

## CG-1 machine Software V6.4 release notes.

### New Features

1. On occasions where the printer controller disk utilisation gets above 90% the printer has been seen to behave in an unpredictable manner. We've added a feature to monitor and report disk utilisation issues so they can be fixed. If the disk warnings are ignored and disk utilisation goes beyond 95% it may require a remote dial in from cleangreen3d support to rectify the issue. This is a temporary measure. We will be adding a feature to automatically manage disk usage in V6.6.
2. We've modified the Low Ink warning behaviour. Previously the machine would pause at 25% and request an ink cartridge change. Now the printer issues a reminder to the user at 25% but pauses at 10%.
3. We've added a gantry calibration item in the set / build plate menu. We've found it can be useful to have for maintenance purposes.
4. We've improved the quality of the firmware used to control Zb movement. This will improve build reliability. It will also eliminate the likelihood of the Build Plate crashing into the Gantry causing damage to the printer.
5. We've seen an incidence where multiple messages on the User Panel can be hidden behind each other and lost causing confusion. The most common occurrence of this appeared to users as a job pause happening for no apparent reason during a build. We've re-written the firmware to eliminate dialogue masking
6. Orange: We've added a feature in the Orange "Service Setup" menu that allows the user to exit "Service Setup Mode" and return to an idle machine. This was only achievable in earlier versions of firmware by a machine re-start.
7. We have added blade life monitoring to the firmware. The knife blade is a consumable item that wears over time and is critical to printer performance. It needs to be replaced periodically. We're not dictating a specific replacement interval as this will vary depending on how the printer is being used. We have added features to allow a printer owner to monitor and manage this activity. 6.4 firmware reports the blade usage in metres of cut length on the job screen and an item has been added to the setup menu to allow the user to reset this value to zero when a blade is replaced.

### Fixes

8. We've amended the paper tear/ paper out dialogue to give clearer instructions.
9. We've added a feature to improve the time to completion estimate given on the active job screen.
10. Orange: We've seen on certain printers where it is possible for a glue wheel to "fall off" the edge of the build mat during the first 3 layers causing a Gantry X-Y Error. We've modified Orange so that support glue is placed in a safer area. To take advantage of this you need to re-build your models using Orange 201129 or later.
11. Orange: We've fixed a bug where a request for the system files in the Service Setup menu would try and fail to take a copy of a file called "async"
12. Orange: We've fixed a bug where Windows installations were failing.

You can download the firmware and Orange releases from our website support page [here](#)