



VPSS 4ie BEND

V3.03.04
Release Note

25 OCT 2025
AMADA CO., LTD.



- Basic Operation Environment
- Released Function List
- Precautions and Limitations on use

Basic Operation Environment



■ Recommended Hardware

Processor (CPU)	Intel Core i5 or higher
Memory	More than 8GB
Hard Disk	More than 30GB

■ Basic Software

OS	Version	32 bit	64 bit
	Windows 10 Pro/Enterprise	N/A	OK
	Windows 11 Pro/Enterprise	N/A	OK
.NET Framework	3.5, 4.6.2		

■ Operation Mode

Server Supported	vSDD, SDDJ
Supported Language	English, Japanese, German, French, Italian, Spanish, Portuguese, Polish, Russian, Hungarian, Chinese (Simplified), Chinese (Traditional), Korean, Thai, Vietnamese, Indonesian
System Unit	Metric, inch
Decimal, Comma Environment	Supported
AP100 System [SDD Support]	Possible; AP100 Client, Server, PCL Client – V6.00.00 or later

Basic Operation Environment



Machine Type	<p>【EGB】 4010/6013/6020/8025/1303</p> <p>【HG】 5020/8025/1003/1303/1703/1704/2203/2204</p> <p>【Compact HG】 5020/8025/1303</p> <p>【HRB】 5020/8025/1003/1303/1703/2204/3503/3504/3506/5005/5006/6006/6007</p> <p>【EG】 4010/6013</p> <p>【SRB】 1003</p> <p>【HFE3i】 5020/1003/1003L/1703/1703L/1704/1704L/8025/8025L/ 1303/2203/2204/2203L/17045/22045/5012/3204/4004/4005/4006</p> <p>【HM】 1003/2204</p> <p>【Old Machines】 FBD3/FMB/FMB2/HFP/HDS/HD/RG-M2/RG-M3/HDSEU</p>
Tool	One touch (Include AFH), Modular (AMTSIII, AMOBIII)
Bend Type	V-bend, RR-bend, FR-bend, Partial-bend, Hemming bend, Z-bend

- *1) Following model of HGEU machine are not supported. (1704)
- *2) Following model of HRB machine are supported only for EU model. (1703)
- *3) Following model of EGBEU machine are only supported. (1303)

There are no improvements that affect the screen operation or output in this version.

Precautions and Limitations on use (1/4)

PD: Production Designer

PX: Parameter Explorer

DX: Data Explorer



#	Category	Content	Planning date
1	As a whole	When repeat data saved in SDDJ is loaded in VPSS 3i BEND, gaging position is not correct depends on part shape or condition. In this case, press auto gaging button and reposition finger contact value properly.	After Ver. 3.04
2	As a whole	Offset gauging issue (Old machine support) When the data using step position of step finger is saved to SDDJ and loaded in AMNC-V3/V4/V5, R-axis value is doubled. In this case, press auto gaging button and reposition finger contact value properly.	After Ver. 3.04
3	As a whole	Regarding EG machine, in the "StepBend" process, if L value is greater than 100 and if $L1 \neq L2$, AMNC3i-BEND shows incorrectly far L value against expected value. In this case, as backgauge position is shown obviously far in 3D view, press auto gaging button and reposition finger contact value properly.	It will be planned after fixing direction is decided by AMNC-BEND Dev.Team
4	As a whole	Regarding server-installer, Detail of BendPrint is not available. Only standard bend print (= BendLine info. And ToolLayout info.) is available.	This is a spec. No plan to be fixed.
5	ABE Planner	On the server/client environment, there is as case that the timing is to be late to get parts data or to be missing to get parts data from SDDJ, because the clock setting of PC with VPSS 3i BEND installed is different from the clock of PC to save or update parts data. If the clocks for both PCs are set to same time, this issue will be solved.	This is a spec. No plan to be fixed.
6	ABE Planner	Full Auto for AP100 are disabled if none of [AP100] / [PCL] / [VPSS 4ie 2D-CAD] is installed.	This is a spec. No plan to be fixed.
7	Manual	In the case that BendCAM is started up and PX (server or client) parameter is changed, modified parameter is not reflected. (Regarding tool parameters, changed parameters are available by re-selecting tool from tool selection.)	After Ver. 3.04

