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NCX v11.1.18 Release Notes

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1. Support reading multi-line text elements (MTEXT) and try following the text height from DXF (all)
2. Improved routine generating cutting sequence for laser machines (C1,P1)
3. Improve efficiency in shear nesting "use one sheet size" mode by trying 2 different part sequence methods (B1)
4. Shear nesting in the "re-nest one plate" mode always assumed that "nest under clamps" flag is ON

NCX v11.1.17 Release Notes

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1. Leave 20mm margin on Y max travel on picking from clamps (robot makes on its own Y+15mm move) (E1)
2. Fixed: Near rightangular destruct could use tool loaded to non-zero angle in wrong angle (all)
3. Improve NCX Tulus stacking diagnostic (all)
4. Do not crash on importing DXF with empty text (all)
5. Support TabSize (undercut) in scrap cutting (D1,P1)
6. Forbid Ctrl-C/Ctrl-V copying of entities on LOCKED layers (all)
7. Allow using obround tool next to micro-joint tool hits in autotool (all)
8. Preserve part properties when importing foreign geometry, like iges (all)
9. Do not output G41/G40 for marking cycles for SYNCRONO (P1)
10. Fixed bug for some cases can't browse tool lib from environment dialog (all).
11. Fix for importing DXFs having some ARC entities drawn in Z=-1 plane (all)
12. "Draw obround" cad command failed for none zero orientation (all)
13. Write part dimensions into JOB.DAT with increased precision (affects renest one sheet in common-line mode) (all)
14. Wrong I/J addresses in "move over skeleton" mode (P1)
15. Add G00 Z=P101 after pre-cut hole type piercing (P1)
16. Fixed: Sometimes micro-joint size in cropline was coming from autotool settings instead of optimizer settings (D1,E1)
17. Part geometry could be violated in shear-nesting, because of the bug in function, checking for contour overlapping.(B1)

NCX v11.1.16 Release Notes

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1. Fixed: Double-hit removal could remove non-overlapping vertical nibbles, broken in 11.1.14 (all)
2. In PLATINO postprocess support shortened z-value for NONE PRE-PIERCE case (P1)
3. In PLATINO postprocess allow shortened z-value only with QUICK piercing (P1)
4. Change format of CAD object names for tooling from ELEM9999 to ELEM99999 and from CYCL9999 to CYCL99999 (all)
5. Support move mirroring in part scripting (all)
6. Prevent crashing on printing 2-nd screen shot (all)
7. Fixed: Adding orders via parancx caused an error, broken in 11.1.7 (all)
8. Fixed: U-notch could get 1-2 hits too few, when nibbled with a single round tool (all)
9. Eliminate duplicate block numbers in scrap cutting section (P1)
10. DXF import was enhanced to support second level blocks (all)

NCX v11.1.15 Release Notes

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1. Fixed bug in Insert Fillet routine in the case of ARC segments
2. Interactive tooling routines had problems with parts having more than 5000 tooling elements (all)
3. Fixed bug for wrong NC code when DPM in combination with marking technology (XML D1).
4. Fix using right trajectory process for 'Mark pierce points' for Tulus-machines (D1,E1)
5. Added <PROGRAMMED_STOP> command for virtual machine stop added in interactive optimizer for Tulus 2.4 machine (XML).
6. Updated Head Up checking with last link/segment of tool element (XML laser).

NCX v11.1.14 Release Notes

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1. Fix in nibble-nibble double hit removal, earlier could leave perfectly overlapping nibbles in non-zero angles (all)
2. Fixed bug for outputting extra new_pierce_technology command (E1).
3. Fixed: Pressing 'View nest' in nest explorer when simulator active, could cause loosing all parts in the sheet (all)
4. Restore Clamp Move function in interactive zone (graphic mode) (all)
5. Support LST presort command for LPE machine (XML E1).
6. Shear nesting program unnecessary broke part grids, When part separation in nest was set to zero (b1)
7. Prevent crashing in the case of part names having "="

