

## MACH-3 postprocessor help

Most of the newer Mach-3 post support subroutines, dwells after all line moves and (M24 Y only moves) and M12 (X and/or Y only moves).

You may turn these commands on and off via the [Post Mod] dialog window. This [Post Mods] button is located in the [Set Operations] Dialog window.

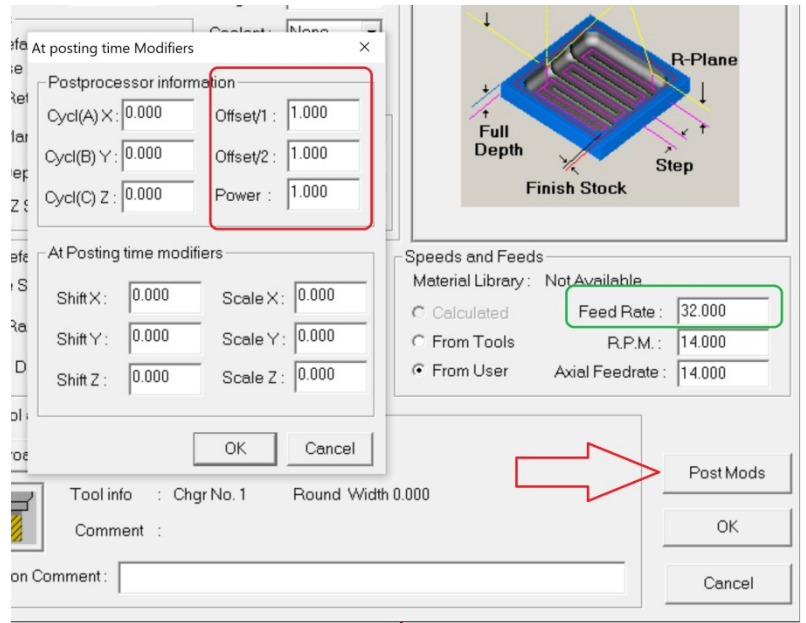
To output a dwell, set the [Power] field to the desired dwell in seconds

e.g. a .5 is a half second.

This post supports a M24 (Y only moves) and M12 (with X moves) To output a M12 M24, set the [TOOL/OFFSET 1] field to 1.

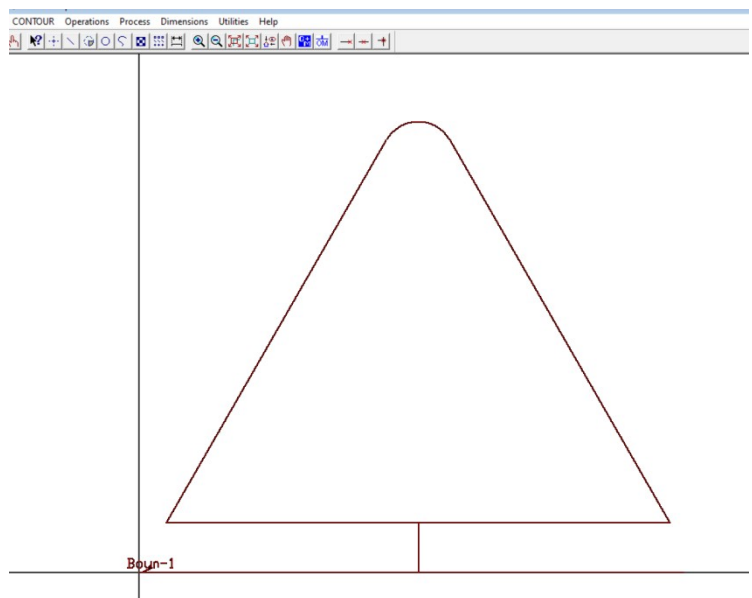
To output a M98 P L subroutine calls, set the [TOOL/OFFSET 2] field to the number of copies.

If these commands are used everytime, set them in the [Info] -> [Setup File] dialog. If you occasionally use them, default them to off and turn them on when you generate the toolpath



### G-code with no parameters set

```
N001 G092 X0 Y0
N002 G01 F25
N003 G01 X0.0000 Y0.0000
N004 G01 X5.7617 Y0.0000 F32.0
N005 G01 X5.7617 Y1.0281
N006 G01 X0.5656 Y1.0281
N007 G01 X5.1122 Y8.9031
N008 G02 X5.7617 Y9.2781 I0.6495 J-0.3750
N009 G02 X6.4112 Y8.9031 I0.0000 J-0.7500
N010 G01 X10.9579 Y1.0281
N011 G01 X5.7667 Y1.0281
N012 G01 X5.7667 Y0.0000
N013 G01 X11.2500 Y0.0000
N014 M02
```



# MACH-3 postprocessor help

## G-code with ALL 3 parameters set

G92 X0 Y0

G92 X0 Y0

G01 F25

G01 X1

M98 P1 L1

M2

O1

N001 G092 X0 Y0

N002 G01 F25

N003 M12

N004 G01 X0.0000 Y0.0000

N005 G01 X5.7617 Y0.0000 F25.0

G4 P3.0

N006 M24

N007 G01 X5.7617 Y1.0281

G4 P3.0

N008 M12

N009 G01 X0.5656 Y1.0281

G4 P3.0

N010 G01 X5.1122 Y8.9031

N011 G02 X5.7617 Y9.2781 I0.6495 J-0.3750

N012 G02 X6.4112 Y8.9031 I0.0000 J-0.7500

N013 G01 X10.9579 Y1.0281

G4 P3.0

N014 G01 X5.7667 Y1.0281

G4 P3.0

N015 M24

N016 G01 X5.7667 Y0.0000

G4 P3.0

N017 M12

N018 G01 X11.2500 Y0.0000

N019 M24

N020 M99

