



# Changelog

## *WinPC-NC* 3.XX

This document describes all published new functions, function extensions and bug fixes for all versions. Please scroll to the last used version and read the changelog to the latest version at the beginning of this document.

### Explanation of font colour and abbreviation

S L U P F      Function/modification applies to *WinPC-NC Starter, Light, USB* or *Professional* or the firmware of the axis controller

blau              New function

grün             Adaption

schwarz        Bug fix

rot               Bug fix of an critical error, Update is recommended



## Version 3.40/57

Date : 20.02.2020

### Faster refresh in graphical display and program code window

#### **S L U P**

At new job load and after job and after manual jogging the new graphical display is refreshed much faster and unneeded refreshes are eliminated

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### Unneeded drop down of tangential knife eliminated

#### **U P**

With certain settings the knife was lowered without any action and lifted again to turn.

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### Program hangup at job start at very poor computers

#### **S L U P**

At less performed computers it could happen that **WinPC-NC** hangs up and could not be operated any more. This was caused by a not correct synchronised job progress windows and is fixed now.

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### More less important fixes

#### **S L U P**

- protocol creation at loading DXF files
  - Gcode interpreter with modal commands at dwell time command
  - display error at saving XY zero point
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## Changelog *WinPC-NC* Version 3.XX

Learn which new functions are included in your latest version of *WinPC-NC*.

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**Version 3.40/52**

**Date : 06.2.2020**

### **Manuell jogging with touch monitors**

Since last update of Windows10 the used messages and internal methods at touch screen driver changed and we updated our interpretation. Now manuall jogging can be used as before.

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### **Differnt speed ups at internal processes**

To meet old and very weak computers like Intel Atom processors we have enhanced lot of internal functions and created a new parameter setting *Reduce processor time*. If active the realtime graphics with red dot and update of current coordinates is reduced and slower but operation on this computers can be done as usual.

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### **Reassignment of key codes for different keypads**

Keypads of CNC-Step, GoCNC, our own bluetooth and cable keypads are interpreted correctly and can be used like before.

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## **Version 3.40/48**

**Date : 22.1.2020**

### **Parameter settings without instant correction**

Modifying of parameter settings work like before, sorry for this fault.

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### **Opening of settings dialog causes delay**

Problem fixed and dialog can be opened as usual

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### **Macro commands for waiting with new message**

At active macro waiting commands there is a new message in status line and you will recognise why the job is paused and which signal is waited for.

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### **Gcode modal commands G02/G03**

Sometimes G02/G03 commands are not set modal and following commands are not interpreted correctly. This is fixed now.

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### **2DCAM enhanced**

Better smoothing of contours in CAM functions.

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### **Macro for tools are invoked at tool selection dialog as well**

Until now defined tool macros are running in job mode only. Now they are invoked in tool selection dialog as well and immediately if a new tool is selected.

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### **Only used tools editable**

Unused tools from a loaded file are disabled and cannot be modified in settings dialog. This will minimise incorrect parameter settings.

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### **Memory problem fixed**

When loading different nc files subsequently sometimes the used memory was not released completely and causes a full memory error. This is fixed in new version.

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**Version 3.40/43**

**Date : 16.12.2019**

### **Import of EPS/AI enhanced**

Better recognition and identify of EPS/AI files.

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### **Macro command SetOutput fixed**

Macro command now can be used several times with different output numbers

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**Version 3.40/41**

**Date : 01.12.2019**

**Laser test function with new focus diameter setting**

**UP**

To avoid overlapping laser lines you can define the focus diameter as a new parameter setting in test functions.

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**Grey scale engraving enhanced**

**UP**

Better grey scale engraving with 8 bit laser power control and much more than 16 possible gray scales as before.

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**Finished drag knife function**

**SLUP**

Drag knife offsets even with very small vectors and contours.

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**New parameter to control JobEnd macro**

**UP**

Selecting the JobEnd macro even if a job is canceled.

