

## New for this release (newest on top)

**NOTE:** As you look at the release notes you will see which specific component each release was intended.

If a release states:

(Core) only in the notes then all you have to do is just a standard install of the new release, no update to your controller is needed.

(Rotary) or (Laser) in the notes then you should do an XMU update after installing the new update.



**\*\* Please Note \*\*** After a Machine Update You **MUST** reboot the electronics again to reload the screen Fonts/Color to their new locations.

### 7-10-19 VCS Release (196)

(All Systems)

1. Added code to copy a needed dll to the XGW folder. XGW used the same DLL to communicate with VCS.

### 6-25-19 VCS Release (195)

(All Color Rotary Systems)

1. Fixed an issue with the external Light Curtain function not always starting the spindle motor when the curtain was interrupted when the job was not running (during material change).  
JE/GE Machines getting wrong value for Z Lead Screw Pitch
2. JE/GE xmi files now installed in their own folders during installation and should have the correct screw pitch set.

### 2-27-19 VCS Release (194)

(All)

1. New .xvf extension for Viper systems running from the Print Driver.

### 1-10-19 VCS Release (193)

(All Color Rotary Systems)

More changes for using Viper systems with the new Print Driver

### 5-02-17 VCS Release (190)

(All Color Rotary Systems)  
Updated for New Print Driver to control Z data and XY Speeds  
etc.

Fixed various HPGL sections as well as Cylindrical with HPGL.

6-3-16 VCS Release (189)

(All 353 Systems)

New Firmware for Updated Screens

4-25-16 VCS Release (188)

(Rotary Color Screen)

Multiple fixes

(Laser Color Screen)

Modified HPGL code.

Fixed stack leak

Updated VCS

7-14-15 VCS Release (187)

(Pre-Release)

3-17-15 VCS Release (186) Monochrome (Viper 1.4.27) (Laser 2.3.5) Color  
(Rotary 2.22.11) (Laser 2.21.5)

(Rotary w/Color Screen)

Added new Clearance Height value to clear clamps between  
plates on multi-plate jobs.

Fixed boot progress bar from under/over sizing.

Reset rotary position after index move.

Corrected some Manual Z issues where the returned value was  
incorrect.

(All Color Systems)

Indexer used REAL\_TABLE\_RES\_R Location 78

Updated Installer with the latest modules.

(Laser w/Color Screen)

Fixed check for rotary fixture on startup

3-20-14 VCS Release (185) Monochrome (Viper 1.4.27) (Laser 2.3.5) Color  
(Rotary 2.22.3) (Laser 2.21.0)

(Rotary w/Color Screen)

Indexer Mode not remembering state of Spindle Motor and ZMode

1. Forgot to add in that section on the Indexer section

3-10-14 VCS Release (184) Monochrome (Viper 1.4.27) (Laser 2.3.5) Color (Rotary 2.22.3) (Laser 2.21.0)

(Rotary w/Color Screens)

Added indexer mode. Allows use of an indexing table or to index the Cylindrical attachment a desired degree.

Example: to engrave numbers 1-4 on 4 sides of a block.

1. Set the Indexer setting to 90deg.
2. In XGW create 5 batch plates with a number on each plate. Leave the 5<sup>th</sup> plate blank. (This will allow the indexer to rotate around to the first plate again.)
3. Run the job and have fun.

Added Basic Screen Mode

Set this in Machine Parameters to change the main screen on the pendant to an easier "Basic" display. This will remove the menus and most of the settings. Useful when you don't want the operator messing with different settings.

Also allows operator to set the system to perform a Mechanical Home upon bootup.

(Laser w/Color Screens)

Fixed Dual Head mode.

1-16-14 VCS Release (183)

Fixed a problem on some computers where JobConsole would not run.

Fix CNC vector profile to include invert Y Job or Y Graphics

1-6-14 VCS Release (182)

(All Color)

Adjusted Z Jog Range. Was set wrong and made the Z slow when jogging.

(Monochrome Rotary)

Fixed the Z Down Speed problem on the first Z Down move of a Manual Z job.

12-18-13 VCS Release (181)  
(All Color Lasers)  
Fixed Focus bug.

12-2-13 VCS Release (180)  
(All 353 Stacks)  
Some updates to "Bios Update"  
(All Color Systems)  
Modified code for "Burn In"  
(Monochrome)  
Fixed stack leak when using manual in speed mode.

11-26-13 VCS Release (179)  
(All 353 Stacks)  
New firmware to allow Bios Update via USB interface.  
Corrects stopping problem when running large jobs.

11-11-13 VCS Release (178)  
(oops)  
Messed up a Z Axis parameter.

11-4-13 VCS Release (177) (Core 4.6.270.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.20.1) (Laser 2.20.2)  
(All Color)  
Corrected error in Stat Test  
Added new code for 353 stacks.  
(Rotary Color)  
Fixed many problems with Forward/Back. Now works correctly  
on large jobs.  
Fixed Manual Cutter Set to return correct Stroke and Home  
values.  
Fixed limit detect. Now you can do a mechanical home if a limit  
was pressed. No need to reset power.  
Fixed inline HPGL commands for Speed Commands.  
Added Xen-Nano code for RPD Stacks.  
(Laser Color)  
Added code for the up and coming Laser 353 release  
Fix a problem with rotary Mode.

