



GIBBSCAM

2027

CAM for
Production Machining

Version 2027 : September 2026

What's New in GibbsCAM 2027



GIBBSCAM

Revised On: 06th May 2026

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Overview of What's New

The significant enhancement to **Milling** in GibbsCAM 2027 is:

- Drill Connectors/Terminators

For details, see “Milling” on page 6.

Important enhancements to **Turning** include:

- Oscillating Thread Turning (Former OptiThreading)
- Variable B-Axis Turning Holder Collision Avoidance

For details, see “Turning” on page 8.

Enhancements to **Visualization and User Interface** include:

- GibbsCAM Copilot Improvements
- Hole FR additional options - Hole Splitting Changes
- Absolute Translate - Clear All
- Visualization of Current Stock Model without running Simulation
- Ability to See Tool on the Part in the Workspace
- Show machine sim model in workspace for setup
- Ability to remove the Detached Material in Simulation
- Reverse-Rewind function for Simulation
- Scaling of Point & Labels on Screen
- Undo/Redo of Machining Marker Changes & Removal
- Control over font size of dimension labels in the Measurement Tool
- Multi-Select Mode and Range-Select Mode options
- An ability to see the tool rotational direction
- Advanced material rendering has been enhanced to simulation/IT bodies

For details, see “Visualization and User Interface” on page 11.

Improvements to **Solids** include:

- Enhancing Advanced 3D Machining

For details, see “Solids” on page 37.

Improvements to **Tooling** include:

- Tool List Editing via Tool Dialog

For details, see “Tooling” on page 38.

Miscellaneous improvements and changes include:

- System requirements
- Third-party-library support
- Approach & Retract UI in Machine Manager
- Update install pictures

For details, see “Miscellaneous” on page 40.

Milling

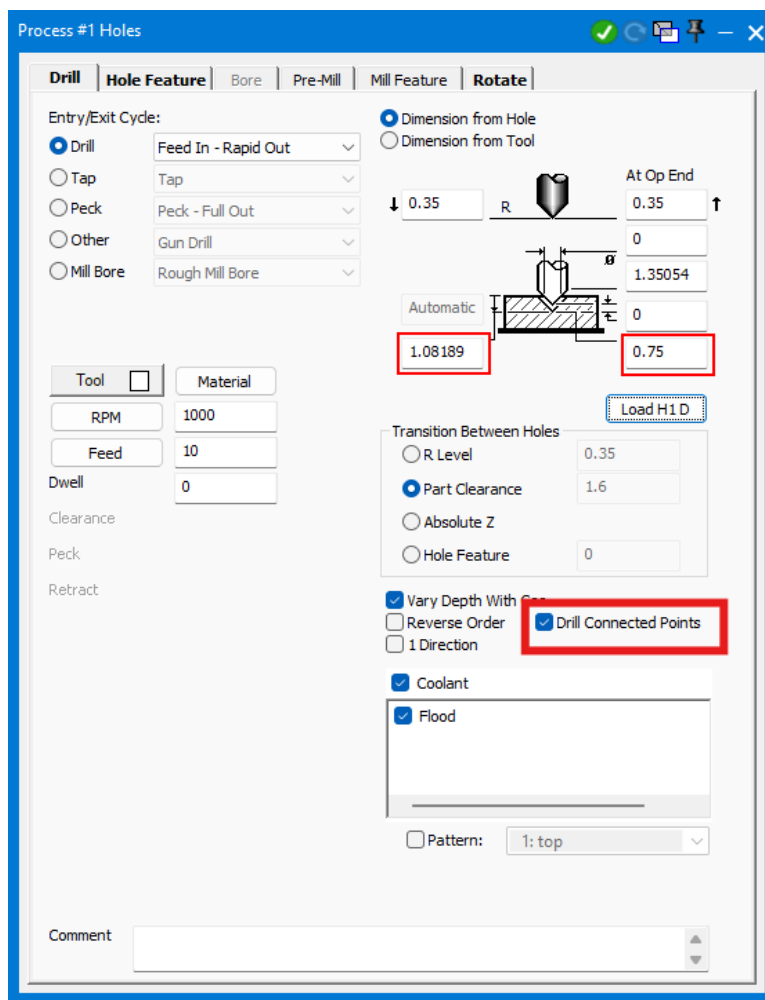
GibbsCAM 2027 provides an important Milling enhancement.

Drill Connectors/Terminators

You can now use the Mill Drill process to drill both standalone and connected points.

Where to find it:

Milling Holes> Drill Tab>Bottom Right corner>Drill connector Points



A new checkbox has been added to the Mill Drill dialog, allowing you to enable or disable drilling of connected points based on your requirements. When enabled **Drill Connected Points** the existing Mill Drill functionality is applied seamlessly to connected point selections, ensuring consistent behavior across different point types.

In addition, the Load H1 Depth option works for connected points, allowing accurate depth control during drilling operations. Drill operations created from a process will continue to store only point data, maintaining consistency in output.

This enhancement improves flexibility and expands the usability of the Mill Drill process by supporting a wider range of point configurations while maintaining a streamlined workflow.

Turning and MTM

Version 2027 enhances Turning and MTM in several important ways.

Oscillating Thread Turning (Former OptiThreading)

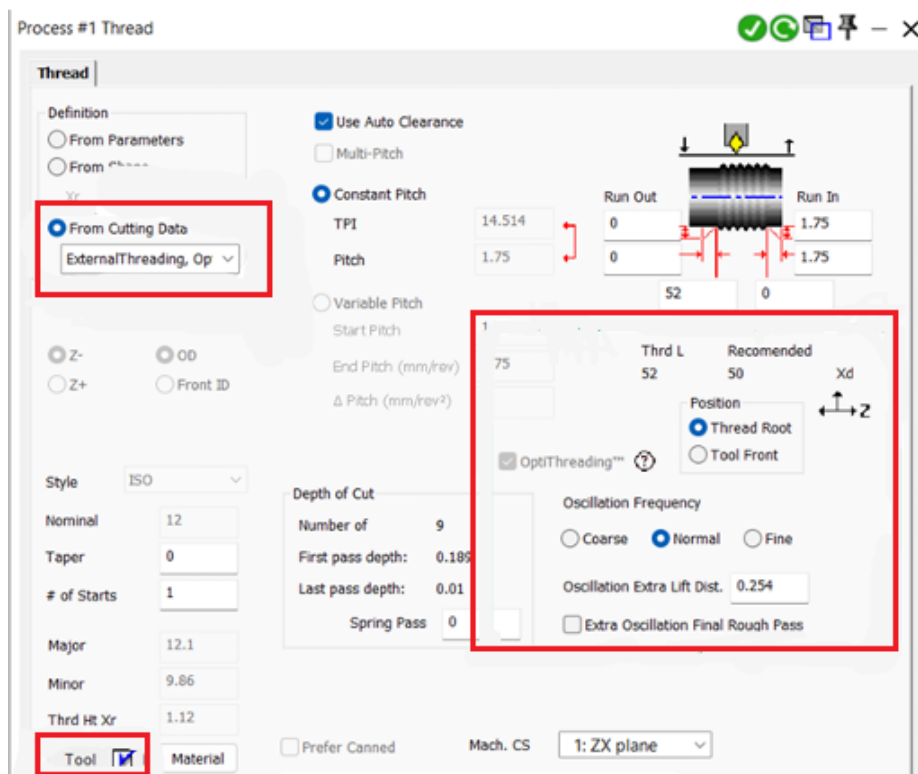
You can now use **Oscillating Thread Turning**, the updated method replacing the previously available OptiThreading.

Where to find it:

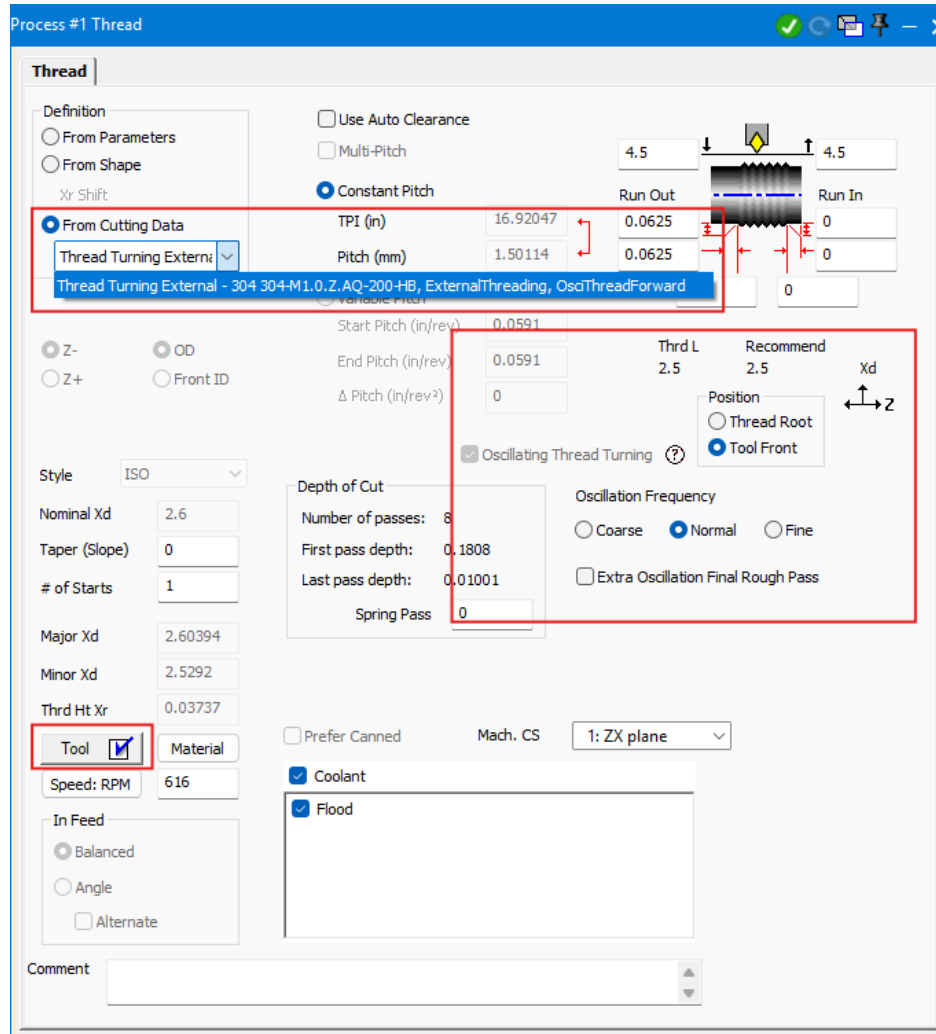
The Threading process dialog>under Definition> From Cutting Data.

This is active when the process uses a Threading tool that has been imported from CPTL (CoroPlus Tool Library) with recommended cutting data.

Before GC2027: OptiThreading



GC2027: Oscillating Thread Turning



All OptiThreading fields and references in the process dialog and tool cutting data table have been updated to reflect **Oscillating Thread Turning**. Existing tool cutting data sets that used OptiThreading remain valid and are now recognized as Oscillating Thread Turning, ensuring backward compatibility with previously created files.

The toolpath calculation has been enhanced to ensure that consecutive passes do not intersect or overlap. For even passes, peak positions maintain the same X (depth) values as the previous pass at the same Z level, including higher oscillation finish passes. A small clearance is applied to peaks and valleys to prevent contact between consecutive passes, while the calculation for odd pass peaks remains unchanged.

Additionally, the Oscillation Extra Lift Distance parameter has been removed. New tools imported through CoroPlus Tool Import will now use Oscillating Thread Turning instead of OptiThreading.

This enhancement improves threading accuracy and consistency while ensuring seamless backward compatibility and alignment with updated oscillating thread turning functionality.

Variable B-Axis Turning Holder Collision Avoidance

In Progress...

