

# CommandCNC 1.2

## Release Notes

### What's new in 1.2

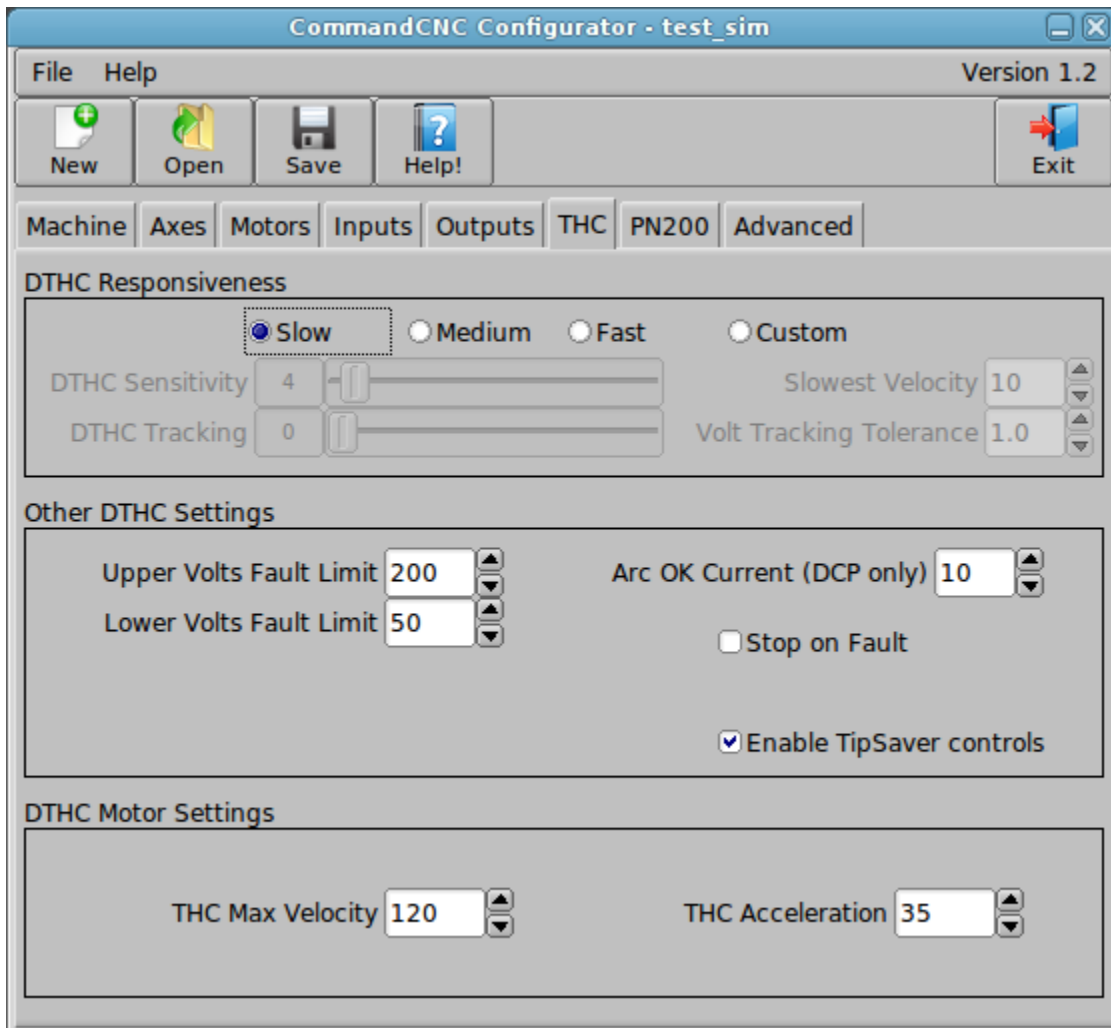
<a href="#">DTHC Settings moved to Configurator.....</a>	<a href="#">2</a>
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***Please read this document carefully  
before contacting CandCNC!***

***In this release most of the THC settings  
have been moved out of CommandCNC  
and into the Configurator!***

## DTHC Settings moved to Configurator

The biggest change in this release is that we have moved almost all of the DTHC settings from the CommandCNC interface to the Configurator.



