# 'Off the Shelf Posts'

### Post Processor library
### Turning Centers (lathes) only

**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 for a mill.

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.  A 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.

The posts are listed two ways.  1) By the control  1) By the machine.   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 4.

## Disclaimer:

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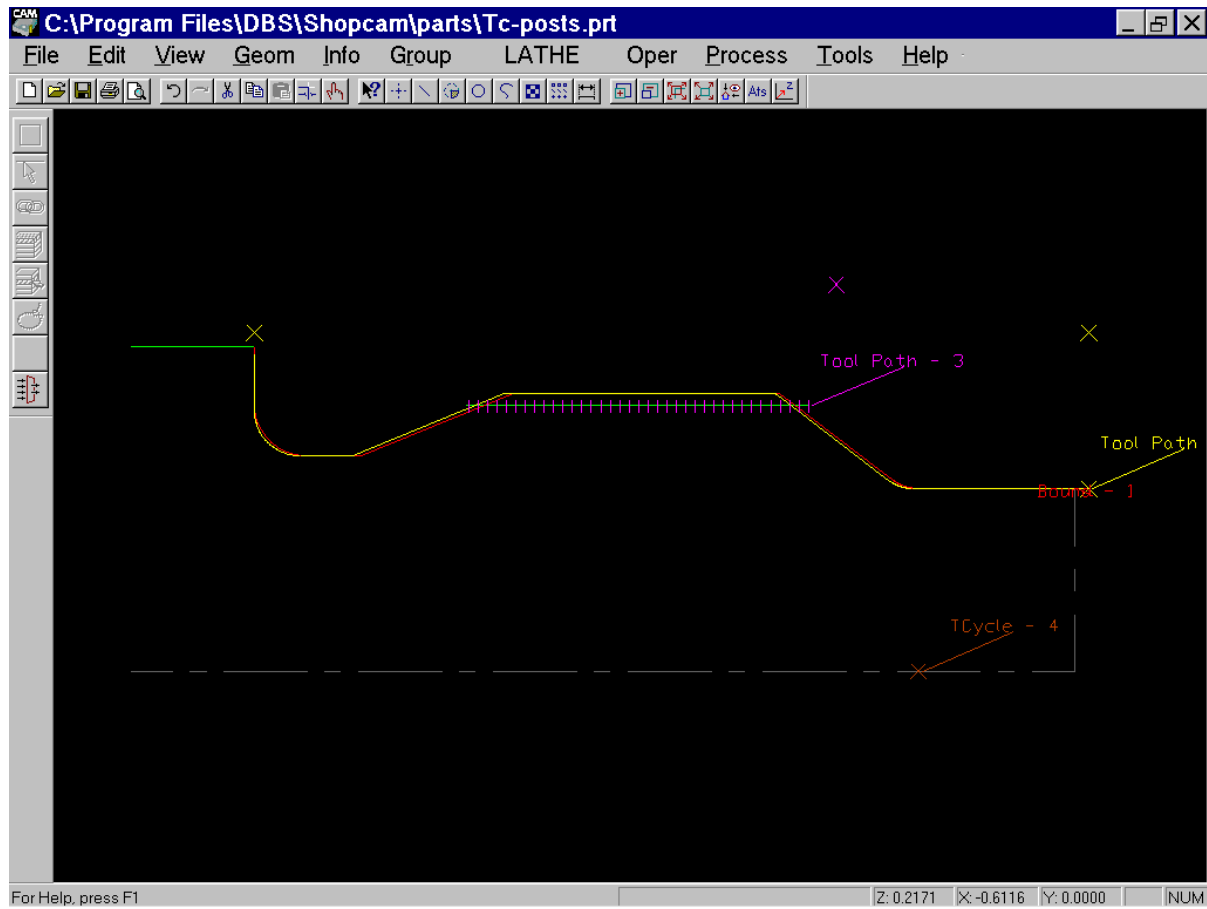
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# About the sample part

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



   The first operation is a finish pass.  The endmill positions at X0.573 Y1.95 then rapids to Z0.1 The full depth is Z-.122

   The second operations is a canned peck drill (cycle 83). With a full depth of Z-.75 and a peck of .3.  Not all lathe controls have canned drill and tapping cycles. Use a drill cycle number set to '1',  for a system simulated drill cycle (Z-in, Z-out).

The third operations is a threading  cycle.  If the post supports a canned thread cycle, it will use it.  Otherwise it will use 3 threading passes .

   The posts listed with:  (Auto 1st T-POSITION?  Not supported) were either written more than five years ago or the customer request that the 1st tool position be forced out automatically.  You should always check the [Auto 1st T-Position] box in the setup file and enter some tool change coordinates even if a M or G code positions for a tool change.

# 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 rev and 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.

**DOs and DON'Ts**

1) **Do not** go back and edit the filename.PRT once you have started editing the tapefile (G-codes).

2) **Do not** simple markup a printout of a 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) Read the helpfile if there is one. This will have a .HLP suffix. Copy to .TXT for WIN95.

6) Print the edited .tap and add notes, if you think it will help.

Send a disk to: DBS llc.  or email to: Dan@shopcam.com Allow one to five days for revisions.

# LATHES

Post name:          1050hl
Machine type:       Generic Lathe
Control:            GE 1050HL
IN/MM output:       Inch
Abso/Incr:          Incremental IK
X Axis:             Negative Diameter
Programmer's notes: Source code looks good

```
%
N10G54T0101
N20G95S1467M3
N30G0X-1.7576Z0.0688M08
N40G92S1111
N50G96R-1.7576S675
N60G1Z-0.0313F.0080
N70Z-0.7838
N80G3X-1.8271Z-0.8864I0.1688
N90X-2.6587Z-1.4297
N100G2X-2.6715Z-
1.4487I0.0248K0.019
N110Z-2.7333
N120G2X-2.6669Z-2.7451I0.0313
N130X-2.0715Z-3.4723
N140Z-3.7285
N150G3X-2.509Z-3.9473I0.2188
N160X-3.0543
N170G0X-3.2543
N180Z0.0688
N190T0000M59
N200X-40.0Z11.0
N210T0303
N220G95
N230G97S777M3
N240G0X0.0Z0.2
N250G83Z-0.75F0.01P10.4P2.250P5.050
N260T0000M59
N270X-40.0Z11.0
N280T0202
N290G95
N300G97S567M3
N310G0X-3.721Z-1.1447
N320G84X-2.5515Z-2.9253P10.06P20.0455P4-
2.9253
N330X-2.5515Z-2.9253
N340T0000M59
N350X-40.0Z11.0M09
N360M05
N370G53
N380M30
%
```

| Post name: | 40N-6tb |
|---|---|
| Machine type: | 40N Lathe |
| Control: | Yasnac 6TB |
| IN/MM output: | Both |
| Abso/Incr: | Incremental IK |
| X Axis: | Diameter |
| Programmer's notes: | Source code looks OK. |

```
%
:0012
M57
N1M63  (T0101 RIGHT REAR TURNING )
G50X40.0Z11.0T0100
G99
G50S1111
M39
G96S675
M03
G00X1.7576Z0.0688M08T0101
G01Z-0.0313F0.008
Z-0.7838
G02X1.8271Z-0.8864I0.1688K0.0
G01X2.6587Z-1.4297
G03X2.6715Z-1.4487I-0.0248K-0.019
G01Z-2.7333
G03X2.6669Z-2.7451I-0.0313K0.0
G01X2.0715Z-3.4723
Z-3.7285
G02X2.509Z-3.9473I0.2188K0.0
G01X3.0543
G00X3.2543
Z0.0688M09
G28X40.0Z11.0T0100M05
N3M63  (T0303 DRILL )
G50X40.0Z11.0T0300
G99
G00X0.0Z0.2M08T0303
G83R0.1Z-0.75P0300Q0F0.01M09
G28X40.0Z11.0T0300
N2M63  (T0202 RIGHT REAR THREADING )
G50X40.0Z11.0T0200
G99
G00X3.721Z-1.1447M08T0202
X2.5515Z-1.2792
G32Z-2.9253F-.04545
G00X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253F-.04545
G00X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253F-.04545
G00X3.721M09
G28X40.0Z11.0T0200
M56
M30
%
#
```

| Post name: | 850-tc |
|---|---|
| Machine type: | Cincinnati |
| Control: | Sabre 850SX TC |
| IN/MM output: | Inch |
| Abso/Incr: | Incremental IK |
| X Axis: | Diameter |
| Programmers notes: | Source code looks OK, mild customization. |

```
%
:1G00X40.0Z11.0T01H01M26
N010(MSG, RIGHT REAR TURNING  T01)
N020G92S1111
N030G97S675M42M13
N040G00X1.7576Z0.0688M08
N050G96R1.7576S675
N060G95G01Z-0.0313F0.008
N070Z-0.7838
N080G02X1.8271Z-0.8864I1.0475K-0.7838
N090G01X2.6587Z-1.4297
N100G03X2.6715Z-1.4487I1.3045K-1.4487
N110G01Z-2.7333
N120G03X2.6669Z-2.7451I1.3045K-2.7333
N130G01X2.0715Z-3.4723
N140Z-3.7285
N150G02X2.509Z-3.9473I1.2545K-3.7285
N160G01X3.0543
N170G00X3.2543
N180Z0.0688
N190G0X40.0Z11.0M09
N200M01

:2G00X40.0Z11.0T03H03M26
N210(MSG, DRILL  T03)
N220G97S777M42M13
N230G00X0.0Z0.2M08
N240G0X40.0Z11.0M09
N250M01

:3G00X40.0Z11.0T02H02M26
N260(MSG, RIGHT REAR THREADING  T02)
N270G97S567M42M13
N280G00X3.721Z-1.1447M08
N290X2.5515Z-1.2792
N300G95G33Z-2.9253I0.0K-0.04545
N310G00X3.721
N320Z-1.1447
N330X2.5515Z-1.2792
N340G33Z-2.9253I0.0K-0.04545
N350G00X3.721
N360Z-1.1447
N370X2.5515Z-1.2792
N380G33Z-2.9253I0.0K-0.04545
N390G00X3.721
N400Z-1.1447
N410G0X40.0Z11.0M09
N420M02
%
```

Post name:           Ab-8200
Machine type:        Bullard Lathe
Control:             Allen Bradley 8200
IN/MM output:        Inch
Abso/Incr:           Incremental IK
X Axis:              Diameter
Programmer's notes:  Source code looks OK, highly customized.

```
%                                   N330 G97 S777 M03
N010 (T1 TURNING TOOL)              N340 G00 X0.0 Z0.2 M08
N020 G54                            N350 G10
N030 G11 G95 G99 G90                N360 G53
N040 G00 X20.0 Z11.0                N370 T0000 M05
N050 G92 X0.0 Z0.0 S1111            N380
N060 T0101                          N390 (T2 THREADING TOOL)
N070 G97 S1111 M03                  N400 G54
N080 G00 X1.758 Z0.069              N410 G11 G95 G99 G90
N090 G96 S0675 R0.879 M08           N420 G00 X20.0 Z11.0 M09
N100 G21 Z-0.031 F0.008             N430 G92 X0.0 Z0.0 S567
N110 Z-0.784                        N440 T0202
N120 G02 X1.827 Z-0.886 I0.169 K0   N450 G97 S567 M03
N130 G21 X2.659 Z-1.43              N460 G00 X3.721 Z-1.145 M08
N140 G03 X2.672 Z-1.449 I0.025      N470 X2.552 Z-1.279
K0.019                              N480 G33 Z-2.925 K-.04545
N150 G21 Z-2.733                    N490 G00 X3.721
N160 G03 X2.667 Z-2.745 I0.031 K0   N500 Z-1.145
N170 G21 X2.072 Z-3.472             N510 X2.552 Z-1.279
N180 Z-3.729                        N520 G33 Z-2.925 K-.04545
N190 G02 X2.509 Z-3.947 I0.219 K0   N530 G00 X3.721
N200 G21 X3.054                     N540 Z-1.145
N210 G00 X3.254                     N550 X2.552 Z-1.279
N220 Z0.069                         N560 G33 Z-2.925 K-.04545
N230 G10                            N570 G00 X3.721
N240 G53                            N580 G10
N250 T0000 M05                      N590 G53
N260                                N600 T0000 M05
N270 (T3 DRILL)                     N610
N280 G54                            N620 T0200
N290 G11 G95 G99 G90                N630 M30
N300 G00 X20.0 Z11.0 M09            #<END OF Tc-posts >#
N310 G92 X0.0 Z0.0 S777
N320 T0303
```

Post name:            Ab-ser2
Machine type:         Generic Lathe
Control:              Allen Bradley
IN/MM output:         Inch
Abso/Incr:            Incremental IK
X Axis:               Radial
Programmer's notes:   Source code looks OK.

```
(Tc-posts)
N0010 M20 (ENABLE BOTH)
N0020 M08 (COOLANT ON)
N0030 M10
N0040 M50 (EXTEND TS)
N0050 M11 (CLAMPS TOOLING)
N0060 G54 (SELECTS OFFSET)
N0070 M40 (SELECTS MID RANGE)
N0080 M03 S1111 (STARTS SPINDLE)
N0090 G00 Z0.069 X0.879
N0100 M100 (SYNCHRONIZE ROLLERS)
N0110 G01 Z-0.031 F0.008
N0120 Z-0.784
N0130 G03 Z-0.886 X0.914 R0.169
N0140 G01 Z-1.43 X1.329
N0150 G02 Z-1.449 X1.336 R0.031
N0160 G01 Z-2.733
N0170 G02 Z-2.745 X1.333 R0.031
N0180 G01 Z-3.472 X1.036
N0190 Z-3.729
N0200 G03 Z-3.947 X1.255 R0.219
N0210 G01 X1.527
N0220 G00 X1.627
N0230 Z0.069
N0240 M03 S777 (STARTS SPINDLE)
N0250 G00 Z0.2 X0.0 F0.01
N0260 M03 S567 (STARTS SPINDLE)
N0270 G00 Z-1.145 X1.861
N0280 Z-1.279 X1.276
N0290 G33 Z-2.925 K-.04545
N0300 G00 X1.861 F0.01
N0310 Z-1.145
N0320 Z-1.279 X1.276
N0330 G33 Z-2.925 K-.04545
N0340 G00 X1.861 F0.01
N0350 Z-1.145
N0360 Z-1.279 X1.276
N0370 G33 Z-2.925 K-.04545
N0380 G00 X1.861 F0.01
N0390 M100 (SYNCHRONIZE ROLLERS)
N0400 M09 (COOLANT OFF)
N0410 M05 (SPINDLE STOP)
N0420 M10
N0430 M51
N0440 M30
```

