

RELEASE NOTES FOR PATHPILOT V2.12.2

Spring 2025

This update contains important safety and functionality fixes. If you're using PathPilot v2.12.0 or v2.12.1, we strongly recommend updating now.

ENHANCEMENTS

- To prevent accidental crashes, the wireless electronic tool setter (ETS) and probe are now disabled after a low battery warning. They are re-enabled after replacing the battery. (PP-4706)
- We added a safety check to prevent the spindle from orienting while a tool is installed in the drawbar. (PP-4731)
- On the **Status** tab, the **ETS Input** LED light now turns white when the wireless ETS is on and ready for use. (PP-4744)

FIXED ISSUES

Mills

We fixed issues where:

- The spindle was allowed to turn faster than OPENDOORMAXRPM with the door open during jog shuttle ring jogging on machines without door locks. (PP-4785 and PP-4780)
- On 1500MX mills, the reference position was lost when you power cycled the drives in a fault / error state. (PP-4766)
- Pressing and holding the **Cycle Start** button on machine consoles could advance through sequential M0/M1 stops, potentially skipping user-displayed comments or images. (PP-4581)
- On 1500MX mills, the ETS occasionally signaled a false contact when it turned on or during rapid XY motion in G37 moves. (PP-4635)
- Using set-start-line to skip over a CAM-provided probing sequence occasionally caused a mismatch between the machine coordinates displayed in the DRO and the actual position until the next program load. (PP-4648)
- Errors detected in program G-code involving G73 / G83 weren't annotated in G-code program view. (PP-4685)
- On non-1500MX mills, the drawbar didn't close after an ATC tool change to a tool not present in the ATC. (PP-4713)
- Some tool parameters (diameter wear, length wear, and maximum RPM) weren't included in the .csv import/export function. (PP-4742)
- The digital height gauge's **Data** button didn't function. (PP-4749)

- In mill CAM-driven probe subroutines, the coordinate system information wasn't printed out in the log file. (PP-4751)
- On PCNC 440 mills, the ++ and -- buttons on the **ATC** tab failed due to a missing parameter. (PP-4754)
- The **Insert** buttons on the **ATC** tab didn't work correctly until after a tool change (initiated by either the program an MDI line command). (PP-4757)
- On 1500MX mills, jog overrides weren't respected if a microARC 6 A axis was connected but not referenced. (PP-4759)
- Jogging would slow or stutter periodically while the **Probe** tab was active. (PP-4767)
- After an ETS contact, the ETS LED didn't turn green or play a sound. (PP-4799)
- While using G95, single block mode executed more than one motion at a time. (PP-4825)

Lathes

We fixed issues where:

- Some first-generation turrets on 15L lathes would fail to change tools. (PP-4728)
- On 15L lathes, selecting the **Turret FWD** button always advanced one tool rather than moving to the tool specified in the Tool DRO field. (PP-4734)

Plasma

- Previously, selecting the **Reset** button while the Z-axis limit switch was active caused an error. Now, PathPilot displays a message to disable hard stop homing before attempting a reset. (PP-4741)

Router

- You can now filter tools in the **Tool Table** to see only those currently loaded in the ATC. A tooltip indicates if a tool listed in the G-code is present or missing from the ATC, or if a tool in the ATC is used by the current G-code. Additionally, on the **ATC** tab, tools used in the G-code are highlighted blue in the ATC graphic for easier management. (PP-4589)

MANAGE PATHPILOT VERSIONS

You don't need to install updates sequentially. You can update from any previous version to the current version of PathPilot. Depending on what you want to do, refer to the following sections:

- "Download and Install an Update File from the Controller" (below)
- "Install an Update File from a USB Drive" (on the next page)
- "Install a Previous Version of an Update File" (page 5)

DOWNLOAD AND INSTALL AN UPDATE FILE FROM THE CONTROLLER

1. Confirm that the PathPilot controller is powered on and out of **Reset** mode.
2. Downloading and installing an update file requires an Internet connection. From the **Status** tab, confirm that the **Internet** button LED light is on. (To configure the network, select the LED light.) Then, select **Update**.



