



Predator CNC Editor™ v9.0 – What’s New

Latest features and benefits in v9.0

Before Installing v9.0

Predator CNC Editor v9.0 requires Windows 2000, XP, Vista, 2003 Server or 2008 Server. Existing customers that have older versions of Windows such as Windows 95, 98, ME or NT v4.0 must upgrade prior to installing v8.0 of Predator CNC Editor.

NOTE: Backup the peditor.mdb file located in the following folder depending on version

c:\program files\predator software\editor 8.0\

c:\program files\predator software\editor 7.0\

V9.0 is 98% backwards compatible with v8.x previous releases but there are a few reverse post changes that might be necessary. These changes primarily affect Fanuc style G28, G29 and G53. Remove the following registers from your reverse posts:

r_reference_pos_X	r_reference_pos_V
r_reference_pos_Y	r_reference_pos_W
r_reference_pos_Z	r_reference_pos_4th
r_reference_pos_U	r_reference_pos_5th

Remove the following parameters from your reverse posts:

Mill_W_Axis	Reference_Axis
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Remove the multi@ patterns from the following keywords:

ReturnToRefP	ReturnFromRefP
MoveInMchCoord	

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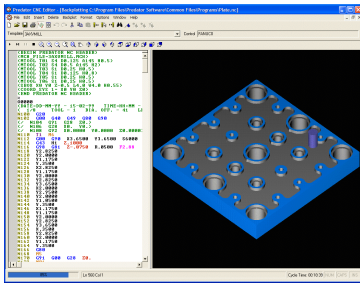
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Microsoft Internet Explorer v5.x or later and the Microsoft .NET Framework 2.0 is required to be installed before installing Predator CNC Editor v8.0.

Why v9.0?

By design, this release focuses on improved backplotting and Predator CNC Editor Enterprise functionality. Support for Windows 2008 Server, Microsoft SQL Server 2008 and Microsoft SQL Server 2008 Express have been added. Details of what’s new are explained throughout this document and within the online help.

Predator CNC Editor



Installing v9.0

A new Install Wizard has been developed for v9. It is based on a single .MSI image and .CAB files have been eliminated. If you are running Windows 98, ME or NT v4.0 you must upgrade to Windows 2000, XP or 2003 Server prior to installing v8.0 of Predator CNC Editor.

By default installation occurs in the \program files\predator software\editor 9.0 directory. If you were previously running v8.x we recommend uninstalling v7.x prior to installing v8.0.

Network Installations of v9.0

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, suppose a user accidentally deletes peditor.exe. Under normal circumstances he would be down and the software would fail to run. With v8.0 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.

The easiest way to perform a network installation is to step through the following:

1. Copy the contents of the CD to a \predator cd images\CD40\ or similar directory.
2. Run the setupeditor.exe from the CD40 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 CD40 directory. If you install from a CD, Predator CNC Editor will be forced to prompt for the CD.

What's New in v9.0?

New! Microsoft Windows 2008 Server Support

Support for Microsoft Windows 2008 Server has been added with v9.0 of Predator CNC Editor. This includes support for the x64 editions.

NOTE: Predator CNC Editor is a 32-bit application and installation of Predator CNC Editor under Windows 2008 Server x64 edition defaults to the following folder

\program files (x86)\predator software\editor 9.0

New! Microsoft SQL Server 2008 Support

Support for Microsoft SQL Server 2008 has been added with v9.0 of Predator CNC Editor.

New! Microsoft SQL Server 2008 Express Support

Support for Microsoft SQL Server 2008 Express has been added with v9.0 of Predator CNC Editor Enterprise. Support for this edition of SQL Server provides a free version of Microsoft SQL Server for small and medium manufacturers. The Express edition can be downloaded from Microsoft's web site.

New! Create Cutters, Cutter Types and Cutter Materials

Creating new cutters, cutter types and cutter materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! Create Inserts, Insert Types and Insert Materials

Creating new inserts, insert types and insert materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! Edit Cutters, Cutter Types and Cutter Materials

Editing existing cutters, cutter types and cutter materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! Edit Inserts and Insert Materials

Editing existing inserts, insert types and insert materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! View Cutters, Cutter Types and Cutter Materials

Viewing cutters, cutter types and cutter materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! View Inserts, Insert Types and Insert Materials

Viewing inserts, insert types and insert materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! Cutters, Cutter Types and Cutter Material Reports

A new cutters, cutter types and cutter material reports have been added to v9.0 of Predator CNC Editor Enterprise.

New! Inserts, Insert Types and Insert Material Reports

A new inserts, insert types and insert material reports have been added to v9.0 of Predator CNC Editor Enterprise.

