

AP100US v2014.1.02 Update & Release Notes



Thank you for purchasing Amada's AP100US! These release notes outline the new features or changes in the latest version of the software as well as information regarding updating to the current version. These modifications are in response to customer feedback. The AP100US CAD/CAM System is licensed software, and cannot be freely distributed. Please read the license agreement that accompanies the software.

AP100US now supports SDDJ v3.6 and SDDJ v5.1.

Important

Cumulative patches described herein are only for the AP100US version indicated! The patches fix various problems and add the enhancements outlined in this document. This most recent patch for 2014 is NOT intended to upgrade 2013.x or earlier versions. ***You will render earlier software versions inoperable if you attempt to use more recent patches!***

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System Requirements

Hardware	Description
CPU	Intel® or AMD Athlon™ dual-core processor, 2.0 GHz or higher.
Memory	4 GB of RAM (8 GB or more recommended).
Hard Disk	1 GB of free hard disk space.
DVD DRIVE	A DVD drive is required for installation.
Video Display	1,024 x 768 display resolution with true color (1,600 x 1,050 with true color recommended).
Browser	Microsoft® Internet Explorer® 7.0 or later web browser.
Protection Block	You must install the protection block before operating the software.
Pointing Device	Serial or USB mouse with wheel button.

Software	Description
Operating System (32 / 64 bit supp.)	Microsoft® Windows® 7 & 8, Ultimate, Professional, or Home Premium.
Sentinel Driver	You must install the Sentinel Driver (v7.5 and above) before you can install the CAD/CAM System or optional software packages.
Network Installation	For a network installation, the server computer must be running the server versions of Windows 2003, 2008 or 2012. It may also be necessary to update the Sentinel Driver on the server computer.
Supported Software	SolidWorks® 2014, SolidEdge® ST6, AutoCAD® 2015, Autodesk® Inventor 2015, Pro/E® WildFire5. Note: If both SolidWorks® and SolidEdge® are installed on the same system, an OLE integration conflict may occur.

Post-Release Enhancements – v2014.1.02

1. Auto Split

Create a checkbox and icon in the CAD/CAM UI for all the parameters in the "AutoSplitHole.ini" file.

2. Cutting Feature

Add another option to control whether the Microjoint should remove the slug destroy or not.

Post-Release Enhancements – v2014.1

1. Split Sheet Setting & Straight Edge Common Cut

Improve Split Sheet Settings by adding Between Parts field to control the distance between split cut and part boundary, and Bottom/Left Edge and Top/Right Edge to control Over/Under cut. Included is the Straight Edge Common Cut option, which cuts notches, inner holes and common cuts, before cutting part boundary.

NEW FEATURES v2014

1. Stacking Table Placement Control

This function gives the user precise control over where unloaded parts are placed on the stacking table. For specified Amada machines a separate interface now launches for this operation.

2. 3D Simulation of Part Remover Robot

This new module gives the user an accurate simulation of a fully automated part removal operation.

3. Arm Edit Assignment Zoom-in

When editing TK/PR the user can double-click a part to zoom in, allowing a more precise view of the TK arm in relation to a specific part.

4. Manual Perimeter Notch Relief function

This function allows the user to place additional cuts along the border of a part to free up areas that can "catch" and prevent the automation arm from successfully removing the part from the sheet during unloading.

5. U-V and Common Cutting Available for F1-TK and PSR

For certain Amada automation systems such as F1-TK and the PSR robot part unloading occurs AFTER sheet processing, meaning that Common Cutting and U-V macros can be used.

6. "View SY2" Added to NC Functions Group

The "View SY2" button enables the user to easily see an editable SY2 (Part Remover) code in the Cut Sequence, Punch Sequence and Modules menus. SY2 files (used only with Amada PR and TK machines) are auto-generated when the NC file is made.

7. Independent Arm Movement Support

This feature allows the Unloader Arms to be moved together or independently by using simple mouse clicks.

8. Split Sheet

With this option the user can have the sheet cut into smaller sections in the X/Y directions for easier handling while unloading.

9. Split Hole

Split Hole allows the user to cut internal slugs into smaller sections in the X/Y directions to allow them to fall through the slats of the shuttle table.

10. Import CSV file for PDC & ATC Storage

To support full automation, FabriWINAP100US now allows the user to import a CSV file, which will be synced with the tool list in PDC or ATC Storage - manually placing tools in one of these storage areas is no longer necessary.

11. Auto Fence Tool Assignment

This function allows the user to select shapes and patterns in a closed-boundary area that will be the target for Auto Tool Assignment.

12. Tool Assignment by Layer

Now the user can assign various behaviors/characteristics (such as etching) to CAD elements that exist on a certain layer in a DXF/DWG file.

13. Launch a .SHT file by Double-clicking

Double-clicking a sheet file will open it in the CAD/CAM work area.

14. Part Search by Tool

The user is able to search through the Parts folder for parts that use a specific tool (standard or Special).

15. Auto-Save / Auto-Recover

The CAD/CAM program can Auto-save at intervals set by the user. If the system should fail by default the last Auto-save folder is used to Auto-recover files.

16. Restore Packed Files

Zip files auto-saved to the SupportFiles folder in the CAD/CAM installed folder can be accessed by the user to restore a project, or these files can be shared with other programmers.

17. Create & Save Reusable Part Groups and Kits with Part Grouping

The Group Part options allow the user to create & save editable part groups and kits that can be easily placed into sheets for later use.

