# AP100US v2013.05 Update & Release Notes
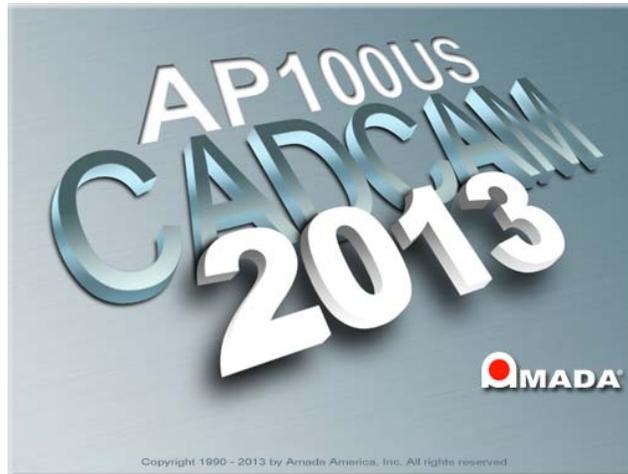
Thank you for purchasing Amada's AP100US! These release notes outline the new features or changes in the latest version of the software as well as information regarding updating to the current version. These modifications are in response to customer feedback. The AP100US CAD/CAM System is licensed software, 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 2013 is NOT intended to upgrade 2011.x or earlier versions. ***You will render earlier software versions inoperable if you attempt to use more recent patches!***

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Contents

System Requirements

Hardware	Description
CPU	Intel® Pentium® 4 or AMD Athlon™ dual-core processor, 3.0 GHz or higher. For Windows XP: Pentium 4 or AMD Athlon dual-core processor, 1.6 GHz or higher with SSE2 technology.
Memory	2 GB of RAM (4 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, or Microsoft® Windows® XP Professional or Home edition (SP3 or later)*.
Sentinel Driver	You must install the Sentinel Driver (v7.5 and above) before you can install the CAD/CAM System or optional software packages. Note: The Sentinel Driver automatically installs in most setups. If it does not, please refer to the Installation Guide located in the AP100US installed folder on the hard disk.
Network Installation	For a network installation, the server computer must be running the server versions of Windows 2003 or 2008. It may also be necessary to update the Sentinel Driver on the server computer.
Supported Software	SolidWorks® 2012/2013, SolidEdge® ST5, AutoCAD® 2012/2013 (2013 DWG/DXF support by 2013.01), AutoDesk® Inventor 2012/2013, Pro/E® WildFire4. Note: If both SolidWorks® and SolidEdge® are installed on the same system, an OLE integration conflict may occur.

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/PRIII 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.

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Post-Release Enhancements – v2010.01

1. Machine Info
Previously the Machine Setup file was automatically output to the NC file folder; the user had no control over this. Now a checkbox has been added and when checked, the user can select another directory.

New Features v2010

1. Microjoint Tool Improvement
This option allows Microjoints to be automatically placed on internal cutouts. In addition, menu items have been added to allow the user to easily Assign, UnAssign, Clear and Inquire MJ Tool.

2. Pre-punch Tool Sequence Control
Pre-Punch hits have become an attribute of the cutting path, giving the user more control over Pre-Punch hits. The pre-punch tool is able to sequence inside the subroutines or macros, and the system generates the macro code for pre-punch tool hits.

3. Import Cutting Table
The Cutting Table from the machine controller has been imported into the program. A new Condition File is used to load the JKA or JKM file into the CAD/CAM system and the View Cutting Table option displays cutting table information.

4. Turret Graphic Numeric Display
In order to identify the location of each station in the view, the Turret Illustration can now display the station numbers for each station. The Turret Illustration with station numbers can also be printed.

5. Output Machine Setup Improvement
The program can now output the Setup Sheet to a separate folder, giving the user full control of the setup sheet files location.

6. Tool Order in NC Code Setup
The user has the option to either output the Tool List in the setup sheet in the order that the tools were sequenced, or in the order that they appear in the turret.

7. Bump Protective Zone
A configurable border or zone can be placed around a part boundary, in order to prevent parts from overlapping during nesting. Moving and copying parts while Bump mode is enabled is still allowed.

8. Laser Cutting Path in Priority Order List
A Cutting Inside Tool and Cutting Perimeter Tool are now available in the Auto Sequence Priority tooling order for a combination machine. For laser machines these tools are called Inside Laser and Perimeter Laser.

