

## **AMNEST Version V2.1 Patch A-Z Update (10/31/06)**

### **NOTE**

This is a cumulative patch file update for Amnest V2.1 that fixes the following problems and adds the following enhancements for nesting.

### **Bug Fixes/Enhancements:**

- 1) "Unable to find SP tool name in GSP/PSP file." error during Production Schedule print from Nesting Data Manager.
- 2) Allows Amnest to change Y size of CR tool to its radius value when saving into MiniSDD.
- 3) Fixes a problem in locating part files from old version of MRP file (version 5.00 and older).
- 4) Fixes a problem with cutting condition number and pierce number when new thickness is added to Laser Cutting Condition table.
- 5) Fixes a buffer overflow error in Layout Editor.
- 6) Fixes a problem with air blow and M-code settings in BCP module.
- 7) Fixes a laser post-processor error (AP100US V5).
- 8) Adds Vip3610 machine.
- 9) Supports AMNC-F setup header output to nested G-code program file.
- 10) Fixes the problem of G41/G42 and G00 being in separate lines.
- 11) Adds Vip2510 machine with AMNC-F setup header support.
- 12) Post Processor error when process a BLS common line part (605811D). CR tool that was placed outside part boundary triggered the bug. (Fnarmain.exe)
- 13) Not able to load AP100G part with Multi-tool station from MiniSDD. Tool station numbers other than T1xx, T2xx, T3xx were not handled correctly. (NcConversion.dll)
- 14) Able to print full G-code file path at the top of the printouts from G-code simulation. (GcodeSim.exe)
- 15) Added user option to disable following two functions:
  - a) Retract clamp when turret rotates
  - b) Avoid clamp travel through turret

Please see Figure 1 for the registry image. You must add string data for each setting. Data value 0 means "disable". You can add new string data in Windows registry by going to Hkey Local Machine => Software => Amada => Nesting => 2.0 => Option folder and clicking right mouse button to select New => String Value. For the first new string, please type in the following text:

Avoid clamp travel through turret

For the second new string, please type in the following text:

Retract clamp when turret rotates

Please ensure that all software are closed and exited before changing/modifying Windows registry.

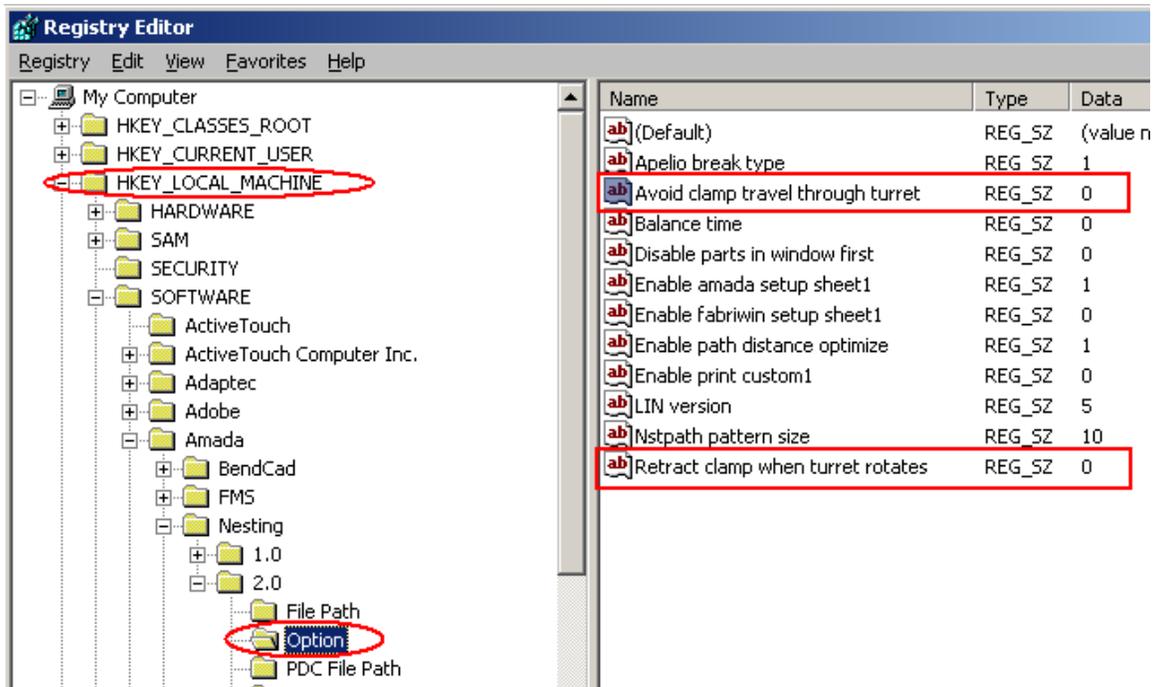


Figure 1.