NCX v11.1.13 Release Notes

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1. Process NO_HIT_MOTION tooling element, which is created in "move over skeleton" mode (P1)
2. Allow negative leads overcut (undercut) (c1,p1)
3. Expand film burning to crop cutting (C1,P1)

4. Move code for prepiercing with shortened Z value from part subroutine to the main program (P1)
5. Automatic Parting Tool Width calculation routine produced 2 correct values, but in the wrong order (a1)
6. Prevent crash in AddPartToNest when nest status is 'Possible zone violation' (all)

NCX v11.1.12 Release Notes

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1. Provide silent mode for DXF import (all)
2. For PRIMA machines for laser paths without leads do not relocate path starting point (P1)
3. Some CAD commands could fail for parts having space inside part name (all)
4. Allow multi-parts to have alias and quantity (all)
5. Fixed bug for missing technology changing command (XML D1).
6. Use next NOT MARKING technology in \$(WORK_OFF)(x,P3) command, when no-pierce cutting is switched to marking (P1)
7. Trim-2-Lines cad command could trim second line from the wrong side (all)
8. Fixed bug for missing radius field (XML)
9. Bug in offset routine could cause nesting to fail with 'out of memory' message (D1,P1)
10. Cad command "Delete Construction Lines" didn't support UNDO (all)
11. Reverse robot gripper y-offset sign for Tulus laser-machines with LST (E1)
12. Allow fillet radius to be $> 0.5 * \text{beamWidth}$
13. Free form nesting crashed if more than 16 different plate sizes were scheduled (all)
14. Disable beam compensation error checking on rounded corners of commonlined parts (C1,D1,E1,P1,P2)
15. More consistent selection overlapping entities: alternate entities and give preference to UNLOCKED layers
16. For Tulus 2.3 machine, manual removal part should use "PROGRAMMED_STOP" command (XML).
17. Unlock construction layer (all)
18. Fixed bug for wrong nc code when wheel soft cutting trap door case (XML).

NCX v11.1.11 Release Notes

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1. Fixed: Accumulated quantity for the whole nest showed just single sheet quantity in report (all)
2. In the "Move nest up" mode do not violate rule for nesting long sheared parts in the clamp zone (B1)
3. Process DXFs with drawing planes Y=0 and X=0 (in the previous versions Z=0 was always assumed) (all)
4. When new nest is being created, take into account material sheet order, previously saved with "Use as default" button
5. When nesting parameters "use sheets in listed order" and "square last plate" were set together program could use wrong plate size for the
6. Updated manual in English, Italian, German, Spanish and Finnish (all)
7. Fixed bug in shear nesting program, which caused "gap" at plate bottom in "remove last part from the clamps" mode (B1).
8. Made changes to provide "top destruct" NCX support for PS machines (B1).
9. Made changes to provide dummy motion after clamp move when needed (A1, A2, B1, D1, E1).

NCX v11.1.10 Release Notes

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1. Filleting was fixed for the case of Line2Arc and arc2Arc (all)
2. Support for shortening Z value in the pre-piercing cycle (P1)
3. When last hit marker is being removed in "Edit sorting" dialog, remove possible outdated LUR marker (A2)
4. Updated Italian translation (all)
5. Added converting non-US ASCII character for subroutine name (XML).
6. Allow nesting of punched parts on sheets pre-sheared in X (A1,A2)
7. Clamp protection area was not displayed after new tool was selected (all)
8. In the nest tooling draw part geometry and do not draw tooling envelopes (all)
9. Fixed bug for Fanuc post missing G72 command (A1, A2).
10. Do not show empty layers in LayerFilterDialog (all)

NCX v11.1.9 Release Notes

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1. Prevent postprocessor from crashing, when stacking fails (a2, b1)
2. Make NCX TULUS staking to distinguish between "sorting to multi-station device" and "sorting to particular station of multi-station device"
3. Change default value for measurement point 2 from PlateSizeX-100 to PlateSizeX-500 (P1)
4. Fixed bug for extra STOP_PROCESS command (XML D1 E1).
5. If stacking is enabled, run NCX TULUS staking on nesting
6. CAD fillet command created fillet on the wrong layer (all)
7. Could not process some DXFs, because BlockTransformMatrix was ignored (all)
8. Fixed bug, which caused always raising head to P3 during pre-piercing (P1)
9. Do not grid different parts if it violates nest-priority rule (B1)