Added a speed setting in the Indexer dialog.

5-29-13 VCS Release (175) (Core 4.6.254.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.19.2) (Laser 2.19.5)

(All Color)

Bounding Box will now run when play icon is pressed. You no longer need to press a corner first.

Fixed Motor Phase Test bug.

(Rotary Color)

Using the pause icons work correctly and no longer switch the screen back to the main screen

Pressing Forward or Backward with a job loaded and at the home position is working again.

(DUO Laser)

Table moves to the correct position when pausing during a diamond drag job.

(Laser Color)

Added Indexer Speed Value so users can control the rotational speed of the indexing unit.

(353) Corrected a stack leak and fixed the tool change position for the new wider screen.

4-26-13 VCS Release (174) (Core 4.6.254.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.18.42) (Laser 2.18.18)

(Rotary 353)

Increased Virtual Pendant response time

4-22-13 VCS Release (173) (Fixes Z out of bounds on Monochrome systems.)

4-18-13 VCS Release (172) (Fixes Z out of bounds on older stacks.)

4-10-13 VCS Release (171) (update Button Resource for USB Screen)

4-4-13 VCS Release (170) (update to fix Z Float not working)

3-21-13 VCS Release (169) (Core 4.6.249.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.18.41) (Laser 2.18.18)

**\*\*\* Full update is needed with this release. DO NOT DO AN XMU UPDATE FOR THIS RELEASE \*\*\***

\*\*\*\* This release is used on the new RPC353 systems.

Updates for New Screen.  
Better Virtual Pendant Support.

10-19-12 VCS Release (168) (Core 4.6.231.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.18.23) (Laser 2.18.14)

**\*\*\* Full update is needed with this release. DO NOT DO AN XMU UPDATE FOR THIS RELEASE \*\*\***

(Core)

Updated Core.

\*\* Many communication updates.

Added various things that cannot be disclosed of at this time.

(Rotary Color)

Various internal updates for new features coming soon..

Modified remote output signals.

Modified CNC/HPGL dialog to allow manual cutter set to return  
z values and set Z mode to Standard Z

Remove extra move at the end

Updates to LocalDnc (Local storing of small jobs)

Reset axis state after cancelling FWD/Back moves.

(Laser Color)

Various internal updates.

Fixed various errors when running cylindrical jobs.

Corrected wrong acceleration and speed that sometimes  
happened after a focus.

Corrected AutoStart so Laser only AutoStarts on first sheet  
and not on subsequent sheets.

Updated Focus Dialog

Updates to LocalDnc (Local storing of small jobs)

Easier to say there have been a lot of modifications and bug fixes.

12-28-11 VCS Release (163) (Core 4.6.134.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.16.2) (Laser 2.15.0)

(Rotary Color)

Added back in the ability to adjust the settings when using the Touch Off Block Feature.

Now you have the ability to run a Cylindrical Job via HPGL by adding a 2 special codes to the header or with 3<sup>rd</sup> party software.

12-5-11 VCS Release (162) (Core 4.6.134.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.15.4) (Laser 2.14.8)

(All Color)

Updated Info screen to also show when a user already "has" the Virtual Pendant Feature enabled.

11-21-11 VCS Release (161) (Core 4.6.134.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.15.4) (Laser 2.14.8)

(All Color)

Fixed the lockup of JC when an Out of Bounds or a Limit was detected.

Added line in the Info Dialog showing if the "Virtual Pendant" feature is "NOT" unlocked.

(Laser Color)

Added 2 saved default locations under Beam Alignment to help switch between testing modes.

Added  $\frac{1}{4}$  speed switch to Bounding box mode. **By selecting the middle button (-) graphic the speed will be reduced to a slower speed.**

(sorry Joe, not easy to put in a variable speed function)

(Rotary Color)

New Bounding Box features added with  $\frac{1}{4}$  speed switch, **By selecting the middle button (-) graphic the speed will be reduced to a slower speed.**

10-21-11 VCS Release (160) (Core 4.6.126.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.15.0) (Laser 2.14.0)

(New Installer now allows you to select engraving system type to speed up installation.)

(Laser Color)

New Bounding Box Features.

(Rotary Color)

Engrave-by-Color using Z Depth now works in Manual Z Mode.

9-23-11 VCS Release (157) (Core 4.6.126.0)|Monochrome (Viper 1.4.25)

(Laser 2.3.5)|Color (Rotary 2.14.1) (Laser 2.13.3)

(Laser MD4 Color)

Fixed Auto Focus.

9-22-11 VCS Release (156) (Core 4.6.126.0)|Monochrome (Viper 1.4.25)

(Laser 2.3.5)|Color (Rotary 2.14.1) (Laser 2.13.2)

(Laser)

Fixed the Focus Dialog.

