ismoving function that it returned false when motion stopped, but before the coordinates update in the position DROs, this was now properly synchronised to the DROs. This problem caused the wait loops to return too early which could cause issues and also it caused problems with probing.**
- Macro precompiling option if set could possibly cause a software crash on startup when the precompile window was closing.**
- The Autoleveler plugin was updated (thanks to Cahit).**
- XHC pendant plugin was updated to read the step distance from the step distance DRO instead of from the step distance buttons.**

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**Postby cncdrive » Wed Feb 15, 2017 7:18 pm**  
**UCCNC version 1.2033 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2033.exe](http://www.cncdrive.com/UCCNC/setup_1.2033.exe)**

**Bug fixes and changes:**

- Fix for the new Q peck parameter for G33.1/2 rigid tapping.**
- M31 macro code got an issue (one while ismoving row was accidentally deleted from the file) in the previous version, was fixed now.**
- Removerunfromhere function was added to the plugin and macro interfaces. The function removes the RFH window to be shown sign after it's button is called. (more info in the docs)**
- Probe stopped not properly with deceleration when the probing was interrupted by the user with a stop button, fixed.**
- Support for CNC4PC M45 motherboard for UC300ETH was added. (The M45 is a near future product, it is not available yet for purchase.)**

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**Postby cncdrive » Wed Mar 15, 2017 8:31 pm**  
**UCCNC version 1.2035 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2035.exe](http://www.cncdrive.com/UCCNC/setup_1.2035.exe)**

## **Bug fixes and changes:**

- **An exception was thrown and not handled if the macro folder was deleted and the software started, fixed.**
- **An exception was thrown and not handled if the g-code viewer was scrolled with the mouse roller while a g-code was being loaded, fixed.**
- **The toolpath current line highlight was not showing the correct vectors after G33.1/2 codes in the g-code program, fixed.**
- **The RFH window was not invoked from the UI thread which could cause problems when the RFH window was shown if the Cycle start was called from plugins from other than the UI thread, fixed.**
- **The UCCNC installer language is now selectable, English, German, French and Hungarian languages are available. (Only the installer language, not the software GUI!)**
- **On multi-monitor systems the Openfiledialog window did not always appear on the same screen on which the UCCNC application was running. This is basically a Windows problem/bug, we've added some tricky codes to solve this issue.**
- **The M10/M11 did not work always properly between arcs, fixed.**
- **The Limits override function did not always work properly in the Demo modes, fixed.**
- **The UCCNC installer and application is now digitally signed by CNCdrive Kft. with our Windows Code certificate which means a higher trust from Windows itself and from other applications like Antivirus softwares.**

**- Arcs radius tolerance parameter was added to the general settings page. The tolerance setting is for G2/3 arcs when defined with the Radius parameter.**

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**Postby cncdrive » Wed Mar 22, 2017 7:09 pm  
UCCNC version 1.2036 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2036.exe](http://www.cncdrive.com/UCCNC/setup_1.2036.exe)**

**Bug fixes and changes:**

- Screenset file load error details are now shown on the error message window.**
- The arc radius tolerance parameter was missing from the Plasma screenset, fixed.**
- The FRO and SRO were blinking the number on the screen when updated from a macro loop or a loop from a plugin, fixed.**

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**Postby cncdrive » Tue Apr 11, 2017 8:33 pm**

**UCCNC version 1.2037 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2037.exe](http://www.cncdrive.com/UCCNC/setup_1.2037.exe)**

**Bug fixes and changes:**

- In the laser engrave plugin in some cases the code execution did not start, but triggered an e-stop, issue fixed.**
- The spindle control analog output was always giving 0 value on the UC300ETH if the spindle PID controller was disabled, issue fixed.**
- The Port 4. pin 6. input was not working properly for homing with the UC300ETH, issue fixed.**

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**Postby cncdrive » Wed May 17, 2017 5:24 pm**

**UCCNC version 1.2038 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2038.exe](http://www.cncdrive.com/UCCNC/setup_1.2038.exe)**

**Bug fixes and changes:**

- Added G50/G51 scaling code.**
- Added G68/G69 rotation code.**
- Added distance to go (DTG) DROs.**
- New startup screen.**
- Startup was made 10-40% faster (depends on PC).**