Post name:              Acra-2
Machine type:           Cincinnati
Control:                Acramatic 2
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Radial
Programmer's notes:     Source code looks good.

```
$
:
O10G70
N10G90
N20G95
N30G97S0100M03
N40G00T0101M06
N50G00X200000Z110000
N60G92S1111
N70G96S675R200000M03
N80X8788Z688M07
N90G01Z-313F0080
N100Z-7838
N110G02X9135Z-8864K-7838I10475
N120G01X13293Z-14297
N130G03X13358Z-14487K-14487I13045
N140G01Z-27333
N150G03X13334Z-27451K-27333I13045
N160G01X10358Z-34723
N170Z-37285
N180G02X12545Z-39473K-37285I12545
N190G01X15271
N200G00X16271
N210Z688
N220G00X200000Z110000M09
N230T0100M06
N240M01
O1000G90
N250G95
N260G97S0100M03
N270G00T0303M06
N280G00X200000Z110000
N290G97S777M03
N300X0Z2000M07
N310G00X200000Z110000M09
N320T0300M06
N330M01
O2000G90
N340G95
N350G97S0100M03
N360G00T0202M06
N370G00X200000Z110000
N380G97S567M03
N390X18605Z-11447M07
N400X12758Z-12792
N410G33Z-29253K04545
N420G00X18605
N430Z-11447
N440X12758Z-12792
N450G33Z-29253K04545
N460G00X18605
N470Z-11447
N480X12758Z-12792
N490G33Z-29253K04545
N500G00X18605
N510Z-11447
N520G00X200000Z110000M09
N530T0200M06
N540M0
N550G90
N560M30
*
```

| Post name: | Amer-ot |
|---|---|
| Machine type: | Amerisieki Lathe |
| Control: | Fanuc OTC |
| IN/MM output: | Both |
| Abso/Incr: | Incremental IK |
| X Axis: | Negative Diameter |
| Programmer's notes: | Source code looks OK, mild customization, has barpull support. |

```
%
O0012(Tc-posts)
N100G50S1111
T101M8(NR=0.03125 TURNING)
G50S1111
G96S675M03
G00X-1.7576Z0.0688
G01Z-0.0313F0.008
Z-0.7838
G02X-1.8271Z-0.8864I0.1688K0.0
G01X-2.6587Z-1.4297
G03X-2.6715Z-1.4487I-0.0248K-0.019
G01Z-2.7333
G03X-2.6669Z-2.7451I-0.0313K0.0
G01X-2.0715Z-3.4723
Z-3.7285
G02X-2.509Z-3.9473I0.2188K0.0
G01X-3.0543
G00X-3.2543
Z0.0688
G28U0
G0Z11.0
M1

N300G50S777
T303M8(0.25 DRILL)
G97S777M03
G00X0.0Z0.2
```

```
G83F0.01
G80
G28U0
G00G0Z11.0
M1

N200G50S567
T202M8(THREADING)
G97S567M03
G00X-3.721Z-1.1447
X-2.5515Z-1.2792
G33Z-2.9253F0.04545
G00X-3.721
Z-1.1447
X-2.5515Z-1.2792
G33Z-2.9253F0.04545
G00X-3.721
Z-1.1447
X-2.5515Z-1.2792
G33Z-2.9253F0.04545
G00X-3.721
Z-1.1447
G28U0
G0Z11.0
M1

T100
M30
%
```

| Post name: | Anilam-l |
| Machine type: | Generic Lathe |
| Control: | Anilam Tape-Mate |
| IN/MM output: | Inch |
| Abso/Incr: | Incremental IK |
| X Axis: | Radial |
| Programmers notes: | Source code looks OK, highly customized, outputs arc segments less than .004 with line moves. |

```
%                                      N251G0X0Z0
M1401                                  N261T03
N11G29T2001X0Z0                        N271G29LV21=0.01
N21G29T2002X0Z0                        N281G95
N31G29T2003X0Z0                        N291M03
N41T0                                  N301X.Z.2
N51G0X0Z0                              N311T0
N61T01                                 N321G0X0Z0
N71G95                                 N331T02
N81M03                                 N341G95
N91X.8788Z.0688                        N351M03
N101G29LV21=0.008                      N361X1.8605Z-1.1447
N111G01Z-.0313                         N371X1.2758Z-1.2792
N121Z-.7838                            N381G33Z-2.9253F-.0455
N131G03X.9135Z-.8864I1.0475K-.7838     N391G00X1.8605
N141G01X1.3293Z-1.4297                 N401Z-1.1447
N151G02X1.3358Z-1.4487I1.3045K-        N411X1.2758Z-1.2792
1.4487                                 N421G33Z-2.9253F-.0455
N161G01Z-2.7333                        N431G00X1.8605
N171G02X1.3334Z-2.7451I1.3045K-        N441Z-1.1447
2.7333                                 N451X1.2758Z-1.2792
N181G01X1.0358Z-3.4723                 N461G33Z-2.9253F-.0455
N191Z-3.7285                           N471G00X1.8605
N201G03X1.2545Z-3.9473I1.2545K-        N481M02
3.7285                                 N491Z-1.1447
N211G01X1.5271                         N501G0X0Z0
N221G00X1.6271                         N511G29E
N231Z.0688                             %
N241T0
```

Post name:          Anilm-tc
Machine type:       Generic Lathe
Control:            Anilam Tape-Mate
IN/MM output:       Inch
Abso/Incr:          Incremental IK
X Axis:             Radial
Programmers notes:  Source code looks OK, outputs arc segments less than .004 with line moves.

```
%
M1401
N11G29T2001X0Z0
N21G29T2002X0Z0
N31G29T2003X0Z0
N41T0
N51G0X0Z0
N61T01
N71G95
N81M03
N91X.8788Z.0688
N101G29LV21=0.008
N111G01Z-.0313
N121Z-.7838
N131G03X.9135Z-.8864I1.0475K-.7838
N141G01X1.3293Z-1.4297
N151G02X1.3358Z-1.4487I1.3045K-
1.4487
N161G01Z-2.7333
N171G02X1.3334Z-2.7451I1.3045K-
2.7333
N181G01X1.0358Z-3.4723
N191Z-3.7285
N201G03X1.2545Z-3.9473I1.2545K-
3.7285
N211G01X1.5271
N221G00X1.6271
N231Z.0688
N241T0
```

```
N251G0X0Z0
N261T03
N271G29LV21=0.01
N281G95
N291M03
N301X.Z.2
N311T0
N321G0X0Z0
N331T02
N341G95
N351M03
N361X1.8605Z-1.1447
N371X1.2758Z-1.2792
N381G33Z-2.9253F-.0455
N391G00X1.8605
N401Z-1.1447
N411X1.2758Z-1.2792
N421G33Z-2.9253F-.0455
N431G00X1.8605
N441Z-1.1447
N451X1.2758Z-1.2792
N461G33Z-2.9253F-.0455
N471G00X1.8605
N481M02
N491Z-1.1447
N501G0X0Z0
N511G29E
%
```

Post name:            Anl-1200
Machine type:         Vertical Lathe
Control:              Anilam Series 1200
IN/MM output:         Both
Abso/Incr:            Incremental IK
X Axis:               Negative Diameter
Programmer's notes:   Source code looks good.

```
N10   G0 G70 G90 T0 Z-20 G95
N20   X0
N30   T1
N40   M3 S1111
N50   G0 X-1.7576 Z0.0688
N60   F0.008
N70   G1 Z-0.0313
N80   Z-0.7838
N90   G2 X-1.8271 Z-0.8864 R0.1688
N100  G1 X-2.6587 Z-1.4297
N110  G3 X-2.6715 Z-1.4487 R0.0313
N120  G1 Z-2.7333
N130  G3 X-2.6669 Z-2.7451 R0.0313
N140  G1 X-2.0715 Z-3.4723
N150  Z-3.7285
N160  G2 X-2.509 Z-3.9473 R0.2188
N170  G1 X-3.0543
N180  G0 X-3.2543
N190  Z0.0688
N200  G0 T0 X0 Z-20
N210  M5
N220  T3
N230  M3 S777
N240  G0 X0.0 Z0.2
N250  G78 Z-0.75 R0.1 F0.01 I-0.3
N260  G0 T0 X0 Z-20
N270  M5
N280  T2
N290  M3 S567
N300  G0 X-3.721 Z-1.1447
N310  G84 F0.0455 Z-2.9253 D0.06 C-0.1 S2
N320  G0 T0 X0 Z-20
N330  M5
N340  M2
```

Post name:                Bend-5t
Machine type:         American Eagle Lathe
Control:                 Bendix 6T
IN/MM output:        Inch
Abso/Incr:             Incremental IK
X Axis:                  Radial
Programmer's notes:   Source code looks good

```
%
N5G90M4
N10G94M83
N15G04X3.0T0101M08
N20G92X20.0Z11.0M62F250
N25G92S1111
N30G96S675R20.0
N35G95
N40G00X0.8788Z0.0688M08
N45G01Z-0.0313F0.008
N50Z-0.7838
N55G02X0.9135Z-0.8864I0.1688K0.0
N60G01X1.3293Z-1.4297
N65G03X1.3358Z-1.4487I-0.0248K-
0.019
N70G01Z-2.7333
N75G03X1.3334Z-2.7451I-0.0313K0.0
N80G01X1.0358Z-3.4723
N85Z-3.7285
N90G02X1.2545Z-3.9473I0.2188K0.0
N95G01X1.5271
N100G00X1.6271
N105Z0.0688
N110M09
N115X20.0Z11.0
N120G04X3.0T0000
N125M01
N130G90M4
N135G04X3.0T0303M08
N140G92X20.0Z11.0M62F250
N145G97S777
N150G95
N155G00X0.0Z0.2M08
N160G83R0.1Z-0.75P0300Q0F0.01
N165G80
N170M09
N175X20.0Z11.0
N180G04X3.0T0000
N185M01
N190G90M4
N195G04X3.0T0202M08
N200G92X20.0Z11.0M62F250
N205G97S567
N210G95
N215G00X1.8605Z-1.1447M08
N220X1.2758Z-1.2792
N225G33Z-2.9253K0.0455
N230G00X1.8605
N235Z-1.1447
N240X1.2758Z-1.2792
N245G33Z-2.9253K0.0455
N250G00X1.8605
N255Z-1.1447
N260X1.2758Z-1.2792
N265G33Z-2.9253K0.0455
N270G00X1.8605
N275Z-1.1447
N280M09
N285X20.0Z11.0
N290G04X3.0T0000
N295M01
N300M30
%
```

Post name:          Cin2100t
Machine type:       Cincinnati Acramatic Lathe
Control:            2100TC
IN/MM output:       Inch
Abso/Incr:          R-word for Radius
X Axis:             Diameter
Programmer's notes: Source code looks good.

```
:T1M6
N2(MSG, R R TURNING  T01)
N4G92S1111
N6G96S675M4
N8G95
N10G0X1.7576Z.0688M8
N12G1Z-.0313F.008
N14Z-.7838
N16G2X1.8271Z-.8864P.1688
N18G1X2.6587Z-1.4297
N20G3X2.6715Z-1.4487P.0313
N22G1Z-2.7333
N24G3X2.6669Z-2.7451P.0313
N26G1X2.0715Z-3.4723
N28Z-3.7285
N30G2X2.509Z-3.9473P.2188
N32G1X3.0543
N34G0X3.2543
N36Z.0688
N38G0X40.0Z11.0M9

:T3M6
N40(MSG, DRILL  T03)
N42G97S777M4
N44G95
```

```
N46G0X.0Z.2M8
N48G0X40.0Z11.0M9

:T2M6
N50(MSG, R R THREADING  T02)
N52G97S567M4
N54G95
N56G0X3.721Z-1.1447M8
N58X2.5515Z-1.2792
N60G33Z-2.9253K0.04545
N62G0X3.721
N64Z-1.1447
N66X2.5515Z-1.2792
N68G33Z-2.9253K0.04545
N70G0X3.721
N72Z-1.1447
N74X2.5515Z-1.2792
N76G33Z-2.9253K0.04545
N78G0X3.721
N80Z-1.1447
N82G97S500
N84X40.0Z11.0
N86M5
N88M9
N90M2
%
```

| Post name: | Cin-850t |
| --- | --- |
| Machine type: | Cincinnati |
| Control: | Avenger 850SX TC |
| IN/MM output: | Inch |
| Abso/Incr: | R-word for radius |
| X Axis: | Diameter |
| Programmer's notes: | Source code looks good. |

```
:G0G90G62G97X40.0Z11.0S1111T1M26M13M42
N10(MSG, R R TURNING  T01)
N20G0X1.7576Z.0688
N30G92S1111
N40G96G95S675R1.7576F.008
N50G1Z-.0313
N60Z-.7838
N70G2X1.8271Z-.8864P.1688
N80G1X2.6587Z-1.4297
N90G3X2.6715Z-1.4487P.0313
N100G1Z-2.7333
N110G3X2.6669Z-2.7451P.0313
N120G1X2.0715Z-3.4723
N130Z-3.7285
N140G2X2.509Z-3.9473P.2188
N150G1X3.0543
N160G0X3.2543
N170Z.0688
N180M50
N190M01
:G0G90G62G97X40.0Z11.0S777T3M26M13M42
N200(MSG, DRILL  T03)
N210G0X.0Z.2
N220M50
N230M01
:G0G90G62G97X40.0Z11.0S567T2M26M13M42
N240(MSG, R R THREADING  T02)
N250G0X3.721Z-1.1447
N260X2.5515Z-1.2792
N270G95F0.0455
N280G33Z-2.9253K0.04545
N290G0X3.721
N300Z-1.1447
N310X2.5515Z-1.2792
N320G33Z-2.9253K0.04545
N330G0X3.721
N340Z-1.1447
N350X2.5515Z-1.2792
N360G33Z-2.9253K0.04545
N370G0X3.721
N380Z-1.1447
N390X40.0Z11.0
N400M50
N410M02
%
```