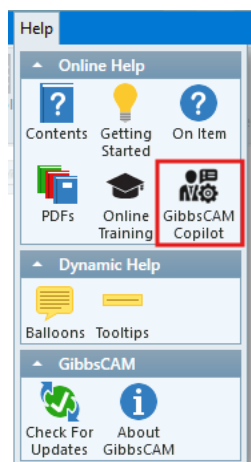
Visualization and User Interface

GibbsCAM Copilot Improvements

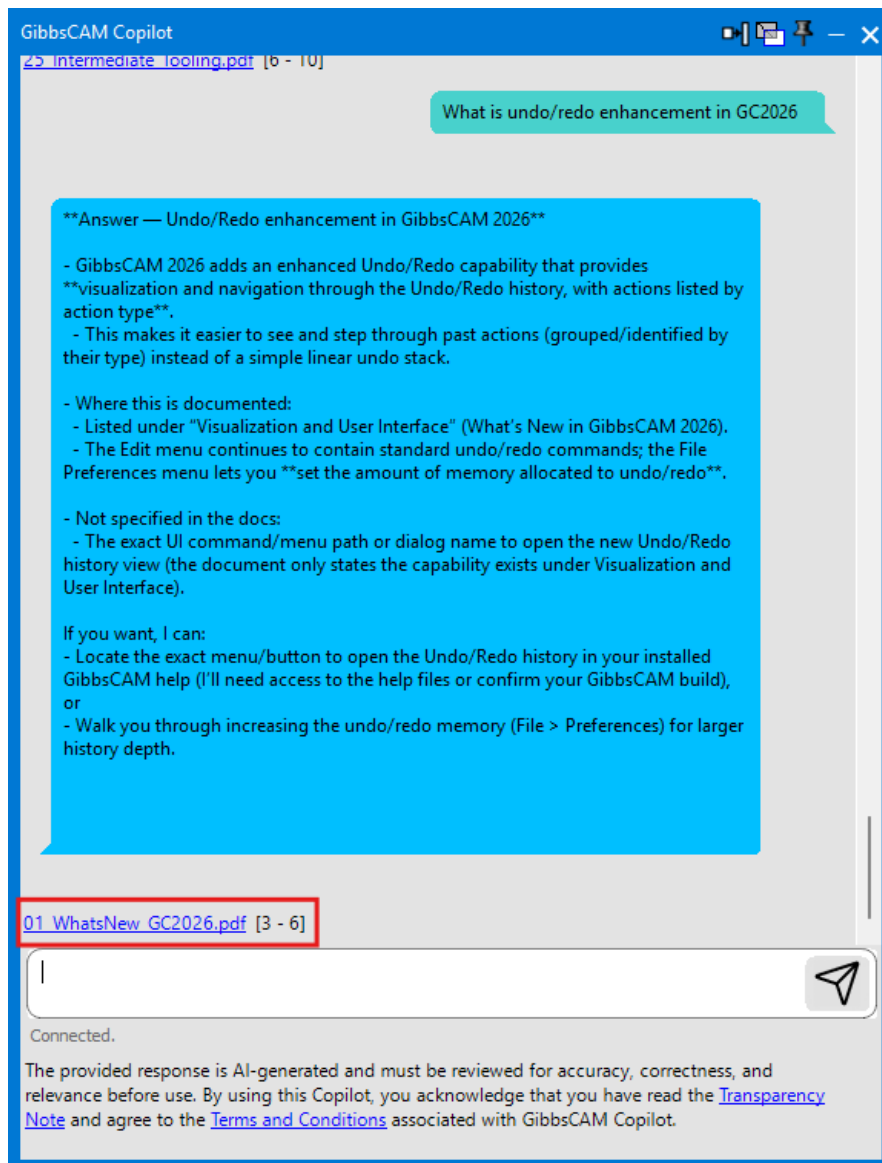
You can now access improved formatting, contextual links, and guided references directly within the Copilot.

Where to find it:

On the Help menu>click  GibbsCAM Copilot.



GibbsCAM Copilot responses now include enhanced formatting for better readability, along with links to supporting and relevant materials. In addition, it provides intelligent suggestions and references to videos, including direct pointers to the exact time stamp of the relevant topic. This enables users to quickly locate and understand the required information without unnecessary navigation.



This enhancement improves content accessibility and helps users find relevant information more efficiently.

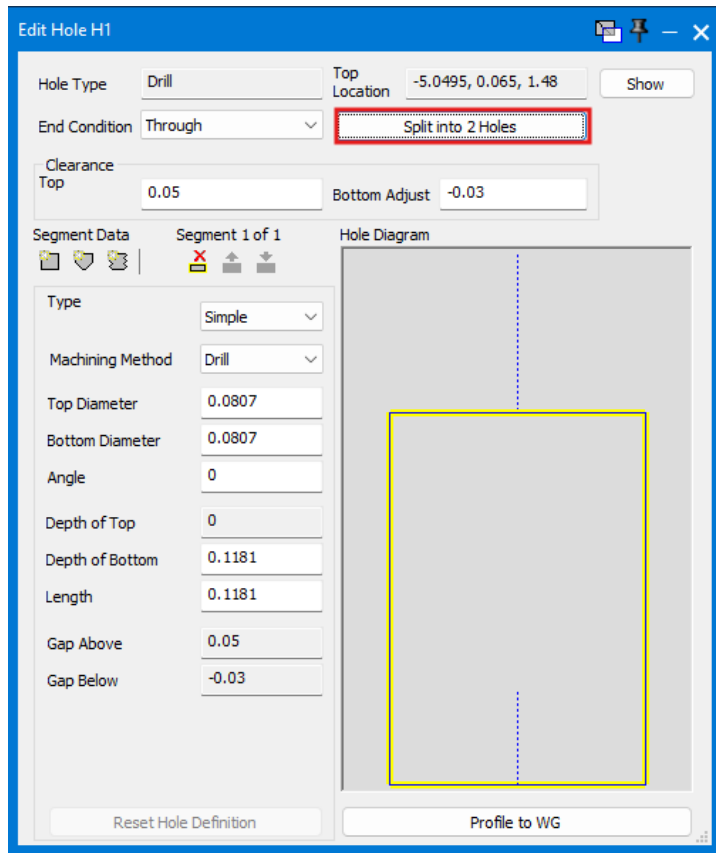
Hole FR additional options - Hole Splitting Changes

You can now control how holes are identified and managed during Automatic Feature Recognition (AFR), including improved handling of holes located on the same centerline.

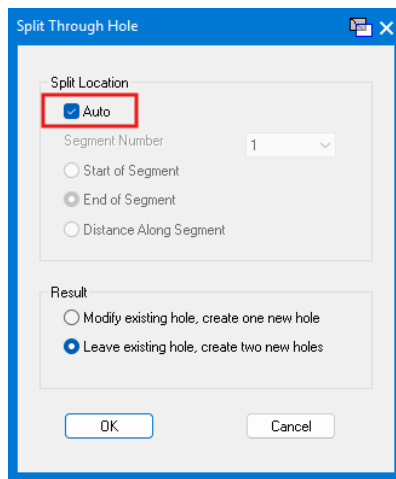
Where to find it:

On the **Features** Menu>Hole Manager>Edit Hole in RMB on the listed hole item>**Split in 2 Holes**>Auto

Holes across layers are now merged into a Single Hole by Default during hole feature recognition, ensuring more accurate and streamlined results.



If needed, merged holes can be separated using the **Split Through Hole** option available from the RMB menu on the listed hole item, or by enabling splitting in **Auto** mode. This provides greater flexibility when working with complex hole configurations and ensures correct hole direction handling.



When **Auto** is checked, All manual options are disabled and software automatically determines the split location of the hole.

This enhancement improves accuracy and user control in hole feature recognition, reducing manual adjustments and enhancing overall workflow efficiency.



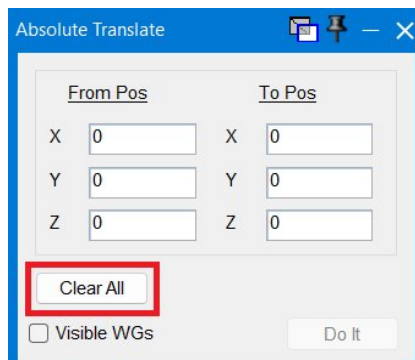
Absolute Translate - Clear All

You can now quickly reset all values in the  **Absolute Translate** dialog using a dedicated Reset button.

Where to find it:

Under the **Modify** menu>Transform> **Absolute Translate**.

A Reset button **Clear All** has been added to the Absolute Translate dialog that clears all input fields and automatically sets their values to zero. This allows users to quickly remove existing entries without manually editing each field.



This enhancement improves usability by allowing faster data clearing and reducing manual effort before re-entering values.

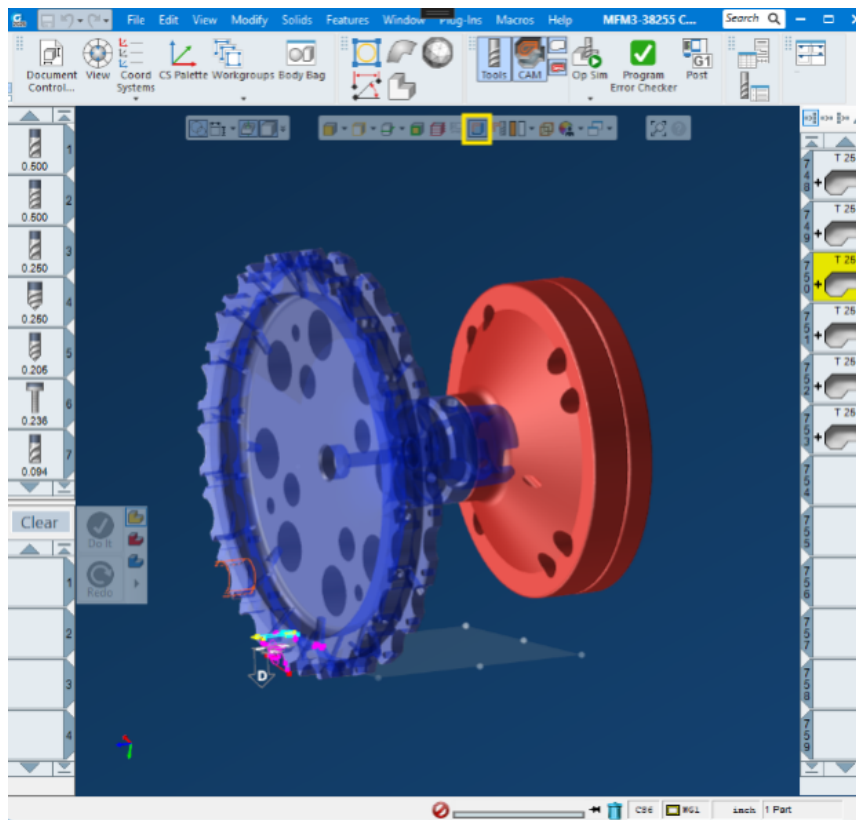
Visualization of Current Stock Model without running Simulation

You can now visualize the machined stock solid directly in the workspace using the  **Show Machined stock** command.

Where to find it:

Floating toolbar >  **Show Machined Stock** command.

The machined stock can be displayed for the highest-numbered selected operation or, if no operation is selected, for the entire program by clicking on the  **Show Machined stock** command.

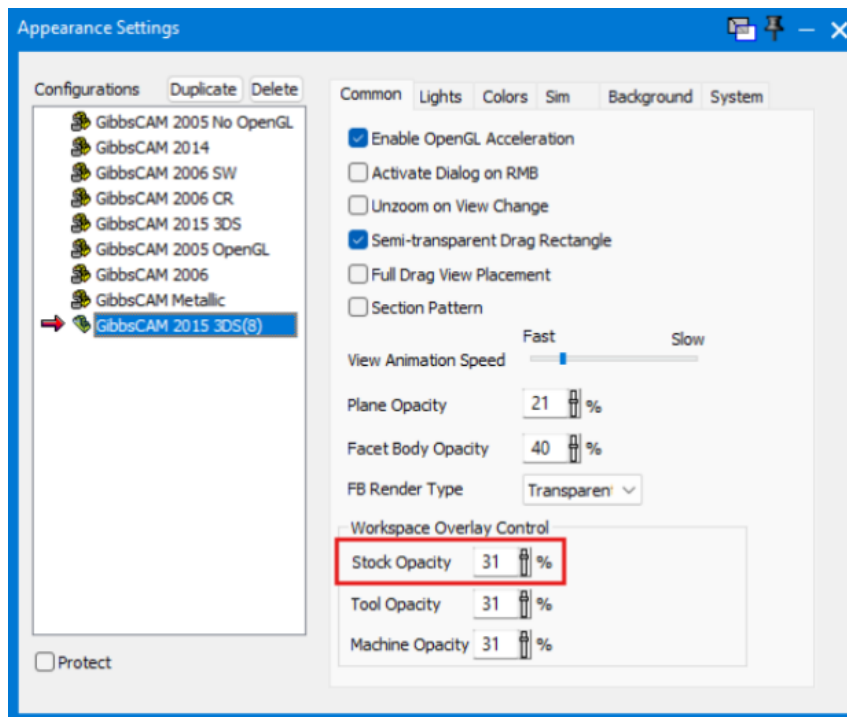


Note:

Show Machined Stock does not render Lathe Threading, Linear Broaching, Rotary Broaching, or Thread Whirling operations within the Workspace. This functionality is intended to align with Material Only visualization and should not be interpreted as equivalent to, or a substitute for, Operation Simulation (Op Sim).