9. Auto-Search for Optimized Cutting Sequence
Previously the snap points were used as starting point in the cutting sequence path. As a result, the sheet cutting path was not optimized. Now the system will find the closest point on the next cutting pattern instead of the closest snap point to minimize the cutting sequence.

10. Run Time Estimate
The Runtime setting feature calculates the operating time after the pattern assigned tool, enabling the user to make decisions based on the calculated runtime.

11. Easy Edit Functions
This feature makes editing patterns easier by allowing patterns in parts to be edited with simple mouse-clicks. Certain editing functions can be pre-selected and applied directly to patterns in the work area.

12. Update Modified Parts
If a part is modified, this feature will automatically compare geometry and tool assignment, and prompt the user that the part was changed after the sheet was created. Changes are viewable in the part preview.

13. Sheet Wizard
The Sheet Wizard now supports multiple sheet generation. The Nested Layout logic is improved and the module can now display NC code in the Results Page. Sheet Wizard also has an improved interface that simplifies setting up a new sheet.

14. Shape Library
The Shape Library allows the creation of a User-Defined Shape Library, allowing the user to conveniently select, modify and place standard shapes onto a part or sheet.

15. Add Die Clearance
This new feature has the ability to batch add Die Clearances to the tool inventory during Setup.

16. Tool Comment Information
A new column is added to the Tool Inventory window and the NC Sequence Viewer, which displays user-entered Tool Comment information.

17. Material Setup
A Material Setup dialog box has been added to the installation procedure, allowing the user to load preset Material Files for different machines.

18. Change Line Side - Scribe Path
The user can change the punch line side for a single pattern, or for an entire scribe path. Individual line segments can be assigned different scribe tools, and different punch line sides.

19. Improve Laser Material Name
The CAD/CAM system will search the Laser Material Name in the JKA file based on the Material Type and Thickness.

20. Cutting Sequence Direction Arrows
Now the user can select the type and quantity of arrows that illustrate the cutting sequence direction.

21. New Bend Parameters Options
New CAD/CAM options allow the user to select bending and V Width options. These selections automatically produce a Bend Deduction value, which is editable by the user.

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. This has been fixed.

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. This has been fixed.

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. These issues have been addressed.

Punch Sequence
>   6. The sheet will double hit a common punch when Macro is ON. This has been fixed.

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. This has been fixed.

Sheet Operation
>   8. The space bar toggle between parts that overlap doesn't function. This has been fixed.

Sheet Wizard
>   9. When nesting and using Common Punch in the nesting, between parts in different grids common punch occurs. This has been fixed.
>   10. The Sheet Wizard won't nest all parts when the order of nesting is changed. This has been fixed.

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. This has been fixed.
>   12. The Dimension column for a special tool is empty when exporting a tool list as an xls file. This has been fixed.

View Menu
> 13. When using the "Unfold" command in SolidWorks, the radius bend relief disappears and a "break" or "tear" appears in its place. This has been fixed.

User Interface
> 14. The patterns flicker and turn odd colors as the mouse is moved over the sheet. This has been fixed.

FIXED ISSUES - v2013.04

Various Reports
> 1. Tool Comment does not appear in the Template Report. This has been added.

Punch Sequence
> 2. The Subroutine doesn't work after hitting "Undo" during the creation of a Subroutine. This has been fixed.

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. This has been fixed.
> 4. A value entered to control the number of hits on an Arc using an OB tool is not accurately controlled by the software. This has been fixed.
> 5. If the user enables the Nibble setting while assigning a tool, that tool is removed from the cursor. This has been fixed.

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

Dimensioning
> 3. Incorrect dimensions display when "Bump Check On" is selected. This has been fixed.

Install Shield
> 4. The AP100US installation process closes if an open instance of the same program is closed by the user. This has been fixed.
> 5. The Ready-only property for the AP100US folder is checked on during online update, not allowing the user to update. This has been fixed.

Installation
> 6. Transfadd.dll cannot be registered when using the 2013.02 patch to update AP100US from a 32bit version to 64bit. This has been fixed.