9-13-11 VCS Release (155) (Core 4.6.126.0)|Monochrome (Viper 1.4.25)

(Laser 2.3.5)|Color (Rotary 2.14.0) (Laser 2.13.0)

\*\*\* Sorry \*\*\* I forgot to add the Virtual Pendant files in the 154 release.

(Laser)

Allow Z(table) jogging when in pause.

9-6-11 VCS Release (154) (Core 4.6.126.0)|Monochrome (Viper 1.4.25) (Laser

2.3.5)|Color (Rotary 2.14.0) (Laser 2.13.0)

(Core)

Major rework on communications between Neti, Job Name Server and Job Console. Should always connect correctly.

7-1-11 VCS Release (153) (Core 4.6.120.0)|Monochrome (Viper 1.4.25) (Laser

2.3.5)|Color (Rotary 2.13.1) (Laser 2.12.6)

(Core)

Added Bootup warning when trying to launch Virtual Pendant without correct feature key.

(Color Laser)

SelfTest under the Service Menu now tests the encoder when running the burn in job. (was really released in

152) This release fixes a wrong value that showed an encoder every time you tried to run SelfTest.

Fixed arc federate.  
(Color Rotary)

Fixed Manual cutter set when for repeats greater than 1. Will not ask to do a manual set on each repeat.

Fixed are federate

6-20-11 VCS Release (152) (Core 4.6.120.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.13.1) (Laser 2.12.6)  
(Core)

Fixed a JobConsole problem where it would show batch plates on top of each other instead of individual plates.

6-17-11 VCS Release (151) (Core 4.6.119.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.13.1) (Laser 2.12.6)  
(Core)

Fixed a Communications Problem with NETI

5-27-11 VCS Release (150) (Core 4.6.113.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.13.1) (Laser 2.12.3)  
(Core)

Fixed a problem where runtime parameters were not being updated on download. May have caused Out of bound Errors and/or wrong engraving speeds.

(Color Systems)

Display now shows more error messages like "Out of Bounds"  
Worked on Job Timer.

(Color Rotary)

Fixed most of the locking up Forward/Back issues.

5-9-11 VCS Release (149) (Core 4.6.109.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.12.3) (Laser 2.11.5)  
(Core)

Improved connections and fixed problems where JC may lose connection and jobs will not go over to controller.

Fixed a pause/repeat problem.

Fixed a problem where certain Xenetech fonts may engrave wrong and create a circle instead of an arc.

(Color Laser)

Fixed a major problem introduced in ver 148 where the screen would not display the main dialog.

148 was not released.

5-6-11 VCS Release (147)

Broken release and was removed.

4-28-11 VCS Release (147) (Core 4.6.106.0)|Monochrome (Viper 1.4.25)  
(Laser 2.3.5)|Color (Rotary 2.12.3) (Laser 2.11.3)  
(Core)

Fixed a problem where certain Xenotech fonts may engrave wrong and create a circle instead of an arc.

3-16-11 VCS Release (146) (Core 4.6.94.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.12.3) (Laser 2.11.3)  
(Color Laser)

Added ability to run a very low DPI

Added support for Virtual Pendant

Fixed Display. Jobs sent over at 0 power now show 0 on the touch screen

(Color Rotary)

Added support for Virtual Pendant

Fixed double pause when doing Grid Cutout

2-9-11 VCS Release (144) (Core 4.6.94.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.12.0) (Laser 2.11.0)  
(Core)

Fixed a Laser scaling problem when engraving pictures.

(Core)

Code added for support of futures features... TBA

1-20-11 VCS Release (143) (Core 4.6.79.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.12.0) (Laser 2.11.0)  
(Laser)

Fixed the problem where the screen would go blank if you canceled a job while the door was open.

Fixed a Servo Servo problem where the Y axis would move when jogging the Cylindrical axis.

12-8-10 VCS Release (142) (Core 4.6.79.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.11.2) (Laser 2.8.13)

(All)

Updated the "PopUp Helper" portion of the installer to guide users better with regards to RPD systems and how to check if their Xenotech

Rotary system is using "Vexta Motors" so the correct XMI file is selected.

(All Color)

Fix a bug where you couldn't set the DHCP check box after setting a static IP address on the controller via the Touch Screen.

(All Color RPD)

Updated XMI files to include systems with Vexta Motors

(Color Laser)

Fixed a bug where the laser would not fire after doing a Pause.

11-19-10 VCS Release (141) (Core 4.6.79.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.11.2) (Laser 2.8.12)

(Color Rotary)

Fixed Auto Start Subsequent Plate problem

11-12-10 VCS Release (140) (Core 4.6.79.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.11.1) (Laser 2.8.12)

(Core)

a. added sheet change by pen to HPGL

(Color Laser)

a. Fixed Pointer Mode for CE Laser Systems

10-1-10 VCS Release (139) (Core 4.6.61.0)|Monochrome (Viper 1.4.25) (Laser 2.3.5)|Color (Rotary 2.11.1) (Laser 2.8.11)

(Color Laser)

a. Fixed the extra move on Focus at start when running from the Print Driver.

b. Fixed the focus offset for the DUO so it moves to the correct location.

c. Internal changes.