Machined stock transparency is controlled with the **Appearance Settings** . On the **File** menu, click

⚙️ Preferences > In Preferences dialog > **Display Tab** > click Edit Appearance Settings > Under **Common Tab** > **Workspace Overlay Control** > **Stock Opacity**.



This enhancement provides better visualization of the machining process by allowing users to quickly review the machined stock for specific operations or the entire program.

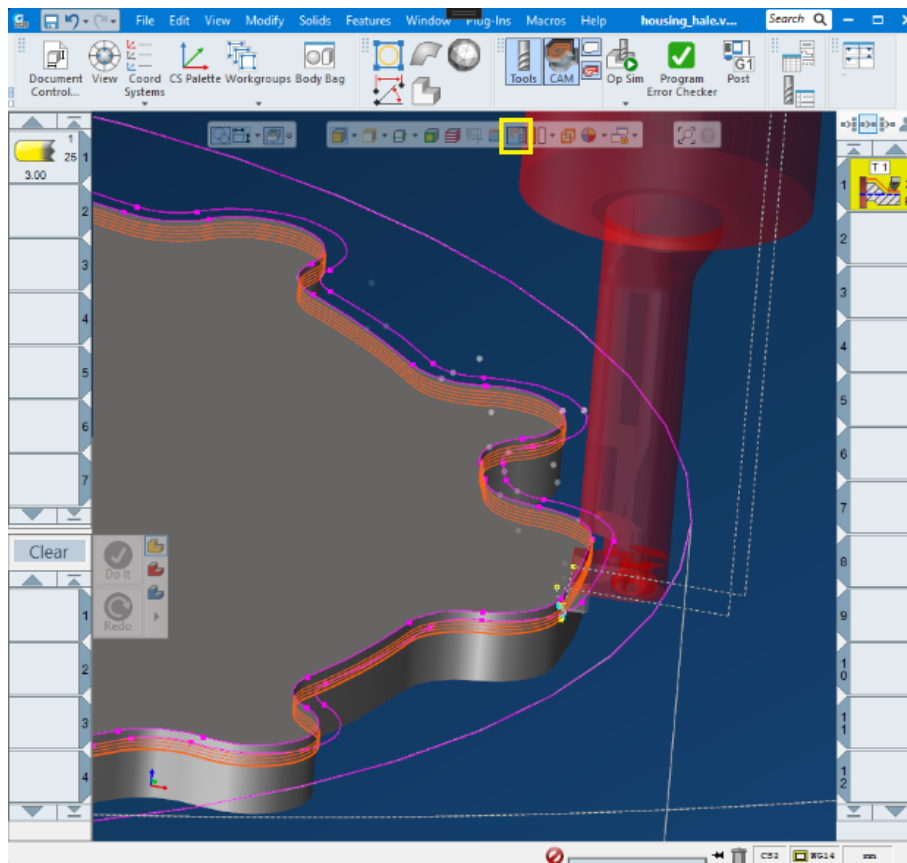
Ability to See Tool on the Part in the Workspace

You can now visualize the Tool in the workspace using the **Show Tool on Toolpath** command.

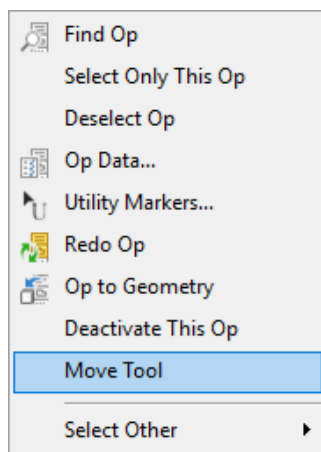
Where to find it:

Floating toolbar > **Show Tool on Toolpath** command.

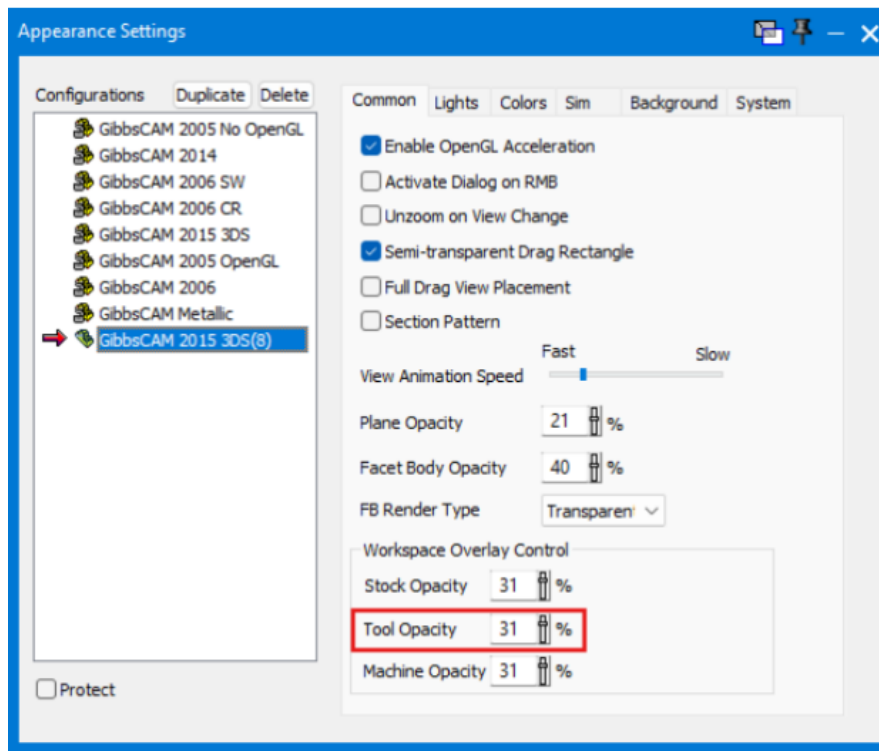
By selecting respective Operation and clicking on **Show Tool on Toolpath** command, The system now displays the tool in the Workspace. When multiple operations are selected, the tool displayed in the workspace corresponds only to the uppermost operation in the Operation Tile List, ensuring consistent visualization. Additionally, the displayed tool can be interactively dragged along the **Toolpath**, enabling improved visualization and verification of machining operations.



The tool can also be positioned using the **toolpath RMM** option **Move Tool**.



Machined stock transparency is controlled with the **Appearance Settings** .
On the **File** menu, click **Preferences**>In Preferences dialog>**Display** Tab> click **Edit Appearance Settings**>Under **Common** Tab >**Workspace Overlay Control**>**Tool Opacity**.



This enhancement provides better visualization of the machining process by allowing users to quickly review the Tool for specific operations or the entire program.

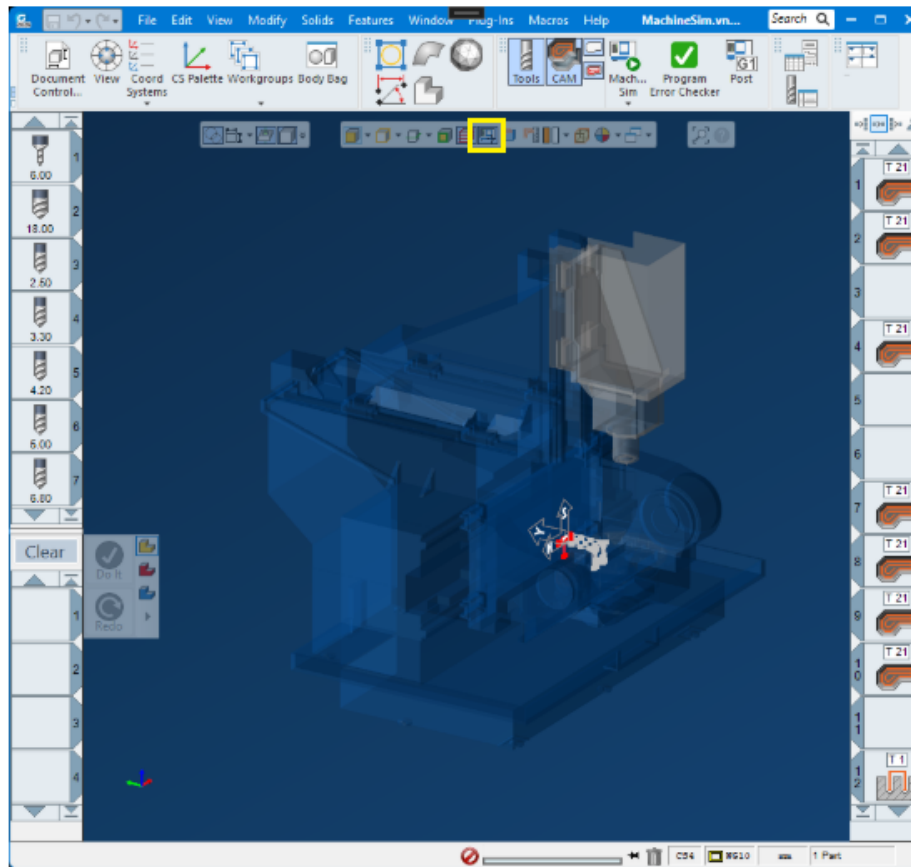
Show machine sim model in workspace for setup

You can now visualize the Machine assembly model currently associated with the part in the workspace using the  **Show Machine Assembly** command.

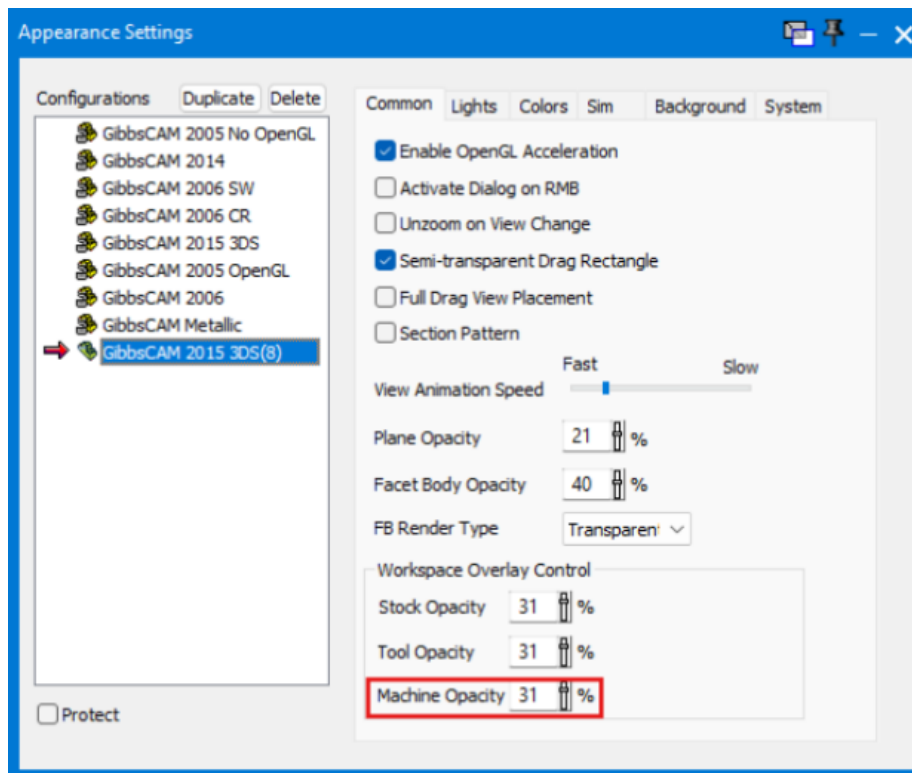
Where to find it:

Floating toolbar  **Show Machine Assembly** command.

By clicking on  **Show Machine Assembly** command, the machine model is displayed to enable accurate visualization of the machine and part layout within the workspace.

