



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@GibbsCAM.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 50MB**, you can:

- Upload your files to your own file share site, if you have one, and send the link to the GibbsCAM Post Department, or
- Email us at solutions@DrCNCConsulting.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.

```
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
N10G1Z-.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
N18G3Y-3.5922Y4.3813T.0232T.019
```

Place T1 and M6 on the same line

Change M8 to M7

Change all I's, J's and K's to R output