NCX v11.1.8 Release Notes

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1. Fixed calculation of object rotation angle. The bug showed in interactive part rotation (all)

2. More reliable shear hit processing in Binary CP mode (B1)
3. Use different line type for Head-Down moves (C1)
4. Fixed bug in Interactive destruct, which caused "double" tooling (all)
5. Fixes in iges importer (all)
6. Fixed bug for missing lubrication command (XML B1).
7. Wrong colors in display slugs and untooled (all)
8. Updated Chinese translation (all).
9. Made changes to provide "691/692" sorting device use for non Tulus machines as well (B1).

NCX v11.1.7 Release Notes

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1. Allow "," in part names (all)
2. Support text in parameters of scripted parts from order database (all)
3. Support production labels from order database (all)
- 4 On import DXF allow user to select layout if current layout is no "Model"
5. If file WORK\StackerIn.xml was found in TULUS stacking mode, then use it instead of StackingPrm.mdb (all)
6. Don't copy FMS-file to NC-target folder on Tulus machines (XML)
7. Write names of accepted sheets in a separate AFL-file and give that filename as a command line parameter to external 'accept'-program (XMI)
8. Support for "Fill tools" mode.
9. Remove message:"More than 10 parts have been moved ..." and always do checking for parts nested in the holes. (all)
10. Fixed bug for missing label text (XML).
11. CAD trimming command now supports trimming arcs against arcs (all)
12. TULUS stacking is now called with additional <RunPath> parameter (all).
13. Made changes to fix bottom scrap cutting problem (B1).
14. Support for CAD command: "Move to different layer"

NCX v11.1.6 Release Notes

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1. Output LD6-style gripper areas for E6x+CE machines (A2)
2. Fixed: Mode and Lubricator tags were switched in the Lubricate command (XML+A1)
3. Fixed: Setting 'Open clamps at end of program' had choices yes/no switched in German (XML+A1)
4. Support lead-in technologies for PRIMA lasers
5. Don't output compensation command until first linear cutting after start process (XML E1).

NCX v11.1.5 Release Notes

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1. Changes to prevent 'out of memory' situation when drawing optimized plates with a lot of hits (all)
2. Update Visual Studio 2010 redistributable package to 10.0.40219.325 (all)
3. Add Remnant, RemnantMinX and RemnantMinY scripting properties in ShearParameters class (B1)
4. Allow sheet count going below zero in plate database when user press 'Accept'-button (all)
5. Align sorting marker (yellow arrow) for shear hits. (B1)
6. Draw CAD origin (all)
7. Fixed: Part id = 1 output in sorting-command for LSR/LST sorted parts rotated to non-zero angle, broken June 1st 2011 (Siemens+D1,E1)
8. Fixed bug in importing DXFs, containing 2D-polylines with non 0 bulge factor (all)

NCX v11.1.4 Release Notes

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1. Remove limit on the length of the path to the run folder (used to be around 114 chars) (all)
2. When clamp initial position left out plate, output CLAMP_SHEET_DETECTOR command (XML machine).
3. Support negative 'notch expansion' in interactive punch destruct (all)
4. Support for 'Move origin' CAD command (all)
5. Support for orthogonal-only moves if drag-drop started with shift key down (all)
6. Break High Speed Cycle when switching technology to/from marking even in NO PIERCE mode (C1)
7. Allow doing tip-cleaning inside subroutine for SYNCHRONO (P1)
8. Fixed bug for outputting wrong DWELLA command for the first line after tool change when tool is auto index tool (A1,A2,B1,E1).
9. When imported drawing has more than 2 layouts, let user to select active layout (all)
10. Fixes in rightangular shape destruct of autotool when shape wasn't exact but still inside environment tolerance (all)
11. Fix in shear nesting for the case of (filler parts + Optim Level > 0) (B1)
12. Fix to activate snapping during drag-drop operations (all)
13. Fixed bug for outputting extra SORTING command when using micro-joint (XML D1,E1).
14. Fixed bug for wrong result when adding laser micro-joint with or without lead in option (C1,D1,E1).
15. Activate snapping for 'click point punch/nibble/shear/destruct' (all)
16. Fixed: output always G91 after START_PROCESS nc-command, broken in 11.1.1 (D1).

