



# **VPSS 4ie WELD**

V3.03.04  
Release Note

25 OCT 2025  
AMADA CO., LTD.



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- 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	Not Supported
AP100 System [SDD Support]	Possible; AP100 Client, Server, PCL Client – V6.00.00 or later

## ■ Support Machine Type

FLW models supported by VPSS 4ie WELD.

Support	Machine	Layout
	FLW1000,2000,4000,6000	M1, M2, M3, M3T, M4, M4T, M4S
	FLW3000EN,FLW6000EN	M2(S2), M3, M3T, M5 (Tables can be added to M2, up to 2)
	FLW3000ENe,FLW6000ENe	M2(S2), M3, M3T, M5
	FLW3000Le	M1, M2(S2)

## ■ vSDD Operation

vSDD of VPSS 4ie WELD V3.03 is available after the following version of AMNC FLW.

VPSS 4ie WELD Version	Machine	AMNC FLW Version
<b>3.03</b>	FLW1000,2000,4000,6000	AW2.02.00 (Not supported V3 and later)
	FLW3000EN,FLW6000EN	AW2.02.00 (Not supported V5 and later)
	FLW3000ENe,FLW6000ENe FLW3000Le	AW5.00.01 or after

# Released Function List (1/1)

PD: Production Designer

PX: Parameter Explorer

DX: Data Explorer



#	Classification	Category	Function Name	Summary
1	Improve	Machine	Robot CAD change support	The ENSIS and ENSISe robot CAD models have been corrected.
2	Improve	Machine	M5 Siegmund Table support	When selecting a Siegmund table in an ENSISe M5 layout, the appropriate shuttle CAD can now be substituted.

# #1 Robot CAD change support (1/3)



Background	Robot CAD models of ENSIS and ENSISe differ from the actual machines, collision may occur in CAM but not in the actual machines, leading to requests to modify the CAD models.
Outline	The ENSIS and ENSISe robot CAD models have been corrected.

Support  
Details

[Change the robot CAD model]  
Supported Robot models: FLW-ENSIS, FLW-ENSISe  
Changes (1) Cable support bracket  
(2) Protrusion  
(3) Filler support(For Filler Real)

[Support for already created machines]  
Select the applicable machine and click the [Update CAD] button.  
[Welding Machine]>[Applicable machine]>  
[Machine Information]>[Machine Setting]

**Machine Setting**

Robot

YASKAWA GA50

Update CAD

Add

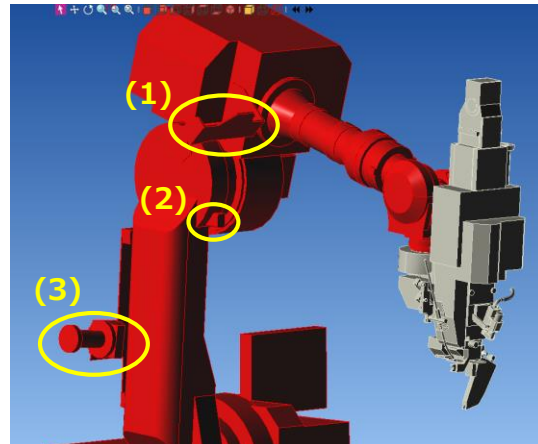
Machine Name

GA50-M3T-01

\* After updating the CAD model, the button will become inactive.

[Adding a new machine]  
A machine will be created using the modified CAD model.

\*For detailed instructions, please refer to the setup guide.

A 3D CAD model of a red industrial robot arm, specifically a Yaskawa GA50. The model is shown against a blue background. Three yellow circles with black outlines are placed on the robot arm to highlight specific modification points: (1) is on the upper arm joint, (2) is on the lower arm joint, and (3) is on the wrist joint. The robot arm is holding a grey and white welding torch assembly.

Robot using the modified CAD model

# #1 Robot CAD change support (2/3)



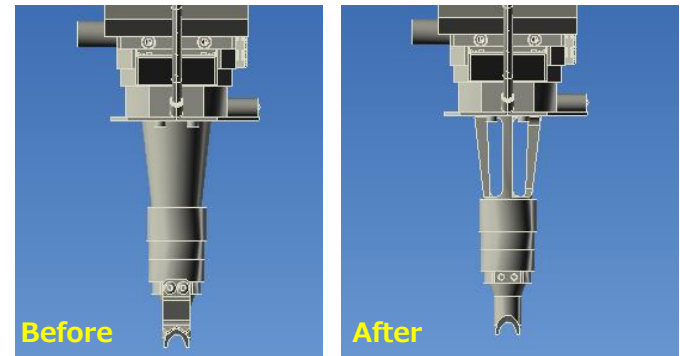
## Support Details

[Change the water cooling nozzle model]  
(Background)

Previously, the CAD models for water-cooled nozzles in ENSIS and ENSISe differed in shape from the actual models, making it impossible to determine from the image that the nozzle being used was a water-cooled nozzle when checking actual setup.

