



Predator CNC Editor™ v6.1 – What's New

Latest features and benefits in v6.1

Before Installing v6.1

Microsoft Internet Explorer v5.5 or later is required to be installed before installing Predator CNC Editor v6.1. Version 6.1 of the Predator CNC Editor does not need to be installed separately if a full install of Predator DNC v4.x or Predator Virtual CNC v5.x will be installed. Both Predator DNC v4.1 and Predator Virtual CNC v5.1 will automatically install v6.1 of the Predator CNC Editor.

NOTE: v6.1 does not support Windows 95, existing users must upgrade to Windows ME, 98, NT, 2000 or XP.

Why v6.1?

By design, this release was intended to fix a few bugs and add some popular requests made by our users. Details of the new features are explained throughout this document and within the online help.

Installing v6.1

By default, installation occurs in the \program files\predator software\editor 6.1\ directory. If you were running v6.0 or earlier simply proceed with the installation normally. If you were running a beta version of 6.1, please un-install it prior to installing v6.1.

NOTE: We have dropped supporting floppy drive or diskette based installs. All installations must be performed from a CD, CDR, CDRW or DVD drive.

© 1994 – 2003 Predator Software Inc. All rights reserved.

THIS IS A LIVING DOCUMENT. The information contained in this document represents the current view of Predator Software Inc. on the issues discussed as of the date of publication. Because Predator Software Inc. must respond to changing market conditions, it should not be interpreted to be a commitment on the part of Predator Software Inc., and Predator Software Inc. cannot guarantee the accuracy of any information presented after the date of publication.

Network Installations of v6.1

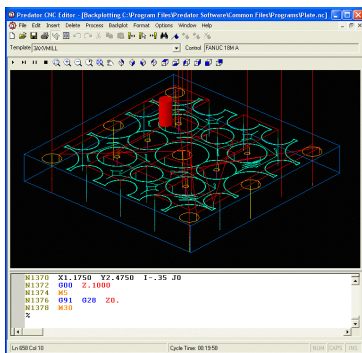
By committing to store the product installation on a server, users will enjoy automatic healing of all critical files upon running Predator CNC Editor. For example, a user accidentally deletes peditor.exe. Under normal circumstances he would be down and the software would fail to run. With v6.1, when the user double clicks the desktop shortcut, all critical files are checked and if necessary restored from the network server and the software begins to run automatically.

To perform a network installation is to step through the following:

1. Copy the contents of the entire CD to a \predator cd\ or similar directory.
2. Run the setupeditor.exe from the \predator cd\ directory.

NOTE: Should any automatic healing be necessary, Predator CNC Editor will be able to automatically extract the necessary files from the appropriate cab files stored in the \predator cd\ directory. If you install from an actual CD, Predator CNC Editor will be forced to prompt for the CD.

Predator CNC Editor



What's New in v6.1?

Improved! HTML based Online Help

Updated HTML based, context sensitive, online help is included with the Predator CNC Editor. Several new and updated topics have been added.

New! Select to Next and Previous Bookmark

A new bookmark option allows selection from the current cursor position to the next or previous bookmark. These commands can be found within the Edit Bookmarks menu.

New! Autofit during Backplotting

During the backplotting process Predator CNC Editor will now automatically autofit the image during the backplot.

NOTE: This eliminates the need for displaying the machine's travel limit envelope.

New! Variable and Expression support for Backplotting and Verification

Support for variables and expressions have been added to the backplotting and 3D animation. For example, Fanuc variables can be #100, #101, #102. These can be assigned to specific values or complex expressions. An expression example would be #100=2*[#200+1.5] and variables can be used for tool motion feed rates etc. Refer to the following example:

```
G1 X#100 F#200/2
```

NOTE: A new sample file putter-sample.nc has been added to the install as an example of Fanuc style variables and expressions.

New! Math, Boolean and Trig Macro support for Backplotting and Verification

Support for math, boolean and trig functions have been added to the backplotting and 3D animation. For example, Fanuc math, boolean and trig functions include +, -, *, /, ^, MOD, INT, OR, AND, XOR, EQ, NE, GT, LT, GE, LE, SIN, COS, TAN, ASIN, ACOS, ATAN, SQRT, ABS, ROUND, LN, and EXP. Refer to the following example:

```
G3X[#2-0.275*TAN[80/2]+#1+#1*COS[80]]Y[#100+#1*SIN[80]]I0J[0.275-#100]
```

NOTE: A new sample file putter-sample.nc has been added to the install as an example of Fanuc style variables and expressions.

