**AcraDyne® SYSREL 1R13**

AcraDyne® is proud to announce the latest improvements and feature additions to our Controlled Tool product platform.

**SYSREL 1R13** is a combination of a new version of our ToolWare™ software package, as well as, improvements to the Spindle Control Code (SCC)/Network Communication(CNC) codes.

**SYSREL 1R13** includes the following updates:

* **Angle Count Management**
	+ Additional selection box added to Parameter Set screen enabling specific selection of when Angle Count is commenced by Parameter Set
	+ Angle Count Reference drop down allow choice of:
		- DEFLT – Parameter will commence angle count as set in Edit Controller Parameters section, sub menu Angle Count Reference and is the global, All Parameters selection
		- THRSH – Parameter will begin Angle Count at desired Threshold Value as set within specific Parameter Set regardless of global setting
		- THRTL – Parameter will begin Angle Count at the press of the Throttle regardless of global setting
* **Restriction of PSET selection by I/O to only Top Level PSET Links**
	+ Restricts the I/O selection of Parameter Sets to parent of links
	+ Does not allow the I/O to select a mid-link PSET. Example..in a Linked PSET of #1, #2 and #3 (only PSET 1 will show active) the I/O cannot command PSET#2 as it is a subset of the Linked PSET #1
* **Backoff Degrees Increased to 30,000 Degrees for Riv Nut Tool Functionality**

**Bug fixes within this release:**

* + Fixed issue with linked Psets not being checked for the torque target out of range of the tool rating.
	+ Fixed issue with speeds not transitioning with linked psets that do not have a time delay between them.
	+ Fixed delay issue with servo velocity gain scheduling timing to reduce drive over current faults (CYC1 FLT512 and CYC1 1024) when in non low speed mode.
	+ Implimented statement to ignore the second trigger input in tools with only a single lever. This was done to block CYC1 FLT64 power on throttle faults if the tool's unconnected second trigger input has mistakenly been calibrated.
	+ Fixed issue with rehit reject and latching throttle, where if a rehit reject occured, the lever would have to be taped twice in order to run again.

AcraDyne® IEC Controllers are now shipping with the new features and benefits of **SYSREL 1R13** on board.

Existing users can take advantage of these exciting new features easily with a field upgrade.

***AcraDyne® iFlash Kit, P/N 25636*** contains a system cable, USB drive with the new Software/Firmware and instructions on how to perform this upgrade on systems currently in use.

ToolWare, as always, is backward compatible with older versions of the IEC controllers. The Spindle Control Card (SCC) firmware is the determining factor of whether a controller is able to handle the feature advancements of **SYREL 1R13**. **SCC code 3.33 is the released version of code with SYSREL 1R13**

**Visit AIMCO’s website,** [**www.aimco-global.com**](http://www.aimco-global.com)**, for the newest version of ToolWare.**

**Simply download it from the Download section of the webpage.**

**For Upgrade of the SCC Code of an existing installed IEC controller, please contact your Authorized AcraDyne Service Representative**