New! Cutters, Cutter Types and Cutter Material History Reports

A new cutters, cutter types and cutter material history reports have been added to v9.0 of Predator CNC Editor Enterprise.

New! Inserts, Insert Types and Insert Material History Reports

A new inserts, insert types and insert material history reports have been added to v9.0 of Predator CNC Editor Enterprise.

New! Import Cutters, Cutter Types and Cutter Materials

Importing cutters, cutter types and cutter materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! Import Inserts, Insert Types and Insert Materials

Importing inserts, insert types and insert materials have been added to v9.0 of Predator CNC Editor Enterprise.

New! View Cutters Toolbar Button

Predator CNC Enterprise v9.0 includes a new View Cutters toolbar button.

New! View Inserts Toolbar Button

Predator CNC Enterprise v9.0 includes a new View Inserts toolbar button.

New! Import Errors Report

A new Errors report has been added to the Import wizard within v9.0 of Predator CNC Editor Enterprise. This report will provide a list of all the import errors that Predator CNC Editor Enterprise identifies. This reduces the trial an error process when cleaning up bad csv files.

New! Remember Password

A new Remember Password option has been added to v9.0 of Predator CNC Editor Enterprise. Enabling this option will automatically logon the user to Predator CNC Editor Enterprise. The password is stored in a secure manor per Windows user.

New! Tool Display Commands

V9.0 of Predator CNC Editor includes new reverse post processor commands to control the display of the tool. Refer to the following example:

```
"M77"           :           ToolNormal
"M78"           :           ToolDim
"M79"           :           ToolHighlighted
```

New! Unload Tool Command

V9.0 of Predator CNC Editor includes a new reverse post processor command to unload a tool. Refer to the following example:

```
"M76"           :           UnLoadTool
```

New! Fanuc G30.2, G30.3 and G30.4 Support

V9.0 of Predator CNC Editor includes a new support for Fanuc style G30.2, G30.3 and G30.4 support.

New! Fanuc G30 Support

Support for Fanuc style G30 second reference point return has been added with v9 of Predator CNC Editor.

New! Haas 5 Axis Drilling Support

V9 of Predator CNC Editor adds a new toolaxisdir keyword for 5 axis drilling.

```
"G161",multi@7           :           DrillCycle (toolaxisdir) ; Haas Style
```

New! Reverse Post Registers

V9.0 of Predator CNC Editor includes the following new registers:

```
r_intermediate_pos_x           r_drill_pos_4thAxis
r_intermediate_pos_y           r_drill_pos_5thAxis
r_intermediate_pos_z           r_drill_peck
r_intermediate_pos_4th         r_drill_peck_inc
r_intermediate_pos_5th         r_drill_retract
```

New! NOT Support

V9 of Predator CNC Editor adds a new NOT keyword for Boolean operations.

```
"NOT",#30           :           Not(double in)
```

New! Incremental Rotary Axis Motion

V9 of Predator CNC Editor adds a new support for incremental rotary axis motion.

```
"H",real           :           IncMove4thAxis           ; Fanuc style
"IB",real          :           IncMove5thAxis
```

New! Reverse Post Parameters

V9.0 of Predator CNC Editor includes the following new parameters:

```
[PARAMETERS]
RefPoint2 = 15,20,25,35,45
RefPoint3 = ignore, ignore, 15
RefPoint4 = 0, 0, 15
Cycle_Modal_Style= Exclude_Def_Call
LatheCycle_RetractAmount=0.01
ArcSense_Modality=On
```

NOTE: RefPoint values not specified are assigned to be ignore. Cycle_Modal_Style's other option is Include_Def_Call.

New! Solidworks eDrawings Support

Predator CNC Editor Enterprise includes Solidworks 2010 eDrawings support for viewing Solidworks assemblies, parts and drawings. In addition Autocad DWG and DXF files are supported.

New! Microsoft Visio Support

Predator CNC Editor Enterprise includes Microsoft Visio support for viewing Microsoft Visio drawings.

Improved! Microsoft Word Support

Predator CNC Editor Enterprise includes Microsoft 2007 Word support for viewing Microsoft Word, Wordperfect, Works and RTF documents.

Improved! Microsoft Excel Support

Predator CNC Editor Enterprise includes Microsoft 2007 Excel support for viewing Microsoft Excel spreadsheets.

Improved! Microsoft Powerpoint Support

Predator CNC Editor Enterprise includes Microsoft 2007 Powerpoint support for viewing Microsoft presentations.

Improved! Adobe Acrobat Reader Support

Predator CNC Editor Enterprise includes Adobe Acrobat Reader v9.2 for viewing PDF documents. This includes 3D PDFs.