- In screen editor mode the page up/ page down to bring objects to the front and back was reversed, fixed.
- FRO/SRO slider validation issue made these DROs to reset to 0 when the DRO value was changed with user value input, fixed.
- Feedrate and Spindle speed overridden DROs were added.
- G-code reload button was added.
- /d command line argument was added to let run in Demo mode only.
- Toolpath boundaries lines switch on/off option was added.
- g-code editor mouse right click Cut, Copy, paste etc. popup menu was added.
- The output triggers function select list contains duplicated entries of port#4, corrected.
- Toolpath drawing error for very very small full circles, the circles may not be drawn at all on the toolpath window, fixed.
- Issue with canned cycles, Peck to always rapid down to the R parameter if defined, fixed.
- Windows 10. mid-March cumulative update and Creators update release OpenGL bugs which slowed down the software to an unusable level, workaround was added.
- Tool center point (TCP) follow view mode was added to the Toolpath viewer.
- FRO sometimes locked after Stop button, it was only locked when there was no motion, so it was not a serious problem, but was now fixed.
- FRO over 100% with arc (G2/G3) codes could cause a problem when the circle toolpath deformed (too

high axis speed was used) if the velocity parameters where different for the XY axis.

- UCCNC message text was added to the message windows to let users always know the message windows is UCCNC's message.
- UC300USB 2nd probe active low setting was not working, fixed.
- Ismoving wait was missing at the end of macros which caused coordintes registration error in exec.Code function calls if the next call did not move an axis but the previous code moved it, then the position could roll back to the previous command.
- Softlimits handling was separated to 2 parts, one is the g-code precheck and the second is checking the softlimits while in motion.
- Apply and Save Settings protection was added to not let to press buttons and enter DROs while applying or saving settings.
- Visual Basic plugin template file was updated.

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Postby cncdrive » Mon May 29, 2017 9:07 am  
UCCNC version 1.2039 is ready for testing.

The download link:

[http://www.cncdrive.com/UCCNC/setup\\_1.2039.exe](http://www.cncdrive.com/UCCNC/setup_1.2039.exe)

Bug fixes and changes:

- S overridden max. and min. limits to show in the DRO were missing, fixed.
- FRO and SRO override with analog input on the UC300 and UC300ETH did not update the S overridden and F overridden DROs, fixed.
- The probed coordinates registration into the # variables was accidentally commented out, so it was not working in the previous test release, fixed.

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**Postby cncdrive » Mon Jun 19, 2017 12:04 pm**

**UCCNC version 1.2040 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2040.exe](http://www.cncdrive.com/UCCNC/setup_1.2040.exe)**

**Bug fixes and changes:**

- Installer bootstrapped to detect the existence of the .NET 2.0 framework prerequisite. The installer now shows an error message and suggests to install the framework if the .NET framework is not installed.
- Plugininterface was missing the .Codelist directive, added.
- Plugininterface was missing the new Addled function prototype with the blinkLED property. This prototype was now added.
- G84 canned rigid tapping cycle code was added.

- G85 canned cycle was added.
- G86 canned cycle was added.
- G89 canned cycle was added.
- Reset function is now called on software exit, to remove the charge pump without any delays on the closing of the software.
- When G02/G03 arcs are stopped or feed hold on the very endpoint of the arc could cause a problem that on the next cycle that g-code line meant a full circle, because the start and endpoint were the same. This was fixed with jumping the g-code line number pointer to the next line when the arc stopped on the very endpoint.
- The macro parameters were not nulled out when a macro was previously called from MDI with parameters and after called from a button, so the parameters were still existed on that macro call, fixed.
- The example plugin (C# and VB) were extended with the Cyclestart\_event which was in the software but was missing from the example.
- Changed how the Save settings work. Till now the Save settings were done with writting the file key by key which was slow especially on computers with slow disk access and also antivirus softwares and the Windows Defender could make this process slow. This was now changed that on Savesettings all keys from the profile file are read to the memory and the keys are written in the memory and finally all settings are written to the file with a single disk access. This speeds up the save settings process and also the offsets etc. saving process on closing.