17. Made changes to improve "Remnants handling" in NCX (B1).

NCX v11.1.3 Release Notes
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1. Forbid selection on optimizer screen (all)
2. "Renest One Plate" had problems when re-nesting was done on different plate size (all)
3. Restore 2-click zoom window (all)
4. Fixed bug for missing clamp move command for Siemens 880N (B1).
5. Use ODA snapping for measuring command (all)
6. Support for POLYGON selection (all)
7. Prevent simulator crash on displaying certain nibble arcs (A1,A2,B1,E1)
8. New selection cursor (all)
9. Ignore construction lines on ZOOM ALL (all)
10. Fixes on bottom status bar panel lengths after main dialog was re-sized (all)
11. Fixed bug when sometimes deleting fillet had crash C1,D1,E1).
12. "Cut from pre-sheared blank" dialog didn't allow select pin2 for pre-ser12 machines (a1)
13. Added NOCUT check for outputting better KeepCuttingHeadDown flag (D1, E1).
14. Fixed bug for outputting wrong station size. (XML A1, A2, B1, E1).
15. If non-existing sorting type given in Part.Shear scripting command, try using just address (B1)
16. "Rubber frame" was not visible in the INTERZONE (A1,A2,B1,E1)
17. Prevent growing memory in "Interactive Optimizer" (A1,A2,B1,E1).
18. Made changes that allow also using negative values in "Min clamp 1 position" setting for pins 3 or 4 (A1, A2, D1, E1).

NCX v11.1.2 Release Notes
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1. Program crashed on saving empty plates (all)
2. Don't check wheel and scribe tool size when using these tool nibble on arc (all).
3. Dialog ModifyPiercing didn't work immediately after closing some dialogs (edit tabs, edit leads) (d1)
4. Wrong azimuth value for bevel cutting (P2)
5. Toggle selection for 2 locked hidden entities (all)
6. New edition of "Modify bevel" dialog (P2)
7. Add Russian translation in the installer (all)
8. Some support for CAD "Stretch" command (all)
9. H1 value output changed after tool change (A1,A2,B1,E1).
10. Allow multi-parts with empty alias and stop maintain job.dat compatibility with versions prior to 4.2 (all)
11. For multi-point STRIKE tooling element show "last hit" arrow only for the last strike (all)
12. Support for NestMoveUp script command (all)
13. Add "2 clicks window selection" option (all)

NCX v11.1.1 Release Notes
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1. Support "LASER" tool ID for XML post (D1, E1).
2. Output part weight as net weight (XML machine).
3. "Selection cursor size" was added to the 'General' section of NCEXpress.ini (all)
4. Added open layer dialog when user clicks menu "Drawing/Layer" (ALL).
5. Snapping to line-to-line intersection points was added do drag-drop function (all)
6. Do not draw last tool hit marker on separate layer (all)
7. Program crashed on View/Unloaders (all)
8. Support floating license with red NetHasp-dongle (all)
9. Fixed bug in "Nest centering" option for 180 deg. parts (all)
10. New menu item 'Database'-'Save parameter changes' to allow user save parameter changes in material database immediately (all)
11. Updated output "G4" code with dados (D1).
12. Support remnant scrap (B1 XML machine).
13. Program sometimes crashed when imported DXFs included text on "closed contours" layers

A1 - punch only
A2 - punch + FMM/LUR/LSR/LST
B1 - shear + FMM + STS/ROBOT/..
C1 - laser L/FPL
D1 - Laser - LC
E1 - laser punch
P1 - Platino
P2 - Domino
ALL - general NCE problem