Post name:           Cin850tc
Machine type:        Cincinnati
Control:             Sabre 850SX TC
IN/MM output:        Inch
Abso/Incr:           Absolute
X Axis:              Diameter
Programmer's notes:  Source code looks good.

```
:1G0G62X1.7576Z.0688T1M26M8          :3G0G62X3.721Z-1.1447T2M26M8
N2(MSG, R R TURNING  T01)            N40(MSG, R R THREADING  T02)
N4G92S1111                           N42G97S567M13
N6G97S675M13                         N44X2.5515Z-1.2792
N8G95G96R1.7576S675F.008             N46G95F0.0455
N10G1Z-.0313                         N48G33Z-2.9253K0.04545
N12Z-.7838                           N50G0X3.721
N14G2X1.8271Z-.8864P.1688            N52Z-1.1447
N16G1X2.6587Z-1.4297                 N54X2.5515Z-1.2792
N18G3X2.6715Z-1.4487P.0313           N56G33Z-2.9253K0.04545
N20G1Z-2.7333                        N58G0X3.721
N22G3X2.6669Z-2.7451P.0313           N60Z-1.1447
N24G1X2.0715Z-3.4723                 N62X2.5515Z-1.2792
N26Z-3.7285                          N64G33Z-2.9253K0.04545
N28G2X2.509Z-3.9473P.2188            N66G0X3.721
N30G1X3.0543                         N68Z-1.1447
N32G0X3.2543                         N70G97S500
N34Z.0688M9                          N72X40.0Z11.0
                                     N74M5
:2G0G62X.0Z.2T3M26M8                 N76M9
N36(MSG, DRILL  T03)                 N78M2
N38G97S777M13M9                      %
```

Post name:            Cin-900
Machine type:         Cincinnati Cinturn 10CU
Control:              Acramatic 900TC
IN/MM output:         Inch
Abso/Incr:            Incremental IK
X Axis:               Radial
Programmer's notes:   Source code looks good

```
%                                      N36G97S777M42
O1G90                                  N37G70M3
N2G99                                  N38G92X200000Z110000
N3G0X200000Z110000M31                  N39G95T03M6
N4(MSG,  RIGHT REAR TURNING  T01)      N40M08
N5(MSG, HOME X+20.0 Z+11.0)            N41G00X0Z2000M32
N6(MSG, OFFSET X+0.0 Z+0.0)            N42M09
N7G97S1111M42                          N43T0200M6
N8G70M3                                N44M1
N9G92X200000Z110000
N10G95T01M6                            O45G90
N11M08                                 N46G99
N12G92S1111                            N47G0X200000Z110000M31
N13G96R8788S675M32                     N48(MSG,  RIGHT REAR THREADING  T02)
N14G00X8788Z688                        N49(MSG, OFFSET X+0.0 Z+0.0)
N15G01Z-313F0080                       N50G97S567M42
N16Z-7838                              N51G70M3
N17G02X9135Z-8864K-7838I10475          N52G92X200000Z110000
N18G01X13293Z-14297                    N53G95T02M6
N19G03X13358Z-14487K-14487I13045       N54M08
N20G01Z-27333                          N55G00X18605Z-11447M32
N21G03X13334Z-27451K-27333I13045       N56X12758Z-12792
N22G01X10358Z-34723                    N57G32Z-29253K-455I0
N23Z-37285                             N58G00X18605
N24G02X12545Z-39473K-37285I12545       N59Z-11447
N25G01X15271                           N60X12758Z-12792
N26G00X16271                           N61G32Z-29253K-455I0
N27Z688                                N62G00X18605
N28M09                                 N63Z-11447
N29T0300M6                             N64X12758Z-12792
N30M1                                  N65G32Z-29253K-455I0
                                       N66G00X18605
O31G90                                 N67Z-11447
N32G99                                 N68T0100M6
N33G0X200000Z110000M31                 N69M30
N34(MSG,  DRILL  T03)                  %
N35(MSG, OFFSET X+0.0 Z+0.0)
```

| Post name: | Cin-acra |
|---|---|
| Machine type: | Cincinnati Chucker |
| Control: | Acramatic 2 |
| IN/MM output: | Inch |
| Abso/Incr: | Incremental IK |
| X Axis: | Radial |
| Programmer's notes: | Source code looks OK. |

```
$
:
N5 G97 S1111 M42
N10 G95
N15 G00 X20.0000 Z11.0000
N20 T0101 M06
N25 G92 S1111
N30 G96 S675 R20.0000 M03
N35 X0.8788 Z0.0688 M07
N40 G01 Z-0.0313 F0.0080
N45 Z-0.7838
N50 G02 X0.9135 Z-0.8864 K-0.7838
I1.0475
N55 G01 X1.3293 Z-1.4297
N60 G03 X1.3358 Z-1.4487 K-1.4487
I1.3045
N65 G01 Z-2.7333
N70 G03 X1.3334 Z-2.7451 K-2.7333
I1.3045
N75 G01 X1.0358 Z-3.4723
N80 Z-3.7285
N85 G02 X1.2545 Z-3.9473 K-3.7285
I1.2545
N90 G01 X1.5271
N95 G00 X1.6271
N100 Z0.0688
N105 G00 X20.0000 Z11.0000 M09
N110 T0100 M06
N115 G00 M01
O120 G90 F200.0
N125 G97 S777 M42
N130 G95

N135 G00 X20.0000 Z11.0000
N140 T0303 M06
N145 G97 S777 M03
N150 X0.0000 Z0.2000 M07
N155 G00 X20.0000 Z11.0000 M09
N160 T0300 M06
N165 G00 M01
O170 G90 F200.0
N175 G97 S567 M42
N180 G95
N185 G00 X20.0000 Z11.0000
N190 T0202 M06
N195 G97 S567 M03
N200 X1.8605 Z-1.1447 M07
N205 X1.2758 Z-1.2792
N210 G33 Z-2.9253 K0.0455
N215 G00 X1.8605
N220 Z-1.1447
N225 X1.2758 Z-1.2792
N230 G33 Z-2.9253 K0.0455
N235 G00 X1.8605
N240 Z-1.1447
N245 X1.2758 Z-1.2792
N250 G33 Z-2.9253 K0.0455
N255 G00 X1.8605
N260 Z-1.1447
N265 G00 X20.0000 Z11.0000 M09
N270 T0200 M06
N275 G00 M01
N280 G00 M30
*
```

Post name:          Cob-f21
Machine type:       Hardinge Lathe
Control:            Cobra-42LC GE Fanuc-21 OTB
IN/MM output:       Inch
Abso/Incr:          Absolute
X Axis:             Diameter
Programmer's notes: Source code looks good, mild customization.


```
%                                    N105 M98 P1
O0012                                N110 M01
#501 = 12.5
#502 = 6.0                           N3  (T0303 DIA=.25 DRILL)
N5 G65 P9150 H2.5                    N115 G97 S777 M13
                                     N120 M98 P1
N1  (T0101 TURN OD .0313 R)          N125 T0303
N10 G97 S1111 M14                    N130 G0 X.0 Z.2
N15 M98 P1                           N135 G65 P9136 K-.75 B.1 F0.01 W.3
N20 T0101                            C.1 A.5
N25 G50 S1111                        N140 M98 P1
N30 G96 S675                         N145 M01
N35 G0 X1.7576 Z.06875
N40 G99 G1 Z-.03125 F0.008           N2  (T0202 THREAD OD TPI 100)
N45 Z-.78381                         N150 G97 S567 M14
N50 G2 X1.8271 Z-.88637 R.16875      N155 M98 P1
N55 G1 X2.6587 Z-1.42968             N160 T0202
N60 G3 X2.6715 Z-1.44868 R.03125     N165 G0 X3.72104Z-1.14472
N65 G1 Z-2.73327                     N170 G92 X2.55154 Z-2.92535
N70 G3 X2.6669 Z-2.74511 R.03125     F.04545
N75 G1 X2.0715 Z-3.47227             N175 M98 P1
N80 Z-3.72851                        N180 M1
N85 G2 X2.509 Z-3.94726 R.21875
N90 G1 X3.0543                       N185 M30
N95 G0 X3.2543                       %
N100 Z.06875
```

Post name:          Cobra-42
Machine type:       Hardinge Lathe
Control:            Cobra-42 GE Fanuc-21T
IN/MM output:       Inch
Abso/Incr:          Absolute
X Axis:             Diameter
Programmer's notes: Highly customized

```
%                                Z.06875
O0012                            M98 P1
#501 = 12.5                      M01
#502 = 6.0
 G65 P9150 H2.5                 N3  (T0303 DIA=.25 DRILL)
                                 G97 S777 M13
N1  (T0101 TURN OD .0313 R)      M98 P1
 G97 S1111 M14                   T0303
 M98 P1                          G0 X.0 Z.2
 T0101                           G65 P9136 K-.75 B.1 F0.01 W.3 C.1 A.5
 G50 S1111                       M98 P1
 G96 S675                        M01
 G0 X1.7576 Z.06875
 G99 G1 Z-.03125 F0.008         N2  (T0202 THREAD OD TPI 100)
 Z-.78381                        G97 S567 M14
 G2 X1.8271 Z-.88637 R.16875     M98 P1
 G1 X2.6587 Z-1.42968            T0202
 G3 X2.6715 Z-1.44868 R.03125    G0 X3.72104Z-1.14472
 G1 Z-2.73327                    G92 X2.55154 Z-2.92535 F.04545
 G3 X2.6669 Z-2.74511 R.03125    M98 P1
 G1 X2.0715 Z-3.47227            M1
 Z-3.72851
 G2 X2.509 Z-3.94726 R.21875     M30
 G1 X3.0543                     %
 G0 X3.2543
```

Post name:            Daewoo
Machine type:         Daewoo Lathe
Control:              Fanuc
IN/MM output:         Inch
Abso/Incr:            Incremental IK
X Axis:               Diameter
Programmer's notes:   Source code looks good


```
%
 G0 T0101
 G54
 G50 S1111
 G96 S675 M3
 G0 X1.7576 Z0.0688 M8
 G1 Z-0.0313 F80
 Z-0.7838
 G2 X1.8271 Z-0.8864 I0.1688 K0.0
 G1 X2.6587 Z-1.4297
 G3 X2.6715 Z-1.4487 I-0.0248 K-0.019
 G1 Z-2.7333
 G3 X2.6669 Z-2.7451 I-0.0313 K0.0
 G1 X2.0715 Z-3.4723
 Z-3.7285
 G2 X2.509 Z-3.9473 I0.2188 K0.0
 G1 X3.0543
 G0 X3.2543
 Z0.0688
 X40.0 Z11.0 M9
 M01

 G0 T0303
 G54
 G97 S777 M3
 G0 X0.0 Z0.2 M8
 G83 R0.1 Z-0.75 P300 Q0.3 F100
 G80
 X40.0 Z11.0 M9
 M01

 G0 T0202
 G54
 G97 S567 M3
 G0 X3.721 Z-1.1447 M8
 X2.5515 Z-1.2792
 G76 P020060 Q56 R30
 G76 X2.5515 Z-2.9253 P600 Q1000 F.0455
 X2.5515 Z-2.9253
 X40.0 Z11.0 M9
 M01

 M30
%
```

Post name:          Daewoo-f
Machine type:       Daewoo Lathe
Control:            Fanuc OT
IN/MM output:       Inch
Abso/Incr:          Incremental IK
X Axis:             Diameter
Programmer's notes: Source code looks good.

```
O0012(Tc-posts)
N10 G90
N20 G50 X40.0 Z11.0  (T01 RIGHT REAR TURNING)
N30 T0101
N40 G50 S1111
N50 G96 S675 M03
N60 G90 G00 X1.7576 Z0.0688 M08
N70 G01 Z-0.0313 F0.008
N80 Z-0.7838
N90 G02 X1.8271 Z-0.8864 I0.1688 K0.0
N100 G01 X2.6587 Z-1.4297
N110 G03 X2.6715 Z-1.4487 I-0.0248 K-0.019
N120 G01 Z-2.7333
N130 G03 X2.6669 Z-2.7451 I-0.0313 K0.0
N140 G01 X2.0715 Z-3.4723
N150 Z-3.7285
N160 G02 X2.509 Z-3.9473 I0.2188 K0.0
N170 G01 X3.0543
N180 G00 X3.2543
N190 Z0.0688 M09
N200 X40.0 Z11.0 T0100
N210 M01
N220 G50 X40.0 Z11.0  (T03 DRILL)
N230 T0303
N240 G97 S777 M03
N250 G90 G00 X0.0 Z0.2 M08
N260 G83 R0.1 Z-0.75 P0300 Q0 F0.01
N270 G80 M09
N280 X40.0 Z11.0 T0300
N290 M01
N300 G50 X40.0 Z11.0  (T02 RIGHT REAR THREADING)
N310 T0202
N320 G97 S567 M03
N330 G00 X3.721 Z-1.1447
N340 X2.5515 Z-1.2792
N350 G76 P020060 Q30 R2
N360 G76 X2.5515 Z-2.9253 P17 Q100 F.0455
N370 G90 X2.5515 Z-2.9253 M08 M09
N380 X40.0 Z11.0 T0200
N390 M01
N400 M30
%
```

| Post name: | Delt-20t |
| --- | --- |
| Machine type: | Generic Lathe |
| Control: | Delta 20-T Conversational |
| IN/MM output: | Inch |
| Abso/Incr: | Absolute |
| X Axis: | Negative Radial |
| Programmer's notes: | Source code looks OK. |

```
(Tc-posts)
N010(M)M3D0$
N020(0)X-20.0Z11.0$
N030(M)D1$
N040(M)M8$
N050(0)X-0.8788Z0.0688$
N060(M)F.0080$
N070(1)Z-0.0313$
N080(1)Z-0.7838$
N090(4)X-0.9135Z-0.8864R0.1688C0$
N100(3)X-1.3293Z-1.4297$
N110(4)X-1.3358Z-1.4487R0.0313C1$
N120(1)Z-2.7333$
N130(4)X-1.3334Z-2.7451R0.0313C1$
N140(3)X-1.0358Z-3.4723$
N150(1)Z-3.7285$
N160(4)X-1.2545Z-3.9473R0.2188C0$
N170(2)X-1.5271$
N180(0)X-1.6271$
N190(0)Z0.0688$
N200(M)D0$
N210(0)X-20.0Z11.0$
N220(M)M00$
N230(M)D3$
N240(0)X0.0Z0.2$
N250(7)G0Z-0.75W0K0.3F0.01$
N260(M)D0$
N270(0)X-20.0Z11.0$
N280(M)M00$
N290(M)D2$
N300(0)X-1.7605Z-1.1447$
N310(5)G0D-2.5515Z-1.6461U2.6715K-0.0455W0C.1P0.1L.001S2F0.01$
N320(0)X-1.7605Z-1.1447$
N330(M)D0$
N340(0)X-20.0Z11.0$
N350(M)M30$
END
```