8-16-10 VCS Release (138) (Core 4.6.61.0)|Monochrome (Viper 1.4.25) (Laser 2.3.4)|Color (Rotary 2.11.1) (Laser 2.8.6)

(Color Rotary)

a. Added new inputs:

Remote Start

Remote Stop

Remote Stop /w Job Cancel

b. Changed the AutoStart feature to allow the following:

1. AutoStart on the first plate only and then press start for all other plates.

2. AutoStart for all plates.

3. AutoStart for all plates **EXCEPT** first plate.

8-5-10 VCS Release (137) (Core 4.6.51.0)|Monochrome (Viper 1.4.25) (Laser 2.3.4)|Color (Rotary 2.10.2) (Laser 2.8.6)

(Monochrome Laser)

a. Fixed German Language error.

b. Fixed code to run conveyor correctly

c. Added presets to Focal Distance for German language.

d. Fixed first traverse move speed issue

(All Rotary)

a. internal fixes and code alignments.

8-4-10 VCS Release (136) (Core 4.6.51.0)|Monochrome (Viper 1.4.25) (Laser 2.3.2)|Color (Rotary 2.10.2) (Laser 2.8.6)

(Color Laser)

a. Added ability to save last run values of Speed and Power to Laser as defaults.

b. Fixed problem of not using first traverse speed value.

c. Added Y Servo code for RPD stacks

d. Fixed first traverse move speed issue

7-20-10 VCS Release (135) (Core 4.6.51.0)|Monochrome (Viper 1.4.25) (Laser 2.3.1)|Color (Rotary 2.9.0) (Laser 2.7.4)

(Color Rotary)

- a. Added CE controls for RPD stack.

6-25-10 VCS Release (134) (Core 4.6.51.0)|Monochrome (Viper 1.4.25) (Laser 2.3.1)|Color (Rotary 2.8.0 (Laser 2.7.1)

(All Color)

- a. Added ability to set a static IP address on the controller.

Service | IP Address

(Color Laser)

- a. Fixed various issues with Duo Systems.

5-19-10 VCS Release (133) (Core 4.6.51.0)|Monochrome (Viper 1.4.25) (Laser 2.3.1)|Color (Rotary 2.6.2 (Laser 2.6.3)

(Color Laser)

- a. DUO Drag Mode now has metric implemented.
- b. Fixed fault handling
- c. Code Cleanup
- d. Fixed some DUO RPD code problems.

(Color Rotary)

- a. Fixed fault handling
- b. Code Cleanup

5-5-10 VCS Release (132) (Core 4.6.50.0)|MonoChrome (Viper 1.4.25) (Laser 2.3.1)|Color (Rotary 2.5.6) (Laser 2.5.2)

(Core)

a. Fixed Laser jobs stopping when trying to run single-pixel bitmaps. (trash/junk from a scanned image)

(Color Rotary)

a. Fixed Travel Speed bug. Sometimes the travel speed would get set to the XY Speed.

5-4-10 VCS Release (131) Short lived... Do an update.

4-29-10 VCS Release (130) (Core 4.6.49.0) MonoChrome (Viper 1.4.25) (Laser 2.3.1)|Color (Rotary 2.5.4) (Laser 2.5.2)

(All)

a. Fixed a problem in NETI that should correct problems with jobs stopping for no reason.

4-22-10 VCS Release (129) (Core 4.6.47.0) Monochrome (Viper 1.4.25) (Laser 2.3.1)|Color (Rotary 2.5.3) (Laser 2.5.1)"

(All)

- a. Fixed Auto starting issue

(Color Rotary)

a. Fixed Z Speed issue while using Manual Z Mode. 1<sup>st</sup> Z move now moves at correct speed.

b. Fixed pause issue while in standard Z mode. Users can now pause using player pause.

- c. Shows Correct ips on player screen.

3-12-10 VCS Release (128) (Core 4.6.40.0) Monochrome (Viper 1.4.25) (Laser 2.3.1)|Color (Rotary 2.5.0) (Laser 2.4.1)

(All Laser)

a. Added special commands to allow Cylindrical output to drive a conveyor attachment.

(Color Laser)

a. Fixed the blank screen problem. Problem would happen is you canceled a job while the door was open.

b. Modified Duo code to correct some drag errors.

(Monochrome Rotary)

a. Fixed advancing to grid cutout with engrave by color jobs.

1-11-10 VCS Release (127) (Core 4.6.29.0) Monochrome (Viper 1.4.24) (Laser 2.2.16)|Color (Rotary 2.5.1) (Laser 2.3.1)

(All)

Various updates. Would be good for all to install this version.

(Color Rotary)

Corrected auto-start feature to not pause at each plate of batch plate jobs.

Forward to Grid Cutout works correctly on standard jobs and with engrave by color jobs.

12-30-09 VCS Release (126) (Core 4.6.20.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 1.0.0) (Laser 1.0.0)

(All)

Fixed JobServerFactory not connecting.

Modularized firmware for ease of updates and features across system line

Added XMU update files to c:\Xenotech32\XMU

Added a folder in Xenotech32 called Interface Backup.

