

AMNEST Version V5.0 Patch A-D Update (12/01/16)

NOTE

This is a cumulative patch file update for Amnest V5.0 that fixes the following problems for nesting.

BUG FIX:

Punch Nesting:

1. M13 code immediately after the U-V block of a series of punch hits in the same x or y coordinate causes an error from the post processor "SRC read error" and nesting fails.

```
:  
(UE1)  
X1.687Y18.125T331  
X1.625  
(VE1)  
M13  
:
```

2. For PDC machine, an extra % was output when G50 is output at the end of program.

3. Fixed unexpected error in AI Sort module when the number of times that T6xx, (and T5xx and T7xx) used in all patterns was exceeding 99 times.

Apelio II Nesting:

1. G-code Simulation did not draw U-V macro #1-#59 during the registration without W call for old Apelio (Apelio II).

2. Fixed a problem with G-code Simulator/Editor not showing tool hits for U-V block command in nested programs for Apelio II (05PLA) combination machine.

EML Nesting:

1. Fixed a problem with Amnest outputting incorrect M103A0 in nested program instead of M103 pierce.

Vipros L-Shear Nesting:

1. For Vipros L-shear machine, Pattern Plot function under the Print menu in Nesting Data Manager did not print parts layout pattern. It printed tool hits only.

2. For Vipros L-shear machine, clamp dead zone error was produced when shearing low-left large part. It happened when the low-left part is exceeding the shear dead zone x of right most clamp and there is a reposition to avoid clamp dead zone punch and blank sheet x size is within machine x travel distance.
3. Incorrect shear code was output when Trim at low left corner option is selected.
4. Fixed problem with missing trim cut in Amnest V5.0 for Vipros L-shear (NstBls.exe).

BLS/RECT Type Nesting:

1. Missing/incorrect parts information in the printout of G-code Simulation when parts are rotated.

Multi-Tool Station Turret Nesting:

1. When a multi-tool station tool is used in a part program, in some situations the G-code simulation gives "Internal error: utools <-- ptools" in the beginning.
2. AI Tool Sort dialog box shows no tools and crashes when press OK button when using multi-tool station turret.

PR/PRUL Nesting:

1. UL_Nester (parts unloading layout module) crashes when File->Save is selected if there is a lot of details on the part boundary geometry.
2. A patch to output M56 before G70Y_ as well as before G70X_G70Y_. M56 is required by the PR-L system. M56 is to move (or to ensure) the PR-L unit is in safe place so that EML can move during Punch mode.

```
M56  
G70Y_  
G70X_
```

or

```
M56  
G70X_Y_
```

3. Fixed an "fnmkgmt_utool-source-code read error" message during post processing in Amnest for ASL+EMLK3610NT+PR-UL system. Pre-processor displays a message and quit nesting when last hit was on a punch hit.

ENHANCEMENT:

General:

1. Blank sheet data editing feature in the Blank Sheet Selection. Highlight the desired blank sheet and click [Edit] button or double click the blank sheet to open a dialog to edit the blank sheet data.
2. Estimated total process time of the nest is included in the production schedule printout from the Nesting Data Manager.

Punch Nesting:

1. Support M180 work chute open/close code from input parts program and able to output to the nesting program.
2. Tool change feature in the G-code Simulation to edit used tools. Click [Tool Change] button available in the step draw G-code dialog to open a dialog to change the used tools. You can also add or delete tools for the G-code program. Make sure to manually edit the G-code program to match the used tools.

PR/PRUL/ASPR Nesting:

1. Unloading layout editor to edit parts stack of already-nested programs is available in the Nesting Data Manager. Click "Unloading Layout" under the "Edit" menu to open Parts Unloading-SY2 Editor. In the Parts Unloading-SY2 Editor, you can select other nested sheets (stacks) if you wish to view them together, then click [Edit Unloading Layout] button to open the unloading layout editor.
2. Support PR-L for EML machines.
3. Able to save/load PR parts unloading layout with nesting MRP input.
4. Added option to output M55 after G10X__. User must select "ASIIIMP Skeleton Pallet" as Unload Sheet destination. Unloader selection must be "PR-UL".

NOTE

- A. Image of parts in the unloading layout editor is represented by a rectangle box. The size of the box is the x and y size of boundary rectangle of the parts at nested angle. No details of outside boundary or inside holes of the parts are shown. In the parts view above the parts list, the location of the last hit is represented by a small circle.
- B. Once you edited the unloading layout, the unloading layout view displayed under the "Draw" menu or unloading layout printed out under "Print" menu will not match the

edited unloading layout. Also, unloading layout edited using Parts Unloading-SY2 Editor cannot be saved back to MRP file.

C. The Parts Unloading-SY2 Editor requires nested programs generated in AMNEST 5.0 w/ Patch A-D. Old programs will be rejected.

*Standalone version of Unloading layout editor is also available for AMNEST 5.0 users. Please contact AMADA software sales for terms and price.

Laser Nesting:

1. Support user option to output M707 (shuttle exchange) code for standalone FO & F1 lasers. User can select either to output M707 at the top of the nesting program or at the end of nesting program. Option setting is located in the Laser G-code tab of the Nesting Configuration.

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. If Amnest was installed to different directory path, please unzip self-extracting zip file to Temp folder and manually copy files to appropriate folder locations. For Win Vista and 7, please disable user account control settings during install.

INSTALLATION INSTRUCTIONS (WIN 2000, XP, Vista, 7):

1. Run Amnest_V500_PatchA_D.exe and enter "C:\\" in Unzip to folder. This will copy "AISortPriority.dll", "Fa2src1e.exe", "Fnarmain.exe", "fnprepro.exe", "Fnstnest.exe", "Fsasrgcd.exe", "Fsatosrc.exe", "Fslsrgcd.exe", "GCode2GeoLib.dll", "GcodeSim.exe", "LastHit.exe", "LayoutEditor.exe", "LayoutEditorDataConv.dll", "Nesting.exe", "Ngtoprc.exe", "NstBLS.exe", "NstConf.dll", "NstMatSelDll.dll", "NstPath.exe", "NstSched.exe", "Nstsrgcd.exe", "PR_param.dll", "Prepro.exe", "SimApelio.dll", "SY2Conv.dll", "UL_Nester.exe", and "ULSY2Editor.exe" to C:\Program Files\Amnest\Amp1e\FMS\Bin\ folder and "PR_L_V2_TEMPLATE.DAT", "PR_P_V1_TEMPLATE.DAT", "PR_P_V2_TEMPLATE.DAT", "SY2conv_template_inch.gmt" and "SY2conv_template_mm.gmt" to C:\Program Files\Amnest\Amp1e\FMS\Data\ folder. Please substitute your hard drive letter for "C" as required. For Win Vista and 7, user may need to unzip self-extracting zip file to Temp folder and manually copy files to appropriate folder locations.

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.

CONTACT INFORMATION:

Amada America Inc.
7025 Firestone Blvd.
Buena Park, CA 90621
(800) 626-6612

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

Microsoft Windows 2000, XP, Vista, and 7 are registered trademarks or trademarks of Microsoft Corporation in the United States and/or other countries. Amnest is a trademark of Amada America Inc.