18. Part-by-Part Common Cut with Microjoint Placement

The system can be set to cut internal patterns and common cuts at the same time. Also, microjoints can be added to common cut paths.

19. Independent Nesting Clearance Support for Two Axes

Improved nesting logic control for horizontal and vertical distances between parts and sheet split function in Sheet Wizard.

20. Independent Tool Removal for Cut and Punch

Controlled removal of cut and punch tools on combo machines is improved – both can be removed together or separately.

21. Intelligent Synchronization of Cut Start Point and Microjoint

The cutting Start Point and Microjoint location can now be synchronized, resulting in a cleaner edge and fewer redundant start points.

22. Flash Cut Support

Flash cutting functions have been added for Amada Fiber cutting machines such as the FOL-AJ, FLC-AJ and LCG-AJ. (This driver-dependent option is enabled/disabled in the Material Files>CNC Code panel.)

23. Improved integration with FabriSIM for Amada machines

FabriSIM synchronizes machine and material to FabriWINAP100US. See FabriSIM documentation in the CAD/CAM installed folder for info.

24. Notch Cut Out option in the Cut Sequence Menu

This option allows the user to easily add an extra cut to a cut sequence, in order to cut out a perimeter notch that may hinder the part remover.

25. Disable Check Thickness for Single Hit

When this box is checked ON, the program will NOT check the thickness of the sheet or compare it with the dimension of the tool when auto tooling.

Post-Release Enhancements – v2013.05

1. Time Estimate

A time estimate for G136 and G137 has been added to the Runtime Details / Time Information dialog.

2. Machine Info

Support has been added for the Edit Condition Table in the Machine Setting>Run Time Estimate window.

3. Material Info

Support for the JKMX format for a cutting condition file has been added.

4. Material Info

A CSV/XLS file imported in the Job Wizard will now be able to capture the preferred material file.

NEW FEATURES v2013

1. Windows-style Ribbon Interface

The new Ribbon Style interface displays all possible options (in a selected tab) at one time. Users will then be able to see other possible ways for completing tasks that can speed up the CAD/CAM process.

2. The “Use Subs” checkbox is now available in the Tool Only Sequence dialog

The user can now toggle the “Use Subs” checkbox in the Tool Only Sequence dialog (Grid in X or Y radio buttons exist.). Previously this option was found only in the Tool Sequence Priority window.

3. Custom Nibble Pitch for tools has been added

The CAD/CAM system now supports a unique nibble pitch for each tool.

4. Improved Tool Deadzone values display

Tool Deadzone values now display in the Tool Information and Station Tool Information dialogs.

5. Double-click on a PRT file to open it in the CAD/CAM system

Now, even if a PRT file is in Windows Explorer, in another folder, or on the desktop, it can be double-clicked to have the CAD/CAM system automatically launch with that file loaded.

6. Lengthen Lead-In to split cutouts in half

This new functionality allows the software to split oversized cutouts in half, so they can easily drop between the workchute rollers (typically for Alpha and Pulsar laser machines).

7. Punch parts can now retain tooling when rotated

The CAD/CAM system now allows parts to keep tooling when rotated by changing the angle of the tool(s) in the turret.

8. Open Part and Sheet windows now have search filter functions

A search filter has been included in the Open Part and Sheet windows, allowing the user to configure and implement a filtered search.

9. License Manager update enhancement

The Network Client Server License Manager logic has been enhanced to require that the detection interval time value must be set to more than 15 seconds.

10. FabriSIM / Sheet Wizard integration enhancement

The user is now able to create or modify the mapping between the CAD/CAM program Sheet Wizard interface and the FabriSIM Simulation program.

11. Improved SolidWorks Assign SP Tool Module

The SolidWorks SP Tool module now allows the user to export a native SolidWorks (flattened) part into formats useful for Amada CAD/CAM systems (BMF, IGA and PRT).

12. Link Design Library items to a specific tool

In 2013 the user can link Library Design items to a specific tool in the Tool Inventory.

13. Sequence Numbers display improvement

If the part/sheet has many patterns, it becomes cluttered with sequence numbers. This is vastly improved because the system now only displays 1 number for each closed or open loop.

14. Optimize Start Points

A new function changes the start points on a part to optimize machine head travel.

15. Clear Sheet Function

Clear Sheet allows the user to quickly delete all the parts and patterns from the sheet, while retaining machine/tool inventory files already loaded into the sheet.

16. Control Part Gridding in Nesting Logic Enhancement

The Common Punch/Cut function now allows selections for X and Y direction grid nesting.

17. Common Punch / Cut by Part option within Job Wizard

The Job Wizard now contains settings that enable a per-part common line cut function.

18. Microjoint Tool Ready List

2013 has the capability to have more than one microjoint tool at various angles in the turret; when parts rotate on a sheet, the system can automatically choose a different tool.

19. Support Pin Analysis Improvement

This option will show parts in the nested sheet that have a likely chance of tilting, which may cause a collision with the cutting head.

20. Non-existent Special tools in the Tool Inventory view are disabled

When assigning Special Tools to a part from Tool Inventory, any Special Tools from the Tool List which do not have an *.SPT file in the Special Tool folder are grayed-out.

21. Contacting the Amada Support Center is greatly simplified

When the user encounters difficulty, he can easily send the files in question to the Amada Support Center for analysis. In addition, calling the Amada Call Center can be done through the CAD/CAM user interface.

22. Generate Schedule for AMNC-IT from the Nesting module interface

The Schedule output from the Job Wizard / Intellinest or SheetWizard can be automatically stored into SDDJ or to a file, so it can be used by the AMNC-IT.