Contains current VCS dll's if XGW is giving DLL errors or not showing connection. Just copy into Xenotech32

(Color Laser)

a. Corrected edge error after first run.

(Color Rotary)

a. Fixed problem where Z would stay down if Stop Job was pressed.

b. Fixed forward to grid when doing an engrave by color job.

c. Changed color of the Stop Job to Red and Yellow.

d. Pressing Stop Job now turns off Spindle Motor.

11-12-09 VCS Release (123) (Core 4.6.12.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.9.5) (Laser 0.14.12)

(Color systems)

a. More work done to speed up job cancels.

11-9-09 VCS Release (122) (Core 4.6.12.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.9.4) (Laser 0.14.10)

(Core)

a. Removed most of the delay when canceling jobs.

(Color Laser)

a. Added Encoder checking.

b. Adjusting Laser Speeds on the fly now works.

(Monochrome Laser)

a. Added 3D moves back in.

(Color Rotary)

a. You can now exit out of limit detects.

b. Fixed cylindrical problem (RPD Stack)

10-13-09 VCS Release (121) (Core 4.6.5.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.9.0) (Laser 0.14.7)

(Core)

Suite Release 4.6 This will act as a new install. If you want to remove the old one you will need to do it before installing this version. You will

Need to use Add/Remove programs to do the removal and then run this installer.

(Color Laser)

3D code added.

10-8-09 VCS Release (116) (Core 4.5.1.2) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.9.0) (Laser 0.14.6)

(All)

Report Position now shows correct position on the screen.

Fixed pointer mode when using report position.

Corrected a stack error when an out-of-bounds occurs.

(Monochrome Systems)

Zoom and batch plate display are corrected. No longer superimposes the image on itself.

(Color Rotary Systems)

Fixed spindle motor not coming back on after pausing on engrave by color jobs.

(Color Laser Systems)

No longer tries to home when pause is pressed during focus.

9-8-09 VCS Release (114) (Core 4.5.1.2) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.8.7) (Laser 0.14.2)

(Color Screens)

Metric is set correctly on cGLCD

Changed Stop Job button to function if held down.

Z no longer plunges if you press Stop Job while in Auto Z

Other small changes.

8-14-09 VCS Release (113) (Core 4.5.1.1) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.7.9) (Laser 0.13.11)

(Color Rotary and Laser) Fixed screen lockup if there was an out of bounds when using cylindrical.

8-10-09 VCS Release (112) (Core 4.5.1.1) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.7.8) (Laser 0.13.10)

(Color GE) Fixed wrong Value in Cylindrical.

Added stat command

Fixed lockup if outbox was empty and user tried to replay job.

8-7-09 VCS Release (111) (Core 4.5.1.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.7.7) (Laser 0.13.9)

(All) Fixed firmware so you can use pause and cancel in JobConsole.

8-5-09 VCS Release (110) (Core 4.5.1.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.7.5) (Laser 0.13.7)

(All) Connection issues are now fixed.

7-30-09 VCS Release (109) (Core 4.5.1.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.7.5) (Laser 0.13.7)

(Laser all)

- a. Fixed Info Screen Error on Laser systems where it showed the Laser as a DUO

(Laser Color)

- a. Fixed Cylindrical Mode engraving scale.

(Laser B/W)

- a. Fixed display when it looked like dashed lines.

7-23-09 VCS Release (108) (Core 4.5.1.0) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.7.5) (Laser 0.13.6)

(Suite) Fixed install issue

\*\*\*New for this release will be kept current starting with release 108 (stable release)

7-20-09 VCS Release (107) (Core 4.5.0.1) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.7.4) (Laser 0.13.6)

7-3-09 VCS Release (105) (Core 4.5.0.1) B/W (Viper 1.4.24) (Laser 2.2.13)\*\*\*\*\*Color (Rotary 0.6.26) (Laser 0.13.3)

1. (Rotary MonoChrome)

a. Fixed manual cutter set and replay. Replay will remember the Z Pos.

2. (Laser MonoChrome)

- a. Range Adjusted.
- 3. (Rotary Color)
  - a. A lot of fixes. Works very well.
  - b. Forward to grid works.
  - c. No longer delays on long multi-point vectors
- 4. (Laser Color)
  - a. Updated

6-4-09 VCS Release (101) (Core 4.1.9.0) B/W (Viper 1.4.23) (Laser 2.2.12)\*\*\*\*\*Color (Rotary 0.6.13) (Laser 0.12.3)

- 1. (Rotary Color)
  - a. Fixed OB error when trying to move forward/back in cylindrical mode.
  - b. Fixed self test speed.
  - c. Fixed Job Offsets not storing Z value.
  - d. Added Spindle Motor Icon in manual Z mode.

