‘Off the Shelf Posts’

Post Processor library
Wire EDM, Punch Press, 2-Axis Machines

Note that these post processor program are supplied “AS IS”. Read the disclaimer on the following page prior to using any of these post.

Since our customers constantly ask ‘Do you have a post off the shelf’, we decided to put most of the custom post we have written into a book. This book is for helping you easily pick a post processor.

All these posts were written based on information supplied by the customer who purchased the post. They are all customized to varying degrees, but we tried not to included any post that were highly customized to one shops specific needs. We went through and had our best post programmer look at and comment on the source code of each post. These comments are not necessarily about the output but about the source code programming itself. Posts with error checking are good to select. They contain logic that checks the part program for errors. Another good choice are the ‘Dealer standard’ posts. These posts are speced out by dealers who bundle Shopcam with their Machine tools. Avoid posts that are highly customized or have features you don’t need. Make sure to read the helpfile associated with the post. It will have the same name as the post with a .txt extension.

We do not verify the post was for a certain machine. So don’t take the actual control model number to serious. Since controls are put on different machines, we suggest you search by control first. We listed the sample output on one page per post. Some long lines of code may have wrapped to the next line. Especially on two column long lines with spaces.

Most of the posts are written to output coordinates in inch mode regardless of the part program mode. Maybe 15% support both based on the mode the part program was written in. A couple output in metric regardless of the part program mode.

Having a post processor fine tuned to your needs is well worth the small fee. If you decide to order a custom post, pick one that is close to your needs. This will reduce our time it takes to program a post exactly the way you want. Make sure to follow the ‘Post processor revision checklist’ on page 3.

Disclaimer:

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POST PROCESSOR REVISION CHECKLIST

In the course of using your post processor, you may find it necessary to request post revisions. Unless there is a problem that makes the post unusable, try to use it for a couple weeks. Keep track of the changes needed and try to use the Shopcam Operations that need support. To avoid any guesswork or assumptions, it is important that you provide the following files.

☐ **filename.PRT; A Shopcam part file with a couple different operations.**

This Shopcam program should be typical of the work you do. It is important to include this file since the post may or may not be doing something, because of the part program. When revising the post, we may be able to suggest easier or quicker ways of programming, based on this part..

☐ **filename.TAP; The tapefile as posted from the part program.**

Do not make any changes to this file. With this file, we can verify that the post you are using is the latest revision and that the changes are made to the same post.

☐ **filename.NEW; The tapefile after making the required edits.**

If possible, try to actually run the part on the machine, after editing it. If the edited part does not run properly, edit the file on the computer and download again. Do not make edits on the control.

DOs and DON'Ts

1) Do **not** go back and edit the filename.PRT once you have started the editing procedure.
2) Do **not** simple markup a printout of an unedited posted filename.tap**.**
3) Do **not** edit in canned ruffing cycles, unless the post was written for canned cycles.
4) Do **not** edit in Subroutines or macros, unless the post was written for subroutines.
5) Do **not** make edits at the control. Make them on the computer and download again.
6) **Do** read the helpfile if there is one. This will have a .HLP suffix. Copy to .TXT for Windows.
7) **Do** print the edited filename.tap and add notes, if you think it will help.
8) Do **not** hesitate to call, if you have any questions.

If you follow this procedure, I can almost guarantee that you will not need anymore revisions.

Either send a disk to: D. Broderick Software LLC.
106 W. Midland Rd.
Auburn, MI 48611

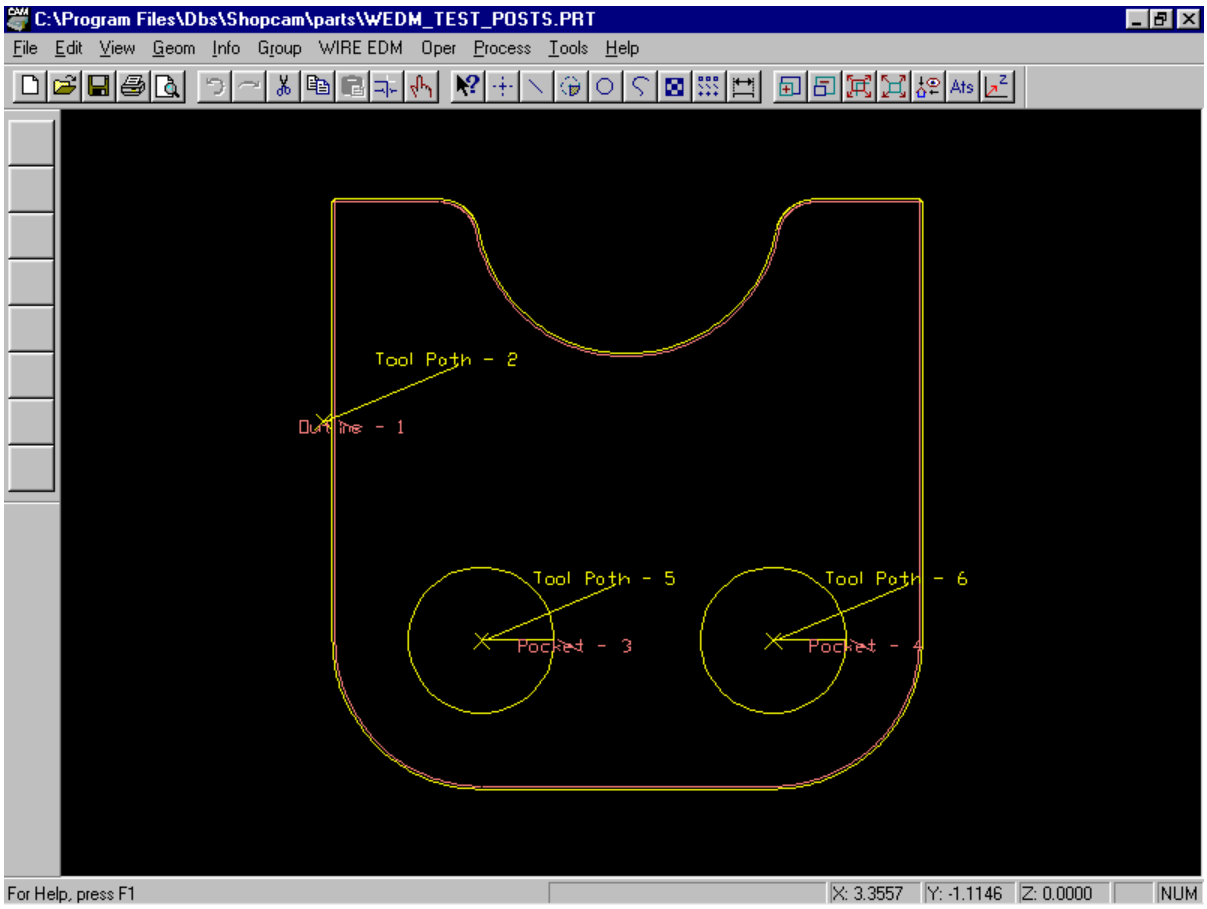
or email to: Dan@shopcam.com

Allow one to five days for revisions.

WIRE EDM

About the sample part

Below is a screen capture of the part used to generate the sample output.



This is a simple part that cuts CCW around the part and then cuts a couple circular pockets.

This part was programmed for the most common posts. Read the post instructions to see if the post requires different program commands.

The tool width is .010 and CDC right is active. [Tool Ang 1] is set to 5 and the [Power] field is set to 23.

Post name:	Agie100b
Machine type:	Wire EDM
Machine name:	Agie DEM 315 Wire EDM
Control:	Agiemeric CNC 100/3
Inch/Metric:	Metric
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good. Has error checking to catch illegal Agie moves. Supports 2-plane (4-axis)

```
%N005 D03 P03 T02 G43
N010 G01 Y-019050 G44
N015 G01 X+000749 G40
N020 G03 X+012827 Y-012827 I+012827 G44
N025 G01 X+025400
N030 G03 X+012827 Y+012827 J+012827
N035 G01 Y+038100
N040 G03 X-000127 Y+000127 I-000127
N045 G01 X-009104
N050 G03 X-003241 Y-002671 J-003302
N055 G02 X-013055 Y-010756 I-013055 J+002544
N060 G02 X-013055 Y+010756 J+013300
N065 G03 X-003241 Y+002671 I-003241 J-000631
N070 G01 X-009104
N075 G03 X-000127 Y-000127 J-000127
N080 G01 Y-019050 G44
N085 G01 Y-001000
N090 G01 X-000749 G40
N095 G01 X+013614 Y-019050 G40  M22
N100 G01 X+006312
N105 G02 X-006350 Y-006350 I-006350
N110 G02 X-006350 Y+006350 J+006350
N115 G02 X+006350 Y+006350 I+006350
N120 G02 X+006350 Y-006350 J-006350
N125 G01 X-006325
N130 G01 X+025413 G40  M22
N135 G01 X+006312
N140 G02 X-006350 Y-006350 I-006350
N145 G02 X-006350 Y+006350 J+006350
N150 G02 X+006350 Y+006350 I+006350
N155 G02 X+006350 Y-006350 J-006350
N160 G01 X-006325
N165 G45 M21 M02
```

Post name: Agie-15
Machine type: Wire EDM
Machine name: Agie DEM 15
Control: Agiemeric NBY 15
Inch/Metric: Inch
Absolute/Incremental: Incremental
Post programmer notes: Highly customized per Agie.

```
##< WEDM_TEST_POSTS AGIE-15NC > Thu May 03 10:58:55 2001'##%      001   01
      000   000   +000295     +000000     01    00
      002   01    000   000   +000000     -007500     01    00
      003   03    180   090   +005050     +005050     01    00
      004   01    000   000   +010000     +000000     01    00
      005   03    270   090   +005050     +005050     01    00
      006   01    000   000   +000000     +015000     01    00
      007   03    000   090   +000050     +000050     01    00
      008   01    000   000   -003584     +000000     01    00
      009   03    090   078   +001300     +001300     01    00
      010   01    000   000   -000004     -000022     01    00
      011   01    000   000   -000018     -000087     01    00
      012   02    012   156   +005236     +005236     01    00
      013   01    000   000   -000018     +000087     01    00
      014   01    000   000   -000004     +000022     01    00
      015   03    012   078   +001300     +001300     01    00
      016   01    000   000   -003584     +000000     01    00
      017   03    090   090   +000050     +000050     01    00
      018   01    000   000   +000000     -007500     01    00
      019   01    000   000   -000295     +000000     01    00
      020   01    000   000   +005360     -007500     01    00
      021   01    000   000   +002485     +000000     01    00
      022   02    360   000   +002500     +002500     01    00
      023   01    000   000   -002490     +000000     01    00
      024   01    000   000   +010005     +000000     01    00
      025   01    000   000   +002485     +000000     01    00
      026   02    360   000   +002500     +002500     01    00
      027   01    000   000   -002490     +000000     01    00
      028   01    000   000   +000000     +000000     00    02
##
```

Post name:	Bro-wedm
Machine type:	Wire EDM
Machine name:	Brother Wire EDM
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Supports 2-plane (4-axis).

```
G90
G0X96550Y225000
G1G42X99500H1
Y150000
G3X150000Y99500I50500J0
G1X250000
G3X300500Y150000I0J50500
G1Y300000
G3X300000Y300500I-500J0
G1X264157
G3X251397Y289986I0J-13000
G2X148603I-51397J10014
G3X135843Y300500I-12760J-2486
G1X100000
G3X99500Y300000I0J-500
G1Y225000
G40X96550
G0X150150Y150000
G1X175000
G2I-25000J0
G1X150100
G0X250150
G1X275000
G2I-25000J0
G1X250100
M02
```

Post name:	Bro-wire
Machine type:	Wire EDM
Machine name:	Brother Wire EDM
Control:	Fanuc
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Has wire tread support and support for 2-plane (4-axis).

```
 G90
 G92 X0 Y0
 M22
 M86
 G01 X0.995
 G42
 Y1.5
 G03 X1.5 Y0.995 I0.505
 G01 X2.5
 G03 X3.005 Y1.5 J0.505
 G01 Y3.0
 G03 X3.0 Y3.005 I-0.005
 G01 X2.6416
 G03 X2.514 Y2.8999 J-0.13
 G02 X1.486 I-0.514 J0.1001
 G03 X1.3584 Y3.005 I-0.1276 J-0.0249
 G01 X1.0
 G03 X0.995 Y3.0 J-0.005
 G01 Y2.25
 G40
 X0.9655
 M23
 G00 X1.5015 Y1.5
 M22
 G01 X1.75
 G02 X1.25 I-0.25
 X1.75 I0.25 J0.0
 G01 X1.501
 M23
 G00 X2.5015 Y1.5
 M22
 G01 X2.75
 G02 X2.25 I-0.25
 X2.75 I0.25 J0.0
 G01 X2.501
 M87
 M23
 M30
%
```