- 16) Support M696 (Power vacuum die for EM machine). Also outputs M13 to cancel press M code instead of M500.
- 17) Partially fixes the memory error after selecting blank sheet (FNSTNEST.EXE error).
- 18) Eliminate unnecessary reposition in the beginning of program when "Process After Repo" is selected.
- 19) Allows free angle part rotation to long punch part (longer than 42 inches) in Layout Editor. User needs to add registry string data of "Max rotation length" under Hkey Local Machine => Software => Amada => Nesting => Option folder. (See Figure 2).

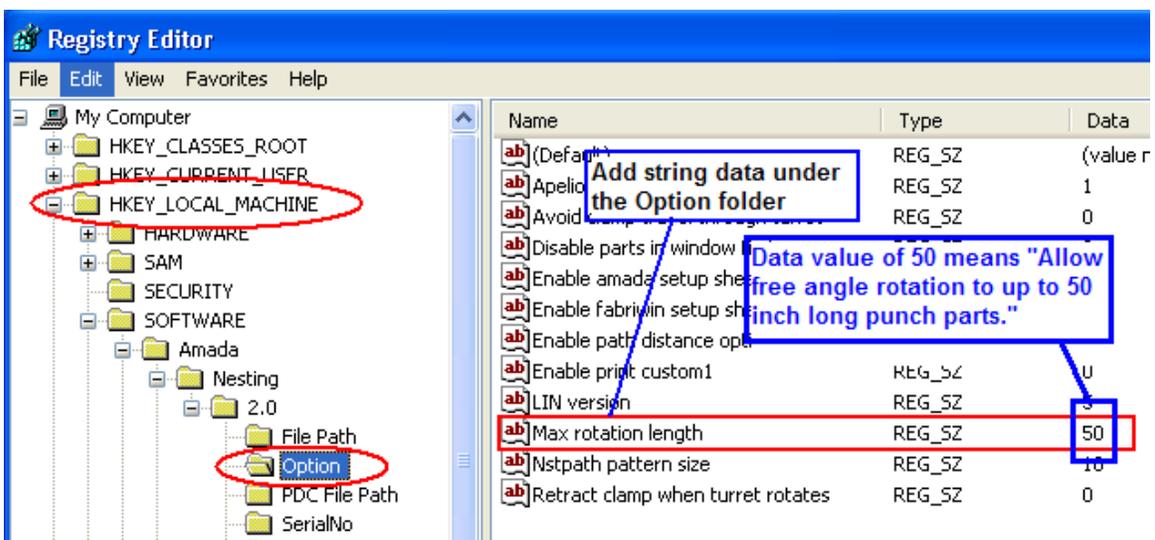


Figure 2.