Precautions and Limitations on use (2/4)

PD: Production Designer

PX: Parameter Explorer

DX: Data Explorer



#	Category	Content	Planning date
8	Manual	PP-value for the bend process using high height punch holder, will be lower value as using default punch holder, when AMNCv5.4.02 loads bend data crated by VPSS using high height punch holder with Set Up.	This is current spec. No plan to be fixed.
9	Manual ABE Planner	In the case that save data load from SDD to vSDD, if there are bend data with same name, the old data will be deleted and new data will be saved. (Same as the AMNC3i). ※ABE Planner judges according to the "Overwrite" setting value in the save setting dialog.	This is a spec. No plan to be fixed.
10	Auto	"ATC" are not considered in Auto Plan collision.	After Ver. 3.04
11	ABE Planner	If calendar setting of MS Windows is set as "Japanese" style, Full Auto fails to retrieve target data to plan.	This is a spec. No plan to be fixed.
12	As a whole	Windows 10 environment has a feature which automatically set a last used printer as a default. This function can be inactivated by following the procedure below. • [Setting] - [Devices] - [Printers & scanners] then turn off 「Let windows manage my default printer」	This is a spec. No plan to be fixed.
13	Auto	Bending Sequence designation (Semi-auto) of "more than one processes" in reverse order is not supported. When designating a bending sequence in reverse order, designate "only one process" or "all processes" to be implemented.	After Ver. 3.04

Precautions and Limitations on use (3/4)

PD: Production Designer

PX: Parameter Explorer

DX: Data Explorer



#	Category	Content	Planning date
14	Auto	<p>There are the following limitations in the automated planning for which a slider hemming tool is specified.</p> <ul style="list-style-type: none">•When selecting the "Setup Mode" in the PX parameters, a planning result that the double deck tool is selected is obtained.•In the batch tool setup repeating function, a planning that the double deck tool is selected is obtained.	After Ver. 3.04
15	ABE Planner	<p>When the number of target files for AP100 full auto over 10,000, the plan may not start (e.g., BMF re-creation was performed for a large number of files in 1 day).</p> <p>In this case, repeat BMF re-creation on the basis of 1500 to 3000 files per day to eliminate the duplication of update date.</p>	After Ver. 3.04
16	As a whole	<p>Some tool length can not be carried out at HRB-ATC machine because of clamp ratio shortage.</p> <p>Please fabricate such part with other machine.</p> <p>Please see the next page to check which tool length is NG.</p>	This is current spec. No plan to be fixed.
17	AiBEND	<p>AiBEND might output tool setting which over the machine table width.</p> <p>Since such tool length can not be used because of machine limitation, do not plan specified part which have 3050mm(3m) / 4000mm(4m) or larger length.</p>	After Ver. 3.04
18	AiBEND	<p>AiBEND result is "OK" or "NG" only.</p> <p>"OK(Warning)" result will not be created by AiBEND (E.g. Insufficient number of storage Tools).</p>	After Ver. 3.04

Precautions and Limitations on use (4/4)

PD: Production Designer

PX: Parameter Explorer

DX: Data Explorer



#	Category	Content	Planning date
19	ABE Planner	Bend schedule can not be used if LIVLOTS setting is ON. The behavior of "Bending Schedule" button is changed to "JOB output for LIVLOTS" from "Bending Schedule output".	This is current spec. No plan to be fixed.
20	Auto	If the language Settings of VPSS 4ie does not match the language Settings of Windows, The detailed Auto and status display may appear in English.	After Ver. 3.04
21	Manual	If you change [Machine Name], the original Die Holder Settings will be inherited. If you use PX's Die Holder default Settings, remove Die Holder and change [Machine Name].	After Ver. 3.04
22	Manual	When executing [Switch Position] to 90mm stopper or 300mm stopper in Y3 Gauge, if a downward forming or others is present on the upper part of the gauge, it may be judged that there is a collision in spite of the absence of the collision, and the switch position may not be possible.	After Ver. 3.04
23	Auto	The tilt setting for the Gauge in Repeat data will not be reflected in the Common layout repeat or the AiBEND Common layout.	After Ver. 3.04