Post name:	Charm-18
Machine type:	Wire EDM
Machine name:	Charmilles Wire EDM
Control:	Fanuc 16WB
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
O0001(WEDM_TEST_POSTS _ Thu May 03 12:16:57 2001')
N0010 G90
N0020 G92
N0030 M31
N0040 G00 X0.9655 Y2.25(RAP 1)
N0050 M60
N0060 M86
N0070 G01 G42 X0.995
N0080 Y1.5
N0090 G03 X1.5 Y0.995 I0.505 J0.0
N0100 G01 X2.5
N0110 G03 X3.005 Y1.5 I0.0 J0.505
N0120 G01 Y3.0
N0130 G03 X3.0 Y3.005 I-0.005 J0.0
N0140 G01 X2.6416
N0150 G03 X2.514 Y2.8999 I0.0 J-0.13
N0160 G02 X1.486 I-0.514 J0.1001
N0170 G03 X1.3584 Y3.005 I-0.1276 J-0.0249
N0180 G01 X1.0
N0190 G03 X0.995 Y3.0 I0.0 J-0.005
N0200 G01 Y2.25
N0210 G40 X0.9655
N0220 M50
N0230 G00 X1.5015 Y1.5(RAP 2)
N0240 G90
N0250 G92
N0260 M60
N0270 G01 X1.75
N0280 G02 I-0.25 J0.0
N0290 G01 X1.501
N0300 M50
N0310 G00 X2.5015 Y1.5(RAP 3)
N0320 G90
N0330 G92
N0340 M60
N0350 G01 X2.75
N0360 G02 I-0.25 J0.0
N0370 G01 X2.501
N0380 M46
N0390 M50
N0400 M30
%
```

Post name:	Charm-f
Machine type:	Wire EDM
Machine name:	Charmilles Wire EDM
Control:	Fanuc 16WB
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
O0001(WEDM_TEST_POSTS _ Thu May 03 12:17:26 2001')
M27
M23
M24
M28
M31
G00X0.9655Y2.25
M60
S301
G01G42X0.995
Y1.5
G03X1.5Y0.995I0.505J0.0
G01X2.5
G03X3.005Y1.5I0.0J0.505
G01Y3.0
G03X3.0Y3.005I-0.005J0.0
G01X2.64157
G03X2.51397Y2.89986I0.0J-0.13
G02X1.48603I-0.51397J0.10014
G03X1.35843Y3.005I-0.1276J-0.02486
G01X1.0
G03X0.995Y3.0I0.0J-0.005
G01Y2.25
G40X0.9655
M50
G00X1.5015Y1.5
G92
S306
M60
G01X1.75
G02I-0.25J0.0
G01X1.501
M50
G00X2.5015Y1.5
G92
S306
M60
G01X2.75
G02I-0.25J0.0
G01X2.501
M50
M30
%
```

Post name:	Chr-robo
Machine type:	Wire EDM
Machine name:	Charmilles Andrew Wire EDM
Control:	Robofil 310
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
( WEDM_TEST_POSTS  Thu May 03 12:17:56 2001')
N5 G70 G90 M28
N10 G92 X0.9655 Y2.25
N15 G01 X0.995 Y2.25
N20 G42 D3
N25 X0.995 Y1.5
N30 G03 X1.5 Y0.995 I1.5 J1.5
N35 G01 X2.5 Y0.995
N40 G03 X3.005 Y1.5 I2.5 J1.5
N45 G01 X3.005 Y3.0
N50 G03 X3.0 Y3.005 I3.0 J3.0
N55 G01 X2.64157 Y3.005
N60 G03 X2.51397 Y2.89986 I2.64157 J2.875
N65 G02 X1.48603 Y2.89986 I2.0 J3.0
N70 G03 X1.35843 Y3.005 I1.35843 J2.875
N75 G01 X1.0 Y3.005
N80 G03 X0.995 Y3.0 I1.0 J3.0
N85 G01 X0.995 Y2.25
N90 M01
N95 G40
N100 X0.9655 Y2.25
N105 G00 X1.5015 Y1.5
N110 G01 X1.75 Y1.5
N115 G02 X1.25 Y1.5 I1.5 J1.5
N120 X1.75 Y1.5 I1.5 J1.5
N125 G01 X1.501 Y1.5
N130 G00 X2.5015 Y1.5
N135 G01 X2.75 Y1.5
N140 G02 X2.25 Y1.5 I2.5 J1.5
N145 X2.75 Y1.5 I2.5 J1.5
N150 G01 X2.501 Y1.5
N155 M02
```

Post name: Ec3040
Machine type: Wire EDM
Machine name: Makino Wire EDM
Control:
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good, mild customization.

```
< WEDM_TEST_POSTS   _   MAK-EC3040 >#  Thu May 03 12:19:23 2001'%
O0001  ( WEDM_TEST_POSTS  Thu May 03 12:19:23 2001')
N5G20G90
N10G92X0.9655Y2.25
N15G01G42D3X0.995E2M17
N20Y1.5
N25G03X1.5Y0.995I0.505J0.0
N30G01X2.5
N35G03X3.005Y1.5I0.0J0.505
N40G01Y3.0
N45G03X3.0Y3.005I-0.005J0.0
N50G01X2.6416
N55G03X2.514Y2.8999I0.0J-0.13
N60G02X1.486I-0.514J0.1001
N65G03X1.3584Y3.005I-0.1276J-0.0249
N70G01X1.0
N75G03X0.995Y3.0I0.0J-0.005
N80G01Y2.25M18
N85G40X0.9655
N90G00X1.5015Y1.5E567
N95G01X1.75M17
N100G02I-0.25J0.0
N105G01X1.501M18
N110G00X2.5015
N115G01X2.75M17
N120G02I-0.25J0.0
N125G01X2.501
N130M02
%~
#< END OF WEDM_TEST_POSTS >#  Thu May 03 12:19:23 2001'
```

Post name:	Elox-6m
Machine type:	Wire EDM
Machine name:	Elox Wire EDM
Control:	Fanuc 6MB
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
N1G90
N2G92X0.9655Y2.25
N3M80
N4G01G42D03G50X0.995Y2.25
N5Y1.5
N6G03X1.5Y0.995I0.505
N7G01X2.5
N8G03X3.005Y1.5J0.505
N9G01Y3.0
N10G03X3.0Y3.005I-0.005
N11G01X2.6416
N12G03X2.514Y2.8999J-0.13
N13G02X1.486I-0.514J0.1001
N14G03X1.3584Y3.005I-0.1276J-0.0249
N15G01X1.0
N16G03X0.995Y3.0J-0.005
N17G01Y2.25
N18G40X0.9655M00
N19G00X1.5015Y1.5M00
N20G01G52X1.75T5.0
N21G02I-0.25
N22G01X1.501
N23G00X2.5015M00
N24G01G51X2.75T3.0
N25G02I-0.25
N26G01X2.501
N27M40
N28G00X0.9655Y2.25M00
N29M30
%
```

Post name:	Fan16edm
Machine type:	Wire EDM
Machine name:	Generic Wire EDM
Control:	Fanuc 16WB
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
O0001(WEDM_TEST_POSTS Thu May 03 12:57:53 2001')
N0010 G92 X0.9655 Y2.25
N0020 G01 G90 G42 X0.995
N0030 Y1.5
N0040 G03 X1.5 Y0.995 I0.505 J0.0
N0050 G01 X2.5
N0060 G03 X3.005 Y1.5 I0.0 J0.505
N0070 G01 Y3.0
N0080 G03 X3.0 Y3.005 I-0.005 J0.0
N0090 G01 X2.6416
N0100 G03 X2.514 Y2.8999 I0.0 J-0.13
N0110 G02 X1.486 I-0.514 J0.1001
N0120 G03 X1.3584 Y3.005 I-0.1276 J-0.0249
N0130 G01 X1.0
N0140 G03 X0.995 Y3.0 I0.0 J-0.005
N0150 G01 Y2.25
N0160 G40 X0.9655
N0170 G00 X1.5015 Y1.5
N0180 G01 X1.75
N0190 G02 I-0.25 J0.0
N0200 G01 X1.501
N0210 G00 X2.5015 Y1.5
N0220 G01 X2.75
N0230 G02 I-0.25 J0.0
N0240 G01 X2.501
N0250 M71
N0260 M99
%
```

Post name:	Fan-16w
Machine type:	Wire EDM
Machine name:	Generic Wire EDM
Control:	Fanuc 16WB
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Mild customization, counts and out puts rapids.

```
%
O0001(WEDM_TEST_POSTS _ Thu May 03 12:58:26 2001')
N0010 G90
N0020 G92
N0030 M31
N0040 G00 X0.9655 Y2.25(RAP 1)
N0050 M60
N0060 M86
N0070 G01 G42 X0.995
N0080 Y1.5
N0090 G03 X1.5 Y0.995 I0.505 J0.0
N0100 G01 X2.5
N0110 G03 X3.005 Y1.5 I0.0 J0.505
N0120 G01 Y3.0
N0130 G03 X3.0 Y3.005 I-0.005 J0.0
N0140 G01 X2.6416
N0150 G03 X2.514 Y2.8999 I0.0 J-0.13
N0160 G02 X1.486 I-0.514 J0.1001
N0170 G03 X1.3584 Y3.005 I-0.1276 J-0.0249
N0180 G01 X1.0
N0190 G03 X0.995 Y3.0 I0.0 J-0.005
N0200 G01 Y2.25
N0210 G40 X0.9655
N0220 M50
N0230 G00 X1.5015 Y1.5(RAP 2)
N0240 G90
N0250 G92
N0260 M60
N0270 G01 X1.75
N0280 G02 I-0.25 J0.0
N0290 G01 X1.501
N0300 M50
N0310 G00 X2.5015 Y1.5(RAP 3)
N0320 G90
N0330 G92
N0340 M60
N0350 G01 X2.75
N0360 G02 I-0.25 J0.0
N0370 G01 X2.501
N0380 M46
N0390 M50
N0400 M30
%
```

Post name:	Fan-wire
Machine type:	Wire EDM
Machine name:	Generic Wire EDM
Control:	Fanuc 16WB
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
O0001(WEDM_TEST_POSTS _ Thu May 03 14:46:08 2001')
N0010 G90
N0020 G92 X0.9655 Y2.25 I1.0 J0
N0030 M31
N0040 G01 G42 X0.995
N0050 M60
N0060 M86
N0070 Y1.5
N0080 G03 X1.5 Y0.995 I0.505 J0.0
N0090 G01 X2.5
N0100 G03 X3.005 Y1.5 I0.0 J0.505
N0110 G01 Y3.0
N0120 G03 X3.0 Y3.005 I-0.005 J0.0
N0130 G01 X2.6416
N0140 G03 X2.514 Y2.8999 I0.0 J-0.13
N0150 G02 X1.486 I-0.514 J0.1001
N0160 G03 X1.3584 Y3.005 I-0.1276 J-0.0249
N0170 G01 X1.0
N0180 G03 X0.995 Y3.0 I0.0 J-0.005
N0190 G01 Y2.25
N0200 G40 X0.9655
N0210 M50
N0220 G00 X1.5015 Y1.5
N0230 G90
N0240 G92
N0250 M60
N0260 G01 X1.75
N0270 G02 I-0.25 J0.0
N0280 G01 X1.501
N0290 M50
N0300 G00 X2.5015 Y1.5
N0310 G90
N0320 G92
N0330 M60
N0340 G01 X2.75
N0350 G02 I-0.25 J0.0
N0360 G01 X2.501
N0370 M50
N0380 M30
%
```