Post-Release Enhancements – v2011.02

Renumber Apps

1. 32 bit and 64 bit Support

The Renumber utility now supports both 32bit and 64bit operating systems.

2. Obtain Correct Nisshinbo NC Code

If the driver has been updated, the user can obtain the correct Nisshinbo NC code by using the “Generate NC” feature in AP100US.

Post-Release Enhancements – v2011.01

TK/PR/III Unloading

1. Implement Rotating Arms

Add an additional function to allow the user to rotate the arms of TK Unloader, so as to specify the location of arms on the parts more conveniently.

2. Check Arm Traveling Range

Before AP100US would not check the Y traveling range for the arms when picking up a part. Now the user can specify the vertical maximum over travel for the arms to ensure the arms are within the specified Y traveling range.

3. Enhance Auto Unloader

There will be a new option added in the Sequence Info dialog called “Auto Unloader”. This option instructs the system to implement unloading parts automatically when the user executes “Auto Sequence” command in the Cutting Sequence or Punching Sequence menus.

4. Parts Stacking

Two different layout methods (Sheet/Stack) after auto unloading must be supported. The new “Layout” item is added in the TK/PRIII Information dialog.

In the “Sheet” layout method, the parts layout on the storage table is the same as on the sheet after auto unloading. With the “Stack” layout method, the same parts with the same angle on the sheet will be piled together within “Max Storage Height” limits after auto unloading.

5. Shift Before Moving Parts (only for punch machine)

To prevent the PRIII from colliding with the turret when it removes parts, the system will shift the sheet before PRIII picks up parts. The user specifies the shifting distance and a corresponding trace line will be shown to sign the shift distance after unload.

6. SY2 View

There will be a new item added in TK Unloading or PRIII Unloading sub-menu called “View SY2” to let the user view SY2 files after unloading parts, which is only available after generating NC code.

7. Sensor Cups

There is information listed in the TK/PRIII information dialog called Sensor Cup to let the user define which cup(s) is a sensor cup. A new symbol is designed for the sensor cup. At least one sensor cup should be on the part while picking up a part.

Punch Die Changer (PDC)

1. Support for Combo Machines

Earlier versions of PDC only supported punch machines. Now PDC supports combination machines as well.

Fine Finish Cut (FFC)

1. Second to Last Cut

An indication flag, which passes special NC code output to the driver, for the second to last cut has been implemented.

Limitations: (1) FFC is only for closed boundaries; open boundaries don't have FFC. (2) Having a lead-in, but not a lead-out is recommended. (3) The user should set the OUTPUT AMNCF HEADER to 1 in the CNC table when generating NC code, otherwise the NC code won't match the patterns.

NEW FEATURES v2011

1. Job Wizard

The Amada Job Wizard has been added to 2011. A powerful module that combines nesting, job scheduling and remnant tracking, Job Wizard is a cost-effective alternative to purchasing third-party nesting systems.

2. Run Time Estimate

The Run Time Estimate for an individual part and for that same part on a sheet is now viewable in the Part and Sheet Information dialogs. In addition, parts and sheets can now be saved with Run Time Estimate information.

3. 32 or 64 bit System Support

To solve compatibility issues arising from the latest hardware releases, the CAD/CAM program has been enhanced to support 64-bit systems. During installation the user can select the 32 or 64 bit version.

4. Enhanced Special Tool Assignment when using OLE with SolidWorks

CAD/CAM tool inventories can be assigned from the SolidWorks UI by clicking the Assign SP Tool button. This add-in module allows tools from a job shop inventory to be embedded.

5. Spline Pattern Processing Improvement

Spline Pattern Processing allows imported dxf/dwg files containing complicated splines to be stably converted into prt files in the CAD/CAM program. In addition to conversion, this feature may reduce processing time.

6. Template Report Design Enhancement

Working in conjunction with the new Job Wizard, template part and sheet reports can now be configured to display WO Number, Router Number and Estimated Run Time variables. These new fields allow data to be shared more easily.

7. Increased License Manager Protection Options

The License Manager allows an administrator to control license monitoring at the license server, conveniently controlling usage of license resources.

FIXED ISSUES - v2014.1.02

Cut Sequence

1. A sequence that is added while in Part View should also display when the user switches to Sheet View, and enables Area Cut Sequence.

Hot Key

2. The part will be deselected when user hits the "Save As" Hot Key.

Microjoint

3. User should be able to setup only one Microjoint on the perimeter.

Nesting

4. NC Popup option that is available in Sheet Wizard should also be available in Job Wizard.

OLE

5. The OLE shape is reversing after a bend assignment.

6. When trying to use AP100USCAD v2013 or v2014 to OLE from SolidWorks v16 the OLE fails; even with the transfcad.dll registered-error the SolidWorks application does not start.

7. User must check after install/update/online update, that the add-in dll files are correctly placed and registered.

Punch Sequence

8. A Refresh issue exists when deleting a pattern on the sheet; the sequence still shows on the sheet but the pattern has been deleted.

Preferences

9. The Parm folder does not focus on the selected folder after changing to another.

10. Interface Style was previously saved in the system registry, which caused instability.

Report

11. The sheet run time is not output in the sheet layout report.

Split Sheet

12. The vertical split cut result is not correct when the sheet's right side is out of range.

Tool Assign

13. Cannot assign auto tooling to all patterns.

Tool Info

14. The Number of hits should display when inquiring tool info. for a standard pattern.

Toolbar

15. Odd looking toolbar in BCG version.

Tool Assignment

16. When assigning a Special tool from the inventory based on the angle of the tool, the tool is not detected based on the keyed angle in the station.
17. Cannot auto assign a Special tool to exploded patterns.