To prevent setup errors, we have changed to a CAD model with a shape that is closer to the actual nozzle.

Supported Robot models : FLW-ENSIS, ENSISe  
Changes : New model has a cavity in the center of the nozzle.  
(No other changes have been made.)



Cooling-nozzle with filler support

[Storage Folder]

Please refer to the setup guide.

[If the water cooling nozzle is already registered]

Need to delete the water cooling nozzle in PX  
and save and re-register it.

[Procedure]

1. Delete the registered nozzle.  
[Welding Machine]>[Nozzle Register]>[Delete]
2. Save.
3. Import the same nozzle (\*1) as the deleted nozzle.  
[Nozzle Register] > [Import]

(\*1) If changed the name of the registered nozzle, refer to next page.

\*For detailed instructions, please refer to the setup guide.

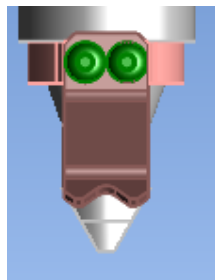
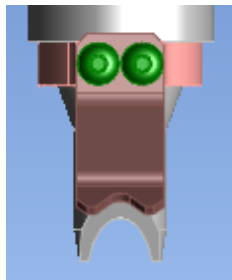
# #1 Robot CAD change support (3/3)



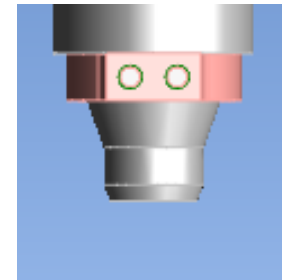
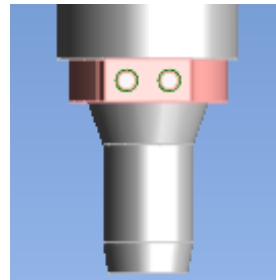
(\*1) If changed the name of the registered nozzle, need to confirm it. (See below)

	Nozzle name	Spec	Cut-angle	Support
1	Cooling_C0-Nozzle_F-Support.SAT	V Cut	0	Filler
2	Cooling_C0-Nozzle_No-Support.SAT	V Cut	0	-
3	Cooling_C0-Nozzle_Support_Ring.SAT	V Cut	0	Ring
4	Cooling_C90-Nozzle_F-Support.SAT	V Cut	90	Filler
5	Cooling_C90-Nozzle_No-Support.SAT	V Cut	90	-
6	Cooling_C90-Nozzle_Support_Ring.SAT	V Cut	90	Ring
7	Cooling_N-Nozzle_cut_15mm_F-Support.SAT	15mm Cut	-	Filler
8	Cooling_N-Nozzle_cut_15mm_No-Support.SAT	15mm Cut	-	-
9	Cooling_N-Nozzle_cut_15mm_Support_Ring.SAT	15mm Cut	-	Ring
10	Cooling_N-Nozzle_Normal_F-Support.SAT	-	-	Filler
11	Cooling_N-Nozzle_Normal_No-Support.SAT	-	-	-
12	Cooling_N-Nozzle_Normal_Support_Ring.SAT	-	-	Ring

Support  
Details



Support Filler  
Cut-Angle deg Left 0  
Right:90



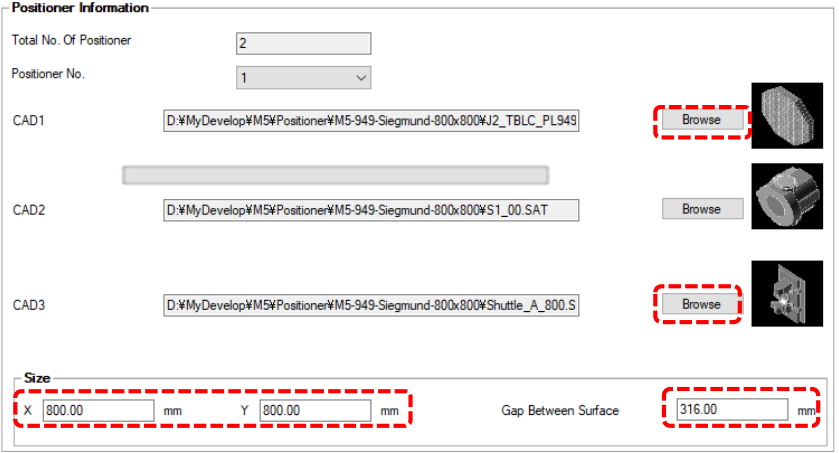
Support Ring  
Spec Left : Length Normal  
Right: 15mm Cut