Input/Output (I/O)

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

Machine Setting

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

OLE

9. Inventor part drops outside lines after OLE. This has been fixed.

Punch Sequence/Cutting Sequence

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

Runtime

11. Runtime should support FOL and FOL-AJ machines. This has been fixed.

Tool Assignment

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

TK/PR

14. The HPTK machine should support stacking function. It is now supported.

View Menu

15. Move the position of the Tolerance Settings dialog into the Dimension Ribbon. This has been done.

FIXED ISSUES - v2013.02

AP100/SDDJ

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

Bump Check

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

Cutting Sequence

5. Standard Cut Holes sequence after the perimeter when the Etch line is close to the perimeter. This has been fixed.

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6. AP100US cuts one boundary first, then cuts the internal etch pattern, and finally cuts the left boundary. This has been fixed. This has been fixed.

7. The system should not sequence a part which is outside of the sheet, but only inside of the overtravel. This has been fixed.

8. Split Cutout is still not active in the Start Cut attribute dialog in 2013.01. This has been fixed.

9. The entire circle of the arc on the right side is cut, instead of just the visible arc. This has been fixed.

10. If the part has been sequenced in Part View, then insert sequence doesn't function in Sheet View. This has been fixed.

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. This has been fixed.

12. The Process All Parts option is enabled only when Process all Parts Common Cutting has been done after ungridding. This has been fixed.

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. This has been fixed.

Time Estimate

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

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. This has been fixed.

16. An *.iga file with a small arc/line on the boundary loaded into AP100US cannot be saved, and the prompt will not close. This has been fixed.

17. In the Ribbon UI, as the user typed, the keyboard was dropping some entries. This has been fixed.

18. When accessing the CAD Editor from DR_ABE while using AP100US or US CAD, the program would crash. This has been fixed.

19. After the part file has been saved using the Save command, the program prompts one more time to confirm the save. This has been fixed.

Inventor

20. The customer wants to OLE from Inventor, picking up both hole sizes on the two faces, which will passed to AP100US. This has been implemented.

21. The program freezes when using Open & OLE for an IPT file through SolidWorks. This is fixed.

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. The list has been widened as needed.

Material Info

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

NC Code Generation

24. The renumber result is incorrect, as it should rearrange the NC code sequence. This has been fixed.

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. This has been fixed.

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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. This has been fixed.
27. The program adds an extra G98 for the special tool, requiring the user to edit the code to remove the extra G98. This has been fixed.
28. Manually sequencing smaller parts inside a larger part is difficult because they cannot easily be selected. This has been fixed.
29. A microjoint tool should not double hit on the sheet when the Double Hits On option is unchecked. This has been fixed.

PDC

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

Part Info

31. Product information tab in the Part Info dialog does not display the upper line. This has been fixed.
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. This has been fixed.

Sheet Wizard

33. The default status for common cutting in the SheetWizard should be "No" when dragging in more than one part. This has been fixed.
34. The "Include Features/Lead" setting doesn't work during nesting in the Job Wizard and SheetWizard. This has been fixed.
35. A dxf file cannot be saved successfully in the Sheet Wizard part edit mode. This has been fixed.
36. In the SheetWizard, when nesting the part will overlap and rotate over an adjacent part or off the sheet. This has been fixed.
37. In SheetWizard, the system will save a part that being edited even if it has an error.
This has been fixed.
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. This has been fixed.

SolidWorks

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

Split Sheet

40. The Split Sheet option will cut through a part on the sheet. This has been fixed.

Tool Assignment

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

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Email: Ap100usSupport@amada.com

ULX/Unloader

43. No message dialog displays to remind the user that microjoints on parts must be processed (removed) first before unloading. This has been fixed.

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. This has been fixed.

45. When users change Cutting is Divided settings, no warning dialog displays to remind them to clear final cut settings. This has been fixed.

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. This behavior has been eliminated.

Cutting Feature

1. If a pattern has a split cutout, the Start Cut Attribute selection mode should function like the end attribution. This has been corrected.

2. When editing the Start Cut Attribute by setting Output Macro to Yes (in the property window), the setting will not remain. The issued has been fixed.

3. Adding a Microjoint will reset the changed start/end cut attribute. The issued has been fixed.

Cutting Sequence

1. An additional sequence appears after undoing subroutines and then selecting auto sequence. This behavior has been eliminated.

2. The lead in is wrong when changing the cut direction to CCW for obrounds and polygons inside. This has been corrected.

3. Over/Under Cut value for lead out can't be saved with the sheet/part. The issued has been fixed.

Dimensioning

1. Comment/label which is saved with the part/sheet will disappear after reopening the part/sheet. This behavior has been eliminated.