Unload

18. A part with a negative Microjoint should be allowed to unload.
19. It's too difficult to focus in on a specific part nested in the Sheet Wizard, when editing the Arm.
20. The Leadin angle changes to 45 degrees when editing the arm.
21. Auto Detect doesn't work correctly in an LCC1 machine.

AP100USCAD

22. Enable the SDDJ material setting in AP100USCAD for bending.

FIXED ISSUES - v2014.1

Cutting Feature

1. The microjoint priority should be higher than the over-cut when they are on the same side.

Cutting Sequence

2. The subroutine uses a G93 to recall each part after a UV macro; this is impractical when using auto sequence for a grid of parts because it generates excess code.
3. The spacebar/right click does not work well for overlapping parts when adding a sequence.

Job Wizard

4. The sheet will disappear after reversing a job in Job Wizard.

NC Code

5. When the percentage of a condition node is set to "0", then the node condition should execute before piercing.

Punch Sequence

6. The Special Tool Sequence is not showing on the Sheet.
7. The system crashes when adding a sequence to the pattern on the sheet.

Ribbon

8. Add a switch to allow the customer to disable Auto Switch mode in the Ribbon UI.

Sequence

9. The tool sequence with Subs and Macro on, is randomly dropping the sequence of some tools when decreasing or increasing the Grid amount in X & Y.

Sheet Wizard

10. If the pierce location is not set in material, when nesting the included features/leads do not work and the lead-ins interfere with other parts.
11. The rotate step angle is incorrect when compared with the setting value in nesting.

Tolerance Setting

12. The Tolerance Setting dialog can't be moved; it's always in the upper right corner.

User Interface

13. Click on an internal pattern to place a microjoint and then use the wheel to zoom in, the microjoint marker jumps to the part boundary.

FIXED ISSUES - v2013.05

Job Wizard

1. When nesting parts in the Sheet Wizard or Job Wizard, an overlap on some part instances may occur.

Machine Info

2. When Unit is set to millimeter, the Connect Tolerance value in Machine Info is not consistent with the Joint Tolerance value in Preferences.

Punch Features

3. The punch condition for tools should remain in the turret after clearing a sheet.
4. When saving a part with a microjoint tool and then re-launching the part, the MJ tool is lost.
5. Set the keyed angle for the microjoint tool, apply/manually place the mj to inner hole patterns and the mj tool cannot be assigned.

Punch Sequence

6. The sheet will double hit a common punch when Macro is ON.

Sequence Features – Add Microjoint

7. When placing a microjoint, then using the mouse wheel to zoom in, the MJ marker jumps to a different pattern than the one originally selected.

Sheet Operation

8. The space bar toggle between parts that overlap doesn't function.

Sheet Wizard

9. When nesting and using Common Punch in the nesting, between parts in different grids common punch occurs.

10. The Sheet Wizard won't nest all parts when the order of nesting is changed.

Tool Assignment

11. FabriWIN is case sensitive to name changes for SPT files; if the case of an SPT file name is changed, the part is grayed out.

12. The Dimension column for a special tool is empty when exporting a tool list as an xls file.

View Menu

13. When using the "Unfold" command in SolidWorks, the radius bend relief disappears and a "break" or "tear" appears in its place.

User Interface

14. The patterns flicker and turn odd colors as the mouse is moved over the sheet.

FIXED ISSUES - v2013.04

Various Reports

1. Tool Comment does not appear in the Template Report.

Punch Sequence

2. The Subroutine doesn't work after hitting "Undo" during the creation of a Subroutine.

Tool Assignment

3. If the user selects a tool from the list of tools assigned, and then clicks on Assign, the tool is not attached to the cursor.

4. A value entered to control the number of hits on an Arc using an OB tool is not accurately controlled by the software.

5. If the user enables the Nibble setting while assigning a tool, that tool is removed from the cursor.

FIXED ISSUES - v2013.03

Cutting Feature

1. The Split Cutouts sequence is incorrect when "Start Point Optimization" is checked on in the Machine Setting dialog.

2. When Cutout Avoid is on, there should not be Cutout Avoid travel lines between the patterns with split cutouts.

Dimensioning

3. Incorrect dimensions display when "Bump Check On" is selected.

Install Shield

4. The AP100US installation process closes if an open instance of the same program is closed by the user.

5. The Ready-only property for the AP100US folder is checked on during online update, not allowing the user to update.

Installation

6. Transfadd.dll cannot be registered when using the 2013.02 patch to update AP100US from a 32bit version to 64bit.

Input/Output (I/O)

7. The system will create two parts when a .dxf or .dwg file is dragged into the AP100US interface.

Machine Setting

8. The *.dat Cutting Condition file type is not supported and should be added to the Files of Type field.

OLE

9. Inventor part drops outside lines after OLE.

Punch Sequence/Cutting Sequence

10. The system should only take into consideration the overtravel when adding a sequence (and not consider the sheet size).

Runtime

11. Runtime should support FOL and FOL-AJ machines.

Tool Assignment

12. The inquired tool should be assigned to a pattern after inquire and assign are performed.

13. When a user loads an inventory and assigns a tool (especially if there are thousands of special tools in the server), the speed is slow.

