

ServoCam[®] Software Release Summary

This is a summary of the software changes from one version to the next.

Targets are:

US = UltraSlide, the classic Turret and auto trippers system

CL = UltraTurn CL, either a CNC or a 2U upgraded to full CNC cross slides and spindle, along with the turret slide

XL = UltraTurn XL, the system with the servo turret indexing and graphical user interface

Release Note	Version	Target	Primary Notes
RN0008	T.002	US, CL	AutoTripper Base Version.
RN0009	T.003	US, CL	
RN0021	T.004	US, CL	
RN0001	1.40c	US	Servocam Base Version
RN0002	1.40d	US	
RN0003	1.40e	US	
RN0004	2.10d	US	
RN0005	3.00d	US	
RN0006	3.01a	US	
RN0007	3.01b	US	
RN0016	3.01f	US	<ul style="list-style-type: none"> - Issue: Tool offsets being lost. Found and fixed. Tool offsets will not be lost now. - Issue: if tool offsets WERE lost, older versions would have not handled it nicely. Now they are shown as #####
RN0017	3.20a	US	<ul style="list-style-type: none"> - Parts Counters added - Aux output added
RN0023	3.20d	US	DNC support added. Fixes issues that have shown up in field use of previous releases. <ul style="list-style-type: none"> - Full retracts in a clear operation issue resolved - File open on long names issue; fixed. - Parts counter handles system with no AutoTripper™ Controls - Manual trip of spindle clutch now works any time, not just in the run screen.
RN0024	3.20f	US	00U feed timing fixed. Aux2 support. Incorrect spindle clutch trip on start up, removed.
RN0028	3.20h	US	New 586 bios support added to support new internal processor board. Last version to NOT support turret actuator offset for the 2U.
RN0022	4.30g	CL	UltraTurn Base version.
RN0010	4.70b	CL	Shifting spindle transmission during part cycle added: <ul style="list-style-type: none"> - auto compute spindle clutches - auto compute spindle velocity only operations Spindle velocity tracking has been improved. Spindle indexing mode added. Spindle constant surface feet cut-off (and form) expert.

			Tap expert enhancements.
RN0011	4.70d	CL	Coordinate system changes for slides.
RN0012	4.70f	CL	<p>Defaults for the cut-off expert were cleaned up so that cutting torque defaults to 50%, and all other fields blank.</p> <p>The cut-off expert now puts in a sequence number at the front of the comment field for spindle speeds. This way the spindle table entries can be unraveled for synchronizing with other operations that are desired to be overlapped.</p> <p>The tap expert now provides a method for reserving cutting torque, just like the cut-off expert.</p> <p>A 'starting up' synchronizing bug was found and fixed. The 'DECL: Intero not initialized. (10)' message should no longer be seen; if it seen, please report it.</p>
RN0013	4.70h	CL	<p>Support for 2 speed CNC with 1 5/8" spindle</p> <p>Caution when using cycle speed less than 100%. Do not use reduced cycle speed with tapping since the spindle does not slow down in this mode. Also, Turret Trips occur based on timed precompensation for a 100% cycle speed, and causes problems when running at reduced cycle speed. See workarounds for remedy.</p>
RN0014	4.80a	CL	<p>Fixes issues that have shown up in field use of previous releases.</p> <ul style="list-style-type: none"> - Issue: Tool offsets being lost. Found and fixed. Tool offsets will not be lost now. - Issue: Loading a part cycle with auto-computed spindle operations would sometimes fail. Found and Fixed. - Issue: Running at reduced cycle speed crashing tools. Feature removed. <p>Version 4.80 will load and run a version 4.70 part cycle without requiring modification.</p>
RN0015	4.80d	CL	<p>Fixes issues that have shown up in field use of previous releases.</p> <ul style="list-style-type: none"> - Issue: Precharge sequence would blow precharge resistors if there was a excessive draw by one controller. Found and fixed. <p>Support for 208 Volt, #2, 1 5/8", 4 speed, regular slide machine.</p> <p>Support for 208 Volt, #2, 3/4", 4 speed, regular slide machine.</p> <p>Support for 208 Volt, #2, 1 5/8", 4 speed, RAM slide machine.</p>
RN0018	4.80h	CL	<p>Fixes issues that have shown up in field use of previous releases.</p> <ul style="list-style-type: none"> - Issue: Master to slave communications drop-outs during brown out. Found and fixed. <p>Support for 2B-3/4", Ram slide. 2 speed B&S.</p>
RN0019	4.80k	CL	<p>CRITICAL: hardware change required before using this software: The home switch targets must be reversed before using this version.</p> <p>Coordinate system changes for slides. Now at full travel.</p> <p>Slide accuracy improvements.</p> <p>An issue with 'Feed Change out' on cross slides would throw an error "Velocity is zero or wrong direction: change Feed Rate or Spindle Speed". This issue has been found and fixed.</p>
RN0020	4.80q	CL	DNC support added.

			<p>Fixes issues that have shown up in field use of previous releases.</p> <ul style="list-style-type: none"> - Full retracts in a clear operation issue resolved - Designer was not saving full precision numbers; fixed. - Constant surface operations generated could not be auto-computed; fixed. - File open on long names issue; fixed. - Cut-off expert was not honoring maximum spindle speed; fixed. - Set-up sheet for spindle inserts was backwards; fixed. - Communication made more robust
RN0027	4.80s	CL	<p>Aux2 added. Stronger Front Gearbox supported on all 2U machine types. Support for 3/4 inch CNC.</p>
RN0029	4.80u	CL	<p>New 586 bios support added to support new internal processor board. Spindle shunt temp fault issue introduced (go back to 4.80s, or go forward to version 5) Long part cycles: at 1000 seconds there was only 160mSec tripper accuracy; now it is 16mSec.</p>
RN0030	5.10a	US, CL	<p>Added US multilobe cross slide cam definitions. Merged US and UT into a single ServoCam Designer. Controller watchdog timer test Controller shunt temperature monitoring Supports both UltraTurns and UltraSlides (Turret slide only systems) UltraSlide 2U systems can now set the machine for 'actuator offset' Stretch-able position operations Drag-able trip times. Tickmarks in timeline blocks show times of interest.</p>
RN0035	5.10c	US, CL	<p>Support UltraTurn $\frac{3}{4}$", 2 speed machine type. Fixed the UltraTurn 'tap expert' to correctly support left-handed tapping. UltraTurn remote controllers: Allows voltage monitoring during precharge.</p>
RN0036	5.20a	US, CL, XL	<p>Supports the Ultraturn XL for the combination 1 5/8" belt drive spindle with servo turret indexing. Long part cycles: Previous limit was 1000 seconds, now up to 1800 seconds.</p>
RN0037	5.20C	US, CL, XL	<p>Addressed an issue for UltraTurn CLs that was not reporting AutoTrippers missing. UltraTurnXL turret indexer now contains an approach segment. UltraTurnXL spindle drift issue has been found and fixed. Designer 'undo' ability has been restored. Designer, support for constant surface speed left handed cutoff added. Hardware support for newer versions of memory devices on processor boards.</p>
RN0038	5.20K	US, CL, XL	<p>Increased spindle capabilities by approximately 18% for the XL (1.625" spindle size) Added support for 1.25" spindle size XL Added XL capability to take selected axes "off-cam"</p>