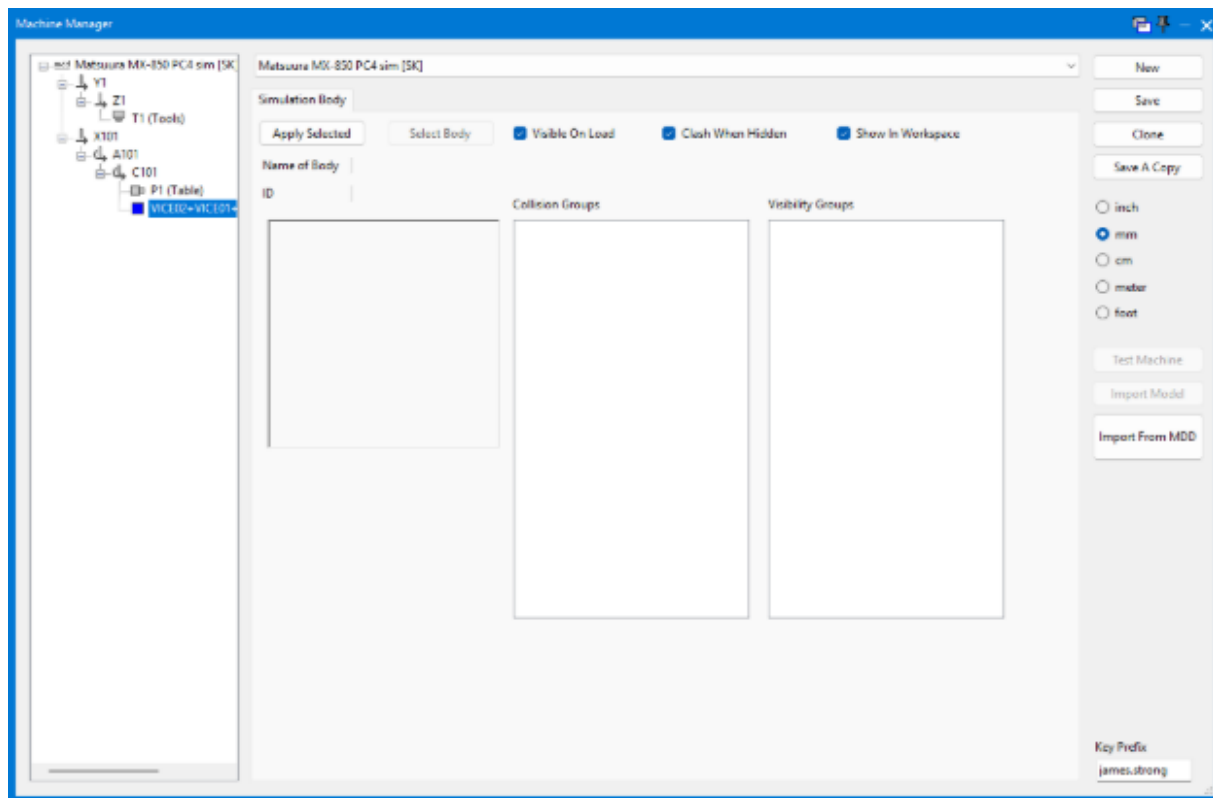


Machined stock transparency is controlled with the Appearance Settings .
 On the **File** menu, click  Preferences>In Preferences dialog>**Display** Tab> click Edit
 Appearance Settings>Under **Common** Tab >Workspace Overlay Control>**Machine Opacity**.



By default, all machine assembly components are displayed in the workspace. However, specific components can be excluded from visualization using either of the following methods:

1. Create a machine assembly visibility group named **Workspace** and add only the required machine components to this group. When the **Workspace** visibility group is present, any components not included in the group will not be rendered in the workspace.
2. Disable the **Show in Workspace** option while defining the machine in the Machine Manager.



This enhancement provides better visualization of the machining process by allowing users to quickly review the Machine assembly for specific operations or the entire program.

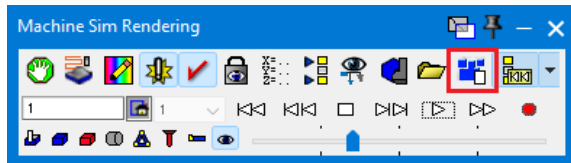
Ability to remove the Detached Material in Simulation

You can now interactively remove unwanted chips generated during simulation.

Where to find it:

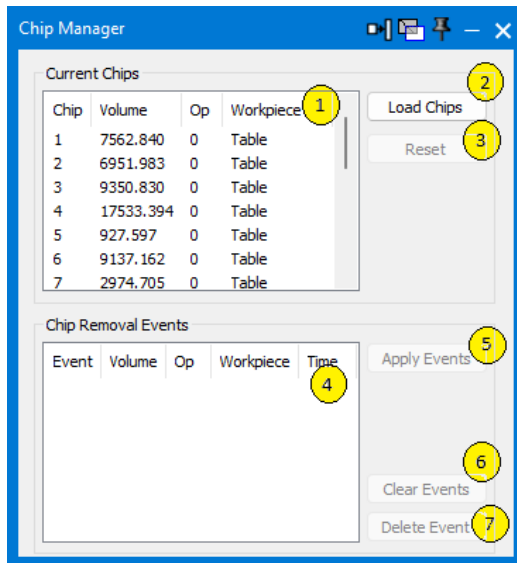
In the Simulation rendering dialog>  **Chip Manager** tab

When material removal during simulation splits the stock into multiple parts (chips), users previously had no direct way to determine which parts should be discarded as the simulation progressed. This enhancement resolves that limitation by allowing users to identify specific chips to remove from the simulation. The removal is then handled through chip removal events, ensuring those chips are consistently discarded in subsequent simulation steps, improving simulation clarity.



The  **chip manager** dialog controls the definition and execution of chip removal events.

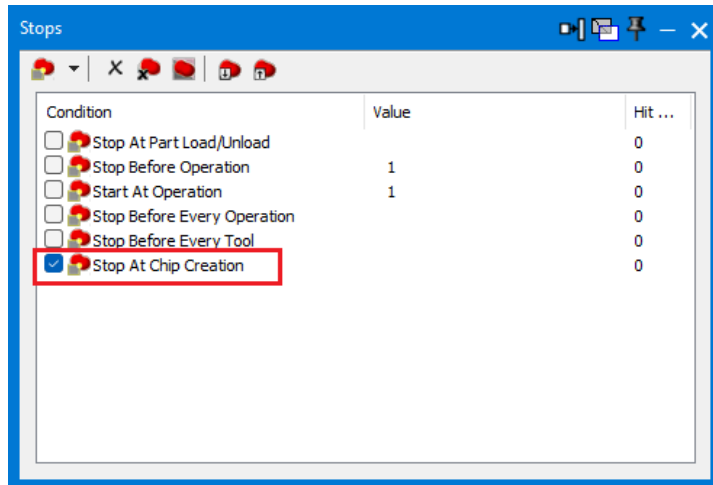
Chip Manager



1. Displays stock body chips when loaded.
2. Detects and loads chips from the current simulation state. Chips are also detected and loaded automatically when the simulation are stopped either through manual interaction, showing the dialog, hitting a breakpoint, or program completion.
3. Clears chip removal events and reverts any chip removal done in the current simulation state. This button is only enabled when a chip has been removed.
4. Displays currently defined chip removal events.
5. Forces the execution of selected chip removal events against the current simulation state.
6. Removes all defined chip removal events.
7. Remove selected chip removal events.

Chip Creation Stop

The Stops dialog now includes a **Stop At Chip Creation** condition. When enabled, the simulation stops whenever the stock splits during material removal. This allows users to review the newly created chips and optionally define chip removal events at that point, although doing so is recommended but not required.



This enhancement provides improved control over chip management during simulation, resulting in a clearer and more accurate representation of the machining process.

Reverse-Rewind function for Simulation

You can now save simulation states for the active flow by enabling the Rewind/Previous Step mode.

Where to find it:

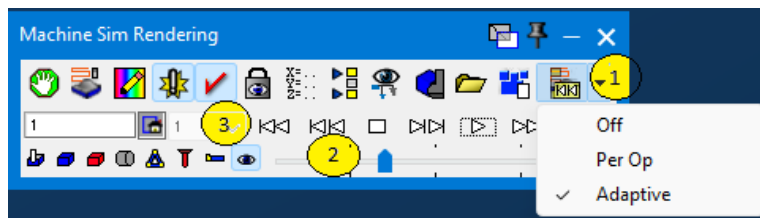
In the Simulation rendering dialog > **Previous Step Mode** tab.

You can now save simulation states for the Active Flow (3) by selecting a **Previous Step Mode**(1).

Saved states can be revisited by clicking the **Previous Step** button (2).

Rewind modes are:

- Off – no states are saved (default).
- Per Op – a state is saved at each operation change.
- Adaptive – a state is saved at each operation change plus each rapid/feed change plus the most recent five features of that operation.



This functionality enables efficient navigation through the simulation, allowing users to quickly review earlier stages of the machining process

Scaling of Point & Labels on Screen

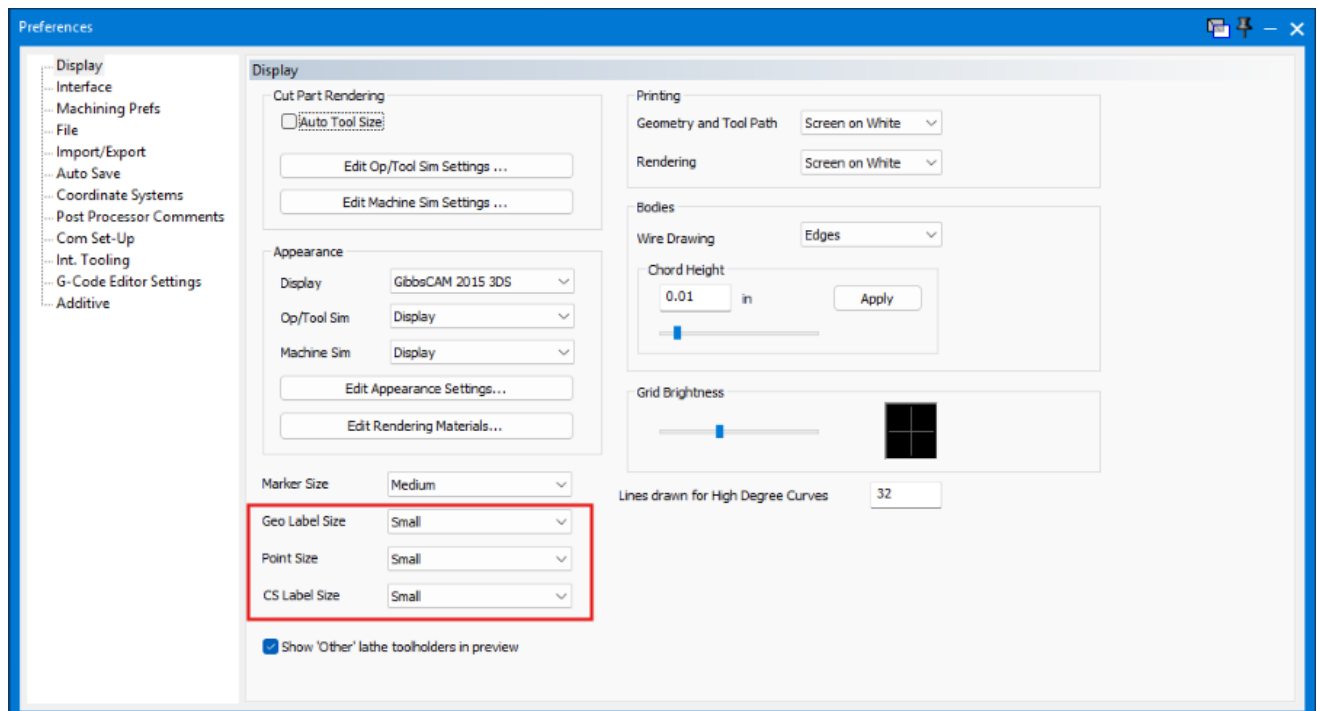
You can now define the display size of Points, Geometry Labels, and Coordinate System (CS) Labels/axis blocks.

Where to find it:

On the **File** menu, click  Preferences>In Preferences dialog>**Display** Tab>in bottom left of the pane, options button let you specify the size of elements.