Post name:              Ema-tc
Machine type:           Ema Lathe
Control:                Fanuc
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Diameter
Programmer's notes:     Source code looks good

```
%
O0012(Tc-posts)
N1G50X40.0Z11.0M8
G0T0101M41
(T01 RIGHT REAR TURNING)
G50S1111
G96S675M3
G0G99X1.7576Z0.0688
G1Z-0.0313F0.008
Z-0.7838
G2X1.8271Z-0.8864I10.0475K8.2162
G1X2.6587Z-1.4297
G3X2.6715Z-1.4487I10.3045K7.5513
G1Z-2.7333
G3X2.6669Z-2.7451I10.3045K6.2667
G1X2.0715Z-3.4723
Z-3.7285
G2X2.509Z-3.9473I10.2545K5.2715
G1X3.0543
G0X3.2543
Z0.0688M9
G0X40.0Z11.0
T0100
M1
N3G50X40.0Z11.0M8
G0T0303M41
(T03 DRILL)
G97S777M3
G0G98X0.0Z0.2
G83R0.1Z-0.75K0.3F0.01
G80M9

G0X40.0Z11.0
T0300
M1
N2G50X40.0Z11.0M8
G0T0202M41
(T02 RIGHT REAR THREADING)
G97S567M3
G0G99X3.721Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253K0.0455
G0X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253K0.0455
G0X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253K0.0455
G0X3.721
Z-1.1447M9
G0X40.0Z11.0M5
T0200
M1T0100

M00

N999
G28U0.0
G28W0.0
M30
%
```

| Post name: | Emco-otc |
| --- | --- |
| Machine type: | Emcotronics Lathe |
| Control: | Fanuc OTC |
| IN/MM output: | Both |
| Abso/Incr: | Incremental IK |
| X Axis: | Negative Diameter |
| Programmer's notes: | Mild customization, supports a barpuller. |

```
%
:0012(Tc-posts)
N0010G00G40X-40.0Z11.0
N0020T101(NR=0.03125 TURNING)
N0030G92S1111
N0040G96S675M03
N0050G00X-1.7576Z0.0688M8
N0060G01Z-0.0313F0.008
N0070Z-0.7838
N0080G02X-1.8271Z-0.8864I0.1688K0.0
N0090G01X-2.6587Z-1.4297
N0100G03X-2.6715Z-1.4487I-0.0248K-0.019
N0110G01Z-2.7333
N0120G03X-2.6669Z-2.7451I-0.0313K0.0
N0130G01X-2.0715Z-3.4723
N0140Z-3.7285
N0150G02X-2.509Z-3.9473I0.2188K0.0
N0160G01X-3.0543
N0170G00X-3.2543
N0180Z0.0688
N0190X-40.0Z11.0T0
N0200T303(0.25 DRILL)
N0210G97S777M03
N0220G00X0.0Z0.2M8
N0230G83F0.01
N0240G80
N0250G00X-40.0Z11.0T0
N0260T202(THREADING)
N0270G97S567M03
N0280G00X-3.721Z-1.1447M8
N0290X-2.5515Z-1.2792
N0300G33Z-2.9253F0.04545
N0310G00X-3.721
N0320Z-1.1447
N0330X-2.5515Z-1.2792
N0340G33Z-2.9253F0.04545
N0350G00X-3.721
N0360Z-1.1447
N0370X-2.5515Z-1.2792
N0380G33Z-2.9253F0.04545
N0390G00X-3.721
N0400Z-1.1447
N0410X-40.0Z11.0T0M05
N0420M30
%
```

Post name:              Emco-t2
Machine type:           Emcotronics Lathe
Control:                TO2
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Diameter
Programmer's notes:     Source code looks good


```
%0012

N0000   G70 G53 G56 M53
N0010   G54 M08
N0020   G0 G59 X40.0 Z11.0 T0101
N0030   G96 S675 M4
N0040   G0 X1.7576 Z0.0688
N0050   G1 Z-0.0313 F80
N0060   Z-0.7838
N0070   G2 X1.8271 Z-0.8864 I0.1688 K0.0
N0080   G1 X2.6587 Z-1.4297
N0090   G3 X2.6715 Z-1.4487 I-0.0248 K-0.019
N0100   G1 Z-2.7333
N0110   G3 X2.6669 Z-2.7451 I-0.0313 K0.0
N0120   G1 X2.0715 Z-3.4723
N0130   Z-3.7285
N0140   G2 X2.509 Z-3.9473 I0.2188 K0.0
N0150   G1 X3.0543
N0160   G0 X3.2543
N0170   Z0.0688
N0180   T0303 G97 S777 M4
N0190   G0 X0.0 Z0.2 M08
N0200   G83 Z-0.75 P30.1 F100
N0210   G80
N0220   T0202 G97 S567 M4
N0230   G0 X3.721 Z-1.1447 M08
N0240   X2.5515 Z-1.2792
N0250   G33 Z-2.9253 F.045455
N0260   G0 X3.721
N0270   Z-1.1447
N0280   X2.5515 Z-1.2792
N0290   G33 Z-2.9253 F.045455
N0300   G0 X3.721
N0310   Z-1.1447
N0320   X2.5515 Z-1.2792
N0330   G33 Z-2.9253 F.045455
N0340   G0 X3.721
N0350   Z-1.1447 M05
N0360   M25
N0370   M30
%
```

Post name:           Fagor800
Machine type:        Generic Lathe
Control:             Fagor 800T
IN/MM output:        Inch
Abso/Incr:           Incremental IK
X Axis:              Negative Diameter
Programmer's notes:  Source code looks good


```
%00012
N10 G0 G90 G97
N20 S1111 M4
N30 T1.1
N40 G92 S1111
N50 G96 S675 M4
N60 X-1.7576 Z0.0688
N70 G1 Z-0.0313 F0.008
N80 Z-0.7838
N90 G2 G06 X-1.8271 Z-0.8864 I-2.0951 K-0.7838
N100 G1 X-2.6587 Z-1.4297
N110 G3 G06 X-2.6715 Z-1.4487 I-2.609 K-1.4487
N120 G1 Z-2.7333
N130 G3 G06 X-2.6669 Z-2.7451 I-2.609 K-2.7333
N140 G1 X-2.0715 Z-3.4723
N150 Z-3.7285
N160 G2 G06 X-2.509 Z-3.9473 I-2.509 K-3.7285
N170 G1 X-3.0543
N180 G0 X-3.2543
N190 Z0.0688
N200 T0.0
N210 M01
N220 G0 G90 G97
N230 S777 M4
N240 T3.3
N250 G97 S777 M4
N260 X0.0 Z0.2
N270 G1 F0.01
N280 G83 P0=K0 P1=K0.1 P4=K0.75 P4=K0.75 P5=K0 P6=K0 P15=K0 P16=K0
N290 T0.0
N300 M01
N310 G0 G90 G97
N320 S567 M4
N330 T2.2
N340 G97 S567 M4
N350 X-3.721 Z-1.1447
N360 G86 P0=K-1.2792 P1=K-2.5515 P2=K-2.9253 P3=K-2.5515 P3=K-2.5515
P4=K0.06 P5=K0010 P6=K0 P7=K0 P10=K0.0455 P11=K0 P12=K60.0
N370 X-2.5515 Z-1.2792
N380 T0.0
N390 M01
N400 M30
```

Post name:          Fagor-tc
Machine type:       Hardinge Lathe
Control:            Fagor 8025/8030 T, TG, TS
IN/MM output:       Inch
Abso/Incr:          Incremental IK
X Axis:             Diameter
Programmer's notes: Source code looks good.

```
%12
N10 G0 G90 G94 G97 G70 G07
N20 S1111 M3
N30 T1.1
N40 G92 S1111
N50 G96 S675 M3
N60 Z0.0688 X1.7576
N70 G01 G95 Z-0.0313 F0.008
N80 Z-0.7838
N90 G02 Z-0.8864 X1.8271 I0.3375 K0.0
N100 G01 Z-1.4297 X2.6587
N110 G03 Z-1.4487 X2.6715 I-0.0496 K-0.019
N120 G01 Z-2.7333
N130 G03 Z-2.7451 X2.6669 I-0.0625 K0.0
N140 G01 Z-3.4723 X2.0715
N150 Z-3.7285
N160 G02 Z-3.9473 X2.509 I0.4375 K0.0
N170 G01 X3.0543
N180 G00 X3.2543
N190 Z0.0688
N200 T0.0
N210 M01
N220 G0 G90 G94 G97 G70 G07
N230 S777 M3
N240 T3.3
N250 G97 S777 M03
N260 Z0.2 X0.0
N270 G1 G95 F0.01
N280 G83 P0=K0 P1=K0.1 P4=K0.75 P4=K0.75 P5=K0 P6=K0 P15=K0 P16=K0
N290 T0.0
N300 M01
N310 G0 G90 G94 G97 G70 G07
N320 S567 M3
N330 T2.2
N340 G97 S567 M03
N350 Z-1.1447 X3.721
N360 G86 P0=K-1.2792 P1=K2.5515 P2=K-2.9253 P3=K2.5515 P3=K2.5515 P4=K0.06
P5=K0010 P6=K0 P7=K0 P10=K0.0455 P11=K0 P12=K60.0
N370 Z-1.2792 X2.5515
N380 T0.0
N390 M01
N400 M30
%
```

| | |
|---|---|
| Post name: | Fan-6t |
| Machine type: | Generic Lathe |
| Control: | Fanuc 6T |
| IN/MM output: | Both |
| Abso/Incr: | R-word for radius |
| X Axis: | Diameter |
| Programmers notes: | Dealer's standard post, mild customization, has live drilling, G32 tapping. |

```
%
O0012(Tc-posts)
G28U0W0
N100G00T0100  (T01 #01 NR=.0313 OD
TURNING)
G50X40.0Z11.0S1111
M40
G99G96S675M03
G00X1.7576Z0.0688T0101M08
G01Z-0.0313F0.008
Z-0.7838
G02X1.8271Z-0.8864R0.1688
G01X2.6587Z-1.4297
G03X2.6715Z-1.4487R0.0313
G01X2.6715Z-2.7333
G03X2.6669Z-2.7451R0.0313
G01X2.0715Z-3.4723
Z-3.7285
G02X2.509Z-3.9473R0.2188
G01X3.0543Z-3.9473
G00X3.2543
Z0.0688
X40.0Z11.0T0100M09
M01

N300G00T0300  (T03 #03 DIA=.25
DRILL)
G50X40.0Z11.0S777
M40
G99G97S777M03

G00X0.0Z0.2T0303M08
G83R0.1Z-0.75P0300Q0F0.01
X40.0Z11.0T0300M09
M01

N200G00T0200  (T02 #02 OD
THREADING TOOL)
G50X40.0Z11.0S567
M40
G99G97S567M03
M23
G00X3.721Z-1.1447
G92X2.5515Z-2.9253K-0.0173E0.0455
(STEP-DIA=.06)
G00M24
X40.0Z11.0T0200
M01

M05
G28U0W0
M01

/M99
M30
%
#
```

Post name:           Fan-vipr
Machine type:        Viper Lathe
Control:             Fanuc
IN/MM output:        Inch
Abso/Incr:           Incremental IK
X Axis:              Diameter
Programmer's notes:  Dealer's standard post, mild customization for parts catcher.

```
%
O0012
(FILE# Tc-posts)
N1G40G80
G28U0W0
G0T0101 ( NR=.0313 OD TURNING)
G50S1111
G96S675M03
G0X1.7576Z0.0688M8
G1Z-0.0313F0.008
Z-0.7838
G2X1.8271Z-0.8864R0.1688
G1X2.6587Z-1.4297
G3X2.6715Z-1.4487R0.0313
G1Z-2.7333
G3X2.6669Z-2.7451R0.0313
G1X2.0715Z-3.4723
Z-3.7285
G2X2.509Z-3.9473R0.2188
G1X3.0543
G0X3.2543
Z0.0688
G28U0W0
T0100
M1
```

```
N3G40G80
G28U0W0
G0T0303 (DIA=0.25 DRILL)
G97S777M03
G0X0.0Z0.2M8
G83X0.0Z0.2Z-0.75F0.01
G80
G28U0W0
T0300
M1
N2G40G80
G28U0W0
G0T0202 ( OD THREADING TOOL)
G97S567M03
G0X3.721Z-1.1447
X2.5515Z-1.2792
G76P010060Q50R20
G76X2.5515Z-2.9253P600Q1000F.0455
X2.5515Z-2.9253M8
G28U0W0
T0200
M1
/M99
M30
%
```

| | |
|---|---|
| Post name: | Ge1050hl |
| Machine type: | Generic Lathe |
| Control: | GE 1050HL |
| IN/MM output: | Inch |
| Abso/Incr: | Incremental IK |
| X Axis: | Negative Diameter |
| Programmer's notes: | Mild customization, outputs G33 for tapping, G84 for canned threading. |

```
%
N10G54T0101
N20G95S1467M3
N30G0X-1.7576Z0.0688M08
N40G92S1111
N50G96R-1.7576S675
N60G1Z-0.0313F.0080
N70Z-0.7838
N80G3X-1.8271Z-0.8864I0.1688
N90X-2.6587Z-1.4297
N100G2X-2.6715Z-1.4487I0.0248K0.019
N110Z-2.7333
N120G2X-2.6669Z-2.7451I0.0313
N130X-2.0715Z-3.4723
N140Z-3.7285
N150G3X-2.509Z-3.9473I0.2188
N160X-3.0543
N170G0X-3.2543
N180Z0.0688
N190T0000M59
N200X-40.0Z11.0
N210T0303
N220G95
N230G97S777M3
N240G0X0.0Z0.2
N250G83Z-0.75F0.01P10.4P2.250P5.050
N260T0000M59
N270X-40.0Z11.0
N280T0202
N290G95
N300G97S567M3
N310G0X-3.721Z-1.1447
N320G84X-2.5515Z-2.9253P10.06P20.0455P4-2.9253
N330X-2.5515Z-2.9253
N340T0000M59
N350X-40.0Z11.0M09
N360M05
N370G53
N380M30
%
```

