

POST PROCESSOR INFO

NEW ORDERS

For new orders it's essential that we obtain all of the requested information to provide a working post processor. Our delivery time is 7-10 business days from when we receive all of the requested information. If any of the requested information has been omitted, is inaccurate or incomplete, it may cause a delay resulting in a longer delivery time.

Requested Information:

- o **Machine Make :** _____
- o **Machine Model :** _____
- o **Controller Make & Model :** _____
- o **Sample Program** *(See below)*
- o **Programming Manual** *(Document or download link)*
- o **Use Subroutines** *(if "Yes" include sample code)*
☐ Yes ☐ No
- o **Drilling Canned Cycles**
☐ Yes ☐ No
- o **Other Canned Cycles** *(i.e. Frame Milling)*
☐ Yes ☐ No
 If "Yes" please specify : _____
- o **Coolant** *(Select all applicable)*
☐ Flood ☐ Thru Spindle ☐ Mist ☐ Air ☐ Other
 If "Other" please specify : _____

(Milling Only)

- o **4TH Axis**
☐ A ☐ B ☐ C ☐ N/A
- o **5TH Axis**
☐ A ☐ B ☐ C ☐ N/A
- o **Right Angle Head**
☐ Yes ☐ No
- o **Gang Drill** *(Routers Only)*
☐ Yes ☐ No
- o **Side Drill** *(Routers Only)*
☐ Yes ☐ No
- o **Tool Changer**
☐ Automatic ☐ Manual
- o **W Axis**
☐ Yes ☐ No

(Turning/Mill-Turn Only)

- o **Sub-Spindle**
☐ Yes ☐ No
- o **Sub-Spindle Axis**
☐ X ☐ Y ☐ Z ☐ A ☐ B ☐ C ☐ None
- o **Live Tooling**
☐ Yes ☐ No
- o **Y Axis**
☐ Yes ☐ No
- o **C Axis**
☐ Yes ☐ No
- o **Auxiliary Equipment** *(i.e. Bar Feeder)*
☐ Yes ☐ No
 If "Yes" please specify: _____

Sample Program

A good sample program should contain the following:

- Preferred Formatting
- Tool Changes
- Drill Cycle
- Tap Cycle
- Contour Operation
- Roughing Operation
- Consecutive operations using the same tool
- Sample code for auxiliary equipment, such as a bar feeder

The information provided above is not comprehensive and we may need additional information upon request. After the completion of this form, please save and upload it with the rest of the requested information using the link below.

[Click Here](#) to upload all requested documentation.

Post Processor Edits

The accuracy and delivery time of post processors are highly dependent on the information provided to us. We expect users to be familiar with their machine tool and to have tested and verified the requested change prior submitting the request.

When submitting a request, keep in mind that all changes are to be taken literally (including perceived typos), and any incomplete, insufficient, or indecisive edit requests may cause a delay in our 7-10 business day delivery time.

Summary

- When Submitting SOLIDWORKS files, remove all operations that are not pertinent to the requested changes. Only send files containing the Setups, Tools, and Operations relevant to the requested changes. We recommend creating a copy of the SOLIDWORKS file for the post edit.
- Include a brief explanation of what you want modified.
- Before submission, verify the requested modification works on your machine.
- If you are unfamiliar with g-code or your particular machine's control requirements, it may be necessary for you to first contact the manufacturer for verification.

Required

1. SOLIDWORKS file(s) used to produce the g-code.
2. Name of the post processor (*see below*).
3. Original g-code file containing the corrections without modifying the original output (*see example below*). Please rename it to match the SOLIDWORKS part/assembly name followed by "-markedup" (filename-markedup.txt).
4. G-code file that **ONLY** contains what the output should look like (*see example below*). This file should not contain anything that you don't want added/modified. Please rename it to match the SOLIDWORKS part/assembly name.

Original g-code file containing corrections

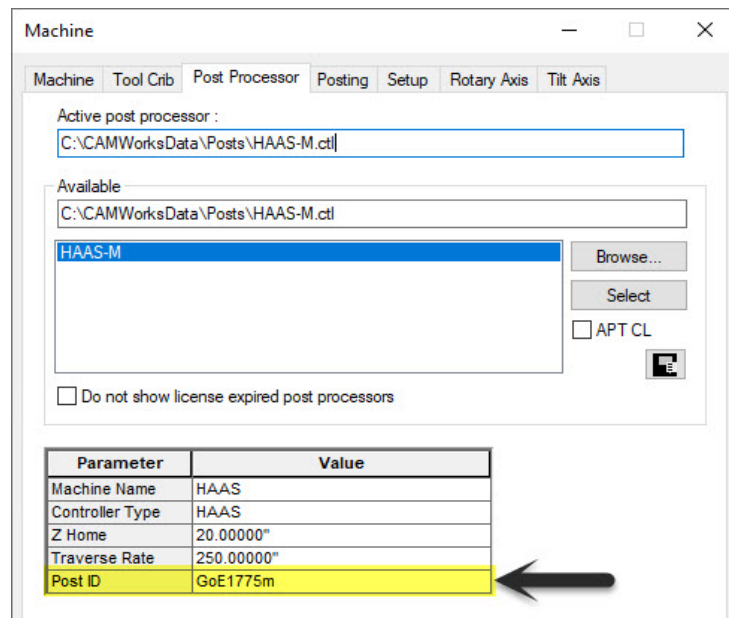
```
O0001
N1 G20
N2 G91 G28 X0 Y0 Z0 <<< Should be G91 G00 G28 X0 Y0
                        <<< Z0 on its own line here
N3 T01 M06             <<< Add tool comment
N4 S2000 M03
N5 G90 G54 G00 X-.778 Y.205
N6 G43 Z5.18 H01 M08 <<< Move coolant to the next line
```

G-code file containing output desired

```
O0001
N1 G20
N2 G91 G00 G28 X0 Y0
Nx Z0
N3 T01 M06 (1/2 EM CRB 2FL 1-1/2 LOC)
N4 S2000 M03
N5 G90 G54 G00 X-.778 Y.205
N6 G43 Z5.18 H01
Nx M08
```

POST ID

You can locate the post ID in the "Post Processor" tab of the Machine Definition



(For post processor edit requests only)

Send All files and information to: support@goengineer.com

Subject line: Post Processor Change Request [POST ID]

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Sorry, access to this document has been removed. Please contact the person who shared it with you.

TECHNICAL DETAILS

GO BACK TO SITE