Like markers, these elements can be displayed at one of 4 sizes:

1. Small
2. Medium
3. Large
4. Extra Large

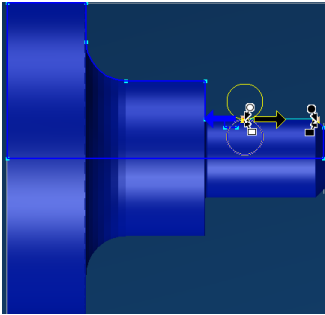


This enhancement provides greater control over graphical window visualization and improved workspace clarity.

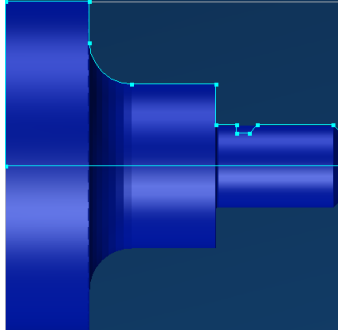
Undo/Redo of Machining Marker Changes & Removal

You can now **Undo/Redo** changes made to marker positions, including clearing of start and end points as well as start and end of features.

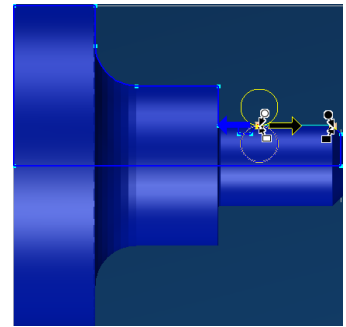
This enhancement allows users to easily recover markers if they are unintentionally cleared, such as when clicking outside the contour. The **Undo/Redo (Ctrl+Z/Ctrl+Y)** functionality improves workflow efficiency by enabling quick correction of marker-related actions without needing to recreate them manually.



Markers placed on the contour



Markers cleared after clicking outside the contour



Markers restored after Undo

This enhancement improves usability and reduces rework by providing greater control and flexibility when working with markers.

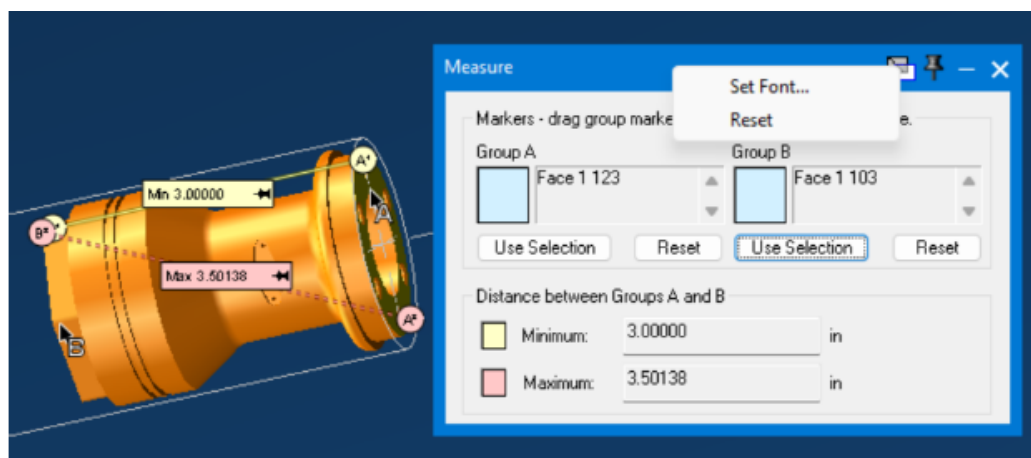
Control over font size of dimension labels in the Measurement Tool

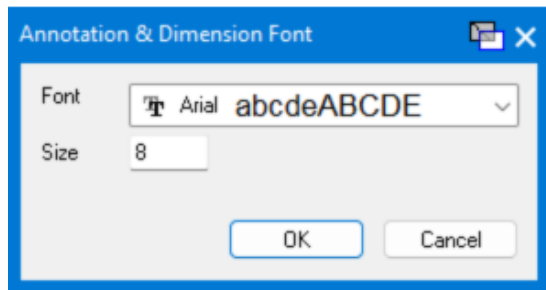
You can now customize the font type and font size for dimensions displayed in the Measurement tool labels within the graphical window.

Where to find it:

View Menu > Measure > Measure Dialog box > RMB anywhere on Dialog box > **Set Font** > **Annotation & Dimension Font**

After creating the required measurement and displaying the dimensions in the graphical window, right-click anywhere within the Measure dialog box and select **Set Font**. This opens the **Annotation & Dimension Font** dialog, where the font type and size can be modified as required. Once the dialog is closed, the updated font settings are applied to the dimension labels displayed in the graphical window.





This enhancement provides greater control over measurement label appearance, improving readability and allowing dimension annotations to be tailored to user preferences and display requirements.

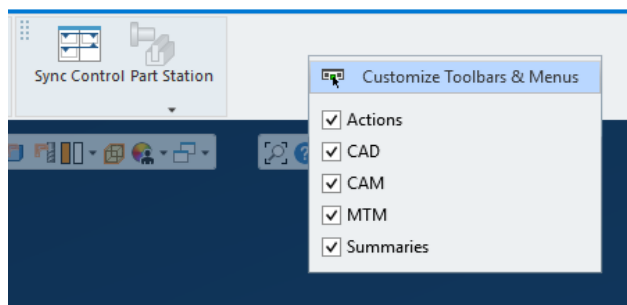
Multi-Select Mode and **Range-Select Mode options**

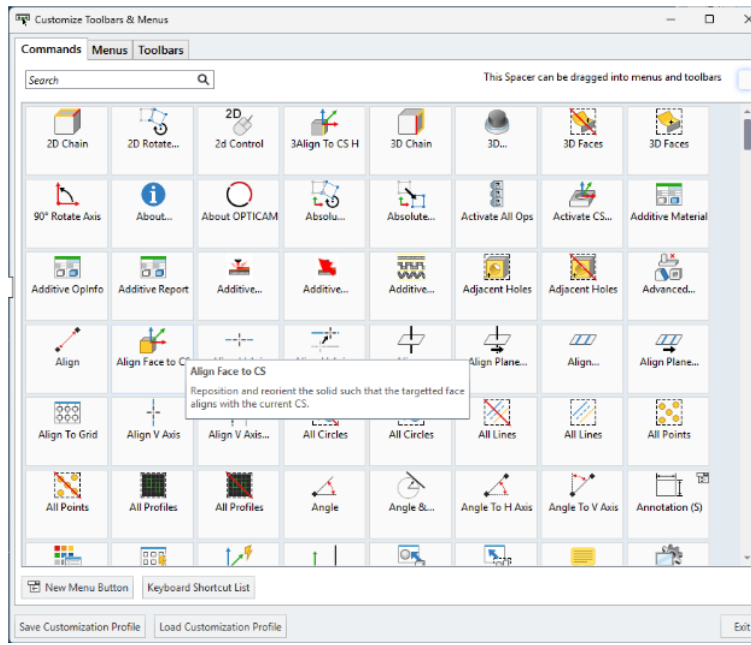
You can now use dedicated  **Multi-Select** and  **Range-Select** commands to control selection

behavior in GibbsCAM without requiring the use of the **CTRL** or **SHIFT** keys.

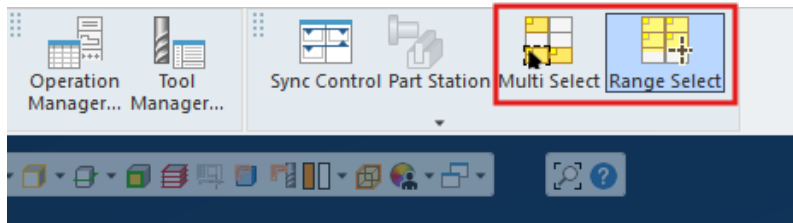
Where to find it:

These commands can be added through **Customize Toolbars & Menus** and are disabled by default. Search for the  **Multi-Select** and  **Range-Select** commands in **Customize Toolbars & Menus**, then drag and drop the commands onto the toolbar to make them available for use.





Multi-Select provides selection behavior equivalent to using the **CTRL** key, while **Range-Select** behaves like the **SHIFT** key, including support for drag selection. Selection mode remains active even after clicking within the graphical window, allowing continuous selection of operations without repeatedly reactivating the command. Only one selection mode can be active at a time, and active modes are visually highlighted for clear identification.



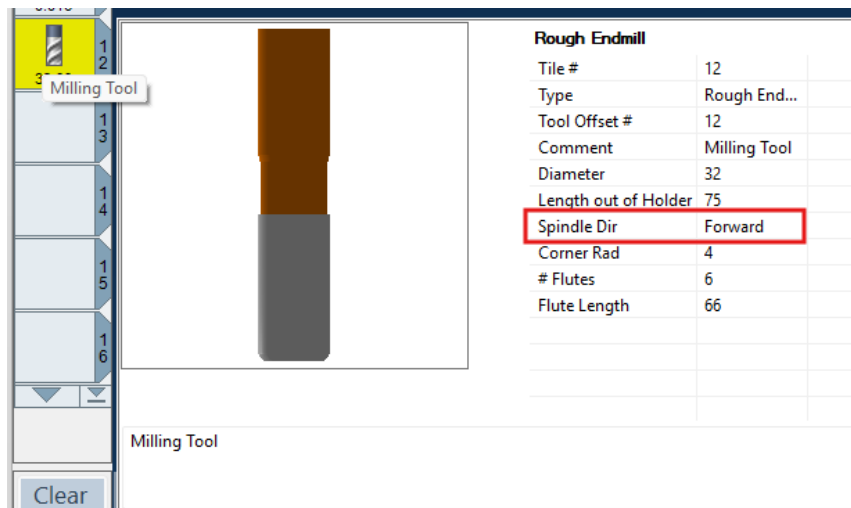
This enhancement streamlines selection workflows by reducing dependency on keyboard modifiers and providing a more efficient and uninterrupted selection experience.

An ability to see the tool rotational direction

You can now view **Spindle direction** directly within the tool preview displayed on tool tiles when hovering over a tool, provided the **Always show tool preview on hover** option is enabled in **Preferences**.

In GC2027, the tool preview includes **Spindle direction** information along with the existing tool details, eliminating the need to open the Tool dialog for verification. In

previous releases, viewing spindle direction required opening the Tool dialog by double-clicking the tool.



This enhancement improves efficiency by allowing quick spindle direction verification directly from the tool preview.

Advanced material rendering has been enhanced to simulation or IT bodies

You can now apply textures, metallic materials, and enhanced per-material lighting properties to individual solids, faces, and solid/tool types in both Simulation and Workspace rendering.