## #2 M5 SIEGMUND Table support



Background	When the Siegmund 800X800 table was selected as an option for the ENSISe M5 layout, the shuttle needed to be raised to prevent collision with the table, which required changes to the CAD model.
Outline	When selecting a SIEGMUND table in an ENSISe M5 layout, the appropriate shuttle CAD can now be substituted.

Support Details	<p>Supported Robot models: FLW-ENSISe M5</p> <p>M5 Option Table (Siegmund) [Storage Folder] Please refer to the setup guide. [Storage file] Please refer to the setup guide.</p> <p>[Welding Machine]&gt;[Applicable machine]&gt;[Machine Setting]&gt;[Positioner Information]</p> <p>[Size] X, Y: 800 mm Gap Between Surface : 316 mm</p> <p>*For detailed instructions, please refer to the setup guide.</p> 
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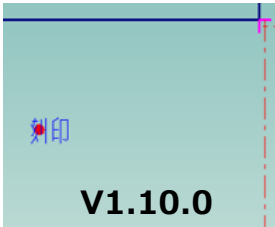
# Precautions and Limitations on use (1/5)

PD: Production Designer

PX: Parameter Explorer

DX: Data Explorer



#	Category	Content	Planned date
1	All	<p>The calculation module specification of the Robot Kinematics does not support the comma (,) separator as the decimal sign.</p> <p>If the comma-separation between a decimal fraction and an integer and the dot-separation for example, 1000, one million, etc., which are used on the control panel of the machine, are different from your country's custom, please change the settings conveniently.</p>	This is current spec. No plan to be fixed.
2	All	<p>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.</p> <ul style="list-style-type: none"> <li>• Turn off the setting of the section "manage the default printer on Windows" with [Setting] - [Devices] - [Printers &amp; scanners] then turn off 「Let windows manage my default printer」</li> </ul>	No plan to be fixed.
3	Stamping Feature	<p>Although 2Byte character Stamping Feature is supported in V1.10.0, regarding DX, VPSS 3i WELD, AMNC3i BEND, the data which 2Byte character was saved in the version before V1.10.0 is shown as square.</p> <p>To show 2Byte character properly, please save the data again. ( E.g. Call "SaveAs" and save with same name. )</p> <div style="display: flex; justify-content: space-around; align-items: center;">   </div>	No plan to be fixed

# Precautions and Limitations on use (2/5)

PD: Production Designer

PX: Parameter Explorer

DX: Data Explorer



#	Category	Content	Planned date
4	Robot Program	Before actually welding with a robot, please confirm the robot's motion and the load of the cable by simulation or teaching operation of the robot.	-
5	Positioner with Space	CAM does not officially support positioners with space. The resolution of the rotation angle is different from the standard positioner, and when moving the data created by CAM on the actual machine, the angle is different. Individual measures are required for operation.	Under planning to be fixed. (Date undecided)
6	Robot Program	The escape operation is large, the rotation speed will be fast, so it is necessary to suppress the table rotation speed to ensure the escape operation.	Under planning to be fixed. (Date undecided)
7	Edit Bounding Box	To enable bounding box editing for batch setup created with CAM prior to V2.05, you need to click the OK button in the Batch Setup command.	No plan to be fixed. *For spec
8	Behavior of YASKAWA arcs	When creating a coordinated arc with a YASKAWA machine (excluding ENe and Le), the M_DOWN command executes deceleration processing. If this affects machining, delete the M_DOWN command and insert the ARCCTE command. For instructions on entering the ARCCTE command, refer to the Operation Reference.	Under planning to be fixed. (Date undecided)
9	Behavior of YASKAWA arcs	When creating a coordinated arc with a YASKAWA machine (excluding Le), there is an issue where the trajectory is shifted during filler welding due to the mechanical specifications. On the actual machine, insert M_FILDW between the approach and start of welding. M_FILDW lowers the filler nozzle and starts machining. At the end, the filler nozzle will rise without any settings. There is no need to add M_FILUP.	Under planning to be fixed. (Date undecided)

