Advanced Support Program Software Release Notification

NEW SOFTWARE RELEASE !!

Software Version 5.05 is now ready for release to the Advanced Support Program members. If your machine already has Version 5.05 Software please disregard this notice.

This email has been sent to all Thermwood customers that are presently on the Advanced Support Program. The new software release is available at no charge to the Advanced Support Program Members, however if hardware is required a quotation will be sent to you for the for the upgrade of the hardware.

The following is a brief summarization of the new features which have been added to the new Version 5.05 software:

Fixture Offset Temporary Adjustment Ability:

Allows an adjustment value to be set for any or all axes involved in a fixture offset. The value is set before the fixture offset is called and can be a positive or negative number.

Syntax: `[ADJFIXOFF,axis,value]`

Example:
```
[ADJFIXOFF,1,-4]
[ADJFIXOFF,2,10.634]
G52L55
```

This will adjust the values for fixture offset #55 by the values set without disturbing the actual values set in the fixture offset table.

The adjustment value is reset to zero by a HOME, G52L0, or a `[ADJFIXOFF,#,0]`for each axis as needed.

AFL Current Programmed Feedrate Function:

This will allow programmed modal federates to remain after a tool change macro is executed.

Syntax: `[PROGSPEED]`

Example:

```
[CUR_FEED=PROGSPEED]
[G01 X10 F[CUR_FEED]
G52L55
```

AFL Random Number Function:

This will allow programmed modal federates to remain after a tool change macro is executed.

Syntax: `[RND(n)]` (n is an integer)

Example:
```
[VAR_NAME=RND(n)]
[PRINT VAR_NAME]
```

Rules are the same as MSBASIC.

Rules are as Follows:

a.) If **n>0**   then a new number will be returned.

b.) If **n=0**   then return the previously generated random number will be returned. If there is no previous, then a new random number is returned.

c.) If **n<0**   then the last number generated by that particular **n** will be returned. If **n** is new, then a new random number is returned. Any negative integer may be used, but there can only be 100 of them in any program.

d.) The random number is always a real number whose value is between 0.0 and 1.0, endpoints inclusive.

Note: the value of n is not considered when generating a new random number.

Communication Feature (Web Forum):

Allows SuperControl users to communicate with other users directly from the control.

Communication Feature (Web Store):

Allows access to the Thermwood Web store from the 91000 SuperControl.

Communication Feature (Machine Part Ordering):

Allows for ordering of machine parts via part numbers or manual description.

Radius Compensation Temporary Adjustment Ability:

Allows an adjustment value to be set for radius compensation. The value is set before the Radius Comp is called and can be a positive or negative number.

Syntax: `[ADJDIAMCOMP]`

Example:

```
[ADJDIAMCOMP,.05]
G41
```

This will cause radius comp to adjust the cutter path by an extra amount. This amount is added to the normal radius value of the currently active tool *(which is defined in the tool setup table)*. This can be very useful for performing cleanup passes without having to call a different tool with a larger diameter. This allows variations of the cutter path without disturbing the actual diameter values set in the tool setup table for a particular tool.

The adjustment value is reset to zero by a HOME, M02, M30, or a
```
[ADJDIAMCOMP,0].
```

Axis Oscillation Feature:

Allows an axis to be commanded to constantly move back and forth from a set location with a preset amplitude (max .05") and number of cycles per minute.
Purpose: extend cutter life by varying the cutter contact points on glue lines, laminates etc.

Syntax: `G65 Z.02 F125.0` (axis oscillation ON for axis Z)
`G64` (axis oscillation OFF)
Note: when an axis is oscillating it cannot be commanded to move within the part program. If it is commanded, an error message will be displayed.

Pointer Misalignment Function (Enhanced):
Any time that the Cursor/Execute bars (Red/Gray Lines) are not aligned the control will warn of the misalignment. This is to help reduce the chance of a programmer/operator starting or restarting a program from an unintended location.

AFL Current Feed Rate Override Function:
This allows the programmer/operator to get a snapshot of the current Feed-Rate Override value.
Syntax: `[FRO]`
Example:
```
[FEED_OVER=FRO][PRINT FEED_OVER]
```

HOW DO I RECEIVE THE NEW SOFTWARE RELEASE ?

To receive the new 5.05 Version of software there are a couple of items we need you to do.

Thermwood will need to receive some files from your Thermwood machine control system. The reason for this is that there are some files that we update that you, the customer, have access to and can make changes to such as fence locations, fixture offsets, tool changer tool positions, etc..

To achieve this Thermwood has placed an extracting file on our website which is www.thermwood.com. The extracting file is a self extracting zip file that will extract the files we need to properly update your software. Once you are on our website home page select the Advance Support Program bullet located on the left side of the page. Select the Version 5.05 Software Release icon. There will be two categories to choose from, OS/2 Operating System and Windows Operating System. If you are unsure of what operating system your machine has you may check the version of software the machine has by simply pressing the "Ctrl" and "V" keys simultaneously. The Windows Operating System will be version number 5.00 or higher, all version numbers under 5.00 will be the OS/2 Operating System. To remove the pop up window simply press "Esc". Select the correct operating system and follow the instructions.

Once this has been accomplished please email the extracted file, ASP_UP.ZIP, per the Extracting File Instructions to support@thermwood.com. Please include your company name along with the machine serial number.