



How to Get Your Post Modified

Follow the steps outlined below to ensure that your post processor is modified to your desired specifications with minimum delay and expense.

Send an email explaining your request, including contact information to: post@camcnc.com

Attach the following to your email:

- One (1) marked-up g-code program (with comments turned on)
- One (1) .gcpkg (Pack and Go) file that was used to create the g-code program

If your email attachment is **larger than 20MB**, you can:

- Upload your files to your own file share site, if you have one, and send the link to post@camcnc.com or:
- Email us at post@camcnc.com and we will send you a direct upload link.

The image below illustrates how the g-code program would be marked up in the desired manner.

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%
O1234( POST EDITS.NCF )
( OUTPUT IN ABSOLUTE INCHES )
( FORMAT: FANUC 30IMB C001.220A.POST )
( MDD: VMILL3A.MDD REV: 12 )
( PARTS PROGRAMMED: 1 )

( -- TOOL LIST -- )          <--( ADD TOOL LIST )
( T1 = 1/2 FINISH ENDMILL, .015 RAD. )    <--( TOOL COMMENT )
( T2 = 1/2 FINISH ENDMILL, .005 RAD. )

( -- WFO LIST -- )          <--( ADD WFO's USED ONLY )
( G54 = X0. Y0. Z0. )

G0G17G20G40G54G80G90G94
G91G49G28Z0.          <--( REMOVE THESE 4 LINES )
G90X.2277Y.1094
M1

( OPERATION 1: CONTOUR )
( T1 = 1/2 FINISH ENDMILL, .015 RAD. )    <--( TOOL COMMENT )
( G54 = X0. Y0. Z0. )
N1 G17 G20 G94 G40 G54 G80 <--( ADD SPACES TO ALL CODES & ADD WFO# HERE )
T1M6
T2
S10000M3
G54
G90G0X.0422Y2.1369
G43Z1.H1
M8
Z.1
G1Z-1.F18.
G41X.0819Y2.1065D1
G3X.152Y2.1157I.0305J.0396
G1X.2554Y2.2504F45.
G2X.9535I.349J.-2679
G1X1.1602Y1.981
G1X.2554Y2.2504F45.
  
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