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**Version 3.40/37**

**Date : 13.11.2019**

### **Check for file access at startup**

#### ***S L U P***

WinPC-NC needs writing access in installation folder to save settings. This is checked at startup and when missing an message will be shown.

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### **Correction of PWM control at lasers**

#### ***U P***

PWM signal is now created much more accurate and creates better grayscale engravings with different lasers.

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**Version 3.40/33**

**Date : 30.9.2019**

**CAM functions : Move in vector**

***S L U P***

In combination with searing closed contours you can define lead in vectors to the contour from inside or outside. This prevents ugly marks at starting end ending the contours.

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**CAM functions : Drag knife compensation**

***S L U P***

With new function WinPC-NC can create and compensate a small knife offset which is typical for drag knives. All moves at angles and edges are a little longer and an arc is created to turn into new direction. The result is much more accurat cutting of foil contours.

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**CAM functions : Better sorting and empty move optimization**

***S L U P***

With a new checkbox in dialog WinPC-NC will completely finish all parts first befor starting with a new part in job. This minimizes job time and helps in handling parts.

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**Enhancements in laser control and calibration**

***U P***

- defined maximum power is used in all functions
  - some corrections in calibrating functions
  - use of correct power values after pausing in grayscale calibration
- 

**Enhancements for oxy and fuel cutting**

***P***

- surface finding function
  - monitoring of digital input lines for moving up/down during job and for manual jogging the Z axis
  - controlling of PROMA height control system with inputs for moving and ArcGood and ArcFault signal
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**Minor fixes**

***S L U P***

- leaving parameter field with ENTER key does not clear current tool
  - completed dutch language block
  - missing tool no in Gcode file like T M6 is handled correctly
-





## **Version 3.40/29**

**Date : 12.8.2019**

### **Correction at Laser test functions**

#### ***U P***

Grayscaletest starts with correct speed. Switching on/off at laser controls PWM signal as well. This is important for lasers which are controlled by PWM only and have no extra digital on/off input.

At very strong lasers the maximum load can be limited at xx%. This is important if machine cannot move fast enough to create any grayscale because of too powerful laser beam.

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### **Laser on/off at commands PU/PD and G0/G1**

#### ***U P***

Laser will be switched correctly at all DXF or PLT or OPT files.

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### **Correction on different input/output info lines**

#### ***U P***

In different parameter tabs the displayed output lines and assigned pins are displayed correctly again.

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**Version 3.40/27**

**Date : 18.7.2019**

### Rehoming check available for all *WinPC-NC USB* softwares

With this version the function rehoming check is available for all *WinPC-NC USB* variants and licenses. Please note that the function can display big deviations, if the machine moves too fast to the reference switches and crashes against the mechanical machine limits.

If the function displays big deviations that are not plausible, please reduce the Homing speed, search parameter.

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### Bugfix New macro command Set offset XZY

Bugfix during the execution of this macro command.

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**Version 3.40/26**

**Date : 11.7.2019**

**Bugfix parking after job**

***L U P***

Sometimes an error occurred during long lasting movements to parking or zero position at end of job

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**New output signal for running homing movement**

***L U P***

A new output signal Q252 homing active is created to signalize a running homing process. This signal is needed to control our new adapters for parallel or slave axes and the new automatic adjustment funktion during homing.

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**Forgotten test lines added**

***S L U P***

At two new functions we forgot to translate the corresponding text lines and added it in this version. Sorry.

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## Version 3.40/25

Date : 9.7.2019

### Bugfix Camera

**S L U P**

An active camera window could not moved correctly

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### Incorrect feedrate speed from Gcode files

**U P**

With very special parameter settings feedrate F commands from Gcode files were not moved and speed settings from tools were used instead.

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### Lost communication during long moves to help points

**S L U P**

During very long moves to zero or parking position the communication was lost sometimes.