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**Postby cncdrive » Tue Jun 20, 2017 12:10 pm**

**We withdraw the 1.2040 test release version now, because a serious bug was found in the new save settings routine which can possibly mess up the profile file.**

**A new release which will fix this will be released soon.**

**For those who already started testing with this new release I ask you guys to please stop the testings and continue only with the next release.**

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**Postby cncdrive » Mon Jun 26, 2017 8:34 am**

**UCCNC version 1.2041 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2041.exe](http://www.cncdrive.com/UCCNC/setup_1.2041.exe)**

**Bug fixes and changes:**

**- The new faster save settings function (introduced in**

the previous test release) issue was fixed.

- G84 peck rigid tapping cycle P parameter was changed to H parameter and the existence of the H parameter was reversed, so that it is now a right hand tap if the H parameter is not defined or if it is 0, and is a left hand tap otherwise.
- The constructor macro startup issue was fixed, when I/O triggers could disable the macro before it was started running.
- The Input trigger was changed in a way that the input bits states are now used as a startup condition, so the input triggers will not trigger on startup, it only triggers when the user triggers the input only after the software is already running. This was originally made the same way, but due to a code error it was not working like this and the input trigger triggered anyways on startup.
- The reset popup message box is now disabled before the M99998 macro starts running

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Postby cncdrive » Fri Jul 07, 2017 6:37 pm  
UCCNC version 1.2042 is ready for testing.

The download link:

[http://www.cncdrive.com/UCCNC/setup\\_1.2042.exe](http://www.cncdrive.com/UCCNC/setup_1.2042.exe)

Bug fixes and changes:

- Save offsets and other things on closing issue which was introduced in the previous release was fixed.
- An issue with the M10/M11 code which caused the sync output to not switch in some circumstances was fixed.
- G86 boring code got a H parameter to select between rapid and feed pullout of the tool.
- Softlimit issue when the g-code softlimits precheck was disabled, but the softlimit was enabled did not stop the motion properly if the axes were commanded to the softlimits with g-code, issue fixed.
- Getrotate function was added to the macro and plugin interfaces.

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**Postby cncdrive » Fri Sep 08, 2017 1:23 am**

**UCCNC version 1.2043 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2043.exe](http://www.cncdrive.com/UCCNC/setup_1.2043.exe)**

**Bug fixes and changes:**

- Altgr + characters like # were not accepted by the MDI, fixed.
- Colorpicker window startup position was changed to not show up out of screen.

- Support for the CNCroom -UB1 motherboard was added.
- Slider control acceptclick parameter was added, so the sliders can't be moved with click only with pull if this parameter is set false.
- In the toolpath viewer a plate with grid can be setup and viewed which plate can show the table working area.
- Some THC settings were not saved on closing, this issue was caused by the recent change of the Save settings function, fixed.
- THC anti-dive switch timing got a workaround to overcome the issue described in this thread:  
[viewtopic.php?f=16&t=619&p=4545#p4545](http://viewtopic.php?f=16&t=619&p=4545#p4545)

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**Postby cncdrive » Thu Sep 14, 2017 6:57 pm**  
**UCCNC version 1.2044 is ready for testing.**  
**The download link:**  
**[http://www.cncdrive.com/UCCNC/setup\\_1.2044.exe](http://www.cncdrive.com/UCCNC/setup_1.2044.exe)**

**Bug fixes and changes:**

- UC300ETH and UC400ETH incorrect accleration calculation caused strange movements to the B-axis, fixed.

**- UC300ETH and UC400ETH when the spindle encoder got enabled caused lost steps due to an interrupt priority problem of the encoder counter.**

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**Postby cncdrive » Sat Sep 30, 2017 6:23 pm  
UCCNC version 1.2045 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2045.exe](http://www.cncdrive.com/UCCNC/setup_1.2045.exe)**

**Bug fixes and changes:**

- Rigid tapping codes set the Fset value to 0. The next motion in g-code execution reset the value properly, but if the motion was Cycle stopped on the rigid tapping g-code line that made the Fset to remain with 0 value which could possibly cause issues on the next g-codes execution, fixed.**
- If e-stopped while homing an axis with a master-slave connection with separate home inputs, if the e-stop happened when the gantry squaring was executed, when the master and slave were disconnected to do the separate homing then the e-stop could cause the master-slave connection to remain broken up, fixed.**
- Interpolation problem in the CV optimiser for very**