Post name: Japax
Machine type: Wire EDM
Machine name: Japax 3F Wire EDM
Control:
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good.

```
#< WEDM_TEST_POSTS  _  JAPAX > Fri May 04 11:55:29 2001'%
G20
G90G92X0.9605Y2.25
G01G42X0.99D01A05
Y1.5
G03X1.5Y0.99R0.51
G01X2.5
G03X3.01Y1.5R0.51
G01Y3.
G03X3.Y3.01R0.01
G01X2.64157
G03X2.50906Y2.90082R0.135
G02X2.Y2.48137R0.51863
X1.49094Y2.90082R0.51863
G03X1.35843Y3.01R0.135
G01X1.
G03X0.99Y3.R0.01
G01Y2.25
G40X0.9605A00A0
M32
G00X1.5015Y1.5
M33
G01X1.75A05
G02X1.5Y1.25R0.25
X1.25Y1.5R0.25
X1.5Y1.75R0.25
X1.75Y1.5R0.25
G01X1.501A0
M32
G00X2.5015
M33
G01X2.75A03
G02X2.5Y1.25R0.25
X2.25Y1.5R0.25
X2.5Y1.75R0.25
X2.75Y1.5R0.25
G01X2.501
M02
%
```

Post name:	Japax-3d
Machine type:	Wire EDM
Machine name:	Japax LV3 Wire EDM
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Has error checking for maximum tilt exceeded. 4-Axis UV outputs the wire guide rather than the part surface.

```
%
N1G20
N2G00G90G92X0.9605Y2.25
N3G00X0.9605Y2.25
N4G42G01X0.99D01
N5Y1.5
N6G03X1.5Y0.99R0.51
N7G01X2.5
N8G03X3.01Y1.5R0.51
N9G01Y3.
N10G03X3.Y3.01R0.01
N11G01X2.64157
N12G03X2.50906Y2.90082R0.135
N13G02X1.49094R0.51863
N14G03X1.35843Y3.01R0.135
N15G01X1.
N16G03X0.99Y3.R0.01
N17G01Y2.25
N18G40X0.9605A00M00
N19G00X1.5015Y1.5A00M00
N20G01X1.75
N21G02R-0.25
N22G01X1.501A00M00
N23G00X2.5015A00M00
N24G01X2.75
N25G02R-0.25
N26G01X2.501M02A00M00M2D00
%
```

Post name:	Jap-ext
Machine type:	Wire EDM
Machine name:	Japax LV3 Wire EDM
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. 4-Axis UV outputs the wire guide rather than the part surface.

```
%
N1G20
N2G00G90G92X0.9605Y2.25
N3G00X0.9605Y2.25
N4G42G01X0.99D01
N5Y1.5
N6G03X1.5Y0.99R0.51
N7G01X2.5
N8G03X3.01Y1.5R0.51
N9G01Y3.
N10G03X3.Y3.01R0.01
N11G01X2.64157
N12G03X2.50906Y2.90082R0.135
N13G02X1.49094R0.51863
N14G03X1.35843Y3.01R0.135
N15G01X1.
N16G03X0.99Y3.R0.01
N17G01Y2.25
N18G40X0.9605A00M00
N19G00X1.5015Y1.5A00M00
N20G01X1.75
N21G02R-0.25
N22G01X1.501A00M00
N23G00X2.5015A00M00
N24G01X2.75
N25G02R-0.25
N26G01X2.501M02A00M00M2D00
%
```

Post name: Jap-lv3
Machine type: Wire EDM
Machine name: Japax LV3 Wire EDM
Control:
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks OK.

```
< WEDM_TEST_POSTS _ JAP-LV3 >#  Fri May 04 11:57:23 2001'%
N5G20
N10G00G90G92X0.9605Y2.25
N15G42G01X0.99D01
N20Y1.5
N25G03X1.5Y0.99R0.51
N30G01X2.5
N35G03X3.01Y1.5R0.51
N40G01Y3.
N45G03X3.Y3.01R0.01
N50G01X2.64157
N55G03X2.50906Y2.90082R0.135
N60G02X1.49094R0.51863
N65G03X1.35843Y3.01R0.135
N70G01X1.
N75G03X0.99Y3.R0.01
N80G01Y2.25
N85X0.9605
N90G00X1.5015Y1.5
N95G01X1.75
N100G02R-0.25
N105G01X1.501
N110G00X2.5015
N115G01X2.75
N120G02R-0.25
N125G01X2.501
N130M02
%
```

Post name:	Ja[x-3f
Machine type:	Wire EDM
Machine name:	Japax 3F Wire EDM
Control:	
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good, no 2 plane support.

```
%
N1 G90 G92 X0.9605 Y2.25
N2 G00 X0.9605 Y2.25
N3 G42 G01 X0.99 D01
N4 Y1.5
N5 G03 X1.5 Y0.99 R0.51
N6 G01 X2.5
N7 G03 X3.01 Y1.5 R0.51
N8 G01 Y3.
N9 G03 X3. Y3.01 R0.01
N10 G01 X2.6416
N11 G03 X2.5091 Y2.9008 R0.135
N12 G02 X1.4909 R0.5186
N13 G03 X1.3584 Y3.01 R0.135
N14 G01 X1.
N15 G03 X0.99 Y3. R0.01
N16 G01 Y2.25
N17 G40 X0.9605 A00 M00
N18 G00 X1.5015 Y1.5 A00 M00
N19 G01 X1.75
N20 G02 R-0.25
N21 G01 X1.501 A00 M00
N22 G00 X2.5015 A00 M00
N23 G01 X2.75
N24 G02 R-0.25
N25 G01 X2.501
N26 A00 M00 D00
N27 M02
%
```

Post name:	Mak-ec4
Machine type:	Wire EDM
Machine name:	Makino Wire EDM
Control:	
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good, extrapolates 4-Axis guides.

```
%
O0123
N1G20G90
N2G0X0.9605Y2.25M6
N3M17G01X0.99E23G51T5.0G42D3
N4Y1.5
N5G03X1.5Y0.99I0.51J0.0
N6G01X2.5
N7G03X3.01Y1.5I0.0J0.51
N8G01Y3.0
N9G03X3.0Y3.01I-0.01J0.0
N10G01X2.6416
N11G03X2.5091Y2.9008I0.0J-0.135
N12G02X1.4909I-0.5091J0.0992
N13G03X1.3584Y3.01I-0.1325J-0.0258
N14G01X1.0
N15G03X0.99Y3.0I0.0J-0.01
N16G01Y2.25
N17X0.9605G40G50
N18G00X1.5015Y1.5M6
N19M17G01X1.75E567G51T5.0
N20G02I-0.25J0.0
N21G01X1.501G50
N22G00X2.5015M6
N23M17G01X2.75G52T3.0
N24G02I-0.25J0.0
N25G01X2.501G50
N26M30
%~
```

Post name:	Meld-w
Machine type:	Wire EDM
Machine name:	Mitsubishi Wire EDM
Control:	
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
N005%%%
N010G90
N015G25X0Y0
N020X.9605Y2.2500F020000
N025M80
N030M82
N035M84
N040M90
N045G01G42X.9900F110000
N050Y1.5000
N055G03X1.5000Y.9900I.5100
N060G01X2.5000
N065G03X3.0100Y1.5000J.5100
N070G01Y3.0000
N075G03X3.0000Y3.0100I-.0100
N080G01X2.6416
N085G03X2.5091Y2.9008J-.1350
N090G02X1.4909Y2.9008I-.5091J.0992
N095G03X1.3584Y3.0100I-.1325J-
.0258
N100G01X1.0000
N105G03X.9900Y3.0000J-.0100
N110G01Y2.2500
N115G40X.9605
N120M81
N125M83
N130M85
N135M91
N140G01X1.5015Y1.5000F020000
N145M80
N150M82
N155M84
N160M90
N165G01X1.7500F060000
N170G02X1.2500Y1.5000I-.2500
N175X1.7500Y1.5000I.2500
N180G01X1.5010
N185M81
N190M83
N195M85
N200M91
N205G01X2.5015F020000
N210M80
N215M82
N220M84
N225M90
N230G01X2.7500F060000
N235G02X2.2500Y1.5000I-.2500
N240X2.7500Y1.5000I.2500
N245G01X2.5010
N250M81
N255M83
N260M85
N265M91
N270M02
%
```

Post name: Mit-2
Machine type: Wire EDM
Machine name: Mitsubishi Wire EDM
Control:
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good, has tilt and volt support.

```
#< WEDM_TEST_POSTS _ MITSUBISHI WIRE-CUT> %
 Fri May 11 10:51:49 2001'
N001M20
N002M80
N003M82
N004M84
N005G90
N006G92X9605Y22500
N007G00X9605Y22500
N008G42
N009G01X9900F110000
N010Y15000
N011G03X15000Y9900I5100
N012G01X25000
N013G03X30100Y15000J5100
N014G01Y30000
N015G03X30000Y30100I-100
N016G01X26416
N017G03X25091Y29008J-1350
N018G02X14909I-5091J992
N019G03X13584Y30100I-1325J-258
N020G01X10000
N021G03X9900Y30000J-100
N022G01Y22500
N023G40
N024X9605
N025G00X15015Y15000
N026G01X17500F60000
N027G02I-2500
N028G01X15010
N029G00X25015
N030G01X27500
N031G02I-2500
N032G01X25010
N033M02
%%<       END>#
```

Post name:	Mit-gbc
Machine type:	Wire EDM
Machine name:	Mitsubishi Wire EDM
Control:	Mitsubishi Series G
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
#<  WEDM_TEST_POSTS _ MIT-GBC >  %
 Fri May 11 10:52:46 2001'

N0001M80
N0002M82
N0003M84
N0004G90
N0005G92X9605Y22500
N0006G01G42H03X9900F110000M91
N0007G01Y15000M90
N0008G03X15000Y9900I5100
N0009G01X25000
N0010G03X30100Y15000J5100
N0011G01Y30000
N0012G03X30000Y30100I-100
N0013G01X26416
N0014G03X25091Y29008J-1350
N0015G02X14909Y29008I-5091J992
N0016G03X13584Y30100I-1325J-258
N0017G01X10000
N0018G03X9900Y30000J-100
N0019G01Y22500
N0020M00
N0021G01G40X9605
N0022M00
N0023G01X15015Y15000F90000M91
N0024M00
N0025G01X17500F60000M91
N0026G02X12500Y15000I-2500
N0027G02X17500Y15000I2500
N0028G01X15010
N0029M00
N0030G01X25015F90000M91
N0031M00
N0032G01X27500F60000M91
N0033G02X22500Y15000I-2500
N0034G02X27500Y15000I2500
N0035G01X25010M91
N0036M02
%% #< END OF WEDM_TEST_POSTS >
           Fri May 11 10:52:47 2001'
```

Post name:	Mit-gn1
Machine type:	Wire EDM
Machine name:	Mitsubishi Wire EDM
Control:	Mitsubishi Series G
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
#< WEDM_TEST_POSTS _ MIT-GN1 >  % Fri May 11 10:56:32 2001'
M80
M82
M84
G90
G92X.9605Y2.25
G01G42H03X.99F11.0000M90
Y1.5
G03X1.5Y.99R.51
G01X2.5
G03X3.01Y1.5R.51
G01Y3.0
G03X3.0Y3.01R.01
G01X2.64157
G03X2.50906Y2.90082R.135
G02X1.49094R.51863
G03X1.35843Y3.01R.135
G01X1.0
G03X.99Y3.0R.01
G01Y2.25
G40X.9605
X1.5015Y1.5
X1.75F6.0000
G02I-.25J.0
G01X1.501
X2.5015
X2.75
G02I-.25J.0
G01X2.501M91
M02
%% #< END OF WEDM_TEST_POSTS >    Fri May 11 10:56:32 2001'
```

Post name:	Mits-fx
Machine type:	Wire EDM
Machine name:	Mitsubishi Wire EDM
Control:	FX-10
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
N0005G90M78
N0010M78
N0015M20
N0020G92X.9605Y2.25
N0025E23H03A5.0
N0030M80M82M84
N0035G01G42X.99F11.0
N0040Y1.5
N0045G03X1.5Y.99I.51
N0050G01X2.5
N0055G03X3.01Y1.5J.51
N0060G01Y3.0
N0065G03X3.0Y3.01I-.01
N0070G01X2.64157
N0075G03X2.50906Y2.90082J-.135
N0080G02X1.49094Y2.90082I-.50906J.09918
N0085G03X1.35843Y3.01I-.13251J-.02582
N0090G01X1.0
N0095G03X.99Y3.0J-.01
N0100G01Y2.25
N0105G40A0X.9605
N0110E567A5.0
N0115M21
N0120M91
N0125G01X1.5015Y1.5F10.0
N0130M90
N0135M20
N0140M80M82M84
N0145G01X1.75F6.0
N0150G02X1.25Y1.5I-.25
N0155X1.75Y1.5I.25
N0160G01X1.501H05
N0165A-3.0
N0170M21
N0175M91
N0180G01X2.5015F10.0
N0185M90
N0190M20
N0195M80M82M84
N0200G01X2.75F6.0
N0205G02X2.25Y1.5I-.25
N0210X2.75Y1.5I.25
N0215G01X2.501
N0220M02
%
```