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### Minor fixes

**S L U P**

- Selective profiles are loaded correctly even if saved with older versions
  - Zero point setting with surface block is saved correctly
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**Version 3.40/20**

**Date : 29.5.19**

**Different minor fixes**

***S L U P***

Fix at hangup when moving to zero point or parking position after homing  
subsequent loading of profiles caused an error in Professional  
Activation of sensor probe macro at plasma cutting in Professional  
Laser engraving and Start from... function caused lot of PWM signals  
Better adjustment of messages in job progress window

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**Invalid parameters without error message**

***S L U P***

Parameters outside valid area will now be corrected silent and without show error message

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**Technology Laser and more activated at one job**

***U P***

Until now only one technology at one time could be active. Now Laser+Circular axis or Laser+Tangential axis can be activated and used at same time.

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**Version 3.40/16**

**Date : 23.5.19**

**Bugfix at start of *WinPC-NC* and different function**

***S L U P***

Certain definitions of spindle speed items caused a program hangup.

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**Version 3.40/15**

**Date : 17.05.2019**

**Enhancements with hand wheel**

***S L U P***

No unexpected jumps when starting movement in step mode. New settings to move to park position with button Goto0s and tool lift height when setting Z zero point.

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**Various minor fixes**

***S L U P***

Endless reset is accepted even at diagonal movements  
Tool length measurement at 30 tools shows now correct tool number  
Canceling of homing also cancels parking and measurement  
Buttons of manual movement dialog are show correctly  
Switching of spindle and cooling with hand wheel creats correct spindle speed

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**Fixes with touch probe**

***U P***

Touching and calculaion of angle is enhanced and prevents any inaccuracy.

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**Definition of tool settings at laser technology**

***U P***

By using a new checkbox setting in laser technology dialog you can select speeds and power settings from tool parameter instead of fixed laser speed.

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**Version 3.40/10**

**Date : 08.05.2019**

### **Program hangup at canceling jobs fixed**

***U***

In certain situations there happend a totally program hangup after canceling a job.  
This is fixed now.

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**Version 3.40/08**

**Date : 06.05.2019**

**Running times and data for machine maintenance are now editable**

**UP**

The running times and machine data are editable now. This allows to enter the previous machine data to the new version 3.40 and keep all information up to date.

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**Running times and data for machine maintenance according to pin assignment**

**UP**

The Running times and data for machine maintenance for spindle, cooling and dispensing/laser are only incremented for assigned output pins of the respective function.

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**Pilot laser can be activated by hand wheel HR-10**

**UP**

The pilot laser of the laser functions can be activated with the **hand wheel HR-10** now. To activate the pilot laser the outputs for spindle and cooling must be set to active.

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**The angle for turning the graphics is saved as nc file parameter**

**UP**

The measured angle from the touching plate is now saved as nc file parameter. This allows to continue the job with the same angle later. The angle is set to 0° during restart of **WinPC-NC** or during opening a new file without own turning angle.

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**Version 3.40/05**

**Date : 26.04.2019**

### Selective Profiles

#### **S L U P**

Additionally to the normal profile functions **WinPC-NC** offers the selective profiles since version 3.40. With that new selective profiles it is possible to load and save only a selective part of the parameters. This new function leads to a much more easier configuration of new additional accesories for your CNC machine in the future.

More information and a detailed explanation of the selective profiles can be found on our [website](#) soon.

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### Turning graphics by degree

#### **S L U P**

Graphic display and file can be turned by any angle in limits of -25 up to +25 degrees to justify a non parallel fixed part. It can be used by help of a touching plate or moving to two different points in graphics or by entering the value as parameter.

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### Maximum of 30 tools

#### **U P**

A maximum of 30 tools can be used instead of limited 10 tools up to now. It must be enabled in settings for compatibility reasons

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### Running times and data for machine maintenance

#### **U P**

Different running times and counters are managed as information and to estimate machine maintenance tasks like machine running time, spindle running time, switching spindle on/off and more. All data can be shown as controller information

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### Correction of key assignment at certain keypads

#### **S L U P**

Wrong key assignment at certain 3rd party keypads is fixed

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### Ignore 0/0 movement

#### **U P**

Movement to X=0/Y=0 at job start and end is detected correctly and can be eliminated on demand

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### G5x commands in Gcodes

#### **U P**

Switching different zero points with G5x commands did not accept a modal moving command like G0 to move to new calculated position.