Estimated Time

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

FabriSIM

1. The "To NC simulate" button should be disabled in part view. The issued has been fixed.

Go To Assistance

1. Using the Pack Up Files option does not include special tools which are assigned as Microjoint tools. This has been corrected.

2. The quotation marks in the e-mail address should be removed when sending an email to support using "Pack Up Files". This has been done.

Input/Output (I/O)

1. The system crashes when dragging a dxf file into the CADCAM program with a cutting/combo machine. This has been corrected.

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2. Saving a part file the first time should display a standard Windows Save As dialog box with a default name entered. The issued has been fixed.
3. The DXF file name should be used as the default name when saving the part from a dxf file. This has been corrected.
4. While in an active folder that doesn't contain a PRT file, then selecting Find, the system will crash. The issued has been fixed.

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. The issued has been fixed.
3. The same material type with different thicknesses can't be loaded into Job Wizard through "Open XLS/CSV/TXT". The issued has been fixed.

Material Info
1. The Material value differs in the Material and Select Material Type dialogs. This has been corrected.

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

Preferences
1. MM units display is incorrect for the Job Wizard material thickness. The issued has been fixed.

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

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

SolidWorks
1. OLE: The attached file with Japanese info cannot unfold correctly when OLE in AP100US. This has been corrected.

Tool Assignment

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

FIXED ISSUES - v2011.03

Cutting

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

Input/Output (I/O)

1. AP100US crashes after deleting text and saving a file. This behavior has been eliminated.

InstallShield

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

Job Wizard

1. An error message displays when batch loading dxf/dwg/igs files in Job Wizard.
The issued has been fixed.

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. This behavior has been eliminated.

OLE

1. When using the OLE function, some random lines are imported when OLE is used on the Inventor Model. The issued has been fixed.

Punch Sequence

1. FabriBend should launch when sending the Flat Layout through DDE in AP100US. This behavior has been eliminated.
2. The X-Axis Control One Tool Sequence is incorrect when assigning a tool to an arc. The issued has been fixed.
3. An error message displays when adding an "unload sheet" special sequence in AP100US 64bit. This has been corrected.

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4. Patterns cannot be auto sequenced when adding "control one tool sequence" to them after undoing the sequence. The issued has been fixed.

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. The issued has been fixed.

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

TK/PR
    1.   For TK, when the arms locate on the 90 degree part with same angle (90 degrees), the unloading job will fail. This has been corrected.

Tool Assignment
    1.   A Special tool can't nibble on a 360 degree arc. This has been corrected.

FIXED ISSUES - v2011.02

Edit
    1. AP100US stops working after deleting some small line segments and then going to the next command. This behavior has been eliminated.

Installation
    1. AP100US must make the installer force the Java 1.2 module to run, in order to support Pro-E OLE. This issue has been fixed.

Job Wizard/Sheet Wizard
    1. Job Wizard and Sheet Wizard are not rotating parts when nesting. These modules now correctly rotate parts during nesting.

Job Wizard
    1. Job Wizard always locks into one sheet size even if multiple sheets are selected when nesting. This issue has been fixed.

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

Part Info
    1. The customer's name can't be saved with the part file. The name now saves with the 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. The Renumber App now functions on a 64bit OS.

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Sequence Feature
      1. The system crashes when using the "Start Cut Attribute" command. This issue has been fixed.
      2. The corner radius is incorrect after entering a small radius corner value. The corner radius is now correct when a small value is entered.

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. PDF files can now be created normally.

NC Output with PDF File
      1. The program name displays as ".nc" when generating a Multiple Sheets Report in AP100US. The full program name now displays.

Standard Report
      1. Printing the work area automatically zooms all even when the "Zoom All Before Printing" checkbox is un-checked. This behavior has been eliminated.

Template Report
      1. The Template Report editable info fields are corrupt on WinXP-64 bit system when using AP100US 2011-64 Bit. This issue has been fixed.
      2. The Template Report printing speed is very slow in AP100US 2011. Printing speed is now satisfactory.

Tool
      1. The program stalls when clearing tools on a sheet that contains small segments. This issue has been fixed.

Turret Info
      1. The program stalls when clearing tools on a sheet that contains small segments. This issue has been fixed.

Unloader
      1. When AP100US checks ULD files when loading an Apelio machine, a warning message displays. This issue has been fixed.