Post name:	Ona-prim
Machine type:	Wire EDM
Machine name:	Ona Prima Wire EDM
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good, supports 2-Axis and tilt.

```
%
G90
G54X1
G00X.9605Y2.25
G00Z0
G51
G64X5.0
M60
G69X-.5U23W3
G42
G01X.99
G01Y1.5
G03X1.5Y.99I.51J.0
G01X2.5
G03X3.01Y1.5I.0J.51
G01Y3.0
G03X3.0Y3.01I-.01J.0
G01X2.64157
G03X2.50906Y2.90082I.0J-.135
G02X1.49094I-.50906J.09918
G03X1.35843Y3.01I-.13251J-.02582
G01X1.0
G03X.99Y3.0I.0J-.01
G01Y2.25
G01X.9605
G50
G40
G00X1.5015Y1.5
G51
G64X5.0
G01X1.75
G02I-.25J.0
G01X1.501
G00X2.5015
G52
G64X3.0
G01X2.75
G02I-.25J.0
G01X2.501
G50
M02
%
```

Post name: Robo-310
Machine type: Wire EDM
Machine name: Charmilles Andrew Wire EDM
Control: Robilfil 310
Inch/Metric: Both
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good.

```
(WEDM_TEST_POSTS.ISO Fri May 11 14:03:08 2001')
%
N5 G92 G70 G90 X0.9605 Y2.25
N10 E23
N15 G01 X0.99 Y2.25 A5.0 G42 D3
N20 G01 X0.99 Y1.5
N25 G03 X1.5 Y0.99 I1.5 J1.5
N30 G01 X2.5 Y0.99
N35 G03 X3.01 Y1.5 I2.5 J1.5
N40 G01 X3.01 Y3.0
N45 G03 X3.0 Y3.01 I3.0 J3.0
N50 G01 X2.64157 Y3.01
N55 G03 X2.50906 Y2.90082 I2.64157 J2.875
N60 G02 X1.49094 Y2.90082 I2.0 J3.0
N65 G03 X1.35843 Y3.01 I1.35843 J2.875
N70 G01 X1.0 Y3.01
N75 G03 X0.99 Y3.0 I1.0 J3.0
N80 G01 X0.99 Y2.25
N85 G40
N90 G01 X0.9605 Y2.25
N95 E567
N100 G00 X1.5015 Y1.5

N105 G01 X1.75 Y1.5
N110 G02 X1.25 Y1.5 I1.5 J1.5
N115 G02 X1.75 Y1.5 I1.5 J1.5
N120 G01 X1.501 Y1.5
N125 G00 X2.5015 Y1.5

N130 G01 X2.75 Y1.5
N135 G02 X2.25 Y1.5 I2.5 J1.5
N140 G02 X2.75 Y1.5 I2.5 J1.5
N145 G01 X2.501 Y1.5
N150 M02
```

Post name:	Robilfil
Machine type:	Wire EDM
Machine name:	Charmilles Andrew Wire EDM
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good, no 4-Axis.

```
%
G70G90M28
G92X0.9605Y2.25
E23H3.1811
G42A5.0D3
G01X0.99
G01Y1.5
G03X1.5Y0.99I1.5J1.5
G01X2.5
G03X3.01Y1.5I2.5J1.5
G01Y3.0
G03X3.0Y3.01I3.0J3.0
G01X2.64157
G03X2.50906Y2.90082I2.64157J2.875
G02X2.0Y2.48137I2.0J3.0
G02X1.49094Y2.90082I2.0J3.0
G03X1.35843Y3.01I1.35843J2.875
G01X1.0
G03X0.99Y3.0I1.0J3.0
G01Y2.25
G40A
G01X0.9605
E567H3.1811
G00X1.5015Y1.5
G01X1.75
G02X1.5Y1.25I1.5J1.5
G02X1.25Y1.5I1.5J1.5
G02X1.5Y1.75I1.5J1.5
G02X1.75Y1.5I1.5J1.5
G01X1.501
G00X2.5015
G01X2.75
G02X2.5Y1.25I2.5J1.5
G02X2.25Y1.5I2.5J1.5
G02X2.5Y1.75I2.5J1.5
G02X2.75Y1.5I2.5J1.5
G01X2.501
M02
```

Post name:	Seibu-w
Machine type:	Wire EDM
Machine name:	Seibu Wire EDM
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good.

```
W000
N001G91
N002A5.0
N003G01G42X2950
N004Y-75000
N005G03X51000Y-51000I51000J0
N006G01X100000
N007G03X51000Y51000I0J51000
N008G01Y150000
N009G03X-1000Y1000I-1000J0
N010G01X-35843
N011G03X-13251Y-10918I0J-13500
N012G02X-101812I-50906J9918
N013G03X-13251Y10918I-13251J-2582
N014G01X-35843
N015G03X-1000Y-1000I0J-1000
N016G01Y-75000
N017G40X-2950
N018X54100Y-75000
N019X24850
N020G02I-25000J0
N021G01X-24900
N022A-3.0
N023X100050
N024X24850
N025G02I-25000J0
N026G01X-24900
N027M02
```

Post name:	Wedmfanp
Machine type:	Wire EDM
Machine name:	Generic Wire EDM
Control:	Fanuc P
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
O0001
N5G90G20
N10G92X0Y0
N15G00G52X0.9605Y2.25T5.0
N20G01G42D03X0.99
N25Y1.5
N30G03X1.5Y0.99I0.51
N35G01X2.5
N40G03X3.01Y1.5J0.51
N45G01Y3.0
N50G03X3.0Y3.01I-0.01
N55G01X2.6416
N60G03X2.5091Y2.9008J-0.135
N65G02X1.4909I-0.5091J0.0992
N70G03X1.3584Y3.01I-0.1325J-0.0258
N75G01X1.0
N80G03X0.99Y3.0J-0.01
N85G01Y2.25
N90G50G40X0.9605
N95G00X1.5015Y1.5
N100G01X1.75
N105G02I-0.25
N110G01X1.501
N115G00G51X2.5015T3.0
N120G01X2.75
N125G02I-0.25
N130G01X2.501
N135M30
N140M99
%
```

Post name: Sod-2801
Machine type: Wire EDM
Machine name: Sodick Wire EDM
Control:
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good.

```
"(WEDM_TEST_POSTS Fri May 11 15:20:15 2001');"
"(            ON OFF  IP  HP MA SV  V   SF  C  WT WS   WP  WC);"
"C000   =    002 020 016 000 19 05 03 0007 00 000 000 000 000;"
"H000   = +00000000(X DISPLAY);"
"H001   = +00000000(Y DISPLAY);"
"T88;"
"T80;"
"T86;"
"C23;"
"H3;"
"G90;"
"G54;"
"G92;"
"G00X.9605Y2.25;"
"G29;"
"G51A5.0;"
"G01G42X.99;"
"G01Y1.5;"
"G03X1.5Y.99I.51J.0;"
"G01X2.5;"
"G03X3.01Y1.5I.0J.51;"
"G01Y3.0;"
"G03X3.0Y3.01I-.01J.0;"
"G01X2.64157;"
"G03X2.50906Y2.90082I.0J-.135;"
"G02X1.49094I-.50906J.09918;"
"G03X1.35843Y3.01I-.13251J-.02582;"
"G01X1.0;"
"G03X.99Y3.0I.0J-.01;"
"G01Y2.25;"
"G01G40X.9605;"
"C567;"
"G00X1.5015Y1.5;"
"G51A5.0;"
"G01X1.75;"
"G02I-.25J.0;"
"G01X1.501;"
"H5;"
"G00X2.5015;"
"G52A3.0;"
"G01X2.75;"
"G02I-.25J.0;"
"G01X2.501;"
"T81;"
"G50;"
"M02;"
";"
```

Post name:	Sodick-w
Machine type:	Wire EDM
Machine name:	Sodick Wire EDM
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
(WEDM_TEST_POSTS Fri May 11 15:20:47 2001')
T84
G54
N001G90
N002G92X.9605Y2.25
N003G52A5.0
C23
H3
N004G52A5.0
N005G01G42X.99
N006G01Y1.5
N007G03X1.5Y.99I.51J.0
N008G01X2.5
N009G03X3.01Y1.5I.0J.51
N010G01Y3.0
N011G03X3.0Y3.01I-.01J.0
N012G01X2.6416
N013G03X2.5091Y2.9008I.0J-.135
N014G02X1.4909I-.5091J.0992
N015G03X1.3584Y3.01I-.1325J-.0258
N016G01X1.0
N017G03X.99Y3.0I.0J-.01
N018G01Y2.25
N019G01G40X.9605
C567
N020G00X1.5015Y1.5
N021G51A5.0
N022G01X1.75
N023G02I-.25J.0
N024G01X1.501
H5
N025G00X2.5015
N026G51A3.0
N027G01X2.75
N028G02I-.25J.0
N029G01X2.501
N030M02
%
```

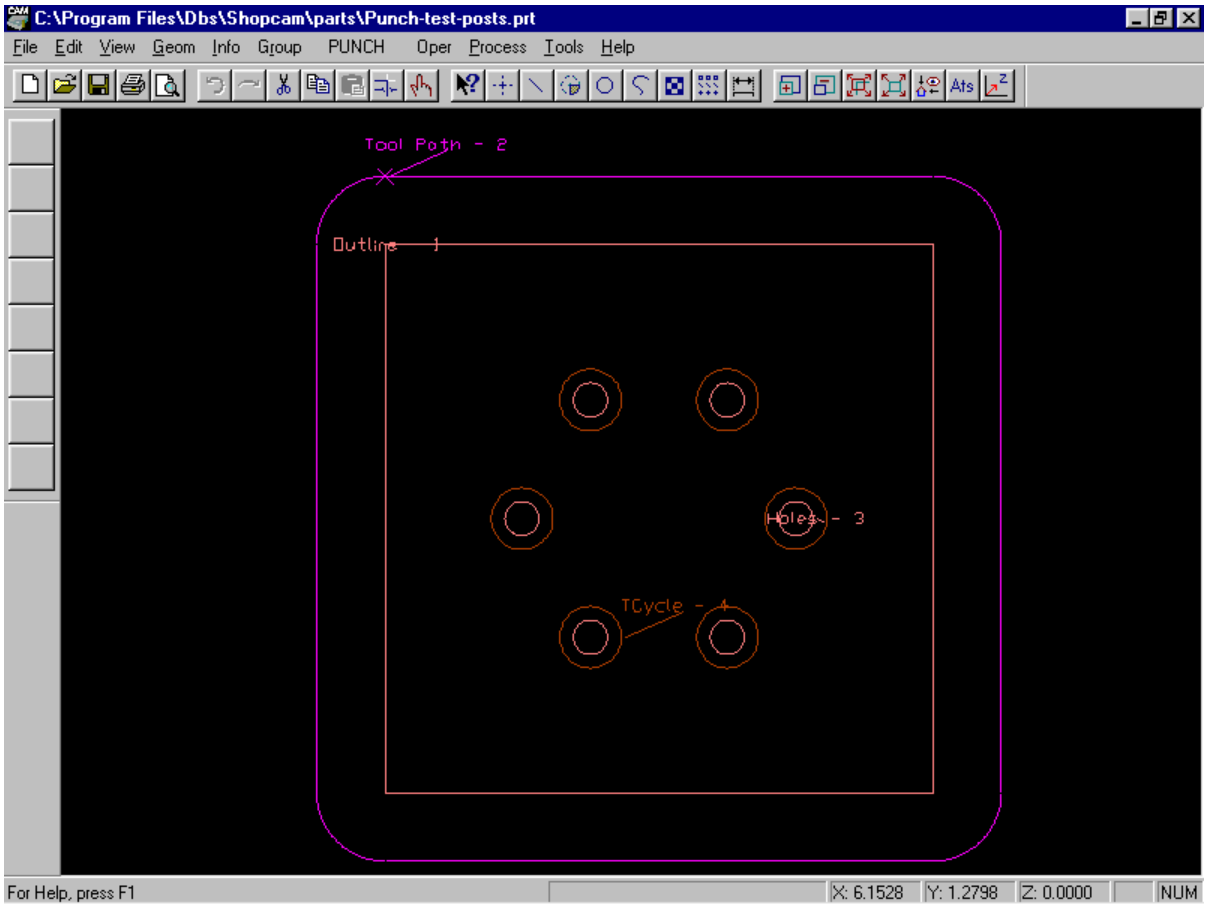
Post name: Sodic-w
Machine type: Wire EDM
Machine name: Sodick Wire EDM
Control:
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good.

```
"(            ON OFF  IP  HP MA SV  V   SF  C  WT WS   WP  WC);"
"C000   =    000 000 000 000 00 000 0 0000 00 000 000 000 000;"
"C001   =    000 000 000 000 00 000 0 0000 00 000 000 000 000;"
"H000   = +00000000;"
"H001   = +00000000;"
"N0000(MAIN PROGRAM);"
"T84;"
"G90;"
"G54;"
"T89;"
"M02;"
"N0001(SUB PRO 1/G42);"
"G51A50000;"
"G42H003;"
"G01X9900Y22500;"
"G01Y15000;"
"G03X15000Y9900I5100J0;"
"G01X25000;"
"G03X30100Y15000I0J5100;"
"G01Y30000;"
"G03X30000Y30100I-100J0;"
"G01X26416;"
"G03X25091Y29008I0J-1350;"
"G02X14909I-5091J992;"
"G03X13584Y30100I-1325J-258;"
"G01X10000;"
"G03X9900Y30000I0J-100;"
"G01Y22500;"
"G01X9605;"
"G40G50;"
"G00X15015Y15000;"
"G51A50000;"
"G01X17500;"
"G02I-2500J0;"
"G01X15010;"
"G00X25015;"
"G52A30000;"
"G01X27500;"
"G02I-2500J0;"
"G01X25010;"
"G50;"
"M99;"
```