Improved! Fanuc G53 Support

Support for Fanuc style G53 machine coordinate system has been improved with v9 of Predator CNC Editor.

```
"G53"              :           MoveInMchCoord
```

NOTE: Patterns should not be used with MoveInMchCoord.

Improved! Fanuc G28 Support

Support for Fanuc style G28 return to reference point has been improved with v9 of Predator CNC Editor. This change orphans some v8 parameters that need to be deleted with any existing reverse post processors.

"G28" : ReturnToRefP

NOTE: Patterns should not be used with ReturnToRefP.

Improved! Fanuc G29 Support

Support for Fanuc style G29 return from reference point has been improved with v9 of Predator CNC Editor. This change orphans some v8 parameters that need to be deleted with any existing reverse post processors.

"G29" : ReturnFromRefP

NOTE: Patterns should not be used with ReturnFromRefP.

Improved! Error Messages

V9.0 of CNC Editor improved reverse post processing error messages.

Improved! Heidenhain Support

Support for Heidenhain conversational has been improved and redesigned with v9 of Predator CNC Editor. Support for Heidenhain cycles 1, 7, 19, 200, 201, 202, 203, 205, 208, 210, 211, 212, 213, 214, 215, 240, 251, 252 and 254 have all been improved. Support for the following Q variables has been improved Q200, Q201, Q202, Q203, Q204, Q205, Q206, Q207, Q208, Q210, Q211, Q212, Q213, Q215, Q216, Q217, Q218, Q219, Q220, Q221, Q222, Q223, Q224, Q244, Q245, Q248, Q256, Q335, Q338, Q342, Q351, Q368, Q334, Q367, Q369 and Q370. Finally support for IPA incremental polar angle is now supported.

Improved! Animation

The Animation model has been improved for higher resolutions screens with a maximum limit of 1GB in v9.0 versus 256MB in v8.0 of Predator CNC Editor. In addition the flip part for animation views has been improved.

Improved! Solid Model

V9.0 of CNC Editor improves the solid model when using low image quality settings, values greater than 1000, cylinders, fixtures and intermittent vertical wall gaps.

Improved! Siemens Drill Cycles

V9.0 of CNC Editor improves support for Siemens drilling cycles.

Improved! Fanuc G76 Support

Support for Fanuc style multiple line G76 threading with taper has been improved with v9 of Predator CNC Editor.

Improved! Maho Support

V9.0 of CNC Editor improves support for Maho repetitive cycles.

Improved! Arc Support

V9.0 of CNC Editor improves arc support in a number of cases including 5 Axis.

Improved! Tool Change Position

4 and 5 axis machine definitions can now define a rotary angle for the tool change position for each axis. This improves 4 and 5 axis tool change realism and collision detection.

Improved! Loading STL Stocks

V9.0 of CNC Editor improves the performance of loading STL stock shapes. Support for very large STL files has also been improved.

Improved! Recursive Expressions

Recursive expressions have been improved with V9.0 of CNC Editor.

Improved! Reverse Post Groups

The number of groups has been increased from 75 to 256 with v9.0 of CNC Editor.

Improved! Reverse Post Examples

Predator CNC Editor v9.0 adds improved reverse posts with additional G & M code support.

Improved! Light Properties Dialog

Lighting options have been improved with V9.0 of CNC Editor.

Improved! Importing

Importing CSV files with Predator CNC Editor Enterprise has been improved to automatically create new components or update existing components with new details. New checkbox options have been added to ignore errors and to display an error report. The ignore errors option can be used when the csv file contains known errors that you don't want to fix and you wish to force the import to continue with the remaining good data. The error report allows you to quickly fix a number of errors within a csv file prior to importing the csv file.

Improved! Pulldown Performance

Pulldowns for cutters, inserts, departments, locations, groups, machines, part types and parts have been improved with Predator CNC Editor Enterprise for greater performance with large datasets within all dialogs. For example 100,000+ part numbers can be selected and changed in less than 1 second. Support for up arrow, down arrow, pg up, pg dwn, ctrl+up arrow and ctrl+down arrow has been improved within pulldowns as well.

Improved! Predator Travelers Compatibility

Support for Predator Travelers v9 has been improved with v9.0 of Predator CNC Editor Enterprise.

Improved! Predator DNC Compatibility

Support for Predator DNC v9 has been improved with v9.0 of Predator CNC Editor Enterprise.

Improved! Predator MDC Compatibility

Support for Predator MDC v9 has been improved with v9.0 of Predator CNC Editor Enterprise.

Improved! HTML based Online Help

Updated online help expands several topics with new details.

Improved! Predator Tracker Compatibility

Support for Predator Tracker v9 has been improved with v9.0 of Predator CNC Editor Enterprise.

For the latest on Predator CNC Editor, check our web site at

<http://www.predator-software.com>