TK/PR

14. The HPTK machine should support stacking function.

View Menu

15. Move the position of the Tolerance Settings dialog into the Dimension Ribbon.

FIXED ISSUES - v2013.02

AP100/SDDJ

1. The Die Clearances value in the UTL (Used Tool List) file is incorrect.
2. The material value is incorrect when saving SDDJ material in metrics into AP100US.
3. The Part Size value is incorrect in the SDDJ database layout diagram.

Bump Check

4. The Bump Value is not accurate if multiple parts are selected and Bump Check is enabled.

Cutting Sequence

5. Standard Cut Holes sequence after the perimeter when the Etch line is close to the perimeter.
6. AP100US cuts one boundary first, then cuts the internal etch pattern, and finally cuts the left boundary.
7. The system should not sequence a part which is outside of the sheet, but only inside of the overtravel.
8. Split Cutout is still not active in the Start Cut attribute dialog in 2013.01.
9. The entire circle of the arc on the right side is cut, instead of just the visible arc.
10. If the part has been sequenced in Part View, then insert sequence doesn't function in Sheet View.

Cutting Features

11. When using a pre-punch tool as the default, the system does not remove the punch for a rectangle feature smaller than the pre-punch diameter.
12. The Process All Parts option is enabled only when Process all Parts Common Cutting has been done after ungridding.
13. If a hole has a split cutout and the part is rotated in the sheet, the lead-in for the cutout does not rotate with the part.

Time Estimate

14. The runtime for the subroutine sheet is not the same as in a real machine.

Input/Output (I/O)

15. When the *.dxf file is loaded into AP100US and there are points on the boundary, the program recognizes it as an open part.
16. An *.iga file with a small arc/line on the boundary loaded into AP100US cannot be saved, and the prompt will not close.
17. In the Ribbon UI, as the user typed, the keyboard was dropping some entries.
18. When accessing the CAD Editor from DR_ABE while using AP100US or US CAD, the program would crash.
19. After the part file has been saved using the Save command, the program prompts one more time to confirm the save.

Inventor

20. The customer wants to OLE from Inventor, picking up both hole sizes on the two faces, which will be passed to AP100US.
21. The program freezes when using Open & OLE for an IPT file through SolidWorks.

Job Wizard

22. The Machine and Material lists in the Job Wizard Part Information dialog are very narrow, making it difficult to show lengthy names over 25 characters.

Material Info

23. The Split Cutout value incorrectly displays metric units in the Lead In and Lead Out > Split Cutouts panel.

NC Code Generation

24. The renumber result is incorrect, as it should rearrange the NC code sequence.
25. When clicking the NC command to see the pattern sequence (in the drawing area and SheetWizard), the part selection highlight on the sheet remains.

Punch Sequence

26. In a punching machine, when the Last AI option is checked, and the angle is set to 0° or 90° , the tool will punch twice.
27. The program adds an extra G98 for the special tool, requiring the user to edit the code to remove the extra G98.
28. Manually sequencing smaller parts inside a larger part is difficult because they cannot easily be selected.
29. A microjoint tool should not double hit on the sheet when the Double Hits On option is unchecked.

PDC

30. When clicking on the Place Tool Hit option, the tool list may randomly show "Turret" , "Tool Inventory" or "PDC Storage".

Part Info

31. Product information tab in the Part Info dialog does not display the upper line.
32. In a punch/cutting machine, after drawing a group pattern, auto sequencing and opening the Part Info Production Info tab to view the part, the group pattern sequences on the patterns disappear.

Sheet Wizard

33. The default status for common cutting in the SheetWizard should be "No" when dragging in more than one part.
34. The "Include Features/Lead" setting doesn't work during nesting in the Job Wizard and SheetWizard.
35. A dxf file cannot be saved successfully in the Sheet Wizard part edit mode.
36. In the SheetWizard, when nesting the part will overlap and rotate over an adjacent part or off the sheet.
37. In SheetWizard, the system will save a part that being edited even if it has an error.
38. Load a part with an Open Boundary into the SheetWizard and it shows an open boundary Status. After resetting the Connect Tol in the Machine Setting>Sheet Layout tab and reopening the SheetWizard the status of the part should update but does not.

SolidWorks

39. A sheet metal part created in SolidWorks using "Centerpoint Arc," when OLE'd to AP100US, will cause an error message to display.

Split Sheet

40. The Split Sheet option will cut through a part on the sheet.

Tool Assignment

41. An SP tool can't be correctly assigned to some angles.
42. The SP tool can't be assigned correctly when Nibble pitch is checked on.

ULX/Unloader

43. No message dialog displays to remind the user that microjoints on parts must be processed (removed) first before unloading.
44. The X offset value doesn't take effect immediately when editing the arm; the arm must be moved so that the value will take effect.
45. When users change Cutting is Divided settings, no warning dialog displays to remind them to clear final cut settings.

FIXED ISSUES - v2013.01

BendCAM

1. The V-Width value still displays in inches while all other values are in metric after DDE from AP100US to BendCAM.

Cutting Feature

1. If a pattern has a split cutout, the Start Cut Attribute selection mode should function like the end attribution.
2. When editing the Start Cut Attribute by setting Output Macro to Yes (in the property window), the setting will not remain.
3. Adding a Microjoint will reset the changed start/end cut attribute.

Cutting Sequence

1. An additional sequence appears after undoing subroutines and then selecting auto sequence.
2. The lead in is wrong when changing the cut direction to CCW for obrounds and polygons inside.
3. Over/Under Cut value for lead out can't be saved with the sheet/part.