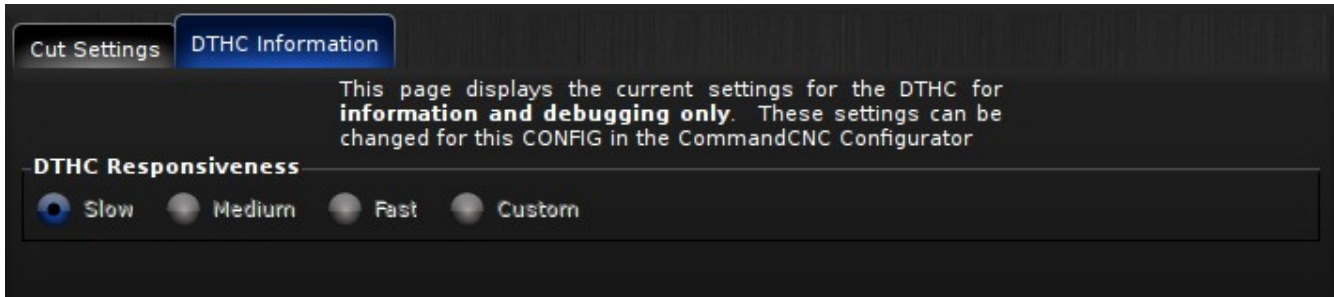
These are all settings which are seldom changed. When you need to change any of these settings (as with any changes in the Configurator), you will need to restart CommandCNC for them to take effect.

Notice the “Enable TipSaver controls” box: **this must be checked to make the TipSaver controls visible in CommandCNC.**

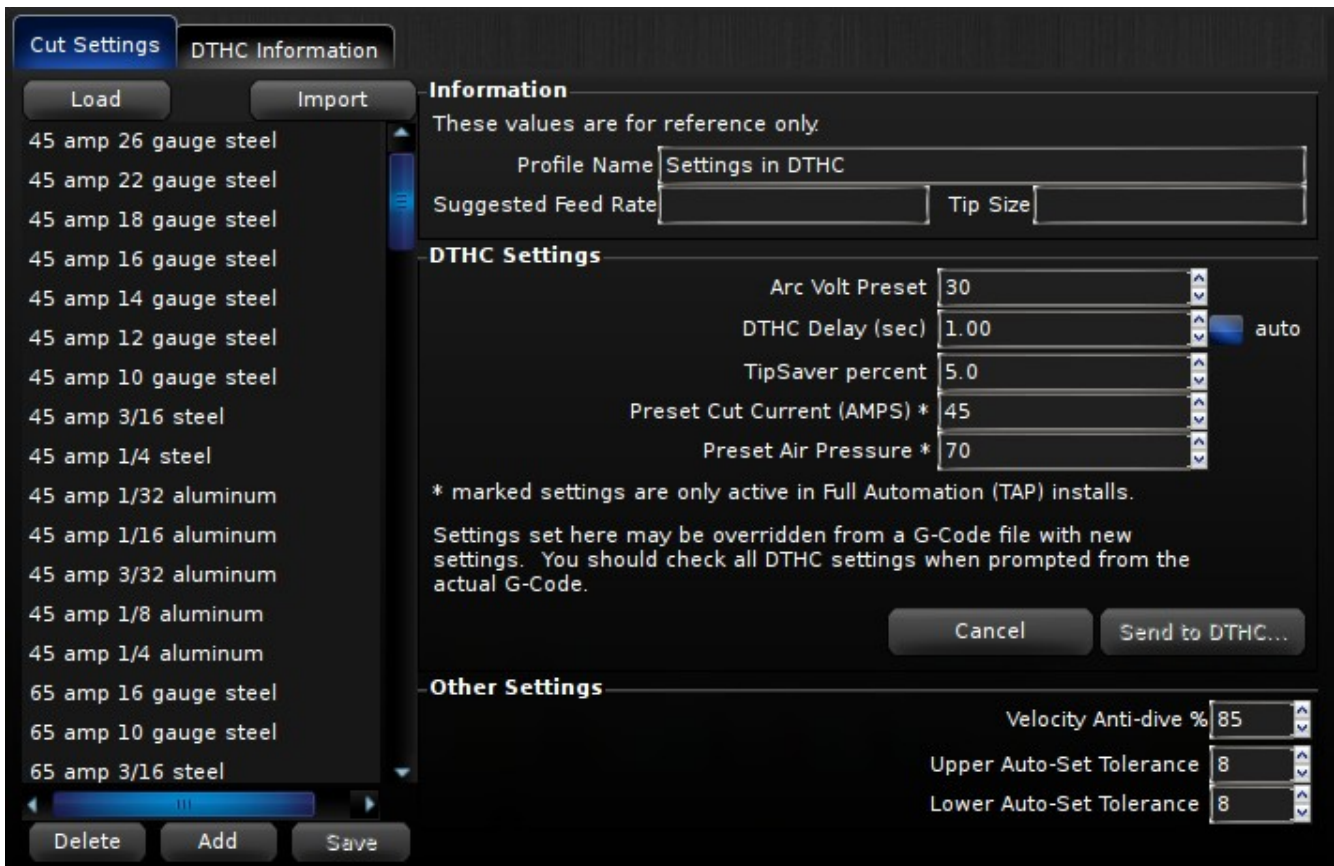
Also notice that there is no setting for “THC Max Down Velocity” now. Instead, the down velocity is limited automatically depending on the DTHC Responsiveness setting in the following way:

- Slow – max down velocity is limited to  $\frac{1}{2}$  of the THC Max Velocity
- Medium – max down velocity is limited to  $\frac{3}{4}$  of the THC Max Velocity
- Fast and Custom – max down velocity is the same as the THC Max Velocity

As shown in the image below, some of these settings are still shown in CommandCNC under the tab “DTHC Information”. They are there for diagnostics so you can verify that the settings are correct, but you cannot change them there.



The “Cut Settings” tab contains settings which can still be changed in CommandCNC.



## DTHC Settings changes in Hub Utility

The “Max Down Velocity” setting was also removed from DTHC Settings in the Hub Utility. The text in that window was also corrected and references to old software removed.

**Please note that these settings are for testing only – they will be overwritten by the machine config settings or settings from g-code during run time!**

**DTHC Settings**

**DTHC Information**

Arc Volts       Current from DCP       EEPROM Read   
EEPROM Write

DTHC Enabled       UP   
Arc OK       DOWN

Torch ON       DTHC HOLD   
Tip Save ON       WD Good       Motor Volts High   
Tip Save Active       DTHC Delay       Test Mode       Motor Volts Low   
      DTHC Fault       Motor Volts Off   
                Gecko Fault

**Z Motor Settings for DTHC**

Steps per unit \*       Units  inch  mm      Full Speed Jog

Max Velocity (units/minute) ~        Dir Active Low       Up

Acceleration (units/second^2) ~        Step Active Low       Down

**DTHC Settings**

Arc Volt Preset        DTHC Enable       Tip Save ON

DTHC Delay (sec)       Upper Volts Fault Limit       Tip Saver %

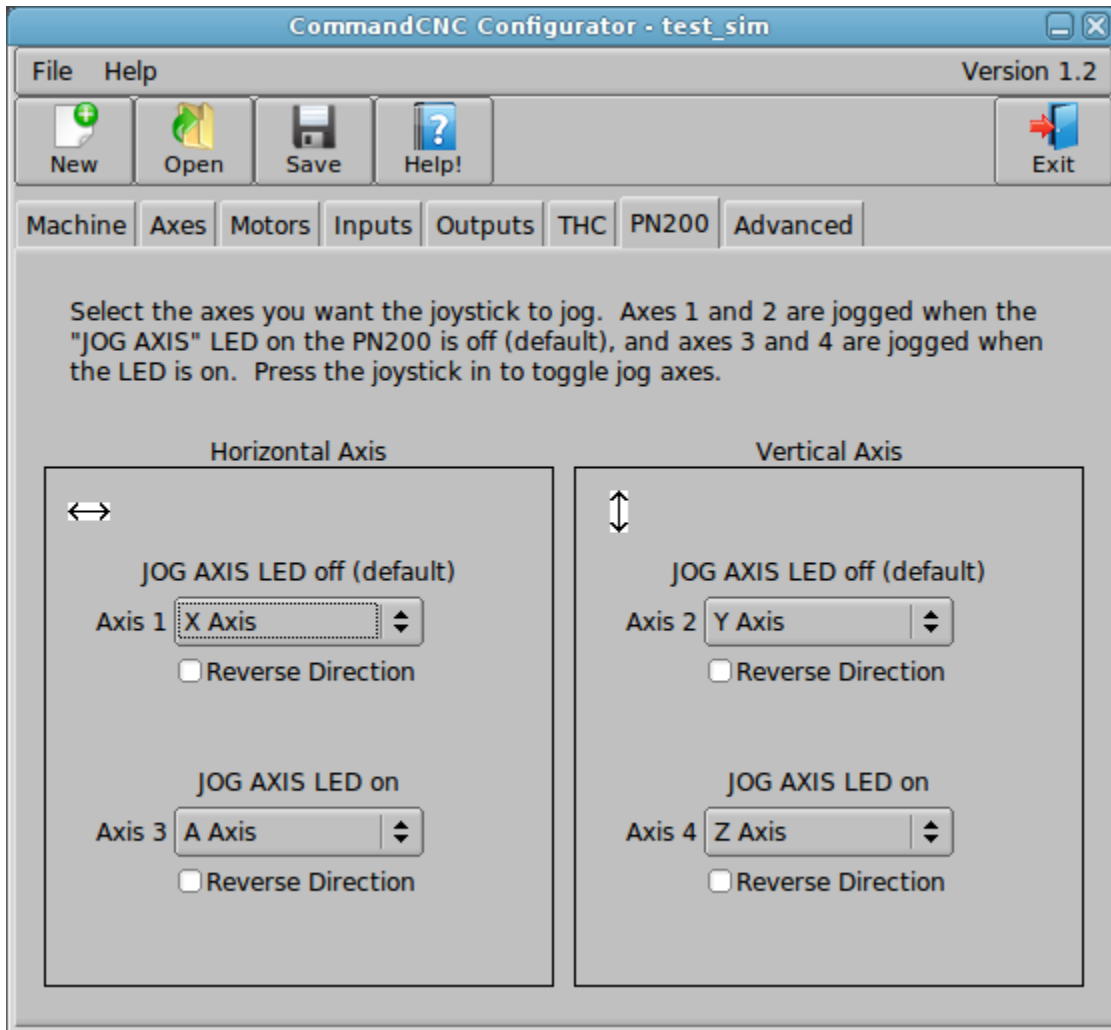
Arc OK Current       Lower Volts Fault Limit       Volt Tracking Tolerance

Slowest Z Velocity       DTHC Sensitivity       DTHC Tracking

These settings are for testing and reflect the actual values stored in the DTHC local memory. They will be overwritten by machine config settings or from G-Code settings during run time.