FIXED ISSUES - v2011.01

Bend Line
      1. A data display issue with Bend data in the V width column when OLE from SolidWorks. The data now correctly displays.
      2. Some bend lines don't show bend deduction values after OLE from SolidWorks. These bend lines are now correctly shown.
      3. The Bend data is not passed correctly into FabriBend. Bend data now successfully passes into FabriBEND.
      4. An error message displays when editing the bend line after OLE from SolidWorks. The error message no longer displays.

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

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. This behavior has been eliminated.

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). The values now saves with the file.

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. Now the save dialog appears on top of the program, and Yes must be clicked to proceed.

Generate NC

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

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. This has been corrected.
2. A display diameter error when loading a file which is from 3rd party CAD software already has dimensions on it. This has been corrected.
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. The programs no longer crash.

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. This has been corrected.
2. Extra cutting displayed on sheet does not show on the part after changing the material setting. The extra cutting now shows on the part.

NC Code Generation

1. AP100US will crash when generating NC view for a nibble hole. The program no longer crashes.

OLE Integration

    1. AP100US crashes when resizing the sheet size after OLE from Inventor. The program no longer crashes.

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. This has been corrected.

Refresh

    1. Multiple patterns will be highlighted including the last tool sequenced pattern after refreshing. This has been corrected.

Special Tool

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

Template Report

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

Tool Assignment

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

Turret

    1. AP100US should be smart enough to know that for a rectangle/square, 90 degrees is the same as 270 degrees. The program can now detect this.

Work Chute

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

FIXED ISSUES - v2010.02

Cutting Sequence
1. Box and Fence Group Edit can't edit the properties correctly. This problem has been fixed.
2. Auto sequencing locks up when using the common cut process. This has been corrected.
3. After cutting the radius, the laser cuts a chamfer which it is not supposed to. This incorrect behavior has been fixed.

Easy Edit
1. Easy Edit cancels the repeated Copy or Move when snapped to another pattern. This problem has been fixed.

Edit
1. Dynamic Origin doesn't function in Copy Patterns. Dynamic Origin now functions correctly.
2. The Origin offset Hot Key does not function. The Hot Key now functions correctly.
3. The ability to blend to lines (with the "blend pattern" function) with a radius of "0.000" to create sharp corners has been added.

Feature Tree
1. When scaling a macro the tool is lost, but the tool info still shows in the Feature tree. The tool info no longer displays.

Installation
1. Place the CADCAM Install Guide in pdf into the route of the directory of the CD. The Install Guide has been included.
2. Place the Converter after the Supplemental Disc during installation. The Converter has been included.

NC Code Generation
1. The Gcode Nesting Module passes an MJ tool, even if it is not used on the sheet. This incorrect behavior has been fixed.
2. Using the NC "Sequence Order" option causes tool setup data to be lost. This has been corrected and setup data is no longer lost.

OLE Integration
1. Bend line info is lost when files from Autodesk Inventor are imported through OLE integration. Bend line information is preserved when importing files from Autodesk.

Part Info
1. Arcs and circles are not calculated in the Cut Length in the part info. This incorrect behavior has been fixed.

Punch Sequence
1. Some grid patterns have a double hits problem. This problem has been fixed.

2. When resetting the sequence and then auto sequencing again, the application crashes. This incorrect behavior has been fixed and the application no longer crashes.

3. Finn power setup sheet shows 32 extra pre-punch hits. These extra hits no longer display.

Run Time

1. A prompt should be added, so the user knows there is a delay in calculating the RunTime. This prompt has been added.

Shape Library

1. In the Design SP tool window, placing an SP instance causes a crash. The program no longer crashes.

2. The SP instance tool in the Shape Library will be replaced when loading another tool inventory. This has been fixed and the instance tool remains the same.

Sheet

1. When gridding grouped parts, and then changing the location of the grid, only the selected part is moved. This incorrect behavior has been fixed.

Sheet/Part Association

1. Part/Sheet Association does not refresh the display window after loading a sheet. This incorrect behavior has been fixed.

Sheet Wizard

1. The error boundary part is highlighted in the first page, but only one is highlighted in the second page. Now error boundaries are highlighted in the second page.

Special Tool

1. The Special Tool name changes in the title bar after selecting another tool. Fixed issue.

Tool

1. When using the clear tabs option when tools have been assigned to the perimeter with the Nibble OFF, the tools will revert back to having the nibble on (H7 SheetMetal Solutions, Inc.).