Post name:           Ge1050t
Machine type:        Generic Lathe
Control:             GE 1050T
IN/MM output:        Inch
Abso/Incr:           Incremental IK
X Axis:              Diameter
Programmer's notes:  Source code looks good.


```
=
N10G70
N20G90
N30G95
N40G97S0100M03
N50G92X0Z0S1111
N60T0001
N70G00X40.0Z11.0
N80G96S0675R40.0M03
N90G00X1.7576Z0.0688
N100G01Z-0.0313F.008
N110Z-0.7838
N120G02X1.8271Z-0.8864I-0.1688
N130G01X2.6587Z-1.4297
N140G03X2.6715Z-
1.4487I0.0248K0.019
N150G01Z-2.7333
N160G03X2.6669Z-2.7451I0.0313
N170G01X2.0715Z-3.4723
N180Z-3.7285
N190G02X2.509Z-3.9473I-0.2188
N200G01X3.0543
N210G00X3.2543
N220Z0.0688
N230G97S0100
N240X40.0Z11.0
N250T0000
N260G0X0Z0
N270M0
N280G90
N290G97S0100M03
N300G92X0Z0S0777
N310T0003
N320G00X40.0Z11.0
```

```
N330G97S0777M03
N340G00X0.0Z0.2
N350G97S0100
N360X40.0Z11.0
N370T0000
N380G0X0Z0
N390M0
N400G90
N410G97S0100M03
N420G92X0Z0S0567
N430T0002
N440G00X40.0Z11.0
N450G97S0567M03
N460G00X3.721Z-1.1447
N470X2.5515Z-1.2792
N480G33Z-2.9253K0.045455
N490G00X3.721
N500Z-1.1447
N510X2.5515Z-1.2792
N520G33Z-2.9253K0.045455
N530G00X3.721
N540Z-1.1447
N550X2.5515Z-1.2792
N560G33Z-2.9253K0.045455
N570G00X3.721
N580Z-1.1447
N590G97S0100
N600X40.0Z11.0
N610T0000
N620G0X0Z0
N630M0
N640G90
N650M30
=
```

Post name:              GE-2000t
Machine type:           Jones & Lamson Lathe
Control:                GE 2000
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Negative Diameter
Programmer's notes:     Source code looks OK.

```
##%#< Tc-posts >#
%
$0000012

N10G70
N20G90
N30G95M08
N40S12T0101M06
N50G92X-40.0000Z11.0000
N60G21X-1.7576Z0.0688F00
N70Z-0.0313F80
N80Z-0.7838
N90G23X-1.8271Z-0.8864I0.1688
N100G21X-2.6587Z-1.4297
N110G22X-2.6715Z-1.4487I0.0248K0.0190
N120G21Z-2.7333
N130G22X-2.6669Z-2.7451I0.0313
N140G21X-2.0715Z-3.4723
N150Z-3.7285
N160G23X-2.5090Z-3.9473I0.2188
N170G21X-3.0543
N180X-3.2543F00
N190Z0.0688
N200X-40.0000Z11.0000M09
N210T0100M08
N220S11T0303M06
N230G21X0.0000Z0.2000F00
N240X-40.0000Z11.0000M09
N250T0300M08
N260S10T0202M06
N270G21X-3.7210Z-1.1447F00
N280X-2.5515Z-1.2792
N290G33Z-2.9253K-0.045455
N300G21X-3.7210
N310Z-1.1447
N320X-2.5515Z-1.2792
N330G33Z-2.9253K-0.045455
N340G21X-3.7210
N350Z-1.1447
N360X-2.5515Z-1.2792
N370G33Z-2.9253K-0.045455
N380G21X-3.7210
N390Z-1.1447
N400X-40.0000Z11.0000M09
N410T0200M30
%
#< END OF Tc-posts>#
```

Post name:          GN-10tf
Machine type:       Metalist TCI Lathe
Control:            GN 10TF
IN/MM output:       Inch
Abso/Incr:          Incremental IK
X Axis:             Radial
Programmer's notes: Source code looks good

```
O0012(Tc-posts)
N0005 M52
N0010 G20
N0015 G95
N0020 G92 X20.0 Z11.0  (T01 RIGHT
REAR TURNING)
N0025 G92 S1111
N0030 G96 S675 M03
N0035 T0101
N0040 G90 G00 X0.8788 Z0.0688 M08
N0045 G01 Z-0.0313 F0.008
N0050 Z-0.7838
N0055 G02 X0.9135 Z-0.8864 I0.1688
K0.0
N0060 G01 X1.3293 Z-1.4297
N0065 G03 X1.3358 Z-1.4487 I-
0.0248 K-0.019
N0070 G01 Z-2.7333
N0075 G03 X1.3334 Z-2.7451 I-
0.0313 K0.0
N0080 G01 X1.0358 Z-3.4723
N0085 Z-3.7285
N0090 G02 X1.2545 Z-3.9473 I0.2188
K0.0
N0095 G01 X1.5271
N0100 G00 X1.6271
N0105 Z0.0688
N0110 M09
N0115 X20.0 Z11.0
N0120 T0100
N0125 M52
N0130 G95
N0135 G92 X20.0 Z11.0  (T03 DRILL)
```

```
N0140 G97 S777 M03
N0145 T0303
N0150 G90 G00 X0.0 Z0.2 M08
N0155 G83 R0.1 Z-0.75 P0300 Q0
F0.01
N0160 G80
N0165 M09
N0170 X20.0 Z11.0
N0175 T0300
N0180 M52
N0185 G95
N0190 G92 X20.0 Z11.0  (T02 RIGHT
REAR THREADING)
N0195 G97 S567 M03
N0200 T0202
N0205 G90 G00 X1.8605 Z-1.1447 M08
N0210 X1.2758 Z-1.2792
N0215 G33 Z-2.9253 K0.0455
N0220 G00 X1.8605
N0225 Z-1.1447
N0230 X1.2758 Z-1.2792
N0235 G33 Z-2.9253 K0.0455
N0240 G00 X1.8605
N0245 Z-1.1447
N0250 X1.2758 Z-1.2792
N0255 G33 Z-2.9253 K0.0455
N0260 G00 X1.8605
N0265 Z-1.1447
N0270 M09
N0275 X20.0 Z11.0
N0280 T0200
N0285 M52
N0290 M30
%
```

Post name:              Good-fan
Machine type:           Generic Lathe
Control:                Fanuc 10T
IN/MM output:           Inch
Abso/Incr:              Absolute
X Axis:                 Diameter
Programmer's notes:     Source code looks good.

```
O0001
N10G50X40.0Z11.0S1111
G00T0101 (T1 0.0313 RAD RR
TURNING)
M42
G96S675M03
G00X1.7576Z0.0688M07
M08
G01Z-0.0313F0.008
Z-0.7838
G02X1.8271Z-0.8864R0.1688
G01X2.6587Z-1.4297
G03X2.6715Z-1.4487R0.0313
G01Z-2.7333
G03X2.6669Z-2.7451R0.0313
G01X2.0715Z-3.4723
Z-3.7285
G02X2.509Z-3.9473R0.2188
G01X3.0543
G00X3.2543
Z0.0688
M09
X40.0Z11.0M08
T0100
M01
N20G50X40.0Z11.0S777
G00T0303 (T3 DRILL)
M42
G97S777M03
G00X0.0Z0.2
M08
G83R0.1Z-0.75P0300Q0.3
```

```
G80
M09
G00X40.0Z11.0M07
T0300
M01
N30G50X40.0Z11.0S567
G00T0202 (T2 THREADING TOOL)
M42
G97S567M03
G00X3.721Z-1.1447
M08
X2.5515Z-1.2792
G32Z-2.9253F-.04545
X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253F-.04545
X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253F-.04545
X3.721
Z-1.1447
T0200
M09
M05
N1000G28U0.0
G28W0.0
G30W0.0
G30U0.0
M30
%
```

Post name:                Hard-1
Machine type:             Hardinge Lathe
Control:                  Allen Bradley 7370
IN/MM output:             Inch
Abso/Incr:                Incremental IK
X Axis:                   Radial
Programmer's notes:       Source code looks OK.

```
< Tc-posts  Tue Apr 10 13:47:11 2001'%
N0005G70G90G95
N0010G92X20.0Z11.0S1111
N0015G96S0675R20.0M03
N0020T0101
N0025G00X0.8788Z0.06875M07M08
N0030G01Z-0.03125F0.008
N0035Z-0.78381
N0040G02X0.91354Z-0.88637I0.16875K0.0
N0045G01X1.32934Z-1.42968
N0050G03X1.33577Z-1.44868I0.02482K0.01899
N0055G01Z-2.73327
N0060G03X1.33344Z-2.74511I0.03125K0.0
N0065G01X1.03577Z-3.47227
N0070Z-3.72851
N0075G02X1.25452Z-3.94726I0.21875K0.0
N0080G01X1.52715
N0085G00X1.62715
N0090Z0.06875
N0095X20.0Z11.0M08M09
N0100T0
N0105M01
N0110G92X20.0Z11.0S0777
N0115G97S0777M03
N0120T0303
N0125G00X0.0Z0.2M08
N0130X20.0Z11.0M07M09
N0135T0
N0140M01
N0145G92X20.0Z11.0S0567
N0150G97S0567M03
N0155T0202
N0160G00X1.86052Z-1.14472M08
N0165X1.27577Z-1.27922
N0170G33Z-2.92535K0.045455
N0175G00X1.86052
N0180Z-1.14472
N0185X1.27577Z-1.27922
N0190G33Z-2.92535K0.045455
N0195G00X1.86052
N0200Z-1.14472
N0205X1.27577Z-1.27922
N0210G33Z-2.92535K0.045455
N0215G00X1.86052
N0220Z-1.14472
N0225X20.0Z11.0M09
N0230T0
N0235M30
<  END OF Tc-posts >#
```

Post name:           Ht30g-tc
Machine type:        Hitachi Seiki HT30G
Control:             Seicos M-III
IN/MM output:        Both
Abso/Incr:           Incremental IK
X Axis:              Diameter
Programmer's notes:  Dealer's standard post, mild customization, has live tooling.

```
%                                      T0300M41
O0012                                  G97S777M08
(Tc-posts.TAP)                         G00X0.0Z0.2M03
N01G50S2000                            G83R0.1Z-0.75P0300Q0F0.01
N02G30U0                               G97G30U0W0M09
N03G30W0                               M01
N04G10P0Z0
N05M01                                 N200  (T02 RR THREADING)
                                       T0200M41
N100  (T01 RR TURNING)                 G97S567M08
T0100M41                               G00X3.721Z-1.1447M03
G99G96S675M08                          X2.5515Z-1.2792
G00X1.7576Z0.0688M03                   G32Z-2.9253F.04545
G01Z-0.0313F0.008                      G00X3.721
Z-0.7838                               Z-1.1447
G02X1.8271Z-0.8864R0.1688              X2.5515Z-1.2792
G01X2.6587Z-1.4297                     G32Z-2.9253F.04545
G03X2.6715Z-1.4487R0.0313              G00X3.721
G01X2.6715Z-2.7333                     Z-1.1447
G03X2.6669Z-2.7451R0.0313              X2.5515Z-1.2792
G01X2.0715Z-3.4723                     G32Z-2.9253F.04545
Z-3.7285                               G00X3.721
G02X2.509Z-3.9473R0.2188               Z-1.1447
G01X3.0543Z-3.9473                     G97G30U0W0M09
G00X3.2543                             M01
Z0.0688
G97G30U0W0M09                          M05
M01                                    G30U0W0
                                       M30
N300  (T03 DRILL)                      %
```

Post name:              L10
Machine type:           Hitachi TC
Control:                Seicos M-III
IN/MM output:           Both
Abso/Incr:              R-word for radius
X Axis:                 Diameter
Programmer's notes:     Highly customized, supports barpuller, tapping.


```
%                                       T0300
O0012(Tc-posts.TAP)                     M40
N01G50S4000                             G99G97S777M03
G30U0W0                                 G00X0.0Z0.2M08
M01                                     G83R0.1Z-0.75P0300Q0F0.01
                                        G00G30G97U0W0M09
   (T01 RR TURNING)                     M01
   (1/32R 0.75 TLWDT)
N100                                       (T02 RR THREADING)
G30U0W0                                    (0.7 TLWDT)
T0100                                   N200
M40                                     G30U0W0
G99G96S675M03                           T0200
G00X1.7576Z0.0688M08                    M40
G01Z-0.0313F0.008                       G99G97S567M03
Z-0.7838                                G00X3.721Z-1.1447
G02X1.8271Z-0.8864R0.1688               G76X2.5515Z-2.9253K0.06D0.1F0.0454545A60L2
G01X2.6587Z-1.4297                      X2.5515Z-2.9253M08
G03X2.6715Z-1.4487R0.0313               G00G30G97U0W0M09
G01X2.6715Z-2.7333                      M01
G03X2.6669Z-2.7451R0.0313
G01X2.0715Z-3.4723                      M05
Z-3.7285                                G28U0W0
G02X2.509Z-3.9473R0.2188                M01
G01X3.0543Z-3.9473
G00X3.2543
Z0.0688
G00G30G97U0W0M09
M01
                                        /M99
   (T03 DRILL)                          M30
   (0.25 TLWDT)                         %
N300                                    #
G30U0W0
```

Post name:            M4-fan5t
Machine type:         Mazak Lathe
Control:              Fanuc 5T
IN/MM output:         Both
Abso/Incr:            Incremental IK
X Axis:               Diameter
Programmer's notes:   Source code looks good.


```
N001 G50 X0 Z0 S1111 M08
N002 G96 S675 M38
N003 G00 T0101 M03
N004 G00 X17576 Z688
N005 G01 Z-313 F80
N006 Z-7838
N007 G02 X18271 Z-8864 I1688 K0
N008 G01 X26587 Z-14297
N009 G03 X26715 Z-14487 I-248 K-190
N010 G01 Z-27333
N011 G03 X26669 Z-27451 I-313 K0
N012 G01 X20715 Z-34723
N013 Z-37285
N014 G02 X25090 Z-39473 I2188 K0
N015 G01 X30543
N016 G00 X32543
N017 Z688
N018 X0 Z0 T0100 M09
N019 M01

N020 G50 X0 Z0 S777 M08
N021 G97 S777 M38
N022 G00 T0303 M03
N023 G00 X0 Z2000
N024G83R1000Z-7500P0300Q0F0.01
N025 X0 Z0 T0300 M09
N026 M01

N027 G50 X0 Z0 S567 M08
N028 G97 S567 M38
N029 G00 T0202 M03
N030 G00 X37210 Z-11447
N031 X25515 Z-12792
N032 G76 X25515 Z-29253 K600 D102 A60 E10000
N033 X25515 Z-29253
N034 X0 Z0 T0200 M09
N035 M01

N036 M30
```