PUNCH PRESS

About the sample part

Below is a screen capture of the part used to generate the sample output.



This punch press part will nibble around the shape then punch the circle pattern. If your machine doesn't support canned nibble cycles, you will need to use the [Nibble Punch] operation.

Post name: 1050-pp
Machine type: Punch Press
Machine name: Generic Punch Press
Control: GE 1050
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good. Mild customization, hard coded starting X & Y

```
%
N0001 X48.0
N0002 M53
N0003 X43.0
N0004 M54
N0005 X001.000 Y05.500   T01B
N0006 X005.000 Y05.500   T01B
N0007 X005.500 Y01.000   T01B
N0008 X001.000 Y00.500   T01B
N0009 X000.500 Y05.000   T01B
N0010 X002.500 Y02.134   T02B
N0011 X002.500 Y03.866   T02B
N0012 X003.500 Y03.866   T02B
N0013 X003.500 Y02.134   T02B
N0014 X004.000 Y03.000   T02B
N0015 X002.000 Y03.000   T02B
N0016 G49
N0017 M02
```

Post name:	Amanda-6
Machine type:	Punch Press
Machine name:	Amanda Punch Press
Control:	Fanuc 6M
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks OK. Has canned punching cycle support.

```
#<Punch-test-posts AMADA>#
(STOCK 0.0 X 0.0 0.0 GALV)
(CLAMP 0.0 0.0)
(Punch-test-posts)
N5G92X39.37Y40.945
N10G90
(T1 1.0 RO)
N15X1.0Y5.5T001
N20G69I4.0J0.0P0Q0.7
N25G72X5.0Y5.0
N30G68I0.5J90.0K-90.0P0Q0.7
N35G69I4.0J-90.0P0Q0.7
N40G72X5.0Y1.0
N45G68I0.5J0.0K-90.0P0Q0.7
N50G69I4.0J-180.0P0Q0.7
N55G72X1.0Y1.0
N60G68I0.5J-90.0K-90.0P0Q0.7
N65G69I4.0J90.0P0Q0.7
N70G72X1.0Y5.0
N75G68I0.5J180.0K-90.0P0Q0.7
(T2 0.45 RO)
N80X2.5Y2.134T002
N85Y3.866
N90X3.5
N95Y2.134
N100X4.0Y3.0
N105X2.0
N110G50
#<END OF Punch-test-posts >#
```

Post name:	Di-acro
Machine type:	Punch Press
Machine name:	Generic Punch Press
Control:	GN 6
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks OK.

```
%
O123
N5 G20
N10 G90 F1
N15 G52 X1.0 Y2.0
N20 G92 X40.0 Y38.0
N25 T1
N30 X5.0
N35 G72 X5.0 Y5.0
N40 G68 I0.5 J90.0 K-90.0 P0 Q0.1
N45 Y1.0
N50 G72 X5.0 Y1.0
N55 G68 I0.5 J0.0 K-90.0 P0 Q0.1
N60 X1.0
N65 G72 X1.0 Y1.0
N70 G68 I0.5 J270.0 K-90.0 P0 Q0.1
N75 Y5.0
N80 G72 X1.0 Y5.0
N85 G68 I0.5 J180.0 K-90.0 P0 Q0.1

N90 T2
N95 X2.5 Y2.134
N100 Y3.866
N105 X3.5
N110 Y2.134
N115 X4.0 Y3.0
N120 X2.0
N125 M30
%
```

Post name:	F3000-pp
Machine type:	Punch Press
Machine name:	Generic Punch Press
Control:	Fanuc 6M
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good.

```
G92X39370Y39370
G90
X1000Y5500T001
G69I4000J000P0Q0700
G72X5000Y5000
G68I0500J9000K-9000P0Q0700
G69I4000J-9000P0Q0700
G72X5000Y1000
G68I0500J000K-9000P0Q0700
G69I4000J-18000P0Q0700
G72X1000Y1000
G68I0500J-9000K-9000P0Q0700
G69I4000J9000P0Q0700
G72X1000Y5000
G68I0500J18000K-9000P0Q0700
X2500Y2134T002
Y3866
X3500
Y2134
X4000Y3000
X2000
G50
#<END OF Punch-test-posts >#
```

Post name:	Flexmate
Machine type:	Punch Press
Machine name:	Whitney Punch Press
Control:	Flexmate
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
N1(CL,1,16000)
N2(CL,2,62000)
N3 M45
N4 G00 G90 G70 G54 M85 G99
/N5 X0 Y-30.0 M87
N6 G00 X1. Y5.5
N7 G01 X5. F1
N8 G02 X5.5 Y5. I0. J-0.5
N9 G01 Y1.
N10 G02 X5. Y0.5 I-0.5 J0.
N11 G01 X1.
N12 G02 X0.5 Y1. I0. J0.5
N13 G01 Y5.
N14 G02 X1. Y5.5 I0.5 J0.
N15 X0 Y0 G92
N16 M06
N17 G00 X2.5 Y2.134
N18 Y3.866
N19 X3.5
N20 Y2.134
N21 X4. Y3.
N22 X2.
N23G99
N24M30
```

Post name:	Mw100
Machine type:	Punch Press
Machine name:	Generic Punch Press
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
N5G92X10Y55
N10G69I4000J0P0Q700T001
N15G72X5Y5
N20G68I500J9000K-9000P0Q700
N25G69I4000J-9000P0Q700
N30G72X5Y1
N35G68I500J0K-9000P0Q700
N40G69I4000J-18000P0Q700
N45G72X1Y1
N50G68I500J-9000K-9000P0Q700
N55G69I4000J9000P0Q700
N60G72X1Y5
N65G68I500J18000K-9000P0Q700T002
N70G90X25Y2134
N75Y3866
N80X35
N85Y2134
N90X40Y30
N95X20
N100G50
%
```

Post name:	Pun-1050
Machine type:	Punch Press
Machine name:	Behrens Punch Press
Control:	GE 1050
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good, has a stock shift.

```
%
($Punch-test-posts)
N0005 X01000 Y05500 T01 M10
N0010 M00
N0015 G01 F1450.0
N0020 X05000
N0025 G02 X05500 Y05000 I05000 J05000
N0030 G01 F1450.0
N0035 X05500 Y01000
N0040 G02 X05000 Y00500 I05000 J01000
N0045 G01 F1450.0
N0050 X01000 Y00500
N0055 G02 X00500 Y01000 I01000 J01000
N0060 G01 F1450.0
N0065 X00500 Y05000
N0070 G02 X01000 Y05500 I01000 J05000
N0075 G00 X01000 Y05500
N0080 X02500 Y02134 T2
N0085 Y03866
N0090 X03500
N0095 Y02134
N0100 X04000 Y03000
N0105 X02000
N0110 T01 M10
N0115 M30
%
```

Post name:	Punch
Machine type:	Punch Press
Machine name:	Generic Punch Press
Control:	Fanuc II
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good, highly customized.

```
O0010
N10(RESERVED FOR COMMENTS)
N20(RESERVED FOR COMMENTS)
N30(RESERVED FOR COMMENTS)
N40(RESERVED FOR COMMENTS)
N50(RESERVED FOR COMMENTS)
N60(PART DESCRIPTION)
N70(CREATED DATE INITIALS)
N80(REVISED)
N90G90
N100G92X0.0A0.0
N110G91
N120G0A-10.0
N130G0A10.0
N140 G90
N150 G0 X0.33     ( 1.0 DIA. ROW 0)
N160 M00          (CHECK FIT )
N170 G10
N180 G11 A270.0 B1
N190 G11 A180.0 B1
N200 G11 A90.0 B1
N210 G11 A0.0 B1
N220 G12
N230 G90
N240M00(INDEX TO CHANGE PART)
N250G0A0.0X0.0
N260M30
N270O8888(RETURN TO PROGRAM ZERO)
N280G12
N290G0X0.0
N300G12
N310M30
%
%
```

Post name:	Speclfab
Machine type:	Punch Press
Machine name:	Amanda Punch Press
Control:	Fanuc 6M
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good, has a custom stock shift.

```
N005 X48.0 Y0.0 M00
N010 X1.0 Y5.5 T01 (RD 1.0)
N015 X5.0
N020 X5.5 Y1.0
N025 X1.0 Y0.5
N030 X0.5 Y5.0
N035 X1.0 Y5.5
N040 X2.5 Y2.134 T02 (RD 0.45)
N045 Y3.866
N050 X3.5
N055 Y2.134
N060 X4.0 Y3.0
N065 X2.0
N070 M30
```

Post name: Strip-5
Machine type: Punch Press
Machine name: Strippit Fabri-Point 5 Punch Press
Control:
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks OK.

```
#< Punch-test-posts _  STRIPPIT > Fri May 11 16:33:32 2001'%
N010G90X1.0Y5.5M75
N015G61M81
N020G01G68X5.0F700T01
N025G02X5.5Y5.0I0.0J-0.5
N030G01X5.5Y1.0
N035G02X5.0Y0.5I-0.5J0.0
N040G01X1.0Y0.5
N045G02X0.5Y1.0I0.0J0.5
N050G01X0.5Y5.0
N055G02X1.0Y5.5I0.5J0.0
N060X2.5Y2.134T02
N065Y3.866
N070X3.5
N075Y2.134
N080X4.0Y3.0
N085X2.0
#< END OF Punch-test-posts >#
```

Post name:	Strip-pp
Machine type:	Punch Press
Machine name:	Strippit Fabri-Center 1000 & 250 Series Punch Press
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
#%
N010G69M06
N015G95
N020G92X010Y055
%
N025G01G68X010Y055T01
N030X050F700
N035G02X055Y050I000J-005
N040G01Y010
N045G02X050Y005I-005J000
N050G01X010
N055G02X005Y010I000J005
N060G01Y050
N065G02X010Y055I005J000
N070G01X010Y055T02
N075X025Y02134
N080Y03866
N085X035
N090Y02134
N095X040Y030
N100X020
N105X010Y055M75
#
```

Post name:	Whitney
Machine type:	Punch Press
Machine name:	Whitney Punch Press
Control:	GE 1050
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
N10G90
N20(/CL,B)
N30(/CL,1,8000)
N40(/CL,2,72000)
N50(/MS,CUSTOMER, )
N60(/MS,126.000X 61.000Y)
N70G39F500.M85
N80(/RZ,X)
N90(/RZ,Y)
N100G00G40G70X-3.Y5.5M87M85M06
N110(/MS,TOOL 1.000 RND)
N120X1.Y5.5M75
N130X5.
N140M17
N150G03X5.5Y5.I0.J0.5
N160Y1.
N170G03X5.Y0.5I0.5J0.
N180X1.
N190G03X0.5Y1.I0.J-0.5
N200Y5.
N210G03X1.Y5.5I-0.5J0.
N220M18
N230M00
N240X-3.Y5.5M85M06
N250(/MS,TOOL 0.450 RND)
N260X2.5Y2.134M75
N270Y3.866
N280X3.5
N290Y2.134
N300X4.Y3.
N310X2.
N320M18
N330M02
N340M00
N350G39
N360X-3.Y5.5M85
N370M02M30M87M99
%
```

