

Changes KFLOP and KMotion Released Versions 4.33l -> 4.33g 8/29/2015

KFLOP

For fopen from KFLOP force close of any previous file before re-opening new file

Add DisableKanalogDetectOnBoot and DisableSnapAmpDetectOnBoot options

Add PC Disk Read capability with fgets, fscanf, and feof

ReadDiskData S N/Set Disk Read Data in KFLOP (as 8 bit Hex words)/into the ReadDisk Buffer/Used internally in conjunction with fgets()/for decimal N words/ie. ReadDiskData 0 3 /41 42 43

Expose CurrentThread in KMotionDef.h

Flash non-volatile constants/functions exposed

```
#define FLASH ((volatile char *)0x90000000) // beginning of FLASH - first 1MByte is for System Use
#define FLASH_USER ((volatile char *)0x90100000) // 2nd MegByte is for User use
#define FLASH_BLOCK_SIZE (0x10000) // FLASH erases in 64KByte Blocks
#define IRAM ((volatile char *)0x10000000)
#define SDRAM ((volatile char *)0x80000000)
int ProgramFlash(volatile char *src, int Length, volatile char *dest, char *message); //Programs Flash source address of
data, length in 16-bit words, dest add must be on 64KByte block, optional \n terminated message
void SetFlashBank(volatile unsigned short *add); // sets the currently addressable flash bank (address bits 14-19)
```

Flash Firmware Update only programs first 1 MByte (not 2nd User 1MByte)

Fixed Reboot! – KFLOP now reliably reboots from Script Command without hardware reset or power cycle

KMotionCNC

KMotionCNC will now apply Interpreter Tool Length and offsets on program startup if the Tool Setup Option "Tool Length/Offset Immediately" and "M6 on Tool Table Changes" are both selected.

SetKFLOPCommandResult all to have negative error return codes

KMotionCNC Tool table Index checks now consistently <100

KMotion Libraries

GCode Interpreter - Fix GCode Interpreter issue with GCode Variables not being updated correctly with Halt/Resume of GCode

GCode Interpreter - Handle Linux Line Endings

GCode Interpreter - Fix Spindle CSS to include Tool Table X Offset

GCode Interpreter - Fix issue with pure angular motion in metric mode being treated as mm rather than degrees causing incorrect feed rate

GCode Interpreter - Fix issue with combined ABC with XYZ motion with inverse time mode

CoordMotion - Add Do Rapids as Feeds Option for non-linear kinematic systems

Trajectory Planner - Fix corner rounding algorithm to have equal angles throughout corner

.NET

Expose to .NET MaxRapidFRO and DoRapidsAsFeeds

Expose Interpreter FeedRate

C Examples

Multiple Flash Non-volatile Examples Added and fixed

MPGSmoothHardwareEnc - Includes check for JOB_ACTIVE to inhibit motion

CS Examples

Measure Fiducials – Some Fixes and beginning of Microscope Offset Feature

VB Examples

Jogger.NET - Example of Thread=-1 to Flash Firmware
Fix KM_ViaVB Short/Integer bugs

Dynomotion VB.net - Fix Compiler build option to fix crash running outside of VS

Jogger - Add PackToFlash to LoadCoff for Flashing new Firmware Version to KFLOP

TCC67

#ifdef for Visual Studio Community 2013 compatibility

KMviaVB

Fix declaration of KMViaVB_LoadCoff

Add PackToFlash to LoadCoff for Flashing new Firmware Version to KFLOP