Kogna Firmware

Remove global variable 's' to not conflict with User Programs

KFLOP Firmware

Remove global variable 's' to not conflict with User Programs

Coordinated Motion Library

Add Warning Controller configuration takes longer to stop than 75% of Trajectory Planner Look Ahead time. Feed Rate will be limited.

Trajectory Planner

Fix Trajectory Planner issue with corner rounding where an ABC axis is linear.

Fix Trajectory Planner issue with corner rounding where one axis has a non-zero radius so represents a distance.

GCode Examples

Add **G81 Drill Cycle with Subroutine.ngc** example

KMotionCNC

'Do Times" Simulation option was added. When checked, Running Simulation will fully Trajectory Plan all Paths the same as a real run and display estimated Job Time. Displayed times have been changed from seconds to hours:minutes:seconds. GViewer Plot will then show Trajectory Planned paths rather than what raw GCode specifies.

Fix UNICODE garbled error message for unable to load previous GCode Files

Update Help for added Do Times option.

Help Manuals

Fix typo for Kogna JP14 Connector Pins 23,24 should be Dir11 not 12

KMotion | Config Screen updated to show Output Chan Drive Mode and Drive options