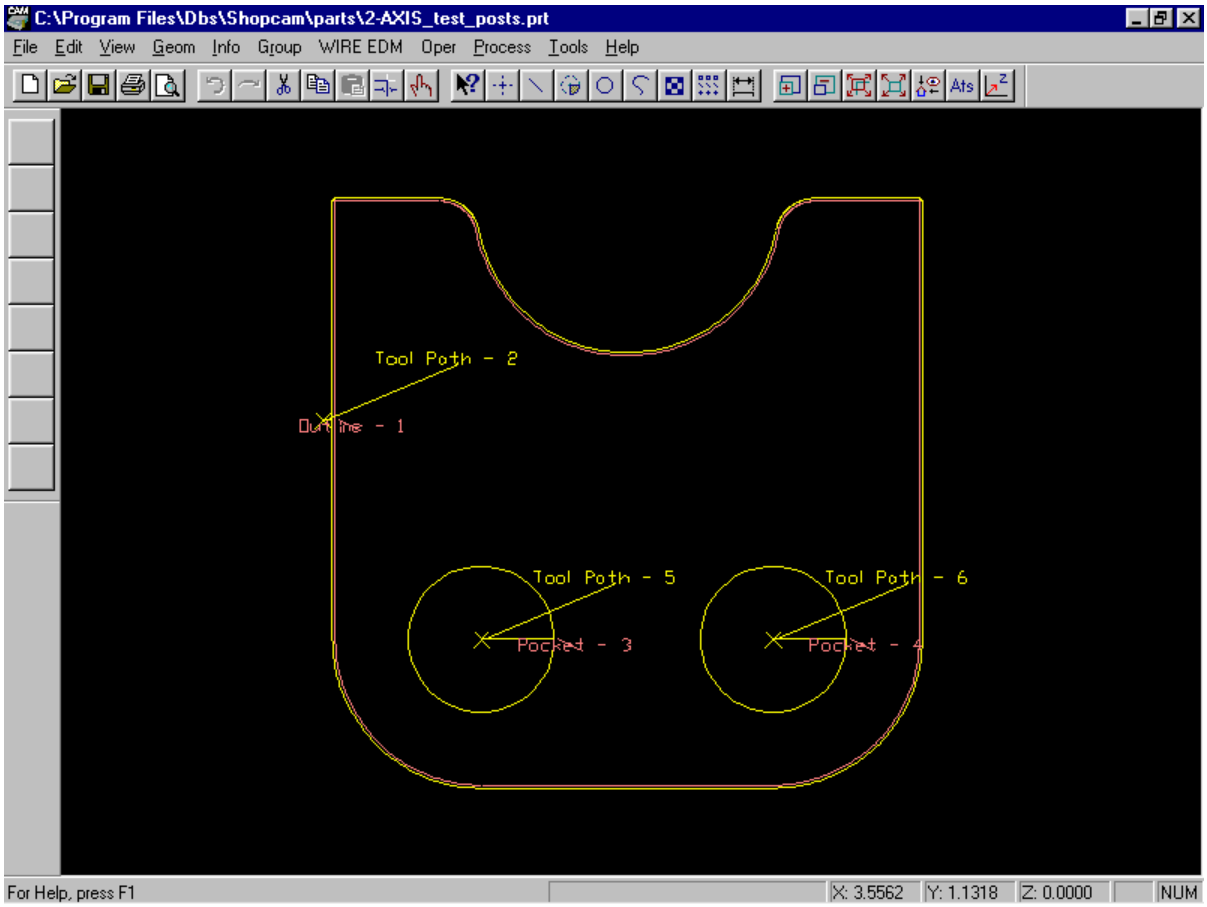
Post name:	Whit1050
Machine type:	Punch Press
Machine name:	Whitney Punch Press
Control:	GE 1050
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%
N10G90
N20G70
N30G00X1.Y5.5
N40X5.
N50G02X5.5Y5.I0.J0.5
N60Y1.
N70G02X5.Y0.5I0.5J0.
N80X1.
N90G02X0.5Y1.I0.J-0.5
N100Y5.
N110G02X1.Y5.5I-0.5J0.
N120G00X2.5Y2.134
N130Y3.866
N140X3.5
N150Y2.134
N160X4.Y3.
N170X2.
N180M00
N190M30
%
```

2-AXIS MACHINES

About the sample part

Below is a screen capture of the part used to generate the sample output.



Some of these 2-axis posts were written for custom designed machines. This is especially true with waterjets. The M-codes used when starting and stopping a cut may be similar to your requirements. Contact DBS if you need fine tuning for your custom machine.

Post name:	Ab-8601
Machine type:	Router
Machine name:	Generic Router
Control:	Allen Bradley 8601
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
(DIS,"2AXIS_TEST_POSTS Thu May 03
11:28:34 2001'=PRG1")
 (DPI,X,Y)
 (UAO,1)
 M21 M22
 G79 G00 Z0
 M05
 G90 G00 X1 Y2
 T1 M06
 T99.1 M06
 M03 S500
 G00 Z0.1
 G01 Z-0.5 F5
 G42 X0.995 F11
 Y1.5
 G03 X1.5 Y0.995 I1.5 J1.5
 G01 X2.5
 G03 X3.005 Y1.5 I2.5 J1.5
 G01 Y3.
 G03 X3. Y3.005 I3. J3.
 G01 X2.642
 G03 X2.514 Y2.9 I2.642 J2.875
 G02 X1.486 Y2.9 I2. J3.
 G03 X1.358 Y3.005 I1.358 J2.875
 G01 X1.
 G03 X0.995 Y3. I1. J3.
 G01 Y2.25
 G40 X0.966
 G00 Z0.1
 X1.502 Y1.5
 G01 Z-0.5 F5
 X1.75 F6
 G02 X1.75 Y1.5 I1.5 J1.5
 G01 X1.501
 G00 Z0.1
 X2.502
 G01 Z-0.5 F5
 X2.75 F6
 G02 X2.75 Y1.5 I2.5 J1.5
 G01 X2.501
 G00 Z0.1
 G00
 T99 M06
 M11 M12
 G79 G00 Z0
 G79 G00 X0 Y0
 M30
%
```

Post name:	Anorad-1
Machine type:	Laser
Machine name:	Anorad Laser System
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Mild customization, CW arcs are G03, ECW arcs are G02.

```
#
N1G69  ;Program  2AXIS_TEST_POSTS
Thu May 03 11:29:15 2001'
N2G90G0X-0.9655Y2.25F300
N3G42
N4M200
N5G90
N6M102
N7M100
N8G4X.5
N9M104M101
N10G4X.2
N11M103
N12M100
N13G9X-0.995F11
N14Y1.5
N15G2X-1.5Y0.995I-0.505J0.0
N16G9X-2.5
N17G2X-3.005Y1.5I0.0J0.505
N18G9Y3.0
N19G2X-3.0Y3.005I0.005J0.0
N20G9X-2.6416
N21G2X-2.514Y2.8999I0.0J-0.13
N22G3X-1.486I0.514J0.1001
N23G2X-1.3584Y3.005I0.1276J-0.0249
N24G9X-1.0
N25G2X-0.995Y3.0I0.0J-0.005
N26G9Y2.25
N27X-0.9655
N28M101M103M105
N29G0X-1.5015Y1.5
N30M200
N31G90
N32M102
N33M100
N34G4X.5
N35M104M101
N36G4X.2
N37M103
N38M100
N39G9X-1.75F6
N40G3I0.25J0.0
N41G9X-1.501
N42M101M103M105
N43G0X-2.5015
N44M200
N45G90
N46M102
N47M100
N48G4X.5
N49M104M101
N50G4X.2
N51M103
N52M100
N53G9X-2.75
N54G3I0.25J0.0
N55G9X-2.501
N56M2
%#
```

Post name:	Ap-gx800
Machine type:	Flame Cutter
Machine name:	Esab Flame Cutter
Control:	Auto Path GXA-800
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Supports a punch marker, oxy-fuel and plasma.

```
%000000001
G70
G90
G92X0Y0
M66
G00X0.966Y2.25
T03
G42
M
G1X0.995Y2.25F11.0
Y1.5
G3X1.5Y0.995I1.5J1.5
G1X2.5
G3X3.005Y1.5I2.5J1.5
G1Y3.0
G3X3.0Y3.005I3.0J3.0
G1X2.642
G3X2.514Y2.9I2.642J2.875
G2X1.486Y2.9I2.0J3.0
G3X1.358Y3.005I1.358J2.875
G1X1.0
G3X0.995Y3.0I1.0J3.0
G1Y2.25
X0.966
G40
G0X1.502Y1.5
M
G1X1.75F6.0
G2X1.75Y1.5I1.5J1.5
G1X1.501
T05
G0X2.502
M
G1X2.75
G2X2.75Y1.5I2.5J1.5
G1X2.501
M
G0X0Y0
M02
%
```

Post name: Burny3
Machine type: Flame Cutter
Machine name: Burny III Flame Cutter
Control:
Inch/Metric: Inch
Absolute/Incremental: Incremental
Post programmer notes: Source code looks good. This is a dealer's standard post, mild customization.

```
%
N1P2AXIS_TEST_POSTS Thu May 03 11:31:59 2001'
N5M04
N10G42X0.029
N15Y-0.75
N20G03X0.506Y-0.505I0.505J0.
N25X0.999
N30G03X0.505Y0.505I0.J0.505
N35Y1.5
N40G03X-0.004Y0.005I-0.005J0.
N45X-0.359
N50G03X-0.128Y-0.105I0.J-0.13
N55G02X-1.027I-0.514J0.1
N60G03X-0.128Y0.105I-0.128J-0.025
N65X-0.359
N70G03X-0.004Y-0.005I0.J-0.005
N75Y-0.75
N80X-0.03
N85M03
N90G40
N95X0.536Y-0.75
N100M04
N105X0.248
N110G02I-0.25J0.
N115X-0.249
N120M03
N125X1.001
N130M04
N135X0.248
N140G02I-0.25J0.
N145X-0.249
N150M03
N155M70
N160M30
~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~
```

Post name:	Burny5
Machine type:	Plasma
Machine name:	Burny Plasma
Control:	MG Sys 20
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good. This is a dealer's standard post.

```
%
N10P1
N20(2AXIS_TEST_POSTS Thu May 03 12:15:26 2001')
N30 X0. Y0.
N40 M03
N50 G45 X0.029
N60 G42 D0.01
N70 Y-0.75
N80 G03 X0.506 Y-0.505 I0.505 J0.
N90 X0.999
N100 G03 X0.505 Y0.505 I0. J0.505
N110 Y1.5
N120 G03 X-0.004 Y0.005 I-0.005 J0.
N130 X-0.359
N140 G03 X-0.128 Y-0.105 I0. J-0.13
N150 G02 X-1.027 I-0.514 J0.1
N160 G03 X-0.128 Y0.105 I-0.128 J-0.025
N170 X-0.359
N180 G03 X-0.004 Y-0.005 I0. J-0.005
N190 Y-0.75
N200 X-0.03
N210 M05
N220 X0.536 Y-0.75
N230 M03
N240 X0.248
N250 G02 I-0.25 J0.
N260 X-0.249
N270 M05
N280 X1.001
N290 M03
N300 X0.248
N310 G02 I-0.25 J0.
N320 X-0.249
N330 M05
N340 M30
```

Post name:	Burny5mn
Machine type:	Plasma
Machine name:	Burny Plasma
Control:	MG Sys 20
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
( PART A:\2AXIS_TEST_POSTS.cnc Thu May 03 12:16:05 2001'
( CONTROL  7 CONTROL.CON
( TYPE BURNY
%
N1G70
N2G90
N3G42
N4M21
N5G01X0.995
N6Y1.5
N7G03X1.5Y0.995I0.505J0.
N8G01X2.5
N9G03X3.005Y1.5I0.J0.505
N10G01Y3.
N11G03X3.Y3.005I-0.005J0.
N12G01X2.642
N13G03X2.514Y2.9I0.J-0.13
N14G02X1.486I-0.514J0.1
N15G03X1.358Y3.005I-0.128J-0.025
N16G01X1.
N17G03X0.995Y3.I0.J-0.005
N18G01Y2.25
N19X0.966
N20G40
N21M20
N22G00X1.502Y1.5
N23M21
N24G01X1.75
N25G02I-0.25J0.
N26G01X1.501
N27M20
N28G00X2.502
N29M21
N30G01X2.75
N31G02I-0.25J0.
N32G01X2.501
N33M20
N34M02
```

Post name:	Delta-wj
Machine type:	Water Jet
Machine name:	Custom Built Water Jet
Control:	Delta TAU
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good, highly customized.