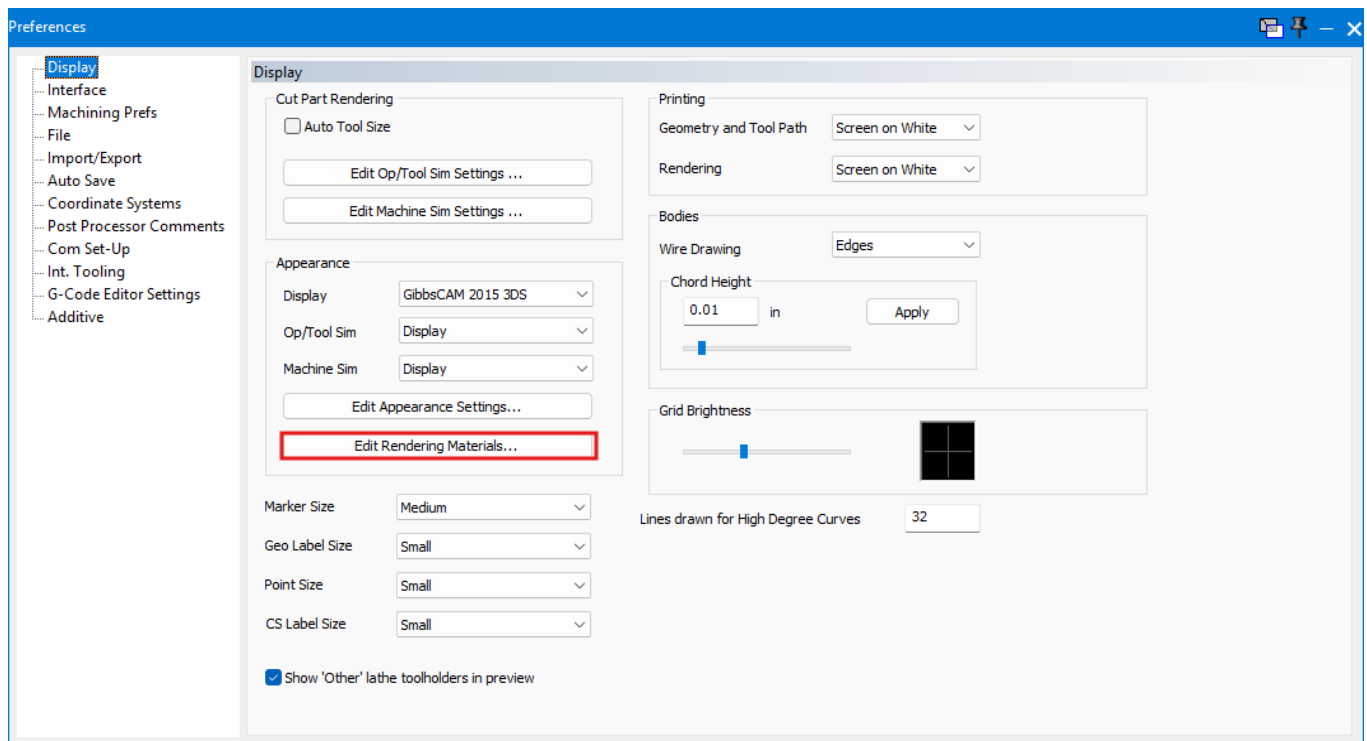
Where to find it:

On the File menu, click Preferences>In Preferences dialog>Display Tab>click **Edit Rendering Materials**

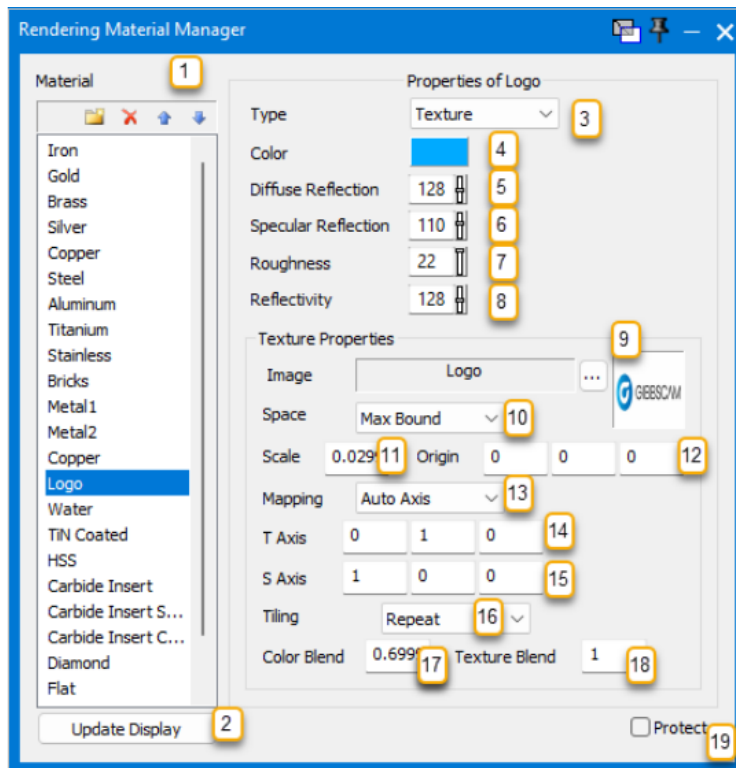
Traditionally, GibbsCAM allowed users to assign colors to solid geometry using a single set of global material and lighting parameters defined by appearance settings. In version 26, metallic materials were introduced, but support was limited to Simulation rendering only.

Rendering Material Manager

Pressing **Edit Rendering Materials** brings up the Rendering Material Manager.



The Rendering Material Manager allows the user to create, modify and delete materials from the rendering material table.



1. Material List

Select, add, delete, rename and reorder defined materials.

2. Update Display

Commits any changes and updates the simulation/workspace display.

3. Material Type

Select between Metallic, Texture and Plain materials.

4. Material Color

Define the material color.

5. Material Diffuse Magnitude Specify the amount of the material's diffuse color (range 0-255). Larger values result in brighter materials.

6. Material Specular Magnitude

Specify the amount of the material's specular reflectance (range 0-255). Larger values result in shinier materials.

7. Material Roughness

Specify the material's roughness (range 0-255). Larger values result in duller materials.

8. Material Reflectivity

Emphasizes the reflective character of the material (range 0-255). Larger numbers reflect more of their environment.

9. Set Current Texture Image

Brings up the **Texture Manager**

10. Texture coordinate spatial mapping.

Selects the spatial relationship between the associated solid and the texture.

Object - assumes textures are effectively the same size as the associated solid.

Bounds - scales the texture to match the bounds of the solid.

Min Bound - scales the texture to match the smallest dimension of the solid bounds.

Max Bound - scales the texture to match the largest dimension of the solid bounds.

11. Texture Tiling scale

Multiplies the texture size to create more or fewer tiles on the solid.

12. Texture Tiling origin

Shifts the texture on the solid.

13. Texture coordinate axis mapping

Linear - Use S and T axes to define location/orientation of the texture on the solid.

Auto Axes - Use the solid's surface normal to define the Location/orientation of the texture on the solid.

14. Texture Height Axis specification

15. Texture Width Axis specification

16. Texture Tiling behavior.

Repeat repeats the texture across the surface

Clamp Out of range texture assignments are set the texture boundary values.

Border Out of range texture assignments are set the material color.

17. Texture material color blend value.

Specifies how much material color to allow in the texture display.

18. Texture color blend value.

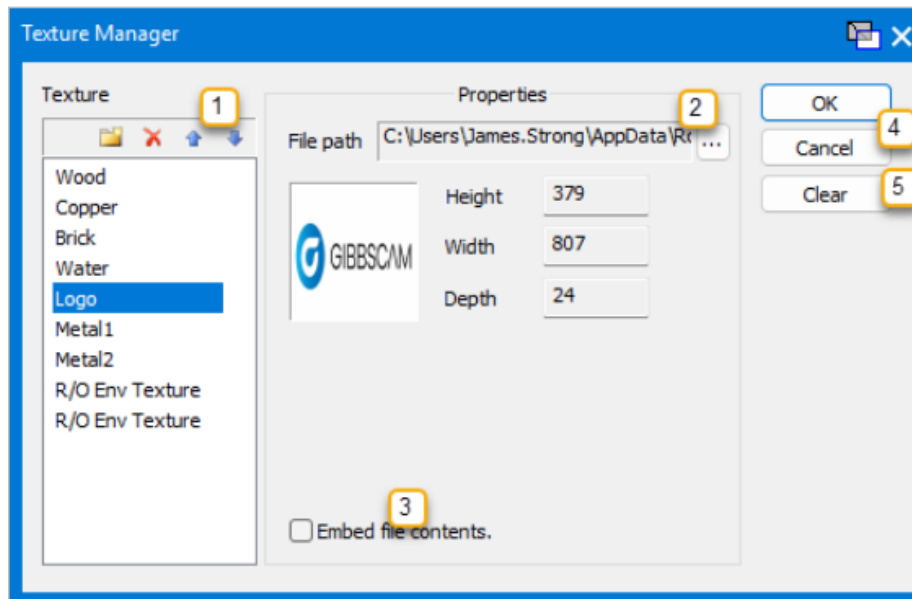
Specifies how much texture color to allow in the texture display.

19. Protect

Disables modifications of material definition. Protected materials can't be renamed,

deleted or have their definitions modified.

Texture Manager



1. Texture image list

Select, add, delete, rename and reorder defined texture images.

2. Texture image file selection.

Pressing the browse button brings up a file selection dialog to select an image file to associated with the current texture. Support file formats are BMP, JPG, and PNG.

3. Embed file contents

Embeds the texture image file contents in rendering table definition file. This allows the texture definition to be file location independent.

4. Ok/Cancel

Apply current texture to current material in the Material Manager.

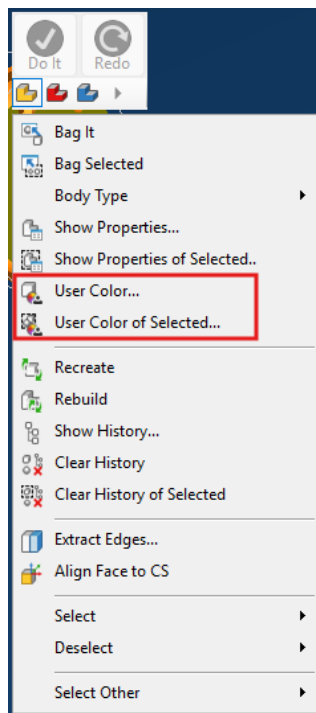
5. Clear

Removes the defined texture from current material.

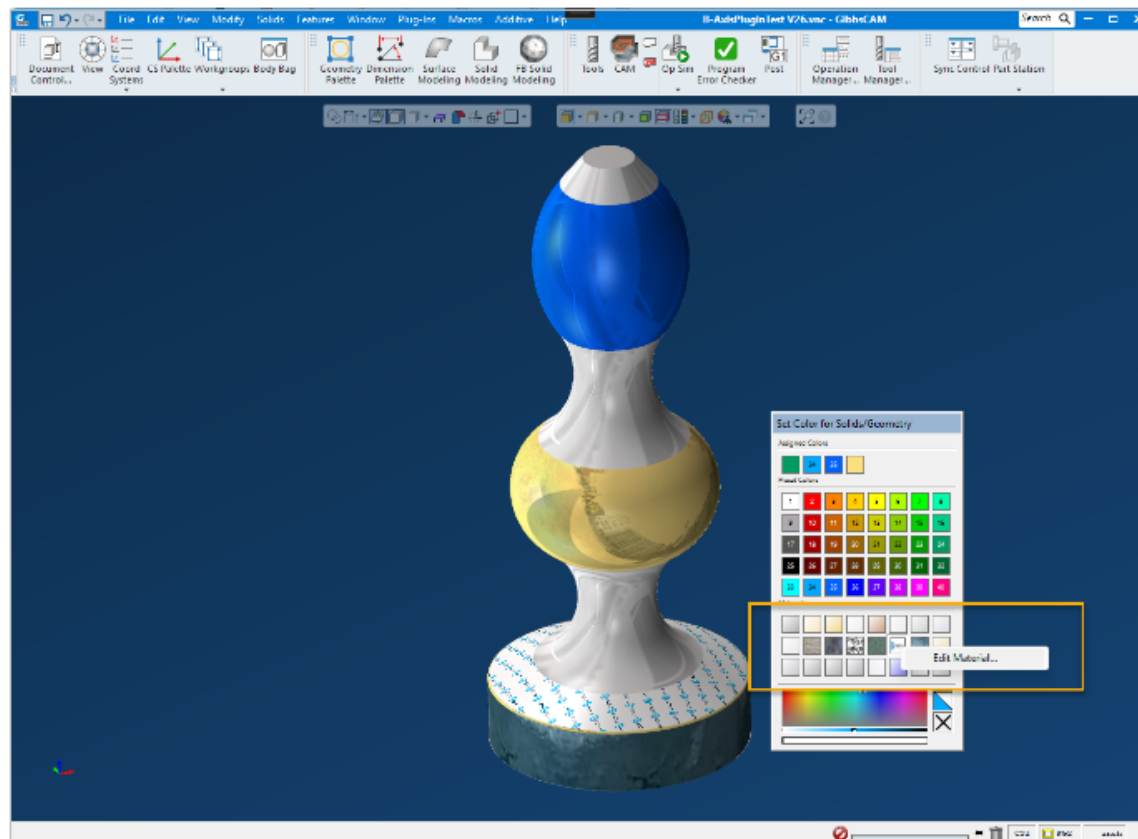
Workspace

Specifying Materials

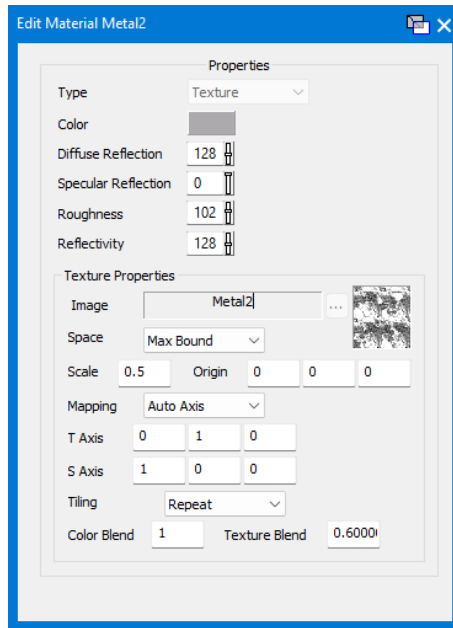
Materials can be assigned to solids/faces through the **User Color** and **User Color of Selected** menu options.



