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Printer	Firmware version	Changelog
3DGence ONE	**3.1.4**	1. Security updates.
3DGence INDUSTRY F340	**3.3.5**	1. Improvement of end filament detection function.
	3.3.6	1. Stability improvements. 2. Improvement of the filament flow control function.
	3.3.7	1. Reliability improvements.
3DGence DOUBLE	**1.1.0**	1. Reliability improvements. 2. Wrong file warning added. 3. Improvements in the precision of the temperature reading.
3DGence DOUBLE P255	**1.1.1**	1. Change of the start logo. 2. 3DGence Slicer pause function support. 3. Reliability improvements.
	1.1.2	1. Improvement to the XY offset calibration assistant.
	1.1.3	1. An automatic resume function after a material flow error has been added. 2. Visual and linguistic corrections. 3. Reliability improvements.
	1.1.4	1. Bug fixes and improvements.
	1.2.0	1. Added Quick Start wizard to perform the complete process to configure printer. 2. Change pause position. 3. Reliability improvements.
3DGence INDUSTRY F420	**0.9.0**	1. Added material unloading support by using WLM. 2. Added detection heatbed-hotend collision during manual movement of the heatbed. 3. Added diagnosis of XYZ axis limit switches. Added printer homing error. 4. Improvements regarding the operation of the signal tower and the notification screen. 5. Reliability improvements.
	0.9.5	1. Added support for working with an uninterruptible power supply. 2. New screen for heating and cooling the printer before and after printing. 3. Solves problems with long file names. 4. Fixed touch issues in the slide list. 5. Improved printer behaviour for material shortage events and (FFC) during load and unload wizards. 6. The range of filament chamber working temperatures was limited (OFF, 30, 35, 40, 45, 50, MAX). 7. Protection against overheating of printing modules has been introduced - the chamber temperature limitation depends on the installed printing module: M280 - 120°C, M360 - 180°C, M500 - 110°C. 8. The configuration of the device firmware parameters has been updated. 9. Predefined material loading parameters updated. 10. Limit switch diagnosis added during printer homing. 11. Added end of material detection during wizards "XY Calibration", "Clean Nozzle", "Filament flow monitor".

		12. Improvement of the working chamber temperature control algorithm. 13. Improvement of the axis homing algorithm. 14. Improvement of the display text and coding. 15. Support for chamber fan diagnostics (for compatible devices). 16. Improvement of the network connection (the problem of automatic connection disconnection).
	0.9.6	1. Increasing the safety margin of the X axis motion range.
	0.10.10	1. New font has been introduced. 2. Multi language support has beed added. For the firmware release, printer supports English and Polish translations. 3. Wait for print wizard has been added to the printer. 4. Starting printjob when the file is incomplete (during the download phase) has been locked for now for higher reliability of the system. 5. Automatic printing module change wizard has been added. 6. New 2-phase material loading system has been introduced. 7. New screen for XY offset calibration has been introduced. 8. New notification has been added for Z offset calibration after changing or installing the printing module. 9. New (faster) Z measurement has been implemented when starting printjob. 10. Display of the WiFi connection status has been improved. 11. Minor fixes for WiFi menu (processing speed) have been implemented. 12. Fan Control option has been added in the service menu. 13. Improvement of the stepper motor measurement (steps per mm) for X and Y axes. 14. Full support for closed loop positioning system has been added. 15. XY step count calibration has been added during the startup and printjob starting procedures. 16. Minor fixes for communication diagnostics between different printer systems have been introduced. 17. Filament Flow Rescue count has been limited when material issue is detected during printjob. After 3 attempts of fixing the material issue (in short period of used material) the printer will pause the job and wait for operator to inspect the issue manually. This limitation is introduced to remove risk of unloading large quantities of materials to the purge bin. 18. The amount of homing moves has been minimised. 19. Status bar for cooling phase has been added after print is aborted manually. 20. Minor efficiency update to material data sent to cloud. 21. During printer startup sequence, the front door will open automatically when open upper cover is detected. 22. Status for Missing printing module has been added to signal tower function list. 23. Full hardware and software support for E-Stop (emergency stop switch) has been added. 24. File downloading resume system has been added to 3DGence Cloud. **ADDITIONAL NOTES:** - To assure proper operation of the printer, it is required to update 3DGence Slicer to the newest version – 2.2.3.

		- 3DGence Cloud and the printer have been upgraded to new communication protocols. For proper operation, please update your printer to the newest firmware version available (0.10.10).
	0.11.0	1. Reliability improvements.
3DGence INDUSTRY F420 **3DGence INDUSTRY F350**	**1.0.0**	1. Added new „quick pause" function where pressing pause button in the middle of the print, stops it almost immediately. This also applies to all print quality related wizards like flow fail monitor or material end detection, allowing printer to react instantly to any potential errors. 2. Added XY dynamic position calibration. After updating the software, the printer signals the necessity to run the Offset Z wizard. During this process, the printer will analyse its behaviour during XY movement and create offset chart used to dynamically adjust XY gantry position. 3. Ethernet driver has been updated to improve stability of internet connection with the printer. 4. New improved method of analysing Z offset, which greatly improves measurement precision. 5. Temperature control during automatic wizards has been improved. 6. Material loading and unloading wizards have been improved for higher stability and process effectiveness. 7. Lists of non-certified materials has been updated for all printing modules.
	1.0.2	1. Reliability improvements.
3DGence INDUSTRY F420 **3DGence INDUSTRY F350**	**1.0.5**	1. Module cooling system diagnostic has been implemented. Before each print, the printer will run short diagnostic procedure on the module cooling system to assure operation safety and to check if nominal working parameters are maintained. 2. New USB driver has been introduced. New driver allows for quicker loading times when flash storage is detected. 3. New "E" error coding system has been implemented to assure that future new error codes will not affect the value of existing ones. 4. Reliability improvements.
3DGence INDUSTRY F420 **3DGence INDUSTRY F350**	**1.0.6**	1. To improve quality and reliability of the calibration process, we introduced new way of nozzle Z-offset measurement. Z offset calibration is performed before each print. 2. Remote print pause has been enabled in the 3DGence Cloud system. 3. Improved algorithm of the printer stopping and starting process after activating the emergency STOP button. 4. Message added when user tries to clean nozzles without loaded active materials. 5. Reliability improvements.