LogViewer installer



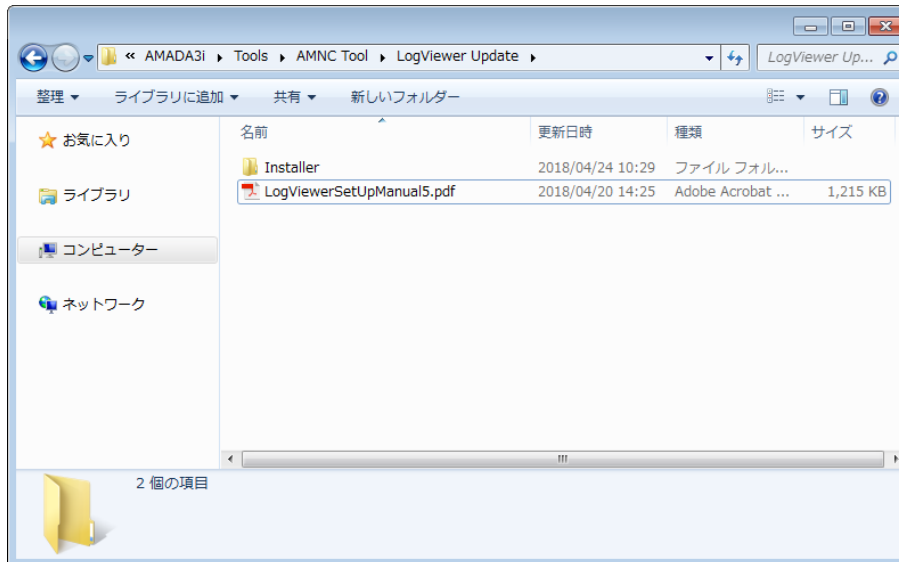
Overview

LogViewer has to be installed to AMNC Ver. 5 when user would like to use it with the data created by VPSS 3i.

Detail

Please install LogViewer based on the manual in below path.

Installer path : [VPSS 3i install path]¥Tools¥AMNC Tool¥LogViewer Update
(Sample path of VPSS 3i install path : C:¥Program Files¥AMADA3i)



Tool length limitation for HRB1003ATC <inch>



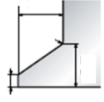











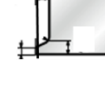


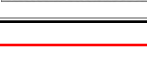
Overview

Some tool length can not be used at HRB1003ATC because of clamp ratio shortage.

Detail

Some tool length can not be used at HRB1003ATC if ear tool is used (Either tool clamp ratio is not enough at any tool position).
In this case, Please use other machine.

※ Even if ear punch is unnecessary, ear punch is required in some cases when the tool length is not enough.

Model	# of stocker	Profile	Combination	Unavailable tool layout length
1003	•L stocker : 3 •S stocker : 1 •OP stocker : 1	Ear length1.378" 1.378 	Two ear punches 	Less than 9.843, 10.039, 10.236, 12.795, 12.992, 13.189
			One ear punch※ 	Less than 4.921, 5.118, 5.315
			No ear punch※ 	Less than 0.591
		Ear length0.984" 0.984 	Two ear punches 	Less than 9.843, 10.039, 10.236
			One ear punch※ 	Less than 4.921, 5.118, 5.315
			No ear punch※ 	Less than 0.591
		Ear length0.787" 0.787 	Two ear punches 	Less than 9.843, 10.039, 10.236, 119.882, 120.079
			One ear punch※ 	Less than 4.921, 5.118, 135, 119.882, 120.079
			No ear punch※ 	Less than 0.591, 119.882, 120.079
		Ear length0.394" 0.394 	Two ear punches 	Less than 9.843, 10.039, 10.236, 119.291~120.079
			One ear punch※ 	Less than 4.921, 5.118, 5.315, 119.291~120.079
			No ear punch※ 	Less than 0.591, 119.291~120.079

Tool length limitation for HRB1003ATC <inch>



Overview	Some tool length can not be used at HRB1003ATC because of clamp ratio shortage.
Detail	<p>①When using ear punches on both ends, tool layout less than 9.843" is not available due to 9.843" ear punch length (total). Minimum sectionalized length is 0.591", so 10.039" and 10.236" tool layout are not available.</p> <p>②When using ear punches(ear length 1.378") on both ends, 12.795", 12.992" and 13.189" tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>③When using ear punch(ear length 0.787"), 119.882" and 120.079" tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>④When using ear punch(ear length 0.394"), 119.291~120.079" tool layout is not available due to shortage of length for clamping tools sufficiently.</p> <p>⑤When using single ear punch, tool layout less than 4.921" is not available due to 4.921" ear punch. Minimum sectionalized length is 0.591", so 5.118" and 5.315" tool layout are not available.</p>