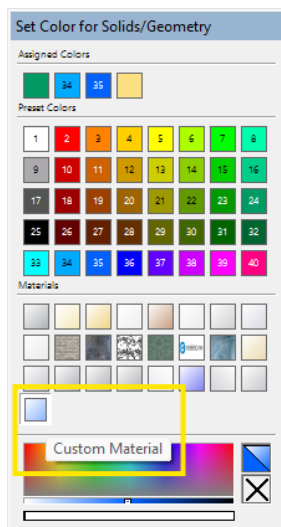
The user color palette contains a Materials section which displays all defined materials.



Right clicking on a material brings up a menu that allows the user to edit the current material definition before it is assigned to the solid. Selecting **Edit Material...** brings up a limited version of the **Rendering Material Manager** that allows the user to modify a subset of the material properties. Material type and associated texture cannot be changed from this dialog.



When a material is modified using this dialog, the corresponding material in the User Color Palette displays an “*” indicator in the upper-left corner to identify it as a customized material. Selecting this modified material assigns it to the target solid(s). The customized material is created as a full copy of the original material defined in the rendering material table, including the updated material parameters. This functionality enables material customization on a per-solid basis. When the User Color Palette is opened with a customized material loaded, the customized material is automatically added to the end of the Palette’s material section.



Facet Body Export

When a solid with assigned materials is associated with a machine definition or Intermediate Tooling, the material data is exported together with the facet body information for use in Simulation. All material-related data, including texture images, is embedded within the facet body file. This eliminates the need to package separate material files with machine assemblies or Intermediate Tooling definitions.

Simulation Visualization

Materials assigned to solid types are displayed across all simulation modes. Materials assigned to specific solids and exported with machine assemblies or Intermediate Tooling are visible only in Machine Simulation.

Environment

The rendering materials environment consists of the following components:

1. Rendering Material Definition File – RMaterialConfig.xml
Contains all material and texture definitions, along with optional embedded texture file data that is independent of file location.
2. Texture Image Folder
Stores the default texture image files used by rendering materials.

The rendering materials environment is automatically copied from the default DISPLAYAPREFERENCES folder the first time the application is launched.

This enhancement provides greater visual realism and flexibility by enabling detailed, per-material rendering customization across both Workspace and Simulation environments.

Solids

Enhancing Advanced 3D Machining

In Progress...

Tooling

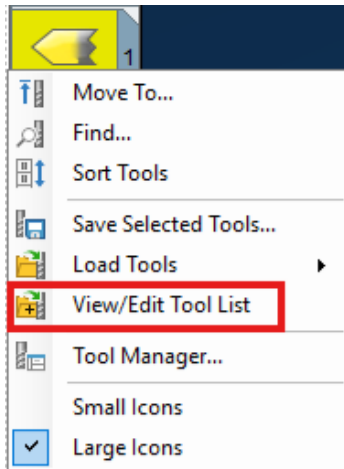
Improvements to tools and tooling have occurred throughout GibbsCAM 2027.

Tool List Editing via Tool Dialog

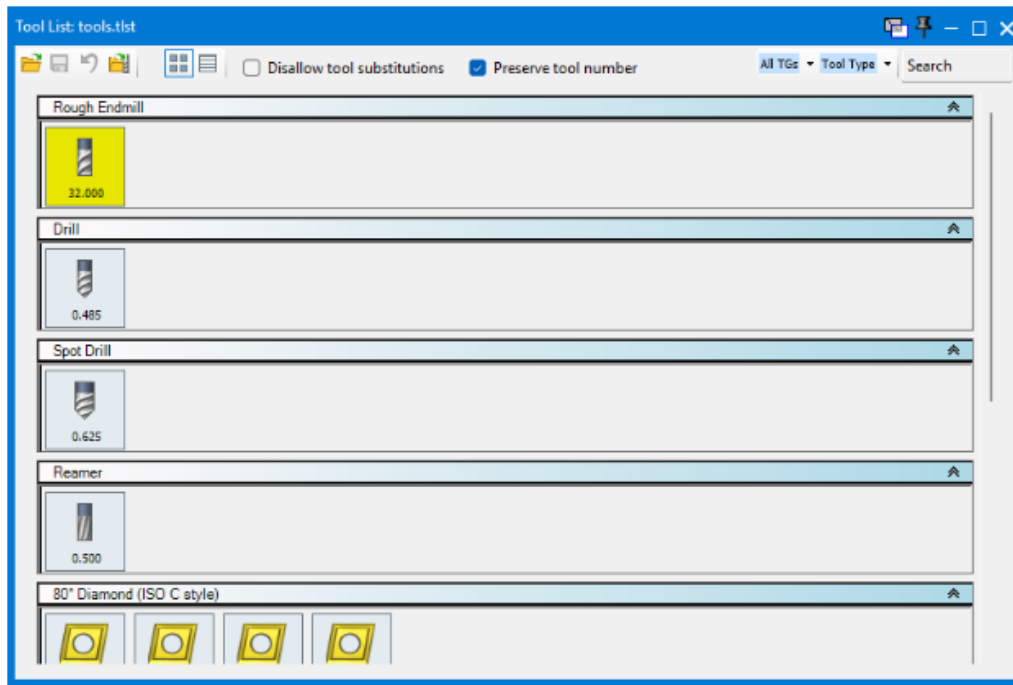
You can now edit tools in the Tool List Editor using the Tool dialog.

Where to find it:

On the Tool tile> RMB on the existing Tool>View/Edit Tool List>Tool List dialog>Double Click on Tool>Tool Dialog>Edit & Cancel>**Tool Import Action** Dialog



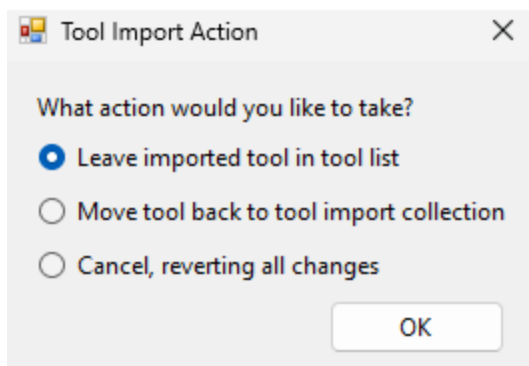
Tools can be edited directly from the Tool List by right clicking on an existing tool and selecting View/Edit Tool List, which opens the Tool List dialog.



Double-clicking any required tool in the list opens the Tool dialog, allowing tool parameters to be reviewed and updated as required. After completing the modifications and closing the Tool dialog, a confirmation dialog is displayed with options:

1. Leave imported tool in tool list
2. Move tool back to tool import collection
3. Cancel, reverting all changes

Additionally, updates to the tool file can now be saved as needed.



This enhancement improves control over tool updates by ensuring changes are reviewed and confirmed before being applied, resulting in improved workflow efficiency and accuracy.

Miscellaneous

System requirements

<i>OS:</i>	Windows 11 or Windows Server 2025
<i>CPU:</i>	Intel: 13th/14th-gen Core i7/i9, or Core Ultra 7/9 AMD: Ryzen 7/9 5000-series or newer, or Threadripper 5000-series or newer
<i>RAM:</i>	16+ GB
<i>Video card:</i>	Nvidia video card with 8+ GB of video memory

Third-party library support

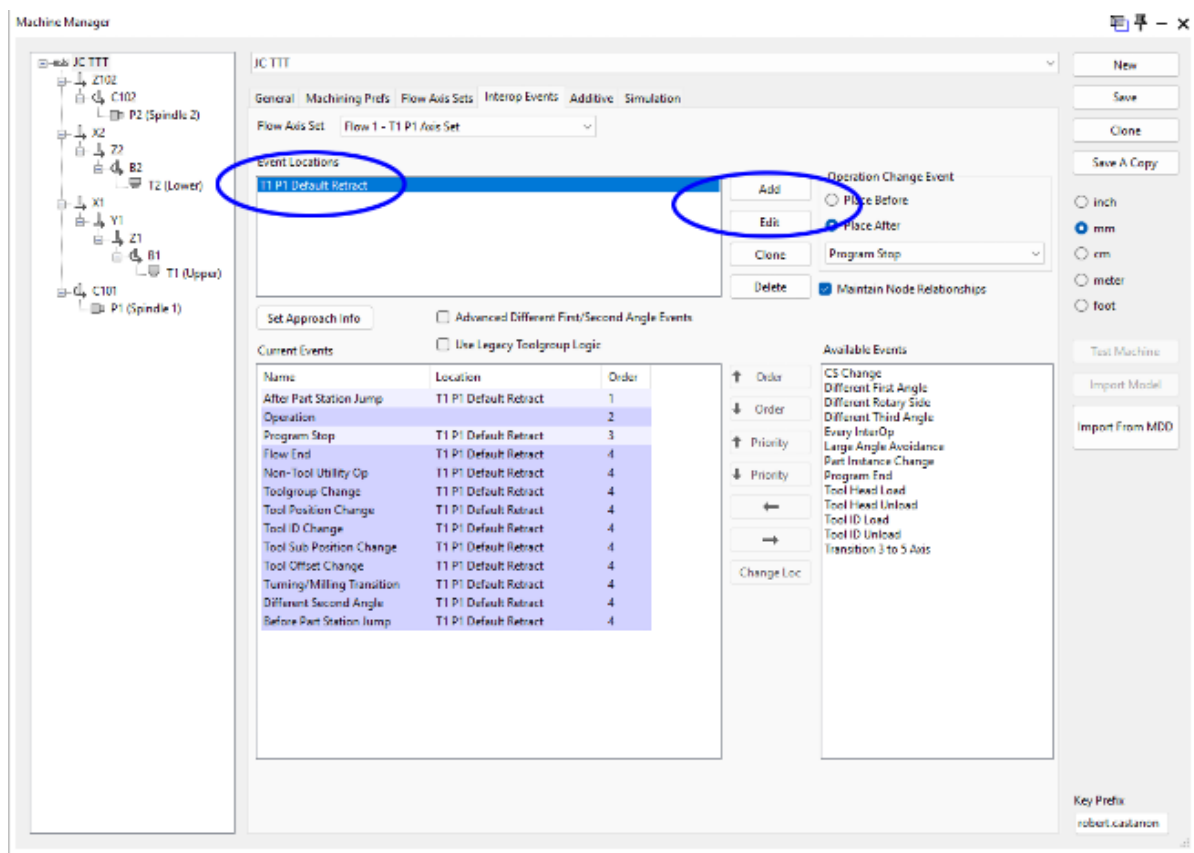
- ModuleWorks 2024.08, 2024.12, and 2025.04
- VoluMill 10.5; VoluTurn 10
- Parasolid 37, ACIS 2025.1, SolidWorks 2025, Solid Edge 2025, Catia v5 R2025, Inventor 2026, etc. , For the complete list, see the [*Data Exchange*](#) guide.

Approach & Retract UI in Machine Manager

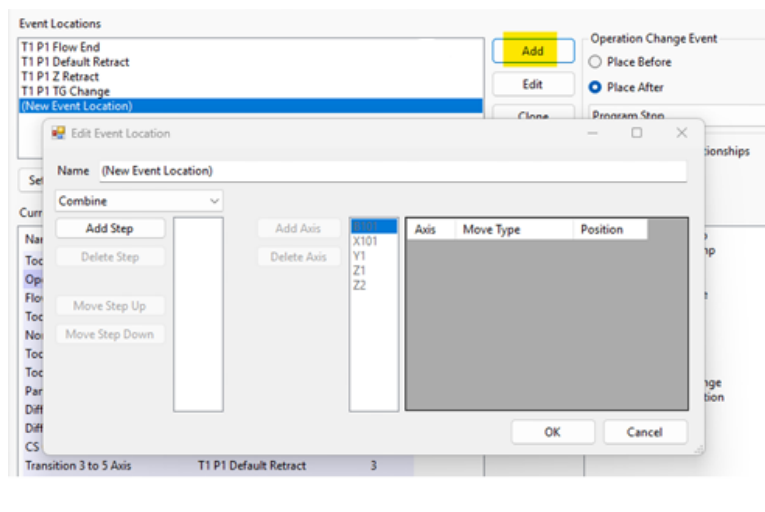
You can now define **Approach** and **Retract** motions in Machine Manager using the updated interface, providing improved access and usability over the previous design.

