MILL**PWR**^{G2}
SOFTWARE
UPDATE

ACU-RITE®

March 30, 2015

MILL**PWR**^{G2} **2 & 3 Axis**

(Version R2SP6**)**

NOTE: HEIDENHAIN Corporation recommends making a backup of the control with the included USB Recovery Drive (684138-xx) before updating the control software. Please refer to the manual included with the drive for the backup procedure.

These enhancements/changes were made:

Correct the following issues with the canned cycle's Mirror cycle: 1. Correct formula for handling nested mirror steps. Mirrored islands do not run correctly resulting in a run-time error.

Graphic do not appear when a feature is returned from the geo calc: A correction to handling of the layouts has been implemented.

The correct number of passes and peck distance is now properly calculated when the peck distance does not divide equally into the depth. This change applies to Rectangle Pocket, Slot Pocket, Circle Pocket, Ring Pocket and Contour steps.

If the programmed units for distance/number do not match the current setting, the default values for peck/pass/tooldist fields in a new step dialog are wrong. The values come from previous steps and no conversion is made. Do not default to previous value if units conflict.

Corrected a system crash most often occurring when having a large g-code program (greater than 10,000 lines) loaded.

1. The GeoChain and IPO are synchronized before continuing after a G-code tool change operation. 2. The Z axis servo is turned off during a G-code tool change to allow setting the Z axis datum.

Corrected an issue that would not allow you to save a loaded G-code program as a different filename or in a different location.

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Units with optional Spindle Control/AMI

Set Tool step does not handle spindle speed correctly: 1. Spindle speed (S) should not be set to 0 rpm when turning off spindle (M5). 2. A blank spindle speed field should not be default to 0 rpm.
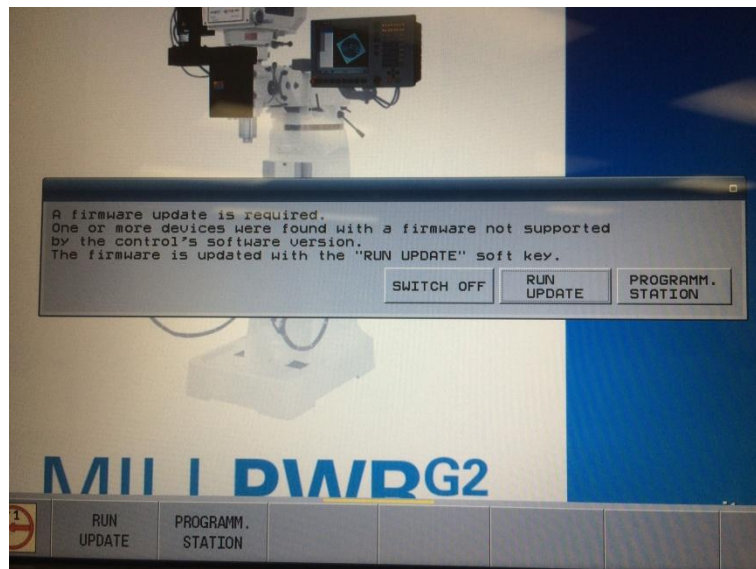
Corrected several issues with the Machine Functions softkey menu; - Manual spindle control is now supported while in DRO mode.
- Offline versions now display the Installation Setup setting to enable the MFSK menu.
- The online help system is now linked so the description of the MFSK menu in the User Manual can be shown via the INFO key.
 - The menu can no longer be displayed while running programs, but is allowed when the program is Paused.
- The key states will now correctly update while the menu is visible.

Analog Wizard fixes: - Inch / Metric units of diagram are correct

* Additional erroneous error were corrected

Select **RUN UPDATE** if prompted with firmware update message

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Version (2 or 3 axis) - The version number was updated to R2SP6.

You can download the software release update from our web site at www.acu-rite.com. If you wish to purchase the software and operation manual from ACU-RITE contact Customer Service to place an order.

Installing the software onto your MILL**PWR**^G2 system:

HEIDENHAIN Corporation recommends making a backup of the control with the included USB Recovery Drive (684138-xx) before updating the control software. Please refer to the manual included with the drive for the backup procedure.

Use a blank USB memory stick (1 GB or larger) to update the software. Do not use any memory stick with a smaller storage capacity. The software installation files are required for updating the software. These files will automatically be recognized by the installation program of the control and must be contained in a folder named **"install"** on the USB memory device with typical files called setup.zip, and setup.ini.

Procedure for updating the software
- Shut down the control software using the normal method of pressing the Shutdown soft key and then confirming the shutdown by pressing Yes.
- Wait for the screen message which indicates that it is safe to switch off power, or restart.
- Insert the USB memory device containing the folder named "install" on the USB memory device.
- Press ENTER to restart the system.
- After starting, the MILL**PWR**^G2 Software Update screen will appear with a confirmation box. If necessary, use the UP/DOWN ARROW keys to select the language (e.g. English) and press ENTER.
- A confirmation box will appear. If necessary, use the LEFT or RIGHT ARROW keys to select Yes, and then press ENTER.
- The software update will now be done automatically, taking approximately 10 - 20 minutes.
- When the update is complete, it will prompt you to remove the USB drive and restart. At this time, remove the USB drive and press ENTER to restart.
- After the system has restarted, it will start up normally to the control software.

If any issues are encountered, please contact your service representative for assistance.

If the USB memory stick used for installation is not removed, then the prompt to install the software will continue to appear on subsequent power cycles.