**small segments between arcs could cause a wrong interpolation of the small segment or arc, fixed.**

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**Postby cncdrive » Wed Oct 25, 2017 6:41 pm  
UCCNC version 1.2046 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2046.exe](http://www.cncdrive.com/UCCNC/setup_1.2046.exe)**

**Bug fixes and changes:**

- Jog stuck in one direction if the axis' jog direction was changed very quickly with calling the opposite jog direction function, fixed. The jog also stuck into the original jogging direction if both jog keys were pressed in for the same axis, now when both pressed then the axis stops jogging.**
- There was a global issue with the laser PWM handling effecting all controllers which appeared only in a few circumstances, fixed.**
- Autoleveler plugin was updated. (Thanks Cahit!)**

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**Postby cncdrive » Sun Nov 12, 2017 6:50 pm**

**UCCNC version 1.2047 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2047.exe](http://www.cncdrive.com/UCCNC/setup_1.2047.exe)**

**Bug fixes and changes:**

- The M3 did not always enable the laser output (M10) in time, fixed.**
- The Setoutputpin function macro call caused the outputs to flicker in demo mode. This did not cause any real machine issue, because it effected the demo mode only, but we fixed the error now.**

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**UCCNC version 1.2101 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2101.exe](http://www.cncdrive.com/UCCNC/setup_1.2101.exe)**

**Bug fixes and changes:**

- G41/G42 tool radius compensation g-codes were added.**
- Function Getcurrgridlinetext was added.**
- Disable virtualmouse option was added.**
- Canned cycle peck Q parameter reset with G80.**
- Autoleveler plugin updated.**
- Individual current hi/low output setting per axis.**

- Enable delay setting to delay the enable signal when removing reset. Delay setable individually per axis.
- Home back off distance parameter was added. Setable per axis.
- Input signals debounce with setable time constant. 3 debounce parameters are separated for THC inputs, Home inputs and the rest of the inputs.
- Peak latency value was added to statistics window.
- IsMovingTHC function was added to detect when the movement paused because of lost arc event when THC control is used.
- Very small arcs appeared polygonal on the toolpath view, fixed.
- Console plugin was added to make plugins and macro debugging easier.
- Russian language was added to the installer.

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**Postby cncdrive » Wed Jan 24, 2018 8:28 am**  
**UCCNC version 1.2102 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2102.exe](http://www.cncdrive.com/UCCNC/setup_1.2102.exe)**

**Bug fixes and changes:**

- The software was re-targetted from the .NET framework 2.0 to the .NET framework 4.0. This means that the software does not require the

**.NET framework 2.0 to run, but it requires the .NET framework 4.0 or compatible framework. The good thing about the .NET 4.0 is that it can load .NET 2.0 plugin .dll files, so the old plugins will still work, the other good thing is that all the .NET 4.x frameworks can run .NET 4.0 targeted assemblies, so for example if the .NET 4.5, 4.6 etc. frameworks are installed on the computers then they will run the UCCNC in .NET 4.0 compatibility mode, no need to install the .NET 4.0 separately. This means that Windows 8, 8.1 and 10 will run the UCCNC without installing any .NET frameworks, because they all have .NET 4.x frameworks installed as part of these Operating System. On Windows XP and 7 the .NET framework 4.x has to be installed.**

**For plugin developers the only thing to do to continue developing their plugins is to re-target the plugin project to .NET 4.0, this can be done with a single setting selection in Visual Studio in the project properties, however Visual Studio 2010 or newer is required which is new enough to support the .NET 4.0 framework.**

**The .NET 4.0 framework also means that plugins can now use more and newer built-in and 3rd party libraries.**

- G41/G42 round joints option.**
- G91 incremental movements issue when radius compensation was enabled, fixed.**

