



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 by default will automatically install v6.1 of the Predator CNC Editor.

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

Why v6.1?

By design, this release was intended to add some popular requests made by our users and to fix a few bugs. 40+ new features and improvements have been made to v6.1 of the Predator CNC Editor to improve its ease of use and flexibility. Details of the new features and enhancements 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.

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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.

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. New intelligent zoom works with Autofit to minimize the effort necessary to backplot and see the tool motion.

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

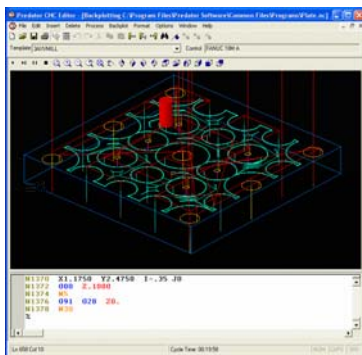
New! Variable and Expression support for Backplotting and Verification

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.

Predator CNC Editor



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. In addition, v6.1 of Predator CNC Editor has improved support for Heidenhain style cutter compensation. Finally, a new parameter has been added to control the style of tool motion when cutter compensation is applied to external corners. Refer to the following .RPx examples:

```
CutterComp_Connect=Standard  
CutterComp_Connect=Round
```

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 have been added to allow ignoring tool numbers, feed rates and spindle speeds during compare. These options can be enabled or disabled as needed.

New! Lathe Cycles support for Backplotting and Verification

Backplotting and 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	; Fanuc Style
"G70"	:	Finishing Cycle	
"G71"	:	Horizontal Roughing	
"G72"	:	Vertical Roughing	
"G75"	:	Vertical Grooving	
"G76"	:	Threading	
"G90"	:	Horizontal Tapping	
"G94"	:	Vertical Tapping	

In addition a new function keyword has been added to support complex profiles within lathe cycles. Refer to the following Fanuc examples:

"G71",multi@4	:	TurnCycle (Horizontal Box_Strategy Pocket)
"G72",multi@4	:	TurnCycle (Horizontal Box_Strategy)

NOTE: The G71 has the additional pocket function keyword, which enables support for complex profiles. The G72 does not have the pocket function keyword, which disables support for complex profiles.

New! Modal Heidenhain Cutter Compensation

Support for modal style Heidenhain cutter compensation has been added. This option can be enabled with the following parameters:

```
CYCLE_PARAM_STYLE=HEIDENHAIN  
CUTTERCOMP_STYLE=MODELESS
```

New! Set ¾ Lathe Section

When verifying a lathe program a new right mouse option to toggle a ¾ section has been added to help display ID tool motion.

New! Show Rapid Moves

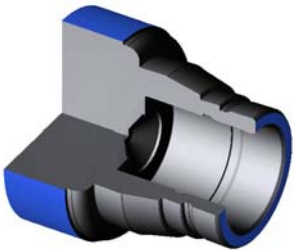
When backplotting a new right mouse option to toggle rapid moves has been added. This option will enable or disable showing rapid moves.

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.

New! Keyboard Shortcuts

When backplotting or verifying two new keyboard shortcuts are available. While holding the CTRL key down and dragging the left mouse button the display can be panned. Finally, while holding the SHIFT key down the left mouse button can initiate a zoom window command.



New! Administrator Mode

A new administrator mode has been added. This adds an Administrator menu and a new Properties command. The new properties dialog enables and disables several security features including a forced Default Directory, Exclude Extension List, Full Pathname display, and Allow Save As. All of these options can be combined to create a secure environment for editing CNC programs.

NOTE: Launching the Predator CNC Editor in Administrator mode is identical to the method used in Predator DNC and Predator Desktop.

Enhanced! Find

The Find command will now automatically use any selection as the default search value. In addition the Find command will remember the last five searches for re-use via a pulldown menu.

Enhanced! Replace

The Replace command will remember the last five search and replace values for re-use via a pulldown menu. In addition, 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 current view, speed, tool holder, tool color, display rapid moves and $\frac{3}{4}$ vie

Enhanced! Backplotting Toolbar Buttons

Improved the large backplotting toolbar buttons to be less confusing for lathe programs.

Enhanced! Programmable Offsets

Improved programmable offsets, typically a G10, to support incremental values.

Enhanced! Resequence and Add Sequence Numbers

A new option to automatically restart sequence numbering after each program number has been added.

Enhanced! Bookmarks and Process Commands

Improved the use of bookmarks with all of the process commands. In the previous version a process command would automatically delete any bookmarks. With v6.1 bookmarks are automatically restored after every process command.

Enhanced! Animation Light Source

Improved the position of the animation's light source to stay constant after switching from one type of machine to another.

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! 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.

Bug Fix! Abort and Pause Toolbar

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

Bug Fix! Checkmarks in Menus

Fixed a display problem with checkmarks on menus.

Bug Fix! Custom Menus with Windows XP

Fixed a problem launching database driven applications under Windows XP from a custom menu.

Bug Fix! Launching Predator CNC Editor under Windows XP

Fixed a problem launching Predator CNC Editor from another database driven applications under Windows XP.

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>