Where to find it:

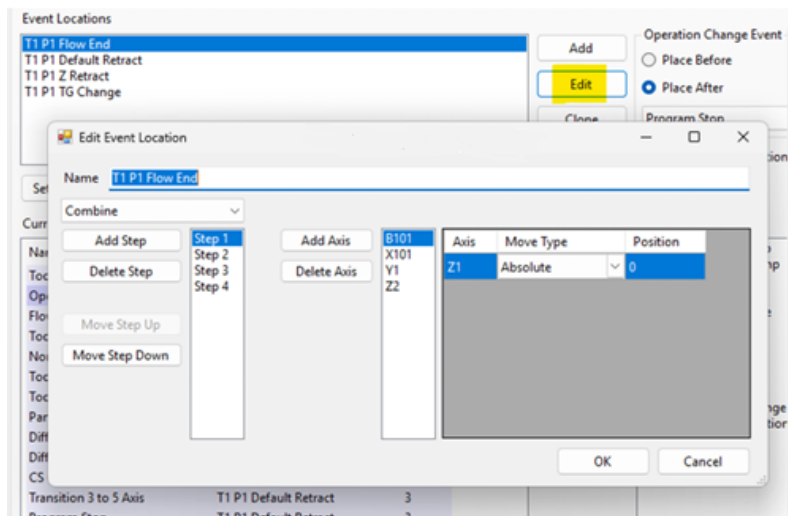
On the **Plugin** Menu(Plugin manager check 'Machinemanager.dll') > Open Machine manager (Under Main Tool section) > Go to **Interop Events** tab > (In this tab UI changes done)



Selecting the Add button creates a New Event Location (Retract move).

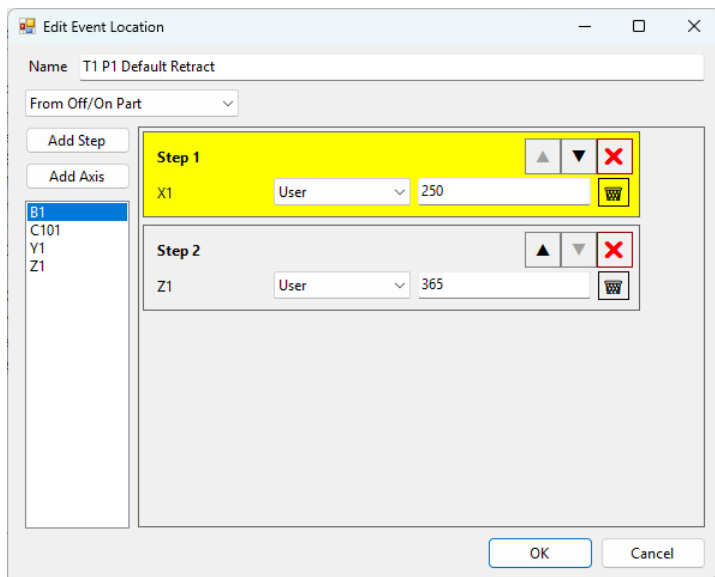


Selecting the **Edit** button, or double-clicking an existing Event Location in the list, opens it for modification. In both cases, the updated interface is launched.

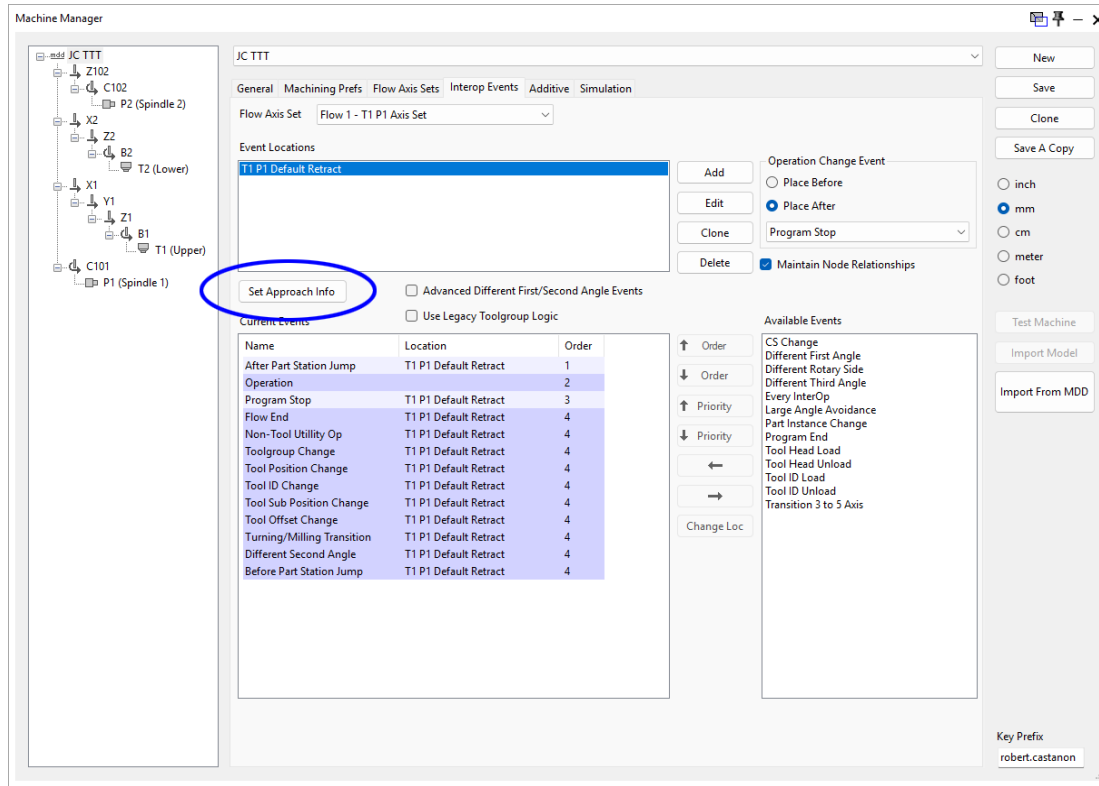


The updated interface allows users to define multiple axis movements within a single Event Location, enhancing the previous limitation of one axis move per Event Location. Users can create steps and associate any available axis with each step. An axis can be added by selecting the Add Axis button or by double-clicking the desired axis label from the list on the left. Once assigned to a step, an axis can be removed using the trash icon adjacent to the axis entry.

Steps define the sequence of motion execution. The order of steps can be modified using the arrow controls located at the top-left of each step group, allowing reordering of movements. An entire step can be removed by selecting the red “X” in the upper-right corner of the step group.

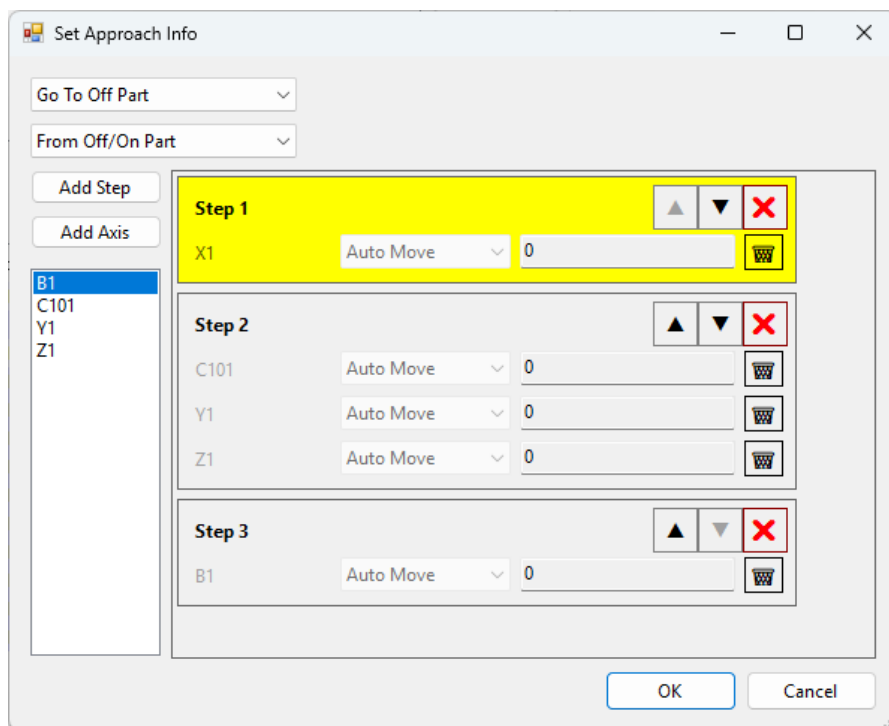


Selecting the **Set Approach Info** button within the Interop Events tab opens a new interface similar to the one described above, with certain constraints applied to interpolation axes.



As shown in the image below, the menu items labeled Auto Move display a value of 0. These fields are disabled and are not user-editable, indicating that the axis belongs to the interpolation set and represents its final occurrence within the sequence of steps.

An interpolation axis may be assigned to any step; however, it remains editable only if it is not the final occurrence. This behavior ensures that control over the last movement of each interpolation axis is maintained by the system. Axes that are not part of the interpolation set can be configured without restriction.

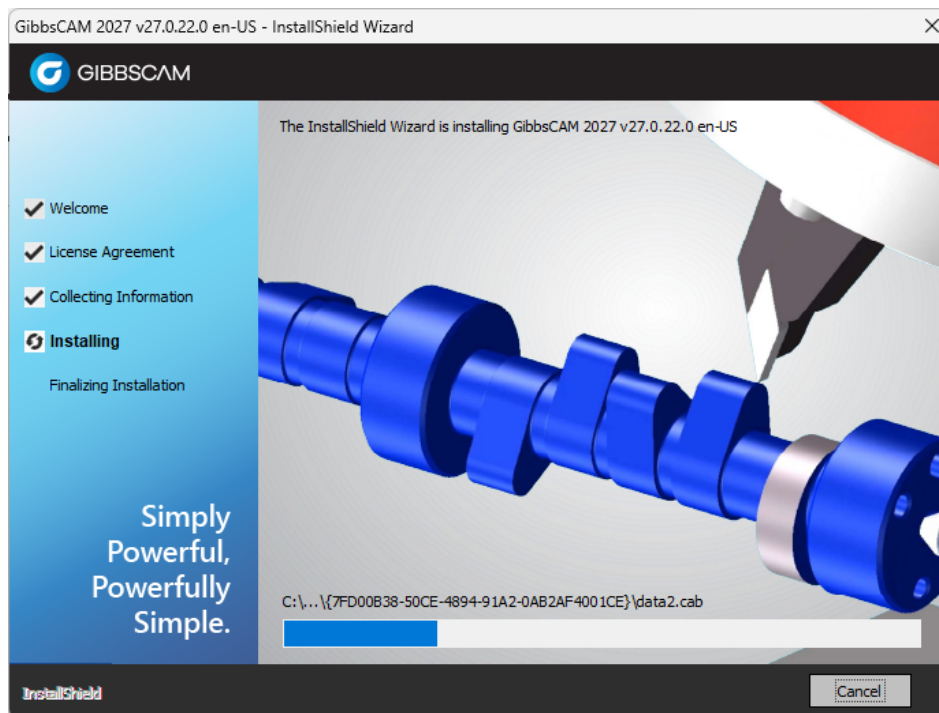


If an invalid axis is defined, a descriptive notification is displayed, guiding the user to the corresponding definition within the interface for correction.

Overall, this enhancement streamlines the definition of approach and retract motions by providing greater flexibility, improved control over axis sequencing, and built-in validation, resulting in a more efficient and reliable workflow.

Update install pictures

The GC2027 installer images have been refreshed with a more modern and relevant look.



This update enhances the overall user experience by providing a more modern and visually engaging installer interface.