- Arc Z movement issue when in G91 and executed arc from macro and Z was not defined, fixed.
- Detailed tooltable settings window.
- Tools length and diameter data auto-validate when changed on the screen.
- New Save tooltable button.
- Option to save tooltable datas on closing.
- G10 L1 "R" parameter was added to upload tools to the tooltable via g-code.
- Console plugin updated.
- Appearance option to do not change the toolpath view on file load.
- Additemtolistbeginning function added to the plugininterface.
- Rigid tapping and Thread cutting possibly missed to make the synchronous motion in some case (~1 out of few hundreds usually), fixed.
- Getcurrgridlinetext did not always give back the proper line numbers, fixed.
- Getcurrentgcodelinenumber function was added to exec and plugininterface.
- Jog panel popup is now disabled when other child Windows has the focus to avoid pushing those windows to minimized when the jogpanel is engaged by the mouse pointer.

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**cncdrive » Fri Feb 23, 2018 12:40 pm**

**UCCNC version 1.2103 is ready for testing.**

**The download link:**

**[http://www.cncdrive.com/UCCNC/setup\\_1.2103.exe](http://www.cncdrive.com/UCCNC/setup_1.2103.exe)**

- Question function to accept negative numbers too. It only accepted positive numbers.
- Added some algorithm for G41/G42 gouging. This will not fix all cases and vectors opposite direction change will be added later.
- Toolpathclick event was added to the plugin interface detecting mouse clicks on the toolpath viewer and calculating the viewer to the workspace coordinate system unprojected coordinates and sending them to the plugins.
- Detailed tooltable tool dia and length values are formatted to have the same number of digits as how it is setup in the UCCNC settings for other DROs.
- M98 did not run correctly in single cycle. Was broken when the G41/G42 was implemented. Fixed.
- M98 when codes with L0 which means to call it 0 times had an issue that if it was codes with a #var, e.g. M98 L#1 Pxx and if #1 was 0 on g-code loading time then the line was not interpreted which was a problem, because if later #1 changed a value to other than 0 then this line still did not execute. Now the line is interpreted just not jumping the subroutine when the L#var parameter is 0, so when the parameter changes to other than 0 then it executes. Fixed.
- In demo mode the reset did not stop the jog if the jog key was held down while triggering the reset. This could not cause an issue for any machines, because it only effected the demo modes which can't control a machine.
- G64 and G68 codes display was not in the proper growing order, the larger number was displayed first, which was only a visual problem, fixed.
- Informplugin(s) function was added to the

**plugininterface. So far only the Informplugin(s) events were in the interface to let macros call plugins. Now plugins can call each other.**

**- OSK plugin functionality was extended, plugin was updated. On-Screen Keyboard / Calculator (OSK) now automatically grows if display is high resolution. In the current profile under [UCCNC\_OSK] section IgnoreFields key fields (usually for text input) can be excluded from OSK. The format is IgnoreFields=<fieldnumber>[,<fieldnumber>] without spaces. By default fields 1000 and 216 (MDI and Newfilename) are already excluded. Also supports x64 platform.**

**- ESC keyboard key function was added to DRO editing to Delete and also exit from the DRO when pressed.**

**- Inches and millimeters CV option was added to the installer to install different default values for users using mm or inch units.**

**- M1 in subroutines did not work properly. Was broken when the G41/G42 was implemented. Fixed.**

**- G10 L1 R.. code did not work properly. Fixed.**

**- The internal variables (#vars) interpretation had a limitation (the same limitation which Mach3 also has) in it's working due to the motion buffering, that the #vars has to be advance calculated, so the external query of the vars did not give the proper timed value if there was a looking ahead in the g-code. The #vars value displayed was always what it was lastly calculated including the looking ahead. So, for example attaching a #var to an analog output and changing the value line by line could not work unless if there was a wait code after each value change**

which blocked the looking ahead. An example code to show this issue:

**G0 X0**

**#1 = 1**

**G0 X1**

**#1 = 2**

In this example the #1 value queried with the Getvar function or if it was attached to an analog output showed value 2 even while the G0 X1 code was being executed, because the software was looking ahead and already calculated the #1 to have value 2.

The working of this was now changed, the #vars are now pushed into the motion buffer and now the queries show the values in synchron with the g-code execution.

- App.config file was changed and installed with the installer to allow plugins compiled with .NET 2.0 and with different appdomain to run.