5-29-09 VCS Release (100) (Core 4.1.9.0) B/W (Viper 1.4.23) (Laser 2.2.12)\*\*\*\*\*Color (Rotary 0.6.8) (Laser 0.12.3)

- 1. (Suite)
  - a. More updates for Color
  - b. Fix for GridZ
- 2. (Rotary All)
  - a. Fix for Grid Z

5-21-09 VCS Release (Core 4.1.8.3) B/W (Viper 1.4.21) (Laser 2.2.12)\*\*\*\*\*Color (Rotary 0.6.1) (Laser 0.12.3) Release(99)

First release of Color Screen Files

5-13-09 VCS Release (4.1.8.3).(1.4.21).(2.2.12).(98)

- 1. (Rotary)
  - a. Fixed a small grid problem.
- 2. (Laser)
  - a. Added files for Color Screens.

4-3-09 VCS Release (4.1.8.3).(1.4.20).(2.2.12).(97)

- 1. (Laser)
  - a. Fixed bug in grid cutout.

b. Created Duo.xmi file.

1-26-09 VCS Release (4.1.8.2).(1.4.20).(2.2.12).(96)

1. (Laser)
  - a. Fixed Out of Bounds message on Cylindrical jobs.

1-24-09 VCS Release (4.1.8.2).(1.4.20).(2.2.11b).(95)

1. (Laser)
  - a. Fixed a hard to find stack leak that was causing the Laser to stop or give stack errors.

1-15-09 VCS Release (4.1.8.2).(1.4.20).(2.2.11a).(94)

1. (Laser)
  - a. Fixed bottom up engraving problem.

1-13-09 VCS Release (4.1.8.2).(1.4.20).(2.2.11a).(93)

1. (Laser)
  - a. Modified Table Limit to only be active during table moves and jogging. It is no longer active during a job.

12-22-08 VCS Release (4.1.8.2).(1.4.20).(2.2.11).(92) \*\*\* Machine Update Needed \*\*\*

1. (Installer)
  - a. Fixed the issue where it couldn't update an older installed version.
2. (Laser)
  - a. Fixed problem of setting a Permanent XY Position.

12-10-08 VCS Release (4.1.8.2).(1.4.20).(2.2.10).(91)

1. (Rotary)
  - a. Fixes Pneumatic Z and Manual Mode. (Stop Job and Pause was not showing) \*\*\* Only affected machines with Pneumatic Z axis

12-9-08 VCS Release (4.1.8.2).(1.4.15).(2.2.10).(90)

1. (Laser)
  - a. Reset Table and Focal Length moving too far has been fixed.

12-8-08 VCS Release (4.1.8.2).(1.4.15).(2.2.10).(89)

1. (Laser)
  - a. Displays a message if a limit switch is pressed when downloading a new job.
2. (Rotary)
  - a. System with a Pneumatic Z will now pause when doing a manual Z Set to allow users to set the cutter depth.

12-8-08 VCS Release (4.1.8.2).(1.4.13).(2.2.9).(88)

1. (Suite) Preview on Laser Systems is now fixed.

12-5-08 VCS Release (4.1.8.1).(1.4.13).(2.2.9).(87) **\*\*\* Some jobs may not display on the Laser Touch Pad. A fix will be ready Monday \*\*\***

1. (Laser)
  - a. Default Lens is now set to 2.5

12-5-08 VCS Release (4.1.8.1).(1.4.13).(2.2.9).(86)

1. (Suite)
  - a. Just a few changes to the main suite.

12-4-08 VCS Release (4.1.8.0).(1.4.13).(2.2.9).(85)

1. (Laser)
  - a. Preview is fixed with new firmware.
  - b. Focal Offset now remembers last selected lens

12-4-08 VCS Release (4.1.8.0).(1.4.13).(2.2.7).(84)

1. (Laser) Rolled back Firmware on Laser to fix job preview. Will have a new release (85) soon.

12-2-08 VCS Release (4.1.8.0).(1.4.13).(2.2.7).(83) **\*\*\*\* Full update needed. Not just an XMU update. \*\*\*\***

1. (Laser)
  - a. Added new text strings and values for the new Focal Length Dialog.

11-25-08 VCS Release (4.1.8.0).(1.4.13).(2.2.7).(82) **\*\*\*\* Full update needed. Not just an XMU update. \*\*\*\***

1. (All)

a. Fixed an installer problem of not setting up InBoxes and OutBoxes correctly.

2. (Laser)

a. Added protection so laser will not fire beam outside of engraving area.

10-27-08 VCS Release (4.1.8.0).(1.4.13).(2.2.4).(81)

1. (Laser)

a. Report Pos added. (Waiting for XGW Release 6.46.x.xxx)

10-23-08 VCS Release (4.1.8.0).(1.4.13).(2.2.3).(80)

1. (All)

Added direct running of DXF/DWG (ver12 thru 14 only) Files are referenced from lower left on table.

Example:

If you have a 13x13 and you set up a DXF job of a 1x1 box where the lower left is at 1 inch... the

Box will engrave on the table with the lower left of the box at 12 inches. Understand???? Just play with it and you'll get the idea.

10-21-08 VCS Release (4.1.7.9).(1.4.13).(2.2.2).(79)

1. (Rotary)

- a. System reporting to XGW
- b. CNC/HPGL tuning.