New! Cutter Compensation support for Backplotting and Verification

Look ahead support for cutter compensation has been added for backplotting and verification within v6.1 of the Predator CNC Editor. For example, Fanuc G40, G41, and G42 support has been added. Finally, v6.1 of Predator CNC Editor has enhanced support for Heidenhain style cutter compensation.

New! Red Rapid Moves for Backplotting

Backplotting has been improved with rapid moves automatically shown in red.

NOTE: Feed moves are still defaulting to blue while backplotting.

New! Always Print in Black and White

A new option has been added that will force Predator CNC Editor to always print in black and white even if color highlighting has been enabled. With this option disabled Predator CNC Editor and color highlighting is enabled then printouts will often have shades of grey.

New! Close All

A new option has been added to the file menu that will close all open files. If any open files have edits that have not been saved, Predator CNC Editor will prompt to save changes before closing the file.

New! Insert File Command Line Option

A new command line option to insert files into the current document at the current cursor position has been added. For example:

```
peditor -i "job1234.nc"
```

NOTE: If a filename is not specified in the command line, Predator CNC Editor will automatically prompt for a filename.

New! Ignore Tool Numbers, Feed Rates and Spindle Speeds during Compare

Three new options allow ignoring tool numbers, feed rates and spindle speeds during compare.

New! Lathe Cycles support for Backplotting and Verification

Backplotting and 3D animation within Predator CNC Editor v6.1 now supports canned lathe cycles for turning, facing, grooving and threading. Refer to the following Fanuc examples:

"G32"	:	Threading
"G70"	:	Finishing Cycle
"G71"	:	Horizontal Roughing
"G72"	:	Vertical Roughing
"G75"	:	Vertical Grooving
"G76"	:	Threading
"G90"	:	Horizontal Tapping
"G94"	:	Vertical Tapping

New! 20 New Machine Templates

Twenty new machine templates have been added to the Predator CNC Editor. Each of these new machines is shared with Predator Virtual CNC. New templates for Anilam, Deckel, Fadal, Haas, Heidenhain, Heidenhain Conversational, Okuma, Seimens, Toshiba and Yasnac have been added.

Enhanced! Replace All

The Replace All option within the Replace command has been made significantly faster.

Enhanced! Temporary Licensing

Temporary licensing has been improved to show the number of days remaining in the status bar.

Enhanced! Find Files

Improved the Find Files wizard to make it easier to adjust the column widths without "accidentally" opening a file.

Enhanced! Backplot

Improved Predator CNC Editor to automatically remember the tool holder and tool color options.

Enhanced! Change Feed Rates and Spindle Speeds

Improved Change Feed Rates and Spindle Speeds to correctly handle non-numeric values.

Enhanced! Lathe Radius and Chamfer support for Backplotting and Verification

Support for lathe radius and chamfer moves within a G1, linear move, within Backplotting and 3D animation has been improved. Finally, v6.1 of Predator CNC Editor has enhanced support for Heidenhain style radius and chamfer motion when combined with cutter compensation.

Bug Fix! Opening Files via the Command Line

Fixed a bug with opening files via the command line while Predator CNC Editor is loaded with an active wizard dialog.

Bug Fix! Compare and Backplot Tool Tips

Fixed a bug with Compare and Backplot tool tips not displaying when the mouse hovered over the toolbar button.

Bug Fix! Adding Spaces

Fixed a bug when Adding spaces to an empty line.

Bug Fix! Editing while Processing

Fixed a bug that allowed a user to edit the document while Predator CNC Editor was processing a command.

Bug Fix! Change Feed Rates and Spindle Speeds

Improved Change Feed Rates and Spindle Speeds to correctly handle non-numeric values.

Bug Fix! Receive from CNC under Windows 98

Fixed a bug with Receive from CNC under Windows 98. v6.1 fixes a bug introduced with v6.0 of the Predator CNC Editor. Customers that do not wish to upgrade to v6.1 can install an updated .exe v6.0.198 that also fixes this problem.

Bug Fix! Abort and Pause Toolbar

Fixed a bug graying and ungraying with all commands that called the abort and pause toolbar.

Bug Fix! Checkmarks in Menus

Fixed a display problem with checkmarks on menus.

Bug Fix! New Template

Fixed a bug sorting machine files within the New Template wizard.

For more information

For the latest information on the Predator CNC Editor, check our web site at <http://www.predator-software.com>