Tool Assignment

1. AP100US incorrectly calculates the pitch when changing from .086 and .087 Materials. The pitch is now correctly calculated.

Turret Info

1. The opening parenthesis is missing when assigning a tool to the turret. The opening parenthesis has been included.

2. The Y Offset To Hold Down value can't be set in Machine>Turret>Station Info. This value can now be set.

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FIXED ISSUES - v2010.01

Bump Check
1. When the user bumped the selected part into a stationary part and then left-clicked, the system selected a completely different part instead. This incorrect behavior has been fixed.
2. When a part is being moved, ghost-images of that part appear on the screen. The ghost-images no longer appear in the display.

Display
1. In the tab corner with Cutting Direction Display turned on, the arrows get cut off in the display. The arrows now display correctly.

BendCAM
1. DDE Bend data (Vwidth and Bend Type data) passed to BendCAM was inaccurate. This problem has been corrected and now the valid values are passed.

File
1. When using F10 Quick Save and the "Y" key once to save, the user must select it twice. The problem has been fixed.

Import Cutting Table
1. The Material Name M102 of the current material file was not entered in the Laser Material Name field in Sheet info and the database. The Material Name now displays.
2. A new sheet with the same material set in preferences didn't select the material name in JKA. This has been fixed.

IntelliNEST
1. NewAssembly2 only shows for an assembly file; if more parts are loaded and saved, the assembly will get an error. This has been fixed.

Material Info
1. When reloading a new driver, values for all conditions were set to "0", even though the user had made no changes. The system now retains the previously entered values.

Microjoint Tool
1. The system gave an Error alarm when the user tried to remove the MJ sequence. Now no error appears when the MJ sequence is removed.

NC Code Generation
1. In the Microjoint tool sequence with AmNEST enabled, the values given for the MJ tool origin in the NC code pane were incorrect. Now the correct tool origin values appear.
2. The parameter is incorrect when setting up Use Part/Sheet Info =1 and generating the NC code. The problem has been fixed

Punch Sequence
1. Using the Insert Sequence function pushed the inserted sequence to the end of the code. This behavior has been eliminated.

Run Time
1. When reloading material the runtime module should calculate the time based on the feedrate and/or other related values set in the CNC Table.
2. The Output machine setup will show ESTIMATED TIME= RUN TIME instead of 00:00:00. This has been fixed.

Sheet
1. When the user selected Sheet>Move/Copy using keyboard commands, the cursor would jump to the comment line and the function didn't work. This behavior has been eliminated.
2. Select a part, snap to the corner of the part and then type .75s to step move it and it will fail. Fixed issue.
3. The part will snap to a clamp or sheet pattern after a move to the right of sheet. Fixed issue.
4. Open the Properties dialog, and it fails to show the location of the selected, copied or active part. Fixed issue.

Sheet Wizard
1. Sheet Wizard only checked if a part had microjoints and showed an alarm if they were absent. Tabs were not checked. Sheet Wizard will now check both MJ and Tabs, only giving an alarm when the part has neither.
2. Common punch should not be active between different parts in Sheet Wizard. This has been addressed.

Tool
1. The tool in the turret display showed an incorrect angle. The tool now shows the correct angle as entered in the Station dialog.
2. A large tool could be placed in a station reserved as a Multi-Tool station. This incorrect behavior has been eliminated.

Turret Station
1. In Multi-tool stations, station numbers didn't display correctly. Station numbers are now correct.

Other
1. The system did not output the correct time in the Runtime Details dialog. A variable flag is now passed from the driver, allowing the XML format to support this type of code.
2. When Logitech® SetPoint is installed, the user couldn't launch AP100US 2010.0. This has been fixed and the CADCAM program now opens normally.
3. "Inquire MJ Tool" has been removed from the Classic Menus and Customize Tool Bar Commands.

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 <u>Download</u>

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

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	
ExpImpDxfDwg.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
ToolInvFactory.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
ExpImpDxfDwg.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 <u>Online Update</u>

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.
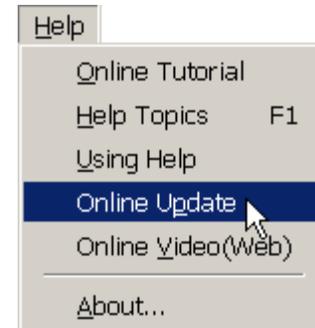
Update Installation via <u>DVD Install</u>

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 CADCAM 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.

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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.

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

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