```
%
N5 G90 G80 G40 G17
N10 G0 G2 X0.9655 Y2.25
N15 G4 X0
N20 M8
N25 G4 X3.0
N30 G1 G42 X0.995 Y2.25 F11.0
N35 Y1.5
N40 G3 X1.5 Y0.995 I0.505 J0.0
N45 G1 X2.5 Y0.995
N50 G3 X3.005 Y1.5 I0.0 J0.505
N55 G1 X3.005 Y3.0
N60 G3 X3.0 Y3.005 I-0.005 J0.0
N65 G1 X2.6416 Y3.005
N70 G3 X2.514 Y2.8999 I0.0 J-0.13
N75 G2 X1.486 I-0.514 J0.1001
N80 G3 X1.3584 Y3.005 I-0.1276 J-0.0249
N85 G1 X1.0 Y3.005
N90 G3 X0.995 Y3.0 I0.0 J-0.005
N95 G1 X0.995 Y2.25
N100 X0.9655
N105 G4 X0
N110 M9
N115 G4 X1.
N120 G0 G567 X1.5015 Y1.5
N125 G4 X0
N130 M8
N135 G4 X3.0
N140 G1 X1.75 Y1.5 F6.0
N145 G2 I-0.25 J0.0
N150 G1 X1.501 Y1.5
N155 G4 X0
N160 M9
N165 G4 X1.
N170 G0 X2.5015 Y1.5
N175 G4 X0
N180 M8
N185 G4 X5.0
N190 G1 X2.75 Y1.5 F6.0
N195 G2 I-0.25 J0.0
N200 G1 X2.501 Y1.5
N205 M30
%
```

Post name:	Esab
Machine type:	Flame Cutter
Machine name:	Esab Flame Cutter
Control:	Auto Path
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
%000000001
M76
G70
G90
G98X0Y0
G00X0.966Y2.25
T03
T01
G42
M20
G01X0.995Y2.25F11.0
Y1.5
G03X1.5Y0.995I1.5J1.5F11.0
G01X2.5F11.0
G03X3.005Y1.5I2.5J1.5F11.0
G01Y3.0F11.0
G03X3.0Y3.005I3.0J3.0F11.0
G01X2.642F11.0
G03X2.514Y2.9I2.642J2.875F11.0
G02X1.486Y2.9I2.0J3.0F11.0
G03X1.358Y3.005I1.358J2.875F11.0
G01X1.0F11.0
G03X0.995Y3.0I1.0J3.0F11.0
G01Y2.25F11.0
G40
X0.966
M21
G00X1.502Y1.5
M20
G01X1.75F6.0
G02X1.75Y1.5I1.5J1.5F6.0
G01X1.501F6.0
T05
M21
G00X2.502
M20
G01X2.75F6.0
G02X2.75Y1.5I2.5J1.5F6.0
G01X2.501F6.0
T00
M02~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~
```

Post name:	Esab-ap
Machine type:	Flame Cutter
Machine name:	Esab Flame Cutter
Control:	Auto Path
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
G70G90
M66
M32
G50
G75F60
M96M97
G0X0.966Y2.25
G98X0Y0
T03
G42
M3G4F5.0
G1X0.995F11.0
T01
Y1.5
G3X1.5Y0.995I1.5J1.5
G1X2.5
G3X3.005Y1.5I2.5J1.5
G1Y3.0
G3X3.0Y3.005I3.0J3.0
G1X2.642
G3X2.514Y2.9I2.642J2.875
G2X1.486Y2.9I2.0J3.0
G3X1.358Y3.005I1.358J2.875
G1X1.0
G3X0.995Y3.0I1.0J3.0
G1Y2.25
G40
X0.966
M6
G0X1.502Y1.5
M3G4F5.0
G1X1.75F6.0
G2X1.75Y1.5I1.5J1.5
G1X1.501
T05
M6
G0X2.502
M3G4F5.0
G1X2.75
G2X2.75Y1.5I2.5J1.5
G1X2.501
M30
##
#<END OF 2AXIS_TEST_POSTS>~~ Thu May 03 12:21:03 2001'
```

Post name: Fagor-jg
Machine type: Jig Grinder
Machine name: Generic Jig Grinder
Control: Fagor CNC 8025/8030 VGA
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Source code looks good, mild customization.

```
%00001
N0 (2AXIS_TEST_POSTS _ Thu May 03
12:57:18 2001')
N10 P1=K1
N20 P2=K2
N30 M15
N40 G74 C
N50 G92 C90
N60 M16
N70 G00 G90 X0.9655 Y2.25
N80 G7 G90 C0
N90 G5 M11
N100 G01 X0.995 FP1
N110 M98
N120 Y1.5 FP2
N130 G03 X1.5 Y0.995 I0.505 J0.0
N140 G01 X2.5
N150 G03 X3.005 Y1.5 I0.0 J0.505
N160 G01 Y3.0
N170 G03 X3.0 Y3.005 I-0.005 J0.0
N180 G01 X2.641571
N190 G03 X2.51397 Y2.899861 I0.0
J-0.13
N200 G02 X1.486029 Y2.899862 I-
0.51397 J0.10014
N210 G03 X1.358429 Y3.005 I-0.1276
J-0.024862
N220 G01 X1.0
N230 G03 X0.995 Y3.0 I0.0 J-0.005
N240 G01 Y2.25
N250 M10
N260 X0.9655
N270 M99
N280 M15
N290 G74 C
N300 G92 C90
N310 M16
N320 G00 X1.5015 Y1.5
N330 G01 X1.75
N340 G02 X1.75 Y1.5 I-0.25 J0.0
N350 G01 X1.501
N360 M99
N370 M15
N380 G74 C
N390 G92 C90
N400 M16
N410 G00 X2.5015
N420 G01 X2.75
N430 G02 X2.75 Y1.5 I-0.25 J0.0
N440 G01 X2.501
N450 M99
N460 M15
N470 G74 C
N480 G92 C90
N490 M16
N500 G90 G0 X0.9655 Y2.25
N510 M30
```

Post name: Ge
Machine type: Jig Grinder
Machine name: Moore Jig Grinder
Control: Allen Bradley
Inch/Metric: Inch
Absolute/Incremental: Absolute
Post programmer notes: Complex post-processor has a C-Axis that remains perpendicular.

```
N001G17
N002G00X0.995
N003C0.0
N004M15
N005G01Y1.5F5.0
N006G03X1.5Y0.995C-
0.75I0.505J0.0K.15915
N007G00C-0.75
N008G01X2.5
N009G03X3.005Y1.5C-
0.5I0.0J0.505K.15915
N010G01Y3.0
N011G03X3.0Y3.005C-
0.25I0.005J0.0K.15915
N012G00C-0.25
N013G01X2.64157
N014G03X2.51397Y2.89986C-
0.03063I0.0J0.13K.15915
N015G02X2.0Y2.47637C-
0.25I0.51397J0.10014K.15915
N016G02X1.48603Y2.89986C-
0.46937I0.0J0.52364K.15915
N017G03X1.35843Y3.005C-
0.25I0.1276J0.02486K.15915
N018G00C-0.25
N019G01X1.0
N020G03X0.995Y3.0C-
1.0I0.0J0.005K.15915
N021G00C-1.0
N022G01Y2.25
N023G00C-1.25
N024G01X0.9655
N025G04X02M16
N026G00C-1.90124
N027G00X1.5015Y1.5
N028C-1.75
N029M15
N030G01X1.75F5.0
N031G02X1.5Y1.25C-
1.25I0.25J0.0K.15915
N032G02X1.25Y1.5C-
1.5I0.0J0.25K.15915
N033G02X1.5Y1.75C-
1.75I0.25J0.0K.15915
N034G02X1.75Y1.5C-
2.0I0.0J0.25K.15915
N035G00C-2.25
N036G01X1.501
N037G04X02M16
N038G00C-2.75
N039G00X2.5015
N040M15
N041G01X2.75
N042G02X2.5Y1.25C-
2.25I0.25J0.0K.15915
N043G02X2.25Y1.5C-
2.5I0.0J0.25K.15915
N044G02X2.5Y1.75C-
2.75I0.25J0.0K.15915
N045G02X2.75Y1.5C-
3.0I0.0J0.25K.15915
N046G00C-3.25
N047G01X2.501
N048M30
```

Post name:	Hauni
Machine type:	Jig Grinder
Machine name:	Hauni Bloom Jig Grinder
Control:	Hauni Bloom
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Highly customized has a axis multiplier for PEA2 (whatever that is).

```
N0010 (ID, GSUB, 0, )
N0020 P16=11.0
N0030 G41 G43 D10
N0040 G1 Z-0.9655 Y-2.25 F(P16)
N0050 Z-0.995 F(P16)
N0060 Y-1.5 F(P16)
N0070 G3 Z-1.5 Y-0.995 R0.505 F(P16)
N0080 Z-2.5 F(P16)
N0090 G3 Z-3.005 Y-1.5 R0.505 F(P16)
N0100 Y-3.0 F(P16)
N0110 G3 Z-3.0 Y-3.005 R0.005 F(P16)
N0120 Z-2.64157 F(P16)
N0130 G3 Z-2.51397 Y-2.89986 R0.13 F(P16)
N0140 G2 Z-1.48603 R0.52363 F(P16)
N0150 G3 Z-1.35843 Y-3.005 R0.13 F(P16)
N0160 Z-1.0 F(P16)
N0170 G3 Z-0.995 Y-3.0 R0.005 F(P16)
N0180 Y-2.25 F(P16)
N0190 Z-0.9655 F(P16)
N0200 Z-1.5015 Y-1.5 F(P16)
N0210 Z-1.75 F(P16)
N0220 G2 R0.25 F(P16)
N0230 Z-1.501 F(P16)
N0240 Z-2.5015 F(P16)
N0250 Z-2.75 F(P16)
N0260 G2 R0.25 F(P16)
N0270 Z-2.501 F(P16)
N0280 (END, GSUB)
```

Post name:	Hybrid
Machine type:	Plasma
Machine name:	Micro Path/ Plus Plasma/ Torch CNC Machine
Control:	
Inch/Metric:	Both
Absolute/Incremental:	Both
Post programmer notes:	Source code looks good. Highly customized, generates moves the graphics won't show.

```
N01G20(HYBRID REV 003)
N02G90
N03G92X0.961Y2.25
N04(2AXIS_TEST_POSTS Fri May 04 11:55:00 2001')
N05G42M07
N06G01X0.99Y2.25
N07Y1.5
N08G03X1.5Y0.99I0.51J0.
N09G01X2.5
N10G03X3.01Y1.5I0.J0.51
N11G01Y3.
N12G03X3.Y3.01I-0.01J0.
N13G01X2.642
N14G03X2.509Y2.901I0.J-0.135
N15G02X1.491Y2.901I-0.509J0.099
N16G03X1.358Y3.01I-0.133J-0.026
N17G01X1.
N18G03X0.99Y3.I0.J-0.01
N19G01Y2.25
N20G40
N21X0.961
N22M08
N23G00X1.502Y1.5
N24M07
N25G01X1.75
N26G02X1.75Y1.5I-0.25J0.
N27G01X1.501
N28M08
N29G00X2.502
N30M07
N31G01X2.75
N32G02X2.75Y1.5I-0.25J0.
N33G01X2.501
N34M08
N35M02
```

Post name:	Laser3
Machine type:	Laser
Machine name:	Ratheon Laser
Control:	Allen Bradley Bandit
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Highly customized, may be for custom built machine.

