



How to Have Your Post Processor Modified

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

Send the following to the GibbsCAM Post Department:

- One (1) marked-up g-code program (with comments turned on)
- One (1) Pack n' Go file (gcpkg) using the GibbsCAM file that was used to create the g-code program
- Your contact information

Upload your Pack n' Go file (gcpkg) and marked-up file here – [GibbsCAM Post Dept Upload Site](#)

Send an email and explain your request to post@gibbscam.com

You will receive notification of receipt right away.

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

The screenshot shows a WordPad window titled "133-24989-01-OP1 - WordPad". The window contains a g-code program with several lines of code. Annotations are placed to the right of the code, indicating modifications to be made. The code is as follows:

```
O2( PROGRAM: 133-24989-01-OP1.NCF )
( REV A )
( FORMAT: FANUC 6M [VG] M001.19.PST )
( 12/7/06 AT 3:38 PM )
( OUTPUT IN ABSOLUTE INCHES )
( PARTS PROGRAMMED: 1 )
( FIRST TOOL NOT IN SPINDLE )
N1G17G40G80
N2T1
N3M6
( OPERATION 1: ROUGHING )
( ROUGH )
( TOOL 1: 2. SHELL ENDMILL )
N4G54
N5S8000M3
N6G90G0X-4.0994Y6.1
N7G43Z1.H1
N8M8
N9Z.1
N10G12-.0845F80.
N11Y5.
N12X-4.75F100.
N13G3X-5.Y4.75J-.25
N14G1Y4.0994
N15G2X-4.0994Y5.I5.J-4.0994
N16G1X-3.6407Y4.3933
N17X-3.6344Y4.3855
N18G3X-3.6407Y4.3813T 0232T 019
```

Annotations in the image:

- "Place T1 and M6 on the same line" is placed to the right of line N2T1.
- "Change M8 to M7" is placed to the right of line N8M8.
- "Change all I's, J's and K's to R output" is placed to the right of line N15G2X-4.0994Y5.I5.J-4.0994.