Tool length limitation for HRB2204ATC <inch>



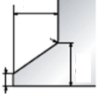
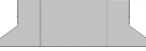



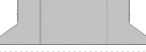


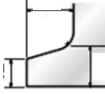







Overview

Some tool length can not be used at HRB2204ATC because of clamp ratio shortage.

Detail

Some tool length can not be used at HRB2204ATC if ear tool is used (Either tool clamp ratio is not enough at any tool position).
In this case, Please use other machine.

※ Even if ear punch is unnecessary, ear punch is required in some cases when the tool length is not enough.

Model	# of stocker	Profile	Combination	Unavailable tool layout length
2204	•L stocker : 4 •S stocker : 1 •OP stocker : 1	Ear length1.378" 1.378 	Two ear punches 	Less than 9.843, 10.039, 10.236, 12.795, 12.992, 13.189, 154.528~155.315, 155.709~157.480
			One ear punch ※ 	Less than 4.921, 5.118, 5.315, 155.118, 155.315, 155.709~157.480
			No ear punch ※ 	Less than 0.591, 155.118, 155.315, 155.709~157.480
		Ear length0.984" 0.984 	Two ear punches 	Less than 9.843, 10.039, 10.236, 155.118, 155.315, 155.709~157.480
			One ear punch ※ 	Less than 4.921, 5.118, 5.315, 155.118, 155.315, 155.709~157.480
			No ear punch ※ 	Less than 0.591, 155.118, 155.315, 155.709~157.480
		Ear length0.787" 0.787 	Two ear punches 	Less than 9.843, 10.039, 10.236, 155.118, 3945, 155.709~157.480
			One ear punch ※ 	Less than 4.921, 5.118, 5.315, 155.118, 155.315, 155.709~157.480
			No ear punch ※ 	Less than 0.591, 155.118, 155.315, 155.709~157.480
		Ear length0.394" 0.394 	Two ear punches 	Less than 9.843, 10.039, 10.236, 155.118, 155.315, 155.709~157.480
			One ear punch ※ 	Less than 4.921, 5.118, 5.315, 155.118, 155.315, 155.709~157.480
			No ear punch ※ 	Less than 0.591, 155.118, 155.315, 155.709~157.480

Tool length limitation for HRB2204ATC <inch>



Overview	Some tool length can not be used at HRB1003ATC because of clamp ratio shortage.
Detail	<p>①When using ear punches on both ends, tool layout less than 9.843" is not available due to 4.921" per ear punch length. Minimum sectionalized length is 0.591", so 10.039" and 10.236" tool layout are not available.</p> <p>②When using ear punches(ear length 1.378") on both ends, 12.795", 12.992", 13.189" and 154.528"~155.315" tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>③When using ear punch(ear length 0.984",0.787",0.394"), 155.118" and 155.315" tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>④When using single ear punch, tool layout less than 4.921" is not available due to 4.921" ear punch. Minimum sectionalized length is 0.591", so 5.118" and 5.315" tool layout are not available.</p> <p>⑤ 5 L-stockers are required for tool layout more than 155.512".</p>

Tool length limitation for HRB1003ATC <mm>



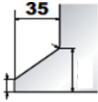
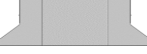


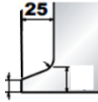



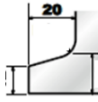



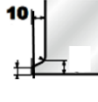
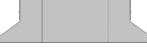
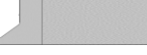

Overview

Some tool length can not be used at HRB1003ATC because of clamp ratio shortage.

Detail

Some tool length can not be used at HRB1003ATC if ear tool is used (Either tool clamp ratio is not enough at any tool position).
In this case, Please use other machine.

※ Even if ear punch is unnecessary, ear punch is required in some cases when the tool length is not enough.