Post name:              Mazak-tc
Machine type:           Mazak BarTC
Control:                Mazatrol T32B
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Diameter
Programmer's notes:     Source code looks good.

```
%                                      (T03 DRILL)
O0012                                  G97S777M3
(Tc-posts)                             G0G98X0.0Z0.2
G0G80G90                               G83R0.1Z-0.75K0.3F0.01
N1G50X40.0Z11.0M8                      G80M9
G0T0101M39                             G0X40.0Z11.0
(T01 RIGHT REAR TURNING)               T0300
G50S1111                               M1
G96S675M3
G0G99X1.7576Z0.0688                    N2G50X40.0Z11.0M8
G1Z-0.0313F0.008                       G0T0202M39
Z-0.7838                               (T02 RIGHT REAR THREADING)
G2X1.8271Z-0.8864R0.1688               G97S567M3
G1X2.6587Z-1.4297                      G0G99X3.721Z-1.1447
G3X2.6715Z-1.4487R0.0313               G76X2.5515Z-2.9253K0.06D1000E0.045455A58
G1Z-2.7333                             X3.721Z-1.1447M9
G3X2.6669Z-2.7451R0.0313               G0X40.0Z11.0
G1X2.0715Z-3.4723                      T0200
Z-3.7285                               M1
G2X2.509Z-3.9473R0.2188                T0100
G1X3.0543
G0X3.2543                              M00
Z0.0688M9
G0X40.0Z11.0                           N999
T0100                                  G28U0.0
M1                                     G28W0.0
                                       M30
N3G50X40.0Z11.0M8                      %
G0T0303M39
```

Post name:              Mazk-tc
Machine type:           Mazak Lathe
Control:                Mazatrol
N/MM output:            Both
Abso/Incr:              Incremental IK
X Axis:                 Diameter
Programmer's notes:     Source code looks good.

```
%
N0005 G50 X40.0 Z11.0 S3000
N0010 G00 T0101
N0015 G96 S675 M39
N0020 M03
N0025 M08
N0030 G0 G99 X1.7576 Z0.0688
N0035 G1 Z-0.0313 F0.008
N0040 Z-0.7838
N0045 G2 X1.8271 Z-0.8864 I0.1688 K0.0
N0050 G1 X2.6587 Z-1.4297
N0055 G3 X2.6715 Z-1.4487 I-0.0248 K-0.019
N0060 G1 Z-2.7333
N0065 G3 X2.6669 Z-2.7451 I-0.0313 K0.0
N0070 G1 X2.0715 Z-3.4723
N0075 Z-3.7285
N0080 G2 X2.509 Z-3.9473 I0.2188 K0.0
N0085 G1 X3.0543
N0090 G0 X3.2543
N0095 Z0.0688 M9
N0100 G28 X0 Z0
N0105 T0100
N0110 M01

N0115 G50 X40.0 Z11.0 S3000
N0120 G00 T0303
N0125 G97 S777 M39
N0130 M03
N0135 M08
N0140 G0 X0.0 Z0.2
N0145 G83 R0.1 Z-0.75 K0.3 F0.01
N0150 G80 M9
N0155 G28 X0 Z0
N0160 T0300
N0165 M01

N0170 G50 X40.0 Z11.0 S3000
N0175 G00 T0202
N0180 G97 S567 M39
N0185 M03
N0190 M08
N0195 G0 X3.721 Z-1.1447

N0200 X2.5515 Z-1.2792
N0205 G32 Z-2.9253 K0.0455
N0210 G0 X3.721
N0215 Z-1.1447
N0220 X2.5515 Z-1.2792
N0225 G32 Z-2.9253 K0.0455
N0230 G0 X3.721
N0235 Z-1.1447
N0240 X2.5515 Z-1.2792
N0245 G32 Z-2.9253 K0.0455
N0250 G0 X3.721
N0255 Z-1.1447 M9
N0260 G28 X0 Z0
N0265 T0200
N0270 M01
N0275 M99
N0280 M30
%
```

| Post name: | Maz-qt6g |
| Machine type: | Mazak QT6-G TC |
| Control: | Mazatrol T32B |
| IN/MM output: | Inch |
| Abso/Incr: | Absolute |
| X Axis: | Diameter |
| Programmer's notes: | Source code looks good. |

```
%
:0012
(PROGRAM Tc-posts)
T0101
(T01 RIGHT REAR TURNING)
G50S1111
G96S675M3M8
G00G99X1.7576Z0.0688
G01Z-0.0313F0.008
G01Z-0.7838
G02X1.8271Z-0.8864R0.1688
G01X2.6587Z-1.4297
G03X2.6715Z-1.4487R0.0313
G01Z-2.7333
G03X2.6669Z-2.7451R0.0313
G01X2.0715Z-3.4723
G01Z-3.7285
G02X2.509Z-3.9473R0.2188
G01X3.0543
G00X3.2543
G00Z0.0688M9
G00X20.0Z11.0T0100

T0303
(T03 DRILL)
G97S777M3M8
```

```
G00G98X0.0Z0.2
G83R0.1Z-0.75K0.3F0.01
G80M9
G00X20.0Z11.0T0300

T0202
(T02 RIGHT REAR THREADING)
G97S567M3M8
G00G99X3.721Z-1.1447
G00X2.5515Z-1.2792
G32Z-2.9253K0.0455
G00X3.721
G00Z-1.1447
G00X2.5515Z-1.2792
G32Z-2.9253K0.0455
G00X3.721
G00Z-1.1447
G00X2.5515Z-1.2792
G32Z-2.9253K0.0455
G00X3.721
G00Z-1.1447M9
G00X20.0Z11.0T0200
M55
M69
M99
%
```

Post name:            Maz-t32b
Machine type:         Mazak Quickturn 30N Chucker TC
Control:              Mazarol T32B
IN/MM output:         Metric
Abso/Incr:            Absolute
X Axis:               Diameter
Programmer's notes:   Source code looks good.

```
%                              N0110G28W0
O0012
(PART NAME: Tc-posts)          N0115G0X508.0Z279.4T0303
N0005G21G0G80G90                (T03 DRILL)
N0010G53                       N0120G97S777M3M8
                               N0125G0G98X0.0Z5.08
N0015G0X508.0Z279.4T0101       N0130G83R2.54Z-19.05K0.3F0.01
(T01 R TURN)                   N0135G80M9
N0020G50S1111                  N0140X508.0Z279.4T0300
N0025G96S675M3M8               N0145G28U0
N0030G0G99X44.643Z1.746        N0150G28W0
N0035G1Z-0.794F0.008
N0040Z-19.909                  N0155G0X508.0Z279.4T0202
N0045G2X46.408R4.286            (T02 R THREAD)
N0050G1X67.53Z-36.314          N0160G97S567M3M8
N0055G3X67.857R0.794           N0165G0G99X94.514Z-29.076
N0060G1Z-69.425                N0170G76X64.809Z-74.304K1.524D254P2A58F0.045455
N0065G3X67.739R0.794           N0175X94.514Z-29.076M9
N0070G1X52.617Z-88.196         N0180X508.0Z279.4T0200
N0075Z-94.704                  N0185G28U0
N0080G2X63.73R5.556            N0190G28W0
N0085G1X77.579
N0090G0X82.659                 N0195M11
N0095Z1.746M9                  N0200M32
N0100X508.0Z279.4T0100         N0205M30
N0105G28U0                     %
```

Post name:              Mini-L
Machine type:           Turnmaster Pro TC
Control:                Mini L
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Radial
Programmer's notes:     Source code looks good, tabletop lathe.

```
%
/Tc-posts.TAP
G90
G74
G92X20.0Z11.0
/ RR TURNING 1-32R 0.75 TLWDT
T01M06
M03
G00X0.8788Z0.0688
G01Z-0.0313F0.008
G01Z-0.7838
G02X0.9135Z-0.8864I0.1688
G01X1.3293Z-1.4297
G03X1.3358Z-1.4487I0.0248K0.019
G01Z-2.7333
G03X1.3334Z-2.7451I0.0313
G01X1.0358Z-3.4723
G01Z-3.7285
G02X1.2545Z-3.9473I0.2188
G01X1.5271
G00X1.6271
G00Z0.0688
M25
/ DRILL0.25 TLWDT
T06M06
M03
G00X0.0Z0.2
G83R0.1Z-0.75P0300Q0F0.01
M25
/ RR THREADING0.7 TLWDT
T03M06
M03
G00X1.8605Z-1.1447
G00X1.3858Z-1.2792
G33X0.06Z-2.9253K0.0455I0.1
M25
M02
%
#
```

Post name:                Mit-lo
Machine type:             Mitsubishi Lathe
Control:                  Meldas LO
IN/MM output:             Inch
Abso/Incr:                Absolute
X Axis:                   Diameter
Programmer's notes:       Source code looks good.

```
%                                    G83Z-0.75F0.01
O12                                  G0X40.0Z11.0
                                     G54
/G28U0W0                             N2T202M13S567
G54                                  G95
N1T101M13S1111                       G97S567
G95                                  G0X3.721Z-1.1447
G50S1111                             G0X2.5515Z-1.2792
G96V675                              G32Z-2.9253E.045455
G0X1.7576Z0.0688                     G0X3.721
G1Z-0.0313F0.008                     G0Z-1.1447
G1Z-0.7838                           G0X2.5515Z-1.2792
G2X1.8271Z-0.8864R0.1688             G32Z-2.9253E.045455
G1X2.6587Z-1.4297                    G0X3.721
G3X2.6715Z-1.4487R0.0313             G0Z-1.1447
G1Z-2.7333                           G0X2.5515Z-1.2792
G3X2.6669Z-2.7451R0.0313             G32Z-2.9253E.045455
G1X2.0715Z-3.4723                    G0X3.721
G1Z-3.7285                           G0Z-1.1447
G2X2.509Z-3.9473R0.2188              G0X40.0Z11.0
G1X3.0543                            G97S1000
G0X3.2543                            M24
G0Z0.0688                            G4X1.0
G0X40.0Z11.0                         M25
G54                                  G96
N3T303M13S777                        G28U0W0
G95                                  M99
G97S777                              %
G0X0.0Z0.2
```

Post name:                Miy-3452
Machine type:             Miyano 3452T
Control:                  Fanuc / GN OTB
IN/MM output:             Both
Abso/Incr:                R-word for radius
X Axis:                   Diameter
Programmer's notes:       Highly customized, support barfeed, parts catcher, and sub-spindle.

```
%
O0012
N1 G00 T0101   ( MAIN RR TURNING )
N101 G50 S1111
N102 G96 S675 M03
N103 G00 X1.7576 Z0.0688
N104 G99 G01 Z-0.0313 F0.008 M93
N105 Z-0.7838
N106 G02 X1.8271 Z-0.8864 R0.1688
N107 G01 X2.6587 Z-1.4297
N108 G03 X2.6715 Z-1.4487 R0.0313
N109 G01 Z-2.7333
N110 G03 X2.6669 Z-2.7451 R0.0313
N111 G01 X2.0715 Z-3.4723
N112 Z-3.7285
N113 G02 X2.509 Z-3.9473 R0.2188
N114 G01 X3.0543
N115 G00 X3.2543
N116 Z0.0688
N117 X40.0 Z11.0
N118 M01
N2 G00 T0303   ( DRILL )
N201 G97 S777 M03
N202 G00 X0.0 Z0.2
N203 G83 B-0.75 R0.1 Q3000 F0.01
N204 G80
N205 X40.0 Z11.0
N206 M01
N3 G00 T0202   ( MAIN RR THREADING )
N301 G00
N302 G97 S567 M03 X3.721 Z-1.1447 T0202
N303 X2.5515 Z-1.2792
N304 G76 P010160
N305 G76 Z-2.9253 P600 Q1000 F0.045455
N306 Z-2.9253 M93
N307 X40.0 Z11.0
N308 M01
N309 M5
N310 M30
```

| | |
|---|---|
| Post name: | Miybnc3x |
| Machine type: | Miyano BNC 30-40 |
| Control: | |
| IN/MM output: | Both |
| Abso/Incr: | R-word for radius |
| X Axis: | Diameter |
| Programmer's notes: | Highly customized, supports barfeeder, has live tooling. |

```
%
:0012
N5 T0100
N10 G99
N15 G50 S1111
N20 G96 S675 M03
N25 G00 X1.7576 Z0.0688 T0101 M08
N30 G01 Z-0.0313 F0.008
N35 Z-0.7838
N40 G02 X1.8271 Z-0.8864 R0.1688
N45 G01 X2.6587 Z-1.4297
N50 G03 X2.6715 Z-1.4487 R0.0313
N55 G01 Z-2.7333
N60 G03 X2.6669 Z-2.7451 R0.0313
N65 G01 X2.0715 Z-3.4723
N70 Z-3.7285
N75 G02 X2.509 Z-3.9473 R0.2188
N80 G01 X3.0543
N85 G00 X3.2543
N90 Z0.0688
N95 G00 X40.0 Z11.0 M09
N100 M1

N105 T0300
N110 G98
N115 G97 S777 M03
N120 G00 X0.0 Z0.2 T0303 M28
N125 G83 B-0.75 R0.1 Q3000 F0.01
N130 G00 X40.0 Z11.0 M29
N135 M1

N140 T0200
N145 G99
N150 G00
N155 G97 S567 M03 T0202 M08
N160 G76 P020060
N165 G76 X2.5515 Z-2.9253 P600 Q1000 F0.045455 M24
N170 G00 X40.0 Z11.0 M09
N175 M1

N180 M02

%
```

```
Post name:              Mori-tc
Machine type:           Mori Seiki
Control:                Yasnac 3000G
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Negative Diameter
Programmer's notes:     Source code looks good.


N1G50T0000M8
G0T0001M42
G97S1111M3                    (0.75 RR 52 DEG. DIAMOND W/0.0313 R)
G0X-17576Z688
G96S675
G1Z-313F80
Z-7838
G3X-18271Z-8864I-1688K0
G1X-26587Z-14297
G2X-26715Z-14487I248K-190
G1Z-27333
G2X-26669Z-27451I313K0
G1X-20715Z-34723
Z-37285
G3X-25090Z-39473I-2188K0
G1X-30543
G0X-32543
Z688
G51M9
M1


N3G50T0000M8
G0T0003M42
G97S777M3              (0.25 DRILL)
G0X0Z2000
G83R1000Z-7500P0300Q0F0.01
G80
G51M9
M1


N2G50T0000M8
G0T0002M42
G97S567M3              (0.7 RR THREADING)
G0X-37210Z-11447
X-25515Z-12792
G32Z-29253F.04545                        G32Z-29253F.04545
G0X-37210                                G0X-37210
Z-11447                                  Z-11447
X-25515Z-12792                           G51M9
G32Z-29253F.04545                        M1
G0X-37210                                T0000
Z-11447                                  M30
X-25515Z-12792
```