2. (Laser)

- a. Z Focus Plunger now act like a limit switch when table is moving. (Don't know how this one got missed)
- b. Added Bounding Box and Pointer Mode
- c. System reporting to XGW

9-18-08 VCS Release (4.1.7.8).(1.4.12).(2.0.18).(78)

1. (Rotary)

a. First release of CNC/HPGL compatible Version. (let me know if you have any questions or problems)

9-18-08 VCS Release (4.1.7.8).(1.4.11).(2.0.18).(77)

1. (Laser)

a. Fixed a problem with certain vector combinations that caused the Laser to move very slow.

2. (Rotary)

a. Added a message to show when a new plate is about to engrave.

b. More work done on CNC/HPGL mode.

9-10-08 VCS Release (4.1.7.8).(1.4.7).(2.0.17).(76)

1. (Core)

a. Fixed indexer mode for Laser **(Must update Laser to 2.0.17 init or later)**

b. Fixed some rubber stamp issues when running from XGW.

2. (Rotary)

a. Added table size on Info Dialog

b. CNC/HPGL modifications. **(Will be in available in next release)**

c. Added self-test dialog. Includes burnin and a self test job.

3. (Laser)

a. Fixed Indexer Mode **(Must update Laser)**

8-1-08 VCS Release (4.1.7.7).(1.3.11).(2.0.15).(74)

1. (Core) oops I left out a file on (73) that if you did a new install or a remove and then an install

You would get a JC error showing up on the pendant. Sorry about that.

7-30-08 VCS Release (4.1.7.6).(1.3.11).(2.0.15).(73)

1. (Rotary) Fixed stack error in Pneumatic Z controls

2. (Rotary) CNC/HPGL Core added (not available to end used at this time..but real soon)

7-25-08 VCS Release (4.1.7.6).(1.3.7).(2.0.15).(72)

1. (Core) New Installer and New Connection Manager

a. Better Connection Detection and starting of JobNameServer

b. Fixed dual network card issues.

2. (Rotary) New Scripa.xmi file added.

a. Added PneumaticZ Support

b. Fixed Job Timer being restarted when using Forward/Backward

6-9-08 VCS Release (4.1.7.5).(1.2.1).(2.0.14).(65)

1. (Rotary) Fixed Z Delay when using No Cutter Set at Start.

6-3-08 VCS Release (4.1.7.5).(1.1.20).(2.0.14).(64)

1. (Core) Fixed Material Focus when using Rubber Stamp Mode.
2. (Laser) Modified CE Code for Laser indicator. (only needed for CE Approved Lasers)

5-20-08 VCS Release (4.1.7.0).(1.1.20).(2.0.10).(62)

1. (Core) Fixed RubberStamp mode.
2. (Laser) Fixed Batch Plate. Now shows each individual plate correctly on Laser Screen.
3. (Laser) Fixed Laser Error where you had to press start twice to start a job.
4. (Rotary) Fixed new Fro Speed Mode. Runs correct speed that is sent from XGW.

5-12-08 VCS Release (4.1.6.7).(1.1.20).(2.0.9).(61)

1. (Core) Added Help Files
2. (Core) Fixed batch plate problem on laser. Laser was displaying plates in wrong order.
3. (Rotary) Added limit checking on bootup.

5-1-08 VCS Release (4.1.6.5).(1.1.19).(2.0.9).(60)

1. (Core) Fixes a problem when using the XMU update system. There was a problem of saved values getting reset or changed.

4-30-08 VCS Release (4.1.6.3).(1.1.19).(2.0.9).(59) \*\*\*\* Rotary Systems MUST do an XMU Update or full Update with this Version \*\*\*\*

1. (Rotary) Fixed an error with replay when the Z would move down before moving to the material.

4-25-08 VCS Release (4.1.6.3).(1.1.18).(2.0.9).(58) \*\*\*\* Rotary Systems MUST do an XMU Update or full Update with this Version \*\*\*\*

1. (Rotary) Speed mode mods
2. (Rotary) Fix for Spindle Delay error.
3. (Rotary) Added CutGrid Z Stroke to VCS.
4. (Core) Modified connection protocol.

4-10-08 VCS Release (4.1.6.2).(1.1.9).(2.0.9).(57)

1. (All) Added code to lock service menu if customer requests it. It's in machine Parameters.

Call Xenotech for the code. Once you have the code please do not give it out.

2. (Rotary) A few fixes for new Speed Modes.

4-5-08 VCS Release (4.1.6.2).(1.1.6).(2.0.6).(56)

1. (Rotary) Added new Speed Menu under Settings. New menu has the following settings:

- a. Standard Mode. Adjust the speed faster or slower than the sent over speed. all speed changes happen at the next cutter down. You cannot adjust the speed on-the-fly on a single vector segment.

- b. FRO. This is Feed Rate Override. This will be the default. This uses the % value on the speed screen. whis it's set to 100 then you can only adjust the speed slower than the sent over speed. The good thing about this mode is that you CAN change the speed on-the-fly.

- c. Manual. This mode overrides all sent over speeds. you can send a job over, adjust the speed on player screen and run at that speed. Any job you send over will engrave at that speed.