Dimensioning

1. Comment/label which is saved with the part/sheet will disappear after reopening the part/sheet.

Estimated Time

1. Keeping cutting options displayed for the punch machine is confusing for the customer and Call Center staff.

FabriSIM

1. The "To NC simulate" button should be disabled in part view.

Go To Assistance

1. Using the Pack Up Files option does not include special tools which are assigned as Microjoint tools.
2. The quotation marks in the e-mail address should be removed when sending an email to support using "Pack Up Files".

Input/Output (I/O)

1. The system crashes when dragging a dxf file into the CAD/CAM program with a cutting/combo machine.
2. Saving a part file the first time should display a standard Windows Save As dialog box with a default name entered.
3. The DXF file name should be used as the default name when saving the part from a dxf file.
4. While in an active folder that doesn't contain a PRT file, then selecting Find, the system will crash.

Job Wizard

1. Job Wizard will crash when nesting multiple parts. This behavior has been eliminated.
2. The Available sheet number is incorrect after reversing the nested sheet and over-committing the material.
3. The same material type with different thicknesses can't be loaded into Job Wizard through "Open XLS/CSV/TXT".

Material Info

1. The Material value differs in the Material and Select Material Type dialogs.

PDC

1. The Inch die clearance value still shows in PDC storage when the units are set to Millimeter for a PDC machine.
2. "From Turret" should be changed to "From PDC Storage" under the Tool Assign menu for a PDC machine.

Preferences

1. MM units display is incorrect for the Job Wizard material thickness.

Ribbon UI

1. The AP100US ribbon screen is not maximized after launching.
2. The workspace button in the Quick Access toolbar should keep the previous status after re-launching AP100US.
3. The Quick Access tool bar will not stay docked below after re-launching AP100US in the ribbon UI.
4. User can't assign another function to the default hot keys in the ribbon UI.
5. The Output window at the bottom does not remain in a set size after restarting CAD/CAM in the ribbon mode.
6. Pin Button in the Right Side Property Box does not remain in set position after restarting CAD/CAM in the ribbon mode.

Sheet Wizard

1. The customer part overlaps after nesting in Sheet Wizard.
2. When rotating a fairly simple part Sheet Wizard completely drops a tool off of a corner notch.

SolidWorks

1. OLE: The attached file with Japanese info cannot unfold correctly when OLE in AP100US.

Tool Assignment

1. Special Tool with a Rectangle symmetrical setting does not support 90 and 270 in NC code.
2. OB and RE tools cannot assign proper overlap or pitch to large Arcs.
3. AP100US will not automatically put the MJ tools (using Special Tools) on each side.
4. The Scallop Height and Overlap are disabled in the Tool Info dialog when inquiring a tool on a standard pattern.
5. When a part is rotated the Microjoint tool does not rotate with the part even if the MJ tool is in an auto station.
6. The angle of Microjoint tool is incorrect after rotating the part and re-assigning the tool.

FIXED ISSUES - v2011.03

Cutting

1. A double path appears where Microjoint and Start Point are on the Arc of both OB and Slot.
2. An "unwanted" cut shows on the sheet after loading the sheet file and viewing the sequence on a combo machine.
3. The cutting path is not correct after changing the tab.

Input/Output (I/O)

1. AP100US crashes after deleting text and saving a file.

InstallShield

1. A switch for a clean environment has been added if the customer has radan.key on the supplemental disk.

Job Wizard

1. An error message displays when batch loading dxf/dwg/igs files in Job Wizard.

Material Info

1. A message displays to remind the user when the pre-punch tool can't be assigned to the pattern in manual assignment.

OLE

1. When using the OLE function, some random lines are imported when OLE is used on the Inventor Model.

Punch Sequence

1. FabriBend should launch when sending the Flat Layout through DDE in AP100US.
2. The X-Axis Control One Tool Sequence is incorrect when assigning a tool to an arc.
3. An error message displays when adding an "unload sheet" special sequence in AP100US 64bit.
4. Patterns cannot be auto sequenced when adding "control one tool sequence" to them after undoing the sequence.

Sheet Operation

1. AP100US will not allow the cursor to immediately snap to the third clamp, as it does on the first and second clamp on the sheet.

Sheet Wizard

1. The Sheet Wizard prompt to overwrite an existing job name should check for the same name like Job Wizard.

TK/PR

1. For TK, when the arms locate on the 90 degree part with same angle (90 degrees), the unloading job will fail.

Tool Assignment

1. A Special tool can't nibble on a 360 degree arc.

FIXED ISSUES - v2011.02

Edit

1. AP100US stops working after deleting some small line segments and then going to the next command.

Installation

1. AP100US must make the installer force the Java 1.2 module to run, in order to support Pro-E OLE.

Job Wizard/Sheet Wizard

1. Job Wizard and Sheet Wizard are not rotating parts when nesting.

Job Wizard

1. Job Wizard always locks into one sheet size even if multiple sheets are selected when nesting.

Material

1. The default material file is not being reloaded into the system when the Sheet Info Dialog appears on New Sheet command.

Part Info

1. The customer's name can't be saved with the part file.

Renumber App

1. The Renumber App can't be used on a 64bit OS; a warning message displays asking the user to contact support for 64 bit.

Sequence Feature

1. The system crashes when using the "Start Cut Attribute" command.
2. The corner radius is incorrect after entering a small radius corner value.

Sheet Wizard

1. The report remains in XML format even though PDF has been selected when generating a report to be included in the NC file.