| Post name: | Nak-10te |
|---|---|
| Machine type: | Nakamura Lathe |
| Control: | Fanuc 10TE |
| IN/MM output: | Both |
| Abso/Incr: | Incremental IK |
| X Axis: | Diameter |
| Programmer's notes: | Source code looks good. |

```
O0012(Tc-posts)
N10G20G40G54G99
(T01 RIGHT REAR TURNING)
N20G50S1111
N30M41
N40G96S675M03T0101
N50G00X1.7576Z0.0688M08
N60G01Z-0.0313F0.008
N70Z-0.7838
N80G02X1.8271Z-0.8864I0.1688K0.0
N90G01X2.6587Z-1.4297
N100G03X2.6715Z-1.4487I-0.0248K-
0.019
N110G01Z-2.7333
N120G03X2.6669Z-2.7451I-0.0313K0.0
N130G01X2.0715Z-3.4723
N140Z-3.7285
N150G02X2.509Z-3.9473I0.2188K0.0
N160G01X3.0543
N170G00X3.2543
N180Z0.0688M09
N190X40.0Z11.0
N200T0100
N210M01
(T03 DRILL)
N220M41
N230G97S777M03T0303
```

```
N240G00X0.0Z0.2M08
N250G83R0.1Z-0.75P0300Q0F0.01
N260G80M09
N270X40.0Z11.0
N280T0300
N290M01
(T02 RIGHT REAR THREADING)
N300M41
N310G97S567M03T0202
N320G00X3.721Z-1.1447M08
N330X2.5515Z-1.2792
N340G32Z-2.9253F.04545
N350G00X3.721
N360Z-1.1447
N370X2.5515Z-1.2792
N380G32Z-2.9253F.04545
N390G00X3.721
N400Z-1.1447
N410X2.5515Z-1.2792
N420G32Z-2.9253F.04545
N430G00X3.721
N440Z-1.1447M09
N450X40.0Z11.0
N460T0200
N470M01
N480M30
%
```

Post name:          Okuma-tc
Machine type:       Okuma
Control:            Fanuc 11T
IN/MM output:       Inch
Abso/Incr:          Incremental IK
X Axis:             Diameter
Programmer's notes: Source code looks good.

```
%
O0012
N1(Tc-posts)
N2G50X40.0Z11.0
N3( RIGHT REAR TURNING  T01)
N4G00T0101M25
N5G50S1111
N6G96S675M04
N7G0X1.7576Z0.0688M08
N8G1Z-0.0313F0.008
N9Z-0.7838
N10G2X1.8271Z-0.8864I0.1688K0.0
N11G1X2.6587Z-1.4297
N12G3X2.6715Z-1.4487I-0.0248K-
0.019
N13G1Z-2.7333
N14G3X2.6669Z-2.7451I-0.0313K0.0
N15G1X2.0715Z-3.4723
N16Z-3.7285
N17G2X2.509Z-3.9473I0.2188K0.0
N18G1X3.0543
N19G0X3.2543
N20Z0.0688M09
N21G27X40.0Z11.0T0100M05
N22M01

N23G50X40.0Z11.0
N24( DRILL  T03)
N25G00T0303M25
```

```
N26G97S777M04
N27G0X0.0Z0.2M08
N28G83R0.1Z-0.75P0300Q0F0.01
N29G80M09
N30G27X40.0Z11.0T0300M05
N31M01

N32G50X40.0Z11.0
N33( RIGHT REAR THREADING  T02)
N34G00T0202M25
N35G97S567M04
N36G0X3.721Z-1.1447M08
N37X2.5515Z-1.2792
N38G32Z-2.9253K0.0455
N39G0X3.721
N40Z-1.1447
N41X2.5515Z-1.2792
N42G32Z-2.9253K0.0455
N43G0X3.721
N44Z-1.1447
N45X2.5515Z-1.2792
N46G32Z-2.9253K0.0455
N47G0X3.721
N48Z-1.1447M09
N49G27X40.0Z11.0T0200M05
N50T0100M01

N51M30
%
```

Post name:           Osp_u10l
Machine type:        Okuma Lathe
Control:             OSP U10L
IN/MM output:        Inch
Abso/Incr:           Incremental IK
X Axis:              Diameter
Programmer's notes:  Mild customization.

```
%
 G00 X40. Z11.
 NAT01
 G50 S1111
 T0101  ( TURN OD .0313 R)
 G96 S675 M03
 G00 X1.7576 Z0.0688 M8
 G01 Z-0.0313 F0.008
 Z-0.7838
 G02 X1.8271 Z-0.8864 I0.1688 K0.
 G01 X2.6587 Z-1.4297
 G03 X2.6715 Z-1.4487 I-0.0248 K-0.019
 G01 Z-2.7333
 G03 X2.6669 Z-2.7451 I-0.0313 K0.
 G01 X2.0715 Z-3.4723
 Z-3.7285
 G02 X2.509 Z-3.9473 I0.2188 K0.
 G01 X3.0543
 G00 X3.2543
 Z0.0688
 X40. Z11. G97 S300 M9
 M1
 NAT03
 G50 S777
 T0303  ( DIA=.25 DRILL)
 G97 S777 M03
 G00 X0. Z0.2 M8
 X40. Z11. G97 S300 M9
 M1
 NAT02
 G50 S567
 T0202  ( THREAD OD)
 G97 S567 M03
 G00 X3.721 Z-1.1447
 G71 B30. D0.2 H0.06 F0.0455
 X40. Z11. G97 S300
 M02
```

Post name:              Osp-500l
Machine type:           Okuma Crown S Lathe
Control:                OSP 500L
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Diameter
Programmer's notes:     Source code looks good.

```
%
N0005 G00 X40. Z11.
N0010 G50 S3800
N0015   ( TURN OD .0313 R)
N0020 G96 S675 M03 M42
N0025 G00 X1.7576 Z0.0688 T0101
N0030 G01 Z-0.0313 F0.008
N0035 Z-0.7838
N0040 G02 X1.8271 Z-0.8864 I0.1688 K0.
N0045 G01 X2.6587 Z-1.4297
N0050 G03 X2.6715 Z-1.4487 I-0.0248 K-0.019
N0055 G01 Z-2.7333
N0060 G03 X2.6669 Z-2.7451 I-0.0313 K0.
N0065 G01 X2.0715 Z-3.4723
N0070 Z-3.7285
N0075 G02 X2.509 Z-3.9473 I0.2188 K0.
N0080 G01 X3.0543
N0085 G00 X3.2543
N0090 Z0.0688
N0095 G97 S1415
N0100 X40. Z11. T0100
N0105   ( DIA=.25 DRILL)
N0110 G97 S777 M03 M42
N0115 G00 X0. Z0.2 T0303
N0120 G97 S1415
N0125 X40. Z11. T0300
N0130   ( THREAD OD)
N0135 G97 S567 M03 M42
N0140 G00 X3.721 Z-1.1447 T0202
N0145 G71 B30. D0.2 H0.06 F0.0455
N0150 G97 S1415
N0155 X40. Z11. T0200
N0160 M02
```

Post name:              Osp-700l
Machine type:           Okuma Crown S Lathe
Control:                OSP 700L
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Diameter
Programmer's notes:     Source code looks OK.

```
%
N0005 G00 X40. Z11.
N0010 G50 S3800
N0015  ( TURN OD .0313 R)
N0020 G96 S675 M03 M42
N0025 G00 X1.7576 Z0.0688 T0101
N0030 G01 Z-0.0313 F0.008
N0035 Z-0.7838
N0040 G02 X1.8271 Z-0.8864 I0.1688 K0.
N0045 G01 X2.6587 Z-1.4297
N0050 G03 X2.6715 Z-1.4487 I-0.0248 K-0.019
N0055 G01 Z-2.7333
N0060 G03 X2.6669 Z-2.7451 I-0.0313 K0.
N0065 G01 X2.0715 Z-3.4723
N0070 Z-3.7285
N0075 G02 X2.509 Z-3.9473 I0.2188 K0.
N0080 G01 X3.0543
N0085 G00 X3.2543
N0090 Z0.0688
N0095 G97 S1415
N0100 X40. Z11. T0100
N0105  ( DIA=.25 DRILL)
N0110 G97 S777 M03 M42
N0115 G00 X0. Z0.2 T0303
N0120 G97 S1415
N0125 X40. Z11. T0300
N0130  ( THREAD OD)
N0135 G97 S567 M03 M42
N0140 G00 X3.721 Z-1.1447 T0202
N0145 G71 B30. D0.2 H0.06 F0.0455
N0150 G97 S1415
N0155 X40. Z11. T0200
N0160 M02
```

Post name:            Osp-u10l
Machine type:         Okuma Lathe
Control:              OSP U10L
IN/MM output:         Inch
Abso/Incr:            Incremental IK
X Axis:               Diameter
Programmer's notes:   Source code looks good.

```
%
N1 G00 X40. Z11.
N2 G50 S1111
N3 T010101  ( TURN OD .0313 R)
N4 G97 S300 M03
N5 G00 X1.7576 Z0.0688
N6 G96 S675 M03 M42
N7 G01 Z-0.0313 F0.008
N8 Z-0.7838
N9 G02 X1.8271 Z-0.8864 I0.1688 K0.
N10 G01 X2.6587 Z-1.4297
N11 G03 X2.6715 Z-1.4487 I-0.0248 K-0.019
N12 G01 Z-2.7333
N13 G03 X2.6669 Z-2.7451 I-0.0313 K0.
N14 G01 X2.0715 Z-3.4723
N15 Z-3.7285
N16 G02 X2.509 Z-3.9473 I0.2188 K0.
N17 G01 X3.0543
N18 G00 X3.2543
N19 Z0.0688
N20 X40. Z11. G97 S300
N21 G50 S777
N22 T030303  ( DIA=.25 DRILL)
N23 G97 S300 M03
N24 G00 X0. Z0.2
N25 G97 S777 M03 M42
N26 X40. Z11. G97 S300
N27 G50 S567
N28 T020202  ( THREAD OD)
N29 G97 S300 M03
N30 G97 S567 M03 M42
N31 G00 X3.721 Z-1.1447
N32 G71 B30. D0.2 H0.06 F0.0455
N33 X40. Z11. G97 S300
N34 M02
```

Post name:              Reg-1050
Machine type:           Regal Lathe
Control:                GE 1050T
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Negative Radial
Programmer's notes:     Source code looks OK.

```
##%#< Tc-posts >#
%
$0000012

N10G70
N20G90
N30G95M08
N40S12T0101M06
N50G92X-20.0000Z11.0000
N60G21X-0.8788Z0.0688F00
N70Z-0.0313F80
N80Z-0.7838
N90G23X-0.9135Z-0.8864I0.1688
N100G21X-1.3293Z-1.4297
N110G22X-1.3358Z-1.4487I0.0248K0.0190
N120G21Z-2.7333
N130G22X-1.3334Z-2.7451I0.0313
N140G21X-1.0358Z-3.4723
N150Z-3.7285
N160G23X-1.2545Z-3.9473I0.2188
N170G21X-1.5271
N180X-1.6271F00
N190Z0.0688
N200X-20.0000Z11.0000M09
N210T0100M08
N220S11T0303M06
N230G21X0.0000Z0.2000F00
N240X-20.0000Z11.0000M09
N250T0300M08
N260S10T0202M06
N270G21X-1.8605Z-1.1447F00
N280X-1.2758Z-1.2792
N290G33Z-2.9253K-0.045455
N300G21X-1.8605
N310Z-1.1447
N320X-1.2758Z-1.2792
N330G33Z-2.9253K-0.045455
N340G21X-1.8605
N350Z-1.1447
N360X-1.2758Z-1.2792
N370G33Z-2.9253K-0.045455
N380G21X-1.8605
N390Z-1.1447
N400X-20.0000Z11.0000M09
N410T0200M30
%
#< END OF Tc-posts>#
```

Post name:          Star
Machine type:       Pratt & Whitney Starturn 820 Lathe
Control:            Pratt & Whitney 6402
IN/MM output:       Inch
Abso/Incr:          Incremental IK
X Axis:             Radial
Programmer's notes: Source code looks good.

```
%
N5T000M99
O10G90
N15G00X20.0Z11.0T100
N20G96I20.0K1111S1111M03
N25G00X0.8788Z0.0688T101
N30G95
N35G01Z-0.0313F.008
N40Z-0.7838
N45G02X0.9135Z-0.8864I1.0475K-0.7838
N50G01X1.3293Z-1.4297
N55G03X1.3358Z-1.4487I1.3045K-1.4487
N60G01Z-2.7333
N65G03X1.3334Z-2.7451I1.3045K-2.7333
N70G01X1.0358Z-3.4723
N75Z-3.7285
N80G02X1.2545Z-3.9473I1.2545K-3.7285
N85G01X1.5271
N90G00X1.6271
N95Z0.0688
N100X20.0Z11.0T0000
O105G90
N110G00X20.0Z11.0T300
N115G97S777M03
N120G00X0.0Z0.2T303
N125X20.0Z11.0T0000
O130G90
N135G00X20.0Z11.0T200
N140G97S567M03
N145G00X1.8605Z-1.1447T202
N150X1.2758Z-1.2792
N155G33Z-2.9253F-0.045455
N160X1.8605
N165Z-1.1447
N170X1.2758Z-1.2792
N175G33Z-2.9253F-0.045455
N180X1.8605
N185Z-1.1447
N190X1.2758Z-1.2792
N195G33Z-2.9253F-0.045455
N200X1.8605
N205Z-1.1447M02
N210
N215X20.0Z11.0T0000
N220M30
%
```