Model	# of stocker	Profile	Combination	Unavailable tool layout length
1003	<ul style="list-style-type: none"> •L stocker : 3 •S stocker : 1 •OP stocker : 1 	Ear length35mm 	Two ear punches 	Less than 250,255,260,325,330,335
			One ear punch※ 	Less than 125,130,135
			No ear punch※ 	Less than 15
		Ear length25mm 	Two ear punches 	Less than 250,255,260
			One ear punch※ 	Less than 125,130,135
			No ear punch※ 	Less than 15
		Ear length20mm 	Two ear punches 	Less than 250,255,260,3045,3050
			One ear punch※ 	Less than 125,130,135,3045,3050
			No ear punch※ 	Less than 15 3045,3050
		Ear length10mm 	Two ear punches 	Less than 250,255,260,3030~3050
			One ear punch※ 	Less than 125,130,135,3030~3050
			No ear punch※ 	Less than 15 3030~3050

Tool length limitation for HRB1003ATC <mm>



Overview	Some tool length can not be used at HRB1003ATC because of clamp ratio shortage.
Detail	<p>①When using ear punches on both ends, tool layout less than 250mm is not available due to 250mm ear punch length (total). Minimum sectionalized length is 15mm, so 255mm and 260mm tool layout are not available.</p> <p>②When using ear punches(ear length 35mm) on both ends, 325mm, 330mm and 335mm tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>③When using ear punch(ear length 20mm), 3045mm and 3050mm tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>④When using ear punch(ear length 10mm), 3030~3050mm tool layout is not available due to shortage of length for clamping tools sufficiently.</p> <p>⑤When using single ear punch, tool layout less than 125mm is not available due to 125mm ear punch. Minimum sectionalized length is 15mm, so 130mm and 135mm tool layout are not available.</p>

Tool length limitation for HRB2204ATC <mm>



Overview

Some tool length can not be used at HRB2204ATC because of clamp ratio shortage.

Detail

Some tool length can not be used at HRB2204ATC if ear tool is used (Either tool clamp ratio is not enough at any tool position).

In this case, Please use other machine.

※ Even if ear punch is unnecessary, ear punch is required in some cases when the tool length is not enough.

Model	# of stocker	Profile	Combination	Unavailable tool layout length
2204	<ul style="list-style-type: none"> •L stocker : 4 •S stocker : 1 •OP stocker : 1 	Ear length 35mm	Two ear punches	Less than 250, 255, 260, 325, 330, 335, 3925~3945, 3955~4000
			One ear punch ※	Less than 125, 130, 135, 3940, 3945, 3955~4000
			No ear punch ※	Less than 15, 3940, 3945, 3955~4000
		Ear length 25mm	Two ear punches	Less than 250, 255, 260, 3940, 3945, 3955~4000
			One ear punch ※	Less than 125, 130, 135, 3940, 3945, 3955~4000
			No ear punch ※	Less than 15, 3940, 3945, 3955~4000
		Ear length 20mm	Two ear punches	Less than 250, 255, 260, 3940, 3945, 3955~4000
			One ear punch ※	Less than 125, 130, 135, 3940, 3945, 3955~4000
			No ear punch ※	Less than 15, 3940, 3945, 3955~4000
		Ear length 10mm	Two ear punches	Less than 250, 255, 260, 3940, 3945, 3955~4000
			One ear punch ※	Less than 125, 130, 135, 3940, 3945, 3955~4000
			No ear punch ※	Less than 15, 3940, 3945, 3955~4000

Tool length limitation for HRB2204ATC <mm>



Overview	Some tool length can not be used at HRB1003ATC because of clamp ratio shortage.
Detail	<p>①When using ear punches on both ends, tool layout less than 250mm is not available due to 125mm per ear punch length. Minimum sectionalized length is 15mm, so 255mm and 260mm tool layout are not available.</p> <p>②When using ear punches(ear length 35mm) on both ends, 325mm, 330mm, 335mm and 3925~3945mm tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>③When using ear punch(ear length 25,20,10mm), 3940mm and 3945mm tool layout are not available due to shortage of length for clamping tools sufficiently.</p> <p>④When using single ear punch, tool layout less than 125mm is not available due to 125mm ear punch. Minimum sectionalized length is 15mm, so 130mm and 135mm tool layout are not available.</p> <p>⑤ 5 L-stockers are required for tool layout more than 3950mm.</p>