3-19-08 VCS Release (4.1.6.2).(1.1.0).(2.0.6).(55)

1. (Core) Fixed a stack leak when jogging on Laser
2. (Core) Added a Desktop Icon for VCS
3. (Laser) Base code for Color GLCD

3-10-08 VCS Release (4.1.6.0).(1.1.0).(15.59).(53) (must use with "6.41.0.70 XGW 32" or later)

1. (Core) Fixed a Laser Bug.

2. (Laser) New core update fixed and AutoStart bug on the Laser. RubberStamp jobs would not AutoStart
3. (Rotary) New Touch-Off-Block Feature. Ability to use Touch-Off-Block to set Material Depth.
4. (Rotary) Color Touch Screen code added.

3-7-08 VCS Release (4.1.5).(9.6).(15.59).(52) (must use with "6.41.0.70 XGW 32" or later)

1. (Core) Added Color GLCD Support
2. (Laser and Rotary) Final fix for Sideways problems

2-13-08 VCS Release (4.1).(9.6).(15.59).(51) (must use with "6.41.0.66 XGW 32" or later)

1. (core) Fixed Reverse and Sideways Bugs while using Grid.
2. (Laser) Fixed Rubber Stamp Jobs not going home.
3. (Laser) Fixed Rubber Stamp Jobs Starting automatically.

1-30-08 VCS Release (4.1).(9.6).(15.57).(50)

1. (Laser) Added the ability to move the z to different depths during a job.
2. (Rotary) Fixed a problem with the new Braille Mode not returning the correct value all the time.

1-25-08 VCS Release (4.1).(9.5).(15.56).(49)

1. Worked on display issues for both Rotary and Laser.
2. Fixed auto focus problem on Laser. No longer set at upper left of table.
3. Fixed some Z problems on Rotary.

1-14-08 VCS Release (4.1).(9.4).(15.55).(48)

Fixed a viper problem of not turning the spindle motor back on when doing a Stop Job

1-9-08 VCS Release (4.1).(9.3).(15.55).(47)

Small core change.

1-7-08 VCS Release (4.1).(9.3).(15.55).(46)

Replaces last build. I forgot to update a file

1-7-08 VCS Release (4.1).(9.3).(15.55).(45)

1. fixed Braille mode when using temp home
2. Added Error Msg to Laser.
3. More core modifications for Neti to help with connections.

1-4-08 VCS Release (4.1).(9.2).(15.54).(44)

1. Added Braille mode to Viper.  
This new feature works in conjunction with the Braille insertion tool to automatically install Braille dots.
2. Viper now remembers the last engraved speed changes when running a job from replay.
3. A core modification for Neti to help with connections.

12-11-07 VCS Release (4.1).(8.53).(15.54).(43)

This is a core code fix.  
Fixed problem with Speed on Laser and Viper Systems. If you sent over a job at one ips it may not engrave at \ that speed. This was introduced in .(42) release.

12-7-07 VCS Release (4.1).(8.53).(15.54).(42)

Added the ability to do an AutoStart. WARNING: This can be dangerous if the machine starts and no one is around.  
Use with caution. Also changed AutoFocus and remove the msg if you were too close to the edge and tried to do a focus. It automatically moves to where it needs to to do a focus.

12-4-07 VCS Release (4.1).(8.53).(15.52).(41)

Fixed Engrave-by-Color issues. If you were running engrave-by-Color the speed values did now work also the z and spindle motor would not function on anything other than the first color.

11-20-07 VCS Release (4.1).(8.47).(15.52).(40)

Fixed several Z Problems. Sometimes when you used Stop Job or Pause the Z Axis would stay down on the material.

If the Z did pick up correctly and then you pressed continue it may move the Z faster than the programs z speed and hit the material hard.

Fixed a 3D problem. If you were running a 3D job and had a value in for Z Home it would cause the Z to plunge down deeper on the first cut move. This Fix was done in the XGW software so you will need ver 6.41.0.46 or newer. If you don't have this ver and can't download it at this time, just set your Z Stroke and Z Home to 0 when doing 3D jobs.

11-16-07 VCS Release (4.1).(8.45).(15.52).(39)

Fixed the Laser Round Fixture. It was not running correctly and sometimes would not turn on.

Also fixed a Z out of bounds error on rotary systems.

11-12-07 VCS Release (4.1).(8.44).(15.51).(38)

Fixed Spindle Motor not running when Mechanical Home on download is set.

11-1-07 VCS Release (4.1).(8.43).(15.51).(37)

Fixed Grid cutout when using multipass.

10-31-07 VCS Release (4.1).(8.43).(15.51).(36)

Fixed Installer Help Balloons. Fixed Connection Manager. (When back was selected you no longer could detect systems)

10-22-07

Init File 0.8.42 plus Suite Update. (fixed spindle motor on round corner grid) Spindle motor would not run on round corner grids

10-22-07

Init file 0.8.42 (Stack Error fixed)

User may see a stack error message or error detected msg on the pendant when running multiple jobs or running many repeats.