NC Output with PDF File

1. The program name displays as “.nc” when generating a Multiple Sheets Report in AP100US.

Standard Report

1. Printing the work area automatically zooms all even when the “Zoom All Before Printing” checkbox is un-checked.

Template Report

1. The Template Report editable info fields are corrupt on WinXP-64 bit system when using AP100US 2011-64 Bit.
2. The Template Report printing speed is very slow in AP100US 2011.

Tool

1. The program stalls when clearing tools on a sheet that contains small segments.

Turret Info

1. The program stalls when clearing tools on a sheet that contains small segments.

Unloader

1. When AP100US checks ULD files when loading an Apelio machine, a warning message displays.

FIXED ISSUES - v2011.01

Bend Line

1. A data display issue with Bend data in the V width column when OLE from SolidWorks.
2. Some bend lines don't show bend deduction values after OLE from SolidWorks.
3. The Bend data is not passed correctly into FabriBend.
4. An error message displays when editing the bend line after OLE from SolidWorks.

Clamp Dead Zone

1. The Clamp Dead Zone at top does not display when the Libra machine installer is upgraded to new version.

Dimensioning

1. The behavior of the Dim Tolerance dialog is improved to stay where the customer places it, or at least docks into the Property Area of the screen.

Dodge Clamps

1. The move NC code is incorrect when using Hole macros with Dodge clamps.

Edit Material

1. The Radius value will not save with the Material file (close the software, re-open it and the value goes back to zero).

FabriBend

1. When the Send Flat Layout command was clicked, the save dialog displayed below the program and was invisible. It appeared that the program was not responding, so the user would click the command several times, launching new program sessions.

Generate NC

1. An error message "Error (-15) in calculator string" displays when trying to generate NC code with customer's sheet.

Input/Output

1. An underlined font on the Note (from 3rd party software) turns into a line in AP100US and causes auto part define problems.
2. A display diameter error when loading a file which is from 3rd party CAD software already has dimensions on it.
3. The AP100US ODA export module for DXF/DWG now supports the dimension data from a PRT.

Job Wizard / IntelliNEST

1. Job Wizard / IntelliNEST crashes when nesting all the customer parts together.

License Server

1. A Program Group Icon for the Administrator Utility displays, when the License Server is installed.

Material Setting

1. The program doesn't recall the value in the CNC table after entering into sheet info dialog and going back to the CNC table.
2. Extra cutting displayed on sheet does not show on the part after changing the material setting.

NC Code Generation

1. AP100US will crash when generating NC view for a nibble hole.

OLE Integration

1. AP100US crashes when resizing the sheet size after OLE from Inventor.

Pre-Punch

1. If the hole is the same size or smaller than the Pre-punch tool, it should not be used for that hole, but should change to standard Pierce.

Refresh

1. Multiple patterns will be highlighted including the last tool sequenced pattern after refreshing.

Special Tool

1. The marker for the angle display should change from clockwise to counter clockwise in the special tool design UI.

Template Report

1. The Template Report is zooming in when doing a Print with "Zoom All before Print" checked off.

Tool Assignment

1. The Manual Corner Radius tool assignment does not allow all mirrored fillets (corner radius) to be assigned after OLE from SolidWorks.
2. The Obround /Double D tool assignment is incorrect after clearing the microjoints.
3. Tools should not be allowed to be assigned to a Multi-Tool station, which is grayed out.

Turret

1. AP100US should be smart enough to know that for a rectangle/square, 90 degrees is the same as 270 degrees.

Work Chute

1. Parts do not drop down to work chute when in the Generate NC or Generate NC view.

IMPORTANT!

Make sure to completely read and understand the installation instructions. You can render your current software unusable if you perform the installation incorrectly! Back up your current set of machine drivers to a safe location. If you encounter any problems, please contact Technical Support. You should develop an installation strategy before performing a new or upgrade installation. Close out the CAD/CAM program before doing any kind of update.

- Files you create in a new version of the AP100US System are not backward compatible with previous versions of the software.
- You can import files created in previous versions of the AP100US System into the latest version. However, some versions require using the Convert File Names option found on the File menu to convert files that use the Virtual Directory file format to the 32 and 64-bit long filename format.
- In some cases, you will have to use the File Stuff/Backup option in a previous version of the software to convert the file names.

Update Installation via Download

Updating the AP100US CAD/CAM System via <http://amadasupport.com>

Note: Do not unzip the service release files to your default CAD/CAM directory.

To update the AP100US CAD/CAM system (32 or 64-bit version) using download:

1. Run Windows Explorer and navigate to the folder C:\AP100US\FabriWIN or the CAD/CAM system folder you specified during installation.
2. Create a temporary folder, such as C:\Temp and unzip AP2011.02(32)english.exe to it. Your version may be "32" or "64" bit and "english" or "spanish".
3. Copy backup.bat in C:\Temp\FabriWIN to C:\AP100US\FabriWIN or the CAD/CAM system folder and run it.
4. Copy all unzipped files and folders in C:\temp\FabriWIN to the CAD/CAM system main folder you previously specified. The default folder is C:\AP100US\FabriWIN.
5. You have now updated your CAD/CAM system and can run it.

