

RELEASE NOTES FOR PATHPILOT V2.12.4

September 2025

ENHANCEMENTS

ALL

- Set start line now uses a default feed rate of 10 IPM for lead-in moves when running programs that use G93 or G95 feed modes. (PP-4830, PP-4619)

1500MX MILLS

- We added a chip conveyor button to the user interface. You can now manually control the conveyor or use run/delay time settings for programmatic control. (PP-4883)

FIXED ISSUES

All

- Previously, using set start line with lead-in moves near machine limits sometimes attempted to plan a lead-in move beyond the machine limits, causing a program error. (PP-4869)
- When you pressed certain keys (such as period or comma) while editing conversational DROs, the machine sometimes jogged instead of entering the value in the DRO field. (PP-4922)
- After updating to PathPilot v2.12.x, touchscreen calibration was incorrect on certain consoles. (PP-4936)

Mills

- Programs that didn't use an A-axis could still raise a warning about an unspecified A-axis position. (PP-4711)
- When you changed from an ATC tool to a manual tool, PathPilot could incorrectly report an EMC_AXIS_ABORT error even though the tool changed successfully. (PP-4752)
- On PCNC 440 mills, the automatic tool changer could report a disconnection even when it was properly connected, requiring a restart to restore functionality. (PP-4779)
- When probing a rectangular boss, the routine didn't allow enough clearance on narrow bosses and couldn't complete. (PP-4816)
- Previously, edits to the **Tool Table** were allowed during program runs, even though the changes had no effect. The table is now disabled while a program is running to prevent unexpected behavior. (PP-4877)
- On 1500MX mills, the wireless probe stayed on after a manual tool change from T99 if it was stored out of sight of the receiver. Now, the probe correctly turns off after a tool change. (PP-4881)

- Previously, the **Work Offset** table didn't show the result of a probing operation unless you clicked off and back on the **Work Offsets** tab. (PP-4890)
- When you edited wear offset values in the **Tool Table** during G21 mode, incorrect unit conversions were applied, resulting in larger-than-expected offset values. (PP-4891)
- You can now use the **Measure Probe** function during probe calibration in G21 mode. (PP-4935)
- On 1500MX mills, we added a waiting period for the wireless probe to prevent probing during receiver calibration. (PP-4962)
- On 1500MX mills, newer versions of the wireless probe required a manual power cycle to reestablish connection after an error. Now, the probe correctly resets after an error. (PP-4963)
- In some cases, pressing the Reset button didn't recover from a temporary communication error (like a loose cable), requiring a restart. (PP-4969)
- microARC 6 servo tuning was improved to eliminate an occasional hum or buzzing sound when the axis was idle. (PP-4614)
- On 1500MX mills, ATC servo tuning was improved to eliminate a hum or buzzing sound at idle with a lightly loaded or empty tool tray. (PP-5058)

Lathes

- In rare cases, lathe conversational profiling created some roughing passes with a larger depth of cut than specified. (PP-3908)
- When you edited a tool property, the change could be interrupted by a program reload due to a previous edit, requiring you to re-enter the value. (PP-4446)
- When you edited the **Wear Offset** table, changes didn't display until after switching to another tab and back. (PP-4774)
- In single-block mode, the spindle could stay on after program completion. Now, the spindle stops correctly when the program ends. (PP-4947)

Plasma

- For safety, 1300PL plasmas now enter the emergency stop state any time the breakaway switch is triggered. (PP-4903)

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**.

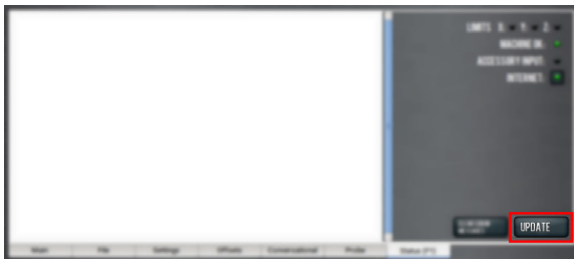


Figure 1: Update button on the Status tab.

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

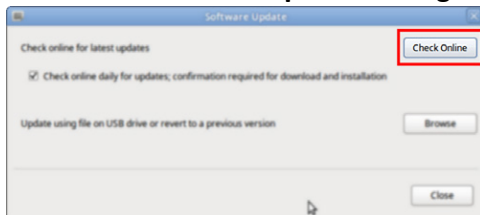


Figure 2: Software Update dialog box.

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**.

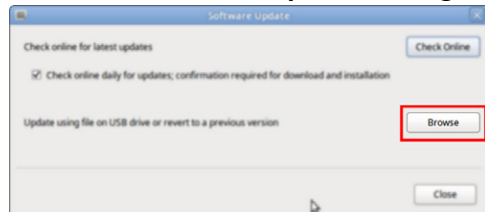


Figure 5: Software Update dialog box.

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**.

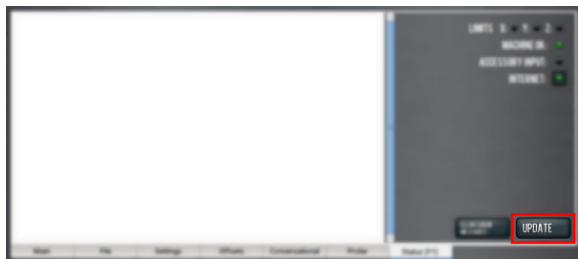


Figure 7: Update button on the Status tab.

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

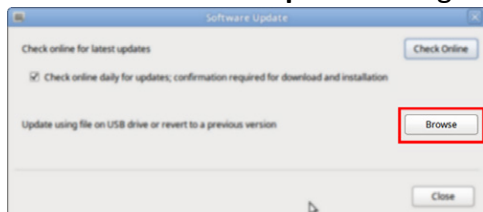


Figure 8: Software Update dialog box.

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

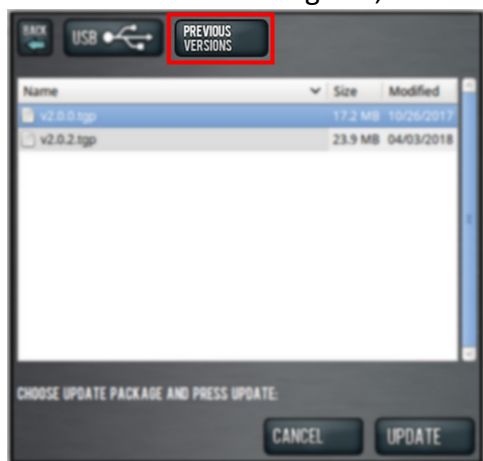


Figure 9: Browse dialog box.

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.