```
;PRELIMINARY
;PROGRAM_????-??
;PROGRAM_REV_ NUMBER
;PROGRAM_REV_DATE
;PART_DESCRIPTION
;PART_NUMBER
;PART_ECL
M44;LIGHT_OFF
G91;SET_INCREMENTAL
G94C5.4
M35;FIRE_ENABLE
M41;AIR_ON
M39;OPEN_SHUTTER
G01G42X0.0295F11.0
Y-0.75
G03X0.51Y-0.51I0.51J0.0
G01X1.0
G03X0.51Y0.51I0.0J0.51
G01Y1.5
G03X-0.01Y0.01I-0.01J0.0
G01X-0.3584
G03X-0.1325Y-0.1092I0.0J-0.135
G02X-1.0182I-0.5091J0.0992
G03X-0.1325Y0.1092I-0.1325J-0.0258
G01X-0.3584
G03X-0.01Y-0.01I0.0J-0.01
G01Y-0.75
G40X-0.0295
M40;CLOSE_SHUTTER
G00X0.541Y-0.75
M39;OPEN_SHUTTER
G01X0.2485F6.0
G02I-0.25J0.0
G01X-0.249
M40;CLOSE_SHUTTER
G00X1.0005
M39;OPEN_SHUTTER
G01X0.2485
G02I-0.25J0.0
G01X-0.249
M40;CLOSE_SHUTTER
M35;STOP_FIRE
M42;AIR_OFF
M36;HORN
M36;HORN
M1;OPTION_STOP
M41;AIR_ON
M44;LIGHT_OFF
M2;PROGRAM_STOP
%
%
```

Post name:	Lasr-fan
Machine type:	Laser
Machine name:	Generic Laser
Control:	GN Fanuc
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks OK.

```
%

N001G91G20G17F100.0
N002M08
N003M11
N004G01X0.0295Y0.0F11.0
N005Y-0.75
N006G02X0.51Y-0.51I0.51J0.0
N007X1.0
N008G02X0.51Y0.51I0.0J0.51
N009Y1.5
N010G02X-0.01Y0.01I-0.01J0.0
N011X-0.3584
N012G02X-0.1325Y-0.1092I0.0J-0.135
N013G03X-1.0182Y0.0I-0.5091J0.0992
N014G02X-0.1325Y0.1092I-0.1325J-0.0258
N015X-0.3584
N016G02X-0.01Y-0.01I0.0J-0.01
N017Y-0.75
N018X-0.0295
N019M41
N020M08
N021G01X0.541Y-0.75
N022M08
N023M11
N024G01X0.2485F6.0
N025G03X0.0Y0.0I-0.25J0.0
N026X-0.249
N027M41
N028M08
N029G01X1.0005
N030M08
N031M11
N032G01X0.2485
N033G03X0.0Y0.0I-0.25J0.0
N034X-0.249
N035M41
N036M08
N037M30
%
```

Post name:	Laser-ol
Machine type:	Laser
Machine name:	Amanda Laser
Control:	Fanuc C-1000 Series O-L
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good, mild customization.

```
%

(DWG. )
(FILE NAME 2-AXIS_TEST_POSTS Fri May 11 10:47:24 2001')
(PART IS X=   Y= )
G93Z0.1
G42D1
G00X0.961Y2.25
M98P100
G01X0.99Y2.25
Y1.5
G03X1.5Y0.99I0.51J0.0
G01X2.5
G03X3.01Y1.5I0.0J0.51
G01Y3.0
G03X3.0Y3.01I-0.01J0.0
G01X2.642
G03X2.509Y2.901I0.0J-0.135
G02X1.491Y2.901I-0.509J0.099
G03X1.358Y3.01I-0.133J-0.026
G01X1.0
G03X0.99Y3.0I0.0J-0.01
G01Y2.25
X0.961
M61
G00X1.502Y1.5
M98P100
G01X1.75Y1.5
G02X1.75Y1.5I-0.25J0.0
G01X1.501
M61
G00X2.502
M98P100
G01X2.75Y1.5
G02X2.75Y1.5I-0.25J0.0
G01X2.501
M61
G40
M00
M99
%
```

Post name:	Lin-ucnc
Machine type:	Plasma
Machine name:	Linde Plasma
Control:	UCNC
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good.

```
N1 M68
N2 M70 G01 X+0.029
N3 Y-0.75
N4 G03 X+0.511 Y-0.51 I+0.51 J+0.0
N5 G01 X+0.999
N6 G03 X+0.51 Y+0.51 I+0.0 J+0.51
N7 G01 Y+1.5
N8 G03 X-0.009 Y+0.01 I-0.01 J+0.0
N9 G01 X-0.359
N10 G03 X-0.132 Y-0.109 I+0.0 J-0.135
N11 G02 X-1.019 I-0.51 J+0.099
N12 G03 X-0.132 Y+0.109 I-0.132 J-0.026
N13 G01 X-0.359
N14 G03 X-0.009 Y-0.01 I+0.0 J-0.01
N15 G01 Y-0.75
N16 X-0.03
N17 M73
N18 M69 X+0.541 Y-0.75
N19 M70 X+0.248
N20 G02 I-0.25 J+0.0
N21 G01 X-0.249
N22 M73 X+1.001
N23 M70 X+0.248
N24 G02 I-0.25 J+0.0
N25 G01 X-0.249
%
```

Post name:	Linde
Machine type:	Plasma
Machine name:	Linde Plasma
Control:	UCNC
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good.

```
%
N1 M68
N2 M65
N3 G1 X0.029
N4 Y-0.75
N5 G3 X0.511 Y-0.51 I0.51 J0.
N6 G1 X0.999
N7 G3 X0.51 Y0.51 I0. J0.51
N8 G1 Y1.5
N9 G3 X-0.009 Y0.01 I-0.01 J0.
N10 G1 X-0.359
N11 G3 X-0.132 Y-0.109 I0. J-0.135
N12 G2 X-1.019 I-0.51 J0.099
N13 G3 X-0.132 Y0.109 I-0.132 J-0.026
N14 G1 X-0.359
N15 G3 X-0.009 Y-0.01 I0. J-0.01
N16 G1 Y-0.75
N17 X-0.03
N18 M66
N19 M69
N20 G1 X0.541 Y-0.75 R
N21 M65
N22 X0.248
N23 G2 I-0.25 J0.
N24 G1 X-0.249
N25 M66
N26 G1 X1.001 R
N27 M65
N28 X0.248
N29 G2 I-0.25 J0.
N30 G1 X-0.249
N31 M66
%
```

Post name:	Mg-8200
Machine type:	Flame Cutter
Machine name:	MG Flame Cutter
Control:	Allen Bradley 8200
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good. Has A-Axis support disabled, would be easy to turn on but needs testing.

```
%
N5M54
N10G92X0.961Y2.25A0
N15M17
N20M16
N25G00X0.961Y2.25
N30G42
N35M04
N40M03
N45G01X0.99F11.
N50Y1.5
N55G03X1.5Y0.99I0.51J0.
N60G01X2.5
N65G03X3.01Y1.5I0.J0.51
N70G01Y3.
N75G03X3.Y3.01I-0.01J0.
N80G01X2.642
N85G03X2.509Y2.901I0.J-0.135
N90G02X1.491Y2.901I-0.509J0.099
N95G03X1.358Y3.01I-0.133J-0.026
N100G01X1.
N105G03X0.99Y3.I0.J-0.01
N110G01Y2.25
N115G40
N120X0.961
N125M05
N130M06
N135G00X1.502Y1.5
N140M04
N145M03
N150G01X1.75F6.
N155G02X1.75Y1.5I-0.25J0.
N160G01X1.501
N165M05
N170M06
N175G00X2.502
N180M04
N185M03
N190G01X2.75
N195G02X2.75Y1.5I-0.25J0.
N200G01X2.501
N205M02
%#
Cycle Time  = 1.84 minutes
Path Length = 18.77 inches
```

Post name:	Mg-ab9
Machine type:	Flame Cutter
Machine name:	MG Flame Cutter
Control:	Allen Bradley 9 Series
Inch/Metric:	Both
Absolute/Incremental:	Absolute
Post programmer notes:	Source code look OK.

```
N5G90A0C0
N10G92X0.00Y0.00
N15G00X0.961Y2.25
N20Z23
N25#1133=200
N30#1132=111
N35G90G00A5.0
N40M10
N45G42D3
N50G01X0.99Y2.25F11
N55X0.99Y1.5
N60G03X1.5Y0.99I0.51J0.0
N65G01X2.5Y0.99
N70G03X3.01Y1.5I0.0J0.51
N75G01X3.01Y3.0
N80G03X3.0Y3.01I-0.01J0.0
N85G01X2.642Y3.01
N90G03X2.509Y2.901I0.0J-0.135
N95G02X1.491Y2.901I-0.509J0.099
N100G03X1.358Y3.01I-0.133J-0.026
N105G01X1.0Y3.01
N110G03X0.99Y3.0I0.0J-0.01
N115G01X0.99Y2.25
N120G40
N125X0.961Y2.25
N130Z567
N135M03
N140G00X1.502Y1.5
N145M10
N150G01X1.75Y1.5F6
N155G02X1.75Y1.5I-0.25J0.0
N160G01X1.501Y1.5
N165G90G00A-3.0
N170M03
N175G00X2.502Y1.5
N180M10
N185G01X2.75Y1.5F6
N190G02X2.75Y1.5I-0.25J0.0
N195G01X2.501Y1.5
N200M28
N205M04
N210G00A0C0
N215M02
```

Post name:	Mx2000
Machine type:	Water Jet
Machine name:	Generic Water Jet
Control:	Superior Electric SLO-SYN MX2000
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks good.

```
'2-AXIS_TEST_POSTS Fri May 11 14:00:21 2001'
move=9605,22500
GOSUB HEADON
path=1,2
line=9900,22500
line=9900,15000
arc=15000,15000,-90
line=25000,9900
arc=25000,15000,-90
line=30100,30000
arc=30000,30000,-90
line=26416,30100
arc=26416,28750,-79
arc=20000,30000,+158
arc=13584,28750,-79
line=10000,30100
arc=10000,30000,-90
line=9900,22500
line=9605,22500
path end
GOSUB HEADOFF
move=15015,15000
GOSUB HEADON
path=1,2
line=17500,15000
arc=15000,15000,+360
line=15010,15000
path end
GOSUB HEADOFF
move=25015,15000
GOSUB HEADON
path=1,2
line=27500,15000
arc=25000,15000,+360
line=25010,15000
path end
GOSUB HEADOFF
```

Post name:	Pilot1
Machine type:	Plasma
Machine name:	Pilot Plasma
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Incremental
Post programmer notes:	Source code looks good.

```
%
N1P2-AXIS_TEST_POSTS Fri May 11 14:04:54 2001'
N5M04
N10G42
N15X0.029
N20Y-0.75
N25G03X0.511Y-0.51I0.51J0.
N30X0.999
N35G03X0.51Y0.51I0.J0.51
N40Y1.5
N45G03X-0.009Y0.01I-0.01J0.
N50X-0.359
N55G03X-0.132Y-0.109I0.J-0.135
N60G02X-1.019I-0.51J0.099
N65G03X-0.132Y0.109I-0.132J-0.026
N70X-0.359
N75G03X-0.009Y-0.01I0.J-0.01
N80Y-0.75
N85X-0.03
N90G40
N95M03
N100X0.541Y-0.75
N105M04
N110X0.248
N115G02I-0.25J0.
N120X-0.249
N125M03
N130X1.001
N135M04
N140X0.248
N145G02I-0.25J0.
N150X-0.249
N155M03
N160M30
~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~
```

Post name:	Ucnc-3
Machine type:	Flame Cutter
Machine name:	Burny Flame Cutter
Control:	
Inch/Metric:	Inch
Absolute/Incremental:	Absolute
Post programmer notes:	Source code looks Ok, mild customization.

```
N001M69
N002M91
N003M68
N004M65
N005G11X29Y0
N006Y-750
N007G13X511Y-510I510J0
N008G11X999
N009G13X510Y510I0J510
N010G11Y1500
N011G13X-9Y10I-10J0
N012G11X-359
N013G13X-132Y-109I0J-135
N014G12X-1019Y0I-510J99
N015G13X-132Y109I-132J-26
N016G11X-359
N017G13X-9Y-10I0J-10
N018G11Y-750
N019X-30
N020M66
N021M69
N022X541Y-750R
N023M68
N024M65
N025G11X248
N026G12X0Y0I-250J0
N027G11X-249
N028M66
N029M69
N030X1001R
N031M68
N032M65
N033G11X248
N034G12X0Y0I-250J0
N035G11X-249
N036M69
N037M30
%
```