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### New firmware at axes controller at WinPC-NC Professional

**P F**

By use of this new version an update of firmware at axes controller is needed.  
Please use new firmware 1.60/75r which is included in update as well as info sheet.

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**Version 3.02/07**

**Date: 14.03.2019**

### Window position for more then one computer screen

*S, L, U, P*

*WinPC-NC* remembers the window positions for the next software start.

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### Numerik keypad and keypad from other manufacturers

*L, U, P*

Adaption of function keys for keypads. The selection of the keypad can be done in the parameter settings basic settings-interface-keypad.

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**Version 3.02/06**

**Date: 04.03.2019**

### Machine speed during first DIN/GCode job

***U, P***

Sometimes *WinPC-NC* did not select the right machine speed during the first DIN/GCode job. Now *WinPC-NC* uses the right speed selections.

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### Correction for minimum laser power

***U, P***

Correction for minimum laser power in the technology functions of *WinPC-NC*.

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**Version 3.02/05**

**Date: 29.01.2019**

### **Progress bar with decimal places**

***U, P***

With this version job files with at least 10000 program lines will be displayed with two decimal places in the progress bar. The function „Move from“ accepts decimal places to continue jobs more accurate.

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**Version 3.02/03**

**Date: 23.01.2019**

### Adaption for Heiz keypad

***L, U, P***

The orientation of buttons in the JOG window will not change automatic during the usage of Heiz keypad.

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**Version: 3.02/02**

**Date: 21.01.2019**

### **G92 command for 3D printing**

***U, P***

In gCode files created from CURA the spending of filament is resetted by G92 command from time to time. *WinPC-NC* will now accept and interpret this command in correct manner.

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**Version: 3.02 /01**

**Date: 18.01.2019**

### Enhanced DXF import

**S, L, U, P**

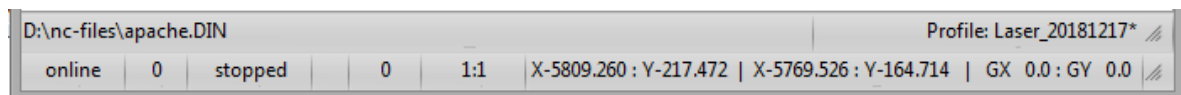
From this version on you can import much more DXF files and with more complex elements. We have realized the import of SPLINES, nested blocks and LWPOLYLINE elements.

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### Display of loaded profile and loaded work file

**L, U, P**

The loaded file with file path is now displayed in the bottom of the program window next to the name of the loaded profile. The profile default names the last saved parameter settings. A \* symbolize not saved changes compared to the loaded profile.



### Adjust a minimum spindle speed

**L, U, P**

*WinPC-NC* supports speed control of spindles with integrated minimum speed. A new parameter is added to the settings Basic Settings-Spindle to configure the a minimum spindle speed.

The default value of this parameter is 0 and should not be changed, if the frequency converter calculates a linear interpolation.

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### Security check to avoid pressing move buttons by mistake

**L, U, P**

Under Parameters-Misc-Display/Operation a new checkbox „Movebutton with confirmation“ is added. If this checkbox is activated, *WinPC-NC* shows a additional security window when clicking on move buttons. With this parameter the activation of „move to zero“, „move to parking place“ and „Homing“ by mistake should be prevent.

The already implemented parameter „Exit with confirmation“ has the same function for the exit button.

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### New functions for Laser

**L, U, P**

*WinPC-NC* offers new functions to control a cutting- or engraving-laser.

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### CAM functions in special function menu

**S, L, U, P**

The CAM functions for 2D data can be found in the menü under Special Functions-2D-CAM.

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