CAD/CAM Updated File List

Name	Path	Edition
MSNestExpert.dll	C:\AP100US\FabriWIN	0.0.1.40
cadcam.exe	C:\AP100US\FabriWIN	2011.0.2.18
cadcam_res.dll	C:\AP100US\FabriWIN	2011.0.2.18
AppUpdate.exe.config	C:\AP100US\FabriWIN	
ExplmpDxfDwg.dll	C:\AP100US\FabriWIN	1.1.0.27
dxfigs.dll	C:\AP100US\FabriWIN	1.1.0.28
FWFileConverter.exe	C:\AP100US\FabriWIN	1.1.0.4
DLLReNumber.dll	C:\AP100US\FabriWIN	1.0.0.1
NFLNEST	C:\AP100US\FabriWIN C:\AP100US\FabriWIN\BlcokEXE	0.0.1.40
OldFWIO.dll	C:\AP100US\FabriWIN	3.1.0.9
TKUtil.dll	C:\AP100US\FabriWIN	3.0.0.3
ConvertSPT.dll	C:\AP100US\FabriWIN	1.0.0.6
FWPDFReport.exe	C:\AP100US\FabriWIN	1.0.2.10
PARTVIEW.dll	C:\AP100US\FabriWIN	1.0.3.20
ToollnvFactory.dll	C:\AP100US\FabriWIN	1.0.0.35
SDDOperation.dll(for SDDJ3.6)	C:\AP100US\FabriWIN\SDDJAPI	1.0.0.3
SDDOperation.dll(for SDDJ5.1)	C:\AP100US\FabriWIN\SDDJAPI	1.0.0.3

Updating 3D Unfold

1. Run Windows Explorer and navigate to the folder C:\Unfold3D\FabriWIN or the folder you specified when you installed it.
2. Create a temporary folder, such as "C:\Temp" and unzip AP3Dand2D.exe to it.
3. Copy backup.bat in "C:\Temp2D3D" to C:\AP100US\Unfold3D\FabriWIN or the folder you specified before and run it.
4. You have updated your 3D Unfold modules and can run 3D applications.

Unfold 3D Updated File List

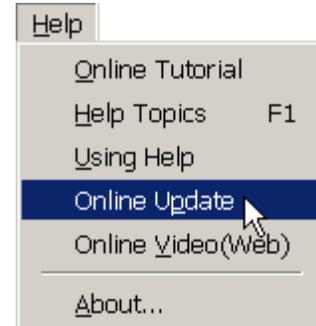
Name	Path	Edition
zw_u.dll	C:\AP100US\Unfold3D\FabriWIN	1.0.0.1
OldFWIO.dll	C:\AP100US\Unfold3D\FabriWIN	3.0.0.5
ExplmpDxfDwg.dll	C:\AP100US\Unfold3D\FabriWIN	1.1.0.26
DxfigsWrapper.dll	C:\AP100US\Unfold3D\FabriWIN	1.1.0.23
dxfigs.dll	C:\AP100US\Unfold3D\FabriWIN	1.1.0.24
design_geom.dll	C:\AP100US\Unfold3D\FabriWIN	
backup.bat	C:\AP100US\Unfold3D\FabriWIN	

Update Installation via Online Update

If you have high-speed access to the Internet, you can use the Online Update utility to check for software updates on a regular basis. Simply select "Online Update" from the AP100US program Help Menu to begin.

To use Online Update:

1. Select Online Update from the AP100US CAD/CAM system submenu. A warning message will appear, instructing you to close all AP100US CAD/CAM system applications. If necessary, exit any open AP100US CAD/CAM System applications.
2. Click Next in the message dialog if you want to proceed with the update. Click Cancel to exit without updating the software.
3. If you click Next, the Online Update window appears and checks for newer versions.
4. If updates are available install to begin otherwise click cancel to exit without updating.
5. Updates will install automatically and when complete click Finish to exit the Update.



Update Installation via DVD Install

Note: If you select install a new copy of this product, the installation utility will install the update as a separate product in an alternate folder, rather than update the software in the default program folder. For more detailed instruction refer to the CAD/CAM Installation Guide on New and Update Installation Procedures.

To perform an Update Installation:

1. Insert the product installation DVD into the DVD drive. The Existing Installed Instances Detected window appears. The message in the window informs you that Setup has detected the following product(s) on your computer that qualify for the update.
2. Select **Maintain or update the instance of this application selected below** and click **Next** to continue.
Note: If you select **Install a new instance of this application**, the installation utility will install the update as a separate product in an alternate folder, rather than update the software in the default program folder. Click **Next** to continue.
3. The Preparing Setup window appears. Wait until the file backup process is completed.
4. The Sentinel Protection Installer, Confirm Upgrade window appears. Select **Upgrade** to start the InstallShield Wizard. In the following windows accept license terms, select complete setup type, and click **Finish** in the final window.
5. The Welcome window appears. Select **Modify, Repair or Remove** and click **Next**.
6. The Components selection window displays. Select the components to reinstall and click **Next** to continue.

7. In Setup Type select the preferred language and click **Next**.
8. The Parameter Settings dialog displays. Confirm the settings in the dialog and make changes if necessary. Click **Next** to continue.
9. The 3D Directory Settings dialog displays. Confirm the settings in the dialog and make changes if necessary. Click **Next** to continue.
10. The Select Program Folder window appears. Specify a program folder for the installation. Click **Next** to continue.
11. The Start Copying Files window appears. The installation utility begins to copy files to your computer system.
12. After the Copying Files process is completed, the License Setting Window appears. Complete the license configuration in this window. Click **Next** to continue.
13. The Maintenance Complete window appears. Click **Finish** to complete the Update.

Contact Information

Amada America Inc.
7025 Firestone Blvd.
Buena Park, CA 90621
1-800-254-7532
Ap100usSupport@amada.com

For more information about Amada and its line of products, please visit www.amada.com.

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