- The application was now compiled with AnyCPU and the associated steps were done to let the UCCNC run as an x64 process on 64-bit machines to let it take advantage of the 64bits architecture. Now the software runs as an x86 process on 32bits computers and it runs as x64 process on 64bits computers. The software can now load large g-code files on x64 computers. Was tested upto 500MBytes g-code file size, but ofcourse the file size limit depends on how many vectors does the g-code file contain.

The plugins which were compiled for x86 architecture will no more work on x64 Windows. The authors of the plugins have to change the target platform in their application to AnyCPU if they want their plugins to work on both platforms.

**The plugins which install with the UCCNC were all recompiled with AnyCPU and the example C# plugin template was also updated to AnyCPU, except the XHC and URC200 pendant plugins, these will be updated only in the next release, they will not work in this release version.**

- The toolpath viewer drawing method was updated to use Vertex buffer object instead of Vertex buffer list to let it draw larger amounts of vertices associated with the larger file sizes which are supported by the x64 platform. For this reason the UCCNC now relies on the OpenGL 1.3 + the ARB\_vertex\_buffer\_object OpenGL extension or the OpenGL 1.5. The software automatically selects between what to use, if one of them is available then the software will run. If the vertex buffer object is not supported at all by the graphics card then the software will show an error and will not run.**
- M215 Px had an issue with updating the pulley in synchron with the g-code cycle execution, fixed.**
- The 5441 motherboard firmware missed to have the internal pullup resistors configured on 2 of the inputs in the firmware, fixed.**
- An issue with full circles execution was fixed, that if the software was forced to synchronise with the motion controller after a motion which movement gave the startpoint of the arc and then the full (360°) circle was executed after the code which caused the synchronisation and if the 1/steps per value was not an integer divisor of the endpoint then the circle was in some cases no more understood as a full circle by the motion software, because the synchronisation caused the start coordinates and the end coordinates**

to become different points, because the steps per value did not allow the programmed coordinate by resolution and so then the circle might not be executed depending on which side the start coordinate offset. The issue was fixed with the controller is now not synchronising the coordinates while in cycle except for certain operations which require the synchronisation.

- Rigid tapping and Thread cutting possibly missed to make the synchronous motion in some case (~1 out of few hundreds usually). This was fixed for the ethernet controllers only in the previous release and now the same was fixed for the USB controllers.

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Postby cncdrive » Thu Mar 29, 2018 9:03 am  
UCCNC version 1.2104 is ready for testing.

The download link:

[http://www.cncdrive.com/UCCNC/setup\\_1.2104.exe](http://www.cncdrive.com/UCCNC/setup_1.2104.exe)

- XHC and UCR200 pendants plugins converted to work on both 32 and 64bits systems.
- Probe #vars did not update, issue was created in previous test release, now fixed.
- The edit file could cause a not correctly handled exception especially when loading large files, fixed.
- Synchronisation problem with G28.1 homing, issue

**was created in previous test release, now fixed.**

**- Plugins init event was not synchronised properly to the plugin loop start. When one or more plugins initialization took long time then the plugin loops could start before all plugins finished the initialization calls. Now all the init calls are made and finish before starting the loops.**

**- Issue was found when an arc was coded and the user pressed stop before the software could fill the motion buffer and so only that one arc item was in the buffer and the stop was made at the end of the arc then the controller could not do the movement ID incrementation which protects against making a full or close to full circle in this special case. Now further protection was added which protects against this situation.**

**- The 6.Aux encoder port and pin numbers saving on Save all was missing.**

**- Macro language is now selectable to VisualBasic. To write the macro in VB language instead of C# write the #VB word into the very first row of the macro file. When the compiler finds the #VB keyword in the first row of a macro then the Visual Basic compiler is used to compile the macro instead of the C# compiler.**

**Only the macro(s) which have the #VB word in their first row compile with the Visual Basic compiler, all other macros which do not contain the #VB word are compiled with the C# compiler.**

**The Visual Basic language option is available for both the macros and the macroloops.**

**- Pin mapping plugin (Pinout.dll) added for checking and monitoring input and output pins. Some error**

**checking is built in, the plugin shows problems if found. For more information see UCCNC\Documentation folder**