# Precautions and Limitations on use (3/5)

PD: Production Designer

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#	Category	Content	Planned date
10	FANUC Program	Repeat data created with CAM, including spot welding, created with YASKAWA machines cannot be used with FANUC machines. "RoboGuide Program File Syntax Error" is displayed in the simulation.	-
11	DUCT	When a spline is split, the split edges may also become candidates for welding lines. If there are few selectable surfaces in a conical shape, product placement may not be possible.	Under planning to be fixed. (Date undecided)
12	Product PSM	When selecting non-sheet metal splines, it may take more than 10 seconds for the weld line to be added.	Under planning to be fixed. (Date undecided)
13	ALL	If you open data for which a setup has been created on another machine, problems may occur. If you open the data on a different machine, delete the setup and recreate it.	-
14	Weld Condition	For duct patterns, modifying the head tilt angle will only change the start point angle. Please change it by using the head edit.	Under planning to be fixed. (Date undecided)
15	PX Load Backup	If the actual machine parameters are not reflected, the trajectory of the collaborative operation simulation may be misaligned. Operate CAM on a machine that has had the actual machine parameters reflected in PX.	Under planning to be fixed. (Date undecided)
16	PX Load Backup	If you are operating WELDCAM in a server-client environment, please run the "Load backup" command on the PX on the client PC.	No plan to be fixed. *For spec

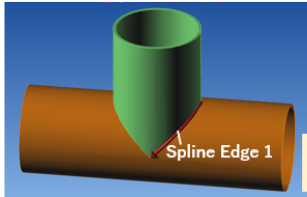

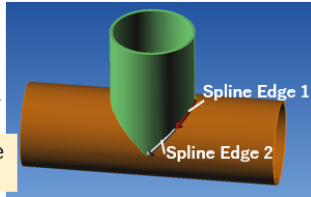









# Precautions and Limitations on use (4/5)

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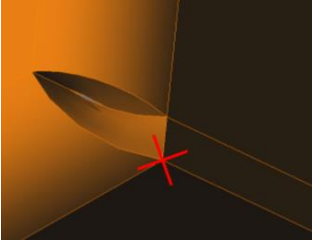


#	Category	Content	Planned date																											
17	DUCT	<p>When a weld edge is divided, all lateral angles after the split in the welding conditions will be the value of the first edge.</p> <p>After the robot path is generated, there will be no effect unless you reset the path or reapply the welding conditions.</p> <p>In this case, to manually change the lateral angle of the starting point.</p> <div><div></div><div></div><div></div></div> <div><div>Spline Edge 1   <input type="text" value="45.00"/>  deg</div><div>Spline Edge 1   <input type="text" value="45.00"/>  deg</div><div>Spline Edge 2   <input type="text" value="45.00"/>  deg</div></div> <table><thead><tr><th></th><th>Robot Path</th><th>Lateral Angle</th></tr></thead><tbody><tr><td>1</td><td>Start Point</td><td>45</td></tr><tr><td>2</td><td>Control Point</td><td>47</td></tr><tr><td>3</td><td>Control Point</td><td>55</td></tr><tr><td>4</td><td>End Point</td><td>63</td></tr><tr><td>5</td><td>Start Point</td><td>45</td></tr><tr><td>6</td><td>Control Point</td><td>82</td></tr><tr><td>7</td><td>Control Point</td><td>90</td></tr><tr><td>8</td><td>End Point</td><td>90</td></tr></tbody></table>		Robot Path	Lateral Angle	1	Start Point	45	2	Control Point	47	3	Control Point	55	4	End Point	63	5	Start Point	45	6	Control Point	82	7	Control Point	90	8	End Point	90	Under planning to be fixed. (Date undecided)
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# Precautions and Limitations on use (5/5)

PD: Production Designer  
 PX: Parameter Explorer  
 DX: Data Explorer



#	Category	Content	Planned date
18	AI-TAS	<p>The shape created by PD shape recognition may differ from the actual shape. In this case, the success rate of AI-TAS correction using CAM images may decrease significantly.</p> <p>If the correction fails, switch the AMNC AI setting from CAM to Camera and run it again.</p> <div> <div>Actual</div>  </div> <div> <div>CAM image</div>  </div>	-