Figure 1: Update button on the Status tab.

3. From the **Software Update** dialog box, select **Check Online**.

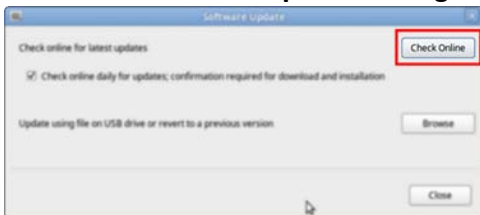


Figure 2: Software Update dialog box.

4. Select **Install**.



Figure 3: Install button on the Software Update dialog box.

The update file is downloaded, and a notification dialog box displays.

5. From the dialog box, select **OK**.
The update file is installed on the PathPilot controller.
6. Follow the on-screen instructions to restart the PathPilot controller.

INSTALL AN UPDATE FILE FROM A USB DRIVE

INSTALL AN UPDATE FILE FROM A USB DRIVE

1. From the [PathPilot support center](#), download the most recent PathPilot update file.
2. Transfer the PathPilot update file to a USB drive.
3. Put the USB drive into the PathPilot controller.
4. Confirm that the PathPilot controller is powered on and out of **Reset** mode.
5. From the **Status** tab, select **Update**.



Figure 4: Update button on the Status tab.

6. From the **Software Update** dialog box, select **Browse**.

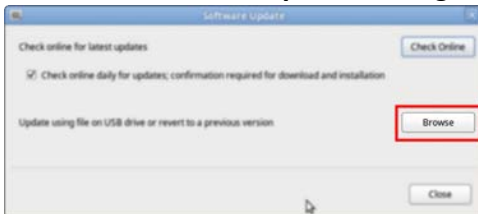


Figure 5: Software Update dialog box.

7. From the **Browse** dialog box, select **USB**.



Figure 6: Browse dialog box.

8. Select the desired update file, and then select **Update**.
The update file is installed on the PathPilot controller.
9. Follow the on-screen instructions to restart the PathPilot controller.

INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

INSTALL A PREVIOUS VERSION OF AN UPDATE FILE

1. Confirm that the PathPilot controller is powered on and out of **Reset** mode.
2. From the **Status** tab, select **Update**.



Figure 7: Update button on the Status tab.

3. From the **Software Update** dialog box, select **Browse**.

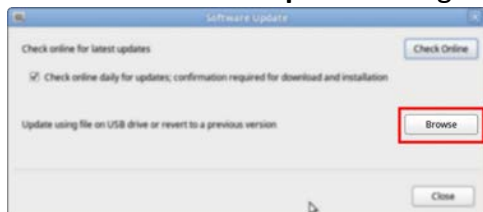


Figure 8: Software Update dialog box.

4. From the **Browse** dialog box, select **Previous Versions**.

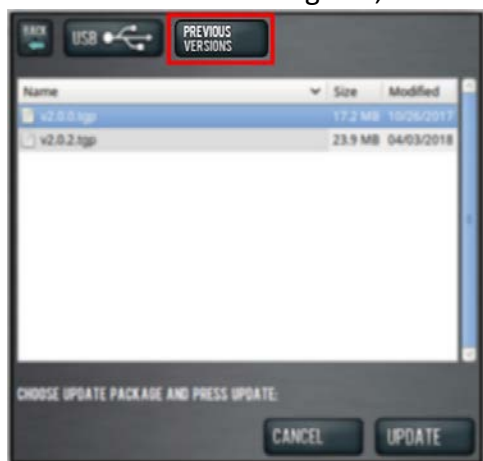


Figure 9: Browse dialog box.

5. Select the desired update file, and then select **Update**.
The update file is installed on the PathPilot controller.
6. Follow the on-screen instructions to restart the PathPilot controller.