- 20) Common line punch being shifted if original code has G66 J180.  
NOTE: Unequal location of gap or break of shear punch along the top and bottom (or left and right) edge of part can cause unexpected tool overlap in common line punch. (Limitation).
- 21) Vipros L-Shear max scrap size (of M228 y and M229 x) has been increased from 17.716 (450mm) to 25.59 (650mm).
- 22) Accept BLS Bin number selection other than 1 thru 9. Also outputs G10M3050 for L-shear sheet unload.
- 23) Fixed BLS G-code simulation bug - Improper y axis overtravel error on L-shear code.
- 24) Fixed an invisible but serious bug in punch free shape pre-processor (G-code Parser error).
- 25) Fixed a problem with UV macro number 1-59 (as well as 90 and larger) not being executed when it's being stored and requires W call to execute it.
- 26) Fixed a problem with duplicate punch hits when Process After Repo option is selected.
- 27) Fixed a problem with laser post outputting improper G92 command with G90 (G92G90X\_\_Y\_\_).
28. Fixed common line punch problem with parts perimeter share by G28 pattern.  
NOTE: Double punch may occur during common-line cut with SP tool hits on part perimeter due to different C angle in single part program since Amnest doesn't know if SP tool shape is symmetrical. (Limitation).
29. Fixed the problem in "Process After Repo" option on long parts.
30. Fixed incorrect vipros M code being output with ULX last hits.
31. Fixed incorrect tool angles appearing in AI Angle Sort when nesting ULX parts.
32. Fixed extra reposition being output in the beginning of laser program when Process After Repo is ON.
33. Resolved "COMBI type is not supported by LayoutEditor data conversion" error after selecting Edit Layout button from Choose Pattern window for particular layout.
34. In DX nesting, allow a part to be nested in low left corner of sheet. As the same as regular BLS nesting, user must know interference of NCT tools when selecting this option.
35. Adds 48A station turret to Amnest V2.1.
36. Generate .GCD file for blank parts nest on L shear. This is because AMNET line controller requires .GCD for blank parts nest sheet. AMNEST will create a replica of .BLS file. So you'll have both .BLS and .GCD file.
37. Eliminate blade clearance M code (M80, M81, M82, M83, or M84) output in L shear nesting program.
38. Output M13 (Press Mode Cancel) to cancel current Vipros press M-code before another Vipros press M-code is called out in the nested program. This function is enabled when the controller type is set to "F-AMNC" in the machine parameter manager.
39. Resolve application error that occurs at end of process under Windows XP such as error at end of pre-process or error at end of layout process.
40. Bug fix for Fnstnest.exe error at middle of SHAPE layout process.
41. Fixes application error in middle of nesting layout process (Rect or BLS Nest type).

42. Fixes application error in middle of preprocessor (after tool check/reassign). Nested parts quantity becomes incorrect when nesting layout is edited in Layout Editor for some cases. (Shape Nest type).
43. Fixes missing laser code in nested program when Process after Repo option is selected with apelio machine. (Apelio Nest).
44. Fixes missing X or Y coordinate in nested program when there are more than one tool punching same position. (Punch Nest).
45. Adds user option in system registry (BLS Repo Option 1) to handle Vipros L-shear clamps going out of sheet. Also, fixes Y-axis overtravel and missing shear data. (BLS Nest).
46. Fixes empty shear cut on L-shear and BLS.
47. Fixes MFC application error during PDC nesting.
48. Fixes undefined tooling error in output G-code after editing a pattern in Layout Editor.

## **NOTE**

Ensure that Amnest software is closed and exited before installing the patch file. Also, it is always a good practice to backup your original files before installing/updating with new files. This update is designed to be installed to default installation path structure of Target Drive Letter\Program Files\AMNEST.

## **Installation Instructions (Win 2000, XP):**

1) Run Amnest\_V210\_PatchA\_W.exe and enter "C:" in Unzip to folder. This will copy "Fnarmain.exe", "Fnlsrgcd.exe", "Fnpost.exe", "Fnprepro.exe", "Fnshare.exe", "Fnstnest.exe", "Fntaprep.exe", "FpreproA.exe", "Fsasrgcd.exe", "Fslsrgcd.exe", "Fsltosrc.exe", "GcdPartLib.dll", "GcodeSim.exe", "LayoutEditorDataConv.dll", "LPM\_FsJkf.dll", "Mahchoic.txt", "NcConversion.dll", "Nesting.exe", "Ngtoprc.exe", "Nsprepro.exe", "NstBls.exe", "Nstblsdx.exe", "NstBpost.exe", "NstConf.dll", "NstMach.exe", "Nstnest.exe", "NstSched.exe", "Nstsrsgcd.exe", "NstStore.exe", "PDEToolChange.dll", "PpreproA.exe", "Prepro.exe", "SimApelio.dll", "SimFsApelio.dll", "SimFsLaser.dll", "SimPlasma.dll", "SimPunch.dll", "TurExpand.dll", and "Vipros\_list.dat" to C:\Program Files\Amnest\Ample\FMS\Bin\ folder; "Cam.dll" to C:\Program Files\Amnest\Ample\BCP\Bin\ folder; "45A4E.tur", "Mach.dat", and "48A.tur" to C:\Program Files\Amnest\Ample\Param\ folder; and "Mecha.dbs" and "Turret.dbs" to C:\Program Files\Amnest\Ample\Times\ folder. Please substitute your hard drive letter for "C" as required.

2) When the Winzip Self-Extractor opens, ensure that "Overwrite files without prompting" is checked.

3) Select the Unzip button to unzip the files.

4) Double-click Amnest icon on the desktop to run Amnest.

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