## PN200 Settings in Configurator

There are now PN200 settings in the Configurator.



The joystick on the PN200 can be pressed in and it activates a button. When this button is pressed it toggles an LED labeled JOG AXIS on the PN200. When the LED is off, the joystick jogs one set of axes on the machine. When the LED is on, the joystick jogs another set of axes on the machine. The default is for the horizontal axis of the joystick to jog X when the LED is off, and A when the LED is on. The vertical axis of the joystick will jog Y with LED off and Z with the LED on.

This page in the Configurator allows you to change which axes the joystick jogs, and also which direction they will move. If you find that an axis moves the opposite direction you want when you jog with the joystick, simply check the “Reverse Direction” checkbox for that axis.

## Other changes

- If the EPSIIA frontpanel is connected to the CandCNC RS485 4 port hub, a new section will appear in diagnostics showing power supply information:

The screenshot displays the CandCNC diagnostics interface. The 'Power Supply' section is highlighted with a red box, showing configuration details for a PS650 power supply. The 'Current Part Runtime' section is also highlighted with a red box, showing a time of 0:0:0. The interface includes various status indicators and controls for the torch and DTHC system.

**Power Supply Section:**

- Configuration: PS650
- DC Volts: 0.0
- DC Current: 0.0
- Main Temp: 88
- Drive Temp: 0
- Core Temp: 0
- Drive Faults: 1 2 3 4 5 6

**Current Part Runtime:**

0 : 0 : 0

**Other Diagnostics:**

- Torch Volts: 0
- DCP Amps: 0
- Preset Volts: 120
- Preset Amps: 45
- Auto-Set: Enable Auto-Set
- Sample Volts: 120
- Last Sample Status: Good
- TipSaver:
- DTHC Online:
- TipSaver Active:

- “Current Part Runtime”: shows time the current gcode has been running. It starts over each time the code is run.
- TipSaver has been brought back. If you want to use TipSaver you must check the box in the Configurator as mentioned on page 2.