Post name:              Tl-500
Machine type:           Mori Seiki
Control:                Fanuc
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Negative Diameter
Programmer's notes:     Source code looks OK.

```
%M05
N100G50X0Z0
N101G00T0101S08M03
N102G00X-17576Z688M07
N103G01Z-313F80
N104Z-7838
N105G03X-18271Z-8864I-1688K0
N106G01X-26587Z-14297
N107G02X-26715Z-14487I248K-190
N108G01Z-27333
N109G02X-26669Z-27451I313K0
N110G01X-20715Z-34723
N111Z-37285
N112G03X-25090Z-39473I-2188K0
N113G01X-30543
N114G00X-32543
N115Z688
N116X0Z0
N117T0100

N300G50X0Z0
N301G00T0303S07M03
N302G00X0Z2000M08
N303G83R1000Z-7500P0300Q0F0.01
N304X0Z0
N305T0300

N200G50X0Z0
N201G00T0202S06M03
N202G00X-37210Z-11447
N203X-25515Z-12792M07
N204G76X-25515Z-29253K600D102F100A60
N205X-25515Z-29253M07
N206X0Z0
N207T0200
N208M30
%
#
```

Post name:             Tos-tc
Machine type:          TOS Huelin Vertical TC
Control:               Siemens 810
IN/MM output:          Inch
Abso/Incr:             Incremental IK
X Axis:                Radial
Programmer's notes:    source code looks OK.

```
%MPF12
N1 M47
N2 R01=1 L730
N3 L193 R60=2
N4 T1 M6
N5 G00 G95
N6 G00 X20.0 Z11.0 D1
N7 G92 S1111
N8 G96 X20.0 S675
N9 X0.8788 Z0.0688 M03 M42
N10 M08
N11 G1 Z-0.0313 F0.008
N12 Z-0.7838
N13 G2 X0.9135 Z-0.8864 I0.1688
K0.0
N14 G1 X1.3293 Z-1.4297
N15 G3 X1.3358 Z-1.4487 I-0.0248
K-0.019
N16 G1 Z-2.7333
N17 G3 X1.3334 Z-2.7451 I-0.0313
K0.0
N18 G1 X1.0358 Z-3.4723
N19 Z-3.7285
N20 G2 X1.2545 Z-3.9473 I0.2188
K0.0
N21 G1 X1.5271
N22 G0 X1.6271
N23 Z0.0688
N24 G97
N25 G00 X20.0 Z11.0
N26 M05 M09
N27 L193 R60=2
N28 T3 M6
N29 M47
N30 G00 G95
N31 G00 X20.0 Z11.0 D3
N32 S777 M03 M42
N33 X0.0 Z0.2

N34 M08
N35 G00 G94
N36 R02=0.1 R03=-0.75 R10=0.2
R00=5 R01=0.6 R05=0.3 R04=1 R011=1
F0.01
N37 G83
N38 G80
N39 G00 X20.0 Z11.0
N40 M05 M09
N41 L193 R60=2
N42 T2 M6
N43 M47
N44 G00 G95
N45 G00 X20.0 Z11.0 D2
N46 S567 M03 M42
N47 X1.8605 Z-1.1447
N48 M08
N49 X1.2758 Z-1.2792
N50 G33 Z-2.9253 K0.0455
N51 G0 X1.8605
N52 Z-1.1447
N53 X1.2758 Z-1.2792
N54 G33 Z-2.9253 K0.0455
N55 G0 X1.8605
N56 Z-1.1447
N57 X1.2758 Z-1.2792
N58 G33 Z-2.9253 K0.0455
N59 G0 X1.8605
N60 Z-1.1447
N61 G00 X20.0 Z11.0
N62 M05 M09
N63 L193 R60=2
N64 L193 R60=1
N65 T7 M6
N66 M47
N67 M30
$
```

Post name:           Vk45-tc
Machine type:        Hitachi Seiki
Control:             VK45
IN/MM output:        Both
Abso/Incr:           R-word for radius
X Axis:              Diameter
Programmer's notes:  Source code looks good.

```
%                                      G83R0.1Z-0.75P0300Q0F0.01
O0012                                  G97G30U0W0M09
(Tc-posts.TAP)                         M01
N01G50S4000
N02G28U0                               N200T0200M40  (T02 RR THREADING)
N03G28W0                               G97S567M03
N04M01                                 G00X3.721Z-1.1447M08
                                       X2.5515Z-1.2792
N100T0100M40  (T01 RR TURNING)         G32Z-2.9253F.04545
G96S675M03                             G00X3.721
G00X1.7576Z0.0688M08                   Z-1.1447
G01Z-0.0313F0.008                      X2.5515Z-1.2792
Z-0.7838                               G32Z-2.9253F.04545
G02X1.8271Z-0.8864R0.1688              G00X3.721
G01X2.6587Z-1.4297                     Z-1.1447
G03X2.6715Z-1.4487R0.0313              X2.5515Z-1.2792
G01X2.6715Z-2.7333                     G32Z-2.9253F.04545
G03X2.6669Z-2.7451R0.0313              G00X3.721
G01X2.0715Z-3.4723                     Z-1.1447
Z-3.7285                               G97G30U0W0M09
G02X2.509Z-3.9473R0.2188               M01
G01X3.0543Z-3.9473
G00X3.2543                             M05
Z0.0688                                G28U0W0
G97G30U0W0M09
M01

N300T0300M40  (T03 DRILL)              M30
G97S777M03                             %
G00X0.0Z0.2M08                         #
```

Post name:            Ws7360
Machine type:         Warner Swasey Lathe
Control:              Allen Bradley 7360
IN/MM output:         Inch
Abso/Incr:            Incremental IK
X Axis:               Radial
Programmer's notes:   Source code looks good.

```
#< Tc-posts  Tue Apr 10 14:06:59      N0270 G92 X20.0 Z11.0 M08
2001'%                                N0280 G90 T0303 M80 (T3 DRILL)
N0010 G95                             N0290 G97 S0777 M04
N0020 G92 X20.0 Z11.0 M08             N0300 G94
N0030 G90 T0101 M80 (T1 TURNING       N0310 G21 X00.0 Z00.2 F0
TOOL)                                 N0320 X20.0 Z11.0
N0040 G92 S1111                       N0330 G01 T0000
N0050 G96 S0675 R00.8788 M04          N0340 M01
N0060 G94                             N0350 G95
N0070 G21 X00.8788 Z00.0688 F0
N0080 G95                             N0360 G92 X20.0 Z11.0 M08
N0090 G21 Z-00.0313 F0.008            N0370 G90 T0202 M80 (T2 THREADING
N0100 Z-00.7838                       TOOL)
N0110 G23 X00.9135 Z-00.8864          N0380 G97 S0567 M04
I00.1688 K0                           N0390 G94
N0120 G21 X01.3293 Z-01.4297          N0400 G21 X01.8605 Z-01.1447 F0
N0130 G22 X01.3358 Z-01.4487          N0410 X01.2758 Z-01.2792
I00.0248 K00.019                      N0420 G33 Z-02.9253 K-.04545
N0140 G21 Z-02.7333                   N0430 G21 X01.8605 F0
N0150 G22 X01.3334 Z-02.7451          N0440 Z-01.1447
I00.0313 K0                           N0450 X01.2758 Z-01.2792
N0160 G21 X01.0358 Z-03.4723          N0460 G33 Z-02.9253 K-.04545
N0170 Z-03.7285                       N0470 G21 X01.8605 F0
N0180 G23 X01.2545 Z-03.9473          N0480 Z-01.1447
I00.2188 K0                           N0490 X01.2758 Z-01.2792
N0190 G21 X01.5271                    N0500 G33 Z-02.9253 K-.04545
N0200 G94                             N0510 G21 X01.8605 F0
N0210 G21 X01.6271 F0                 N0520 Z-01.1447
N0220 Z00.0688                        N0530 X20.0 Z11.0
N0230 X20.0 Z11.0                     N0540 G01 T0000
N0240 G01 T0000                       N0550 M01
N0250 M01                             N0560 G95
N0260 G95                             N0570 M30
                                      #<END OF Tc-posts >#
```

Post name:              Ws-7360
Machine type:           Warner Swasey Lathe
Control:                Allen Bradley 7360
IN/MM output:           Inch
Abso/Incr:              Incremental IK
X Axis:                 Radial
Programmer's notes:     Source code looks good.

```
%
N0010G95
N0020G92X20.0Z11.0M08
N0030G90T0101M80
N0040G92S1111
N0050G96S0675R.8788M04
N0060G21X.8788Z.0688F0
N0070G21Z-.0313F.008
N0080Z-.7838
N0090G23X.9135Z-.8864I.1688K0
N0100G21X1.3293Z-1.4297
N0110G22X1.3358Z-1.4487I.0248K.019
N0120G21Z-2.7333
N0130G22X1.3334Z-2.7451I.0313K0
N0140G21X1.0358Z-3.4723
N0150Z-3.7285
N0160G23X1.2545Z-3.9473I.2188K0
N0170G21X1.5271
N0180G21X1.6271F0
N0190Z.0688
N0200X20.0Z11.0
N0210T0M81
N0220M01
N0230G95

N0240G92X20.0Z11.0M08
N0250G90T0303M80
N0260G97S0777M04
```

```
N0270G21X.0Z.2F0
N0280X20.0Z11.0
N0290T0M81
N0300M01
N0310G95

N0320G92X20.0Z11.0M08
N0330G90T0202M80
N0340G97S0567M04
N0350G21X1.8605Z-1.1447F0
N0360X1.2758Z-1.2792
N0370G33Z-2.9253K-.04545
N0380G21X1.8605F0
N0390Z-1.1447
N0400X1.2758Z-1.2792
N0410G33Z-2.9253K-.04545
N0420G21X1.8605F0
N0430Z-1.1447
N0440X1.2758Z-1.2792
N0450G33Z-2.9253K-.04545
N0460G21X1.8605F0
N0470X20.0Z11.0
N0480T0M81
N0490M01
N0500G95
N0510T0200
N0520M30
#<END OF Tc-posts >#
```

Post name:              Yas-2000
Machine type:         Mori Seiki
Control:                 Yasnac 2000C
IN/MM output:         Both
Abso/Incr:             Incremental IK
X Axis:                 Negative Diameter
Programmer's notes:    Source code looks good.

```
%
O0012
N0001G00M07
G50Z100000X-131500
T0101M42
G96S675M03
G00X-17576Z688
G01Z-313F80
Z-7838
G03X-18271Z-8864I-1688K0
G01X-26587Z-14297
G02X-26715Z-14487I248K-190
G01Z-27333
G02X-26669Z-27451I313K0
G01X-20715Z-34723
Z-37285
G03X-25090Z-39473I-2188K0
G01X-30543
G00X-32543
Z688
G00Z100000X-131500
T0100M09

N0002G00M08
```

```
G50Z100000X-131500
T0303M42
G97S777M03
G00X0Z2000
G83R1000Z-7500P0300Q0F0.01
G00Z100000X-131500
T0300M09

N0003G00M07
G50Z100000X-131500
T0202M42
G97S567M03
G00X-37210Z-11447
X-25515Z-12792M07
G76X-25515Z-29253K600D102E10000A60
X-25515Z-29253M07
G00Z100000X-131500
T0200M09

M05
/M30
M02
%
#
```

Post name:           Yas2000b
Machine type:        Mori Seiki Lathe
Control:             Yasnac 2000B
IN/MM output:        Both
Abso/Incr:           Incremental IK
X Axis:              Negative Diameter
Programmer's notes:  Source code looks OK.

```
%
N0001G50X-400000Z110000
N0002G50X-400000Z110000S1400
G00T0101
M42
G97S1111M03
G00X-17576Z688M08
G96S675
G01Z-313F80
Z-7838
G00X-18271Z-8864I-1688K0
X-26587Z-14297
G00X-26715Z-14487I248K-190
Z-27333
G00X-26669Z-27451I313K0
X-20715Z-34723
Z-37285
G00X-25090Z-39473I-2188K0
X-30543
G00X-32543
Z688
G00X-400000Z110000M09
T0100
M01
N0003G50X-400000Z110000S1400
G00T0303
M42
G97S777M03
G00X0Z2000M08
G83R1000Z-7500P0300Q0F0.01
G00X-400000Z110000M09
T0300
M01
N0004G50X-400000Z110000S1400
G00T0202
M42
G97S567M03
G00X-37210Z-11447M08
X-25515Z-12792
G33Z-29253K455
G00X-37210
Z-11447
X-25515Z-12792
G33Z-29253K455
G00X-37210
Z-11447
X-25515Z-12792
G33Z-29253K455
G00X-37210
Z-11447
G00X-400000Z110000M09
T0200
M01
M05
M02
%
#
```

Post name:              Yasn-lx3
Machine type:           Mori Seiki Lathe
Control:                Yasnac LX3
IN/MM output:           Both
Abso/Incr:              Incremental IK
X Axis:                 Diameter
Programmer's notes:     Source code looks good.

```
%
O0012
(Tc-posts)
( Tue Apr 10 14:08:50 2001')
G50S2200

N100G00T0100 (T1 TURNING TOOL)
G99M40
G96S675M08
G00X1.7576Z0.0688M03
G01Z-0.0313F0.008
Z-0.7838
G02X1.8271Z-0.8864R0.1688
G01X2.6587Z-1.4297
G03X2.6715Z-1.4487R0.0313
G01Z-2.7333
G03X2.6669Z-2.7451R0.0313
G01X2.0715Z-3.4723
Z-3.7285
G02X2.509Z-3.9473R0.2188
G01X3.0543
G00X3.2543
Z0.0688
G97G30U0W0
M01

N300G00T0300 (T3 DRILL)
G98M40
G00X0.0Z0.2M08
```

```
G98G83R0.1Z-0.75P0300Q0F0.01
G97G30U0W0
M01

N200G00T0200 (T2 THREADING TOOL)
G99M40
G00X3.721Z-1.1447M08
X2.5515Z-1.2792
G33Z-2.9253E-.045455
G00X3.721
Z-1.1447
X2.5515Z-1.2792
G33Z-2.9253E-.045455
G00X3.721
Z-1.1447
X2.5515Z-1.2792
G33Z-2.9253E-.045455
G00X3.721
Z-1.1447
G97G30U0W0
M01

M09
M05
G28U0W0
M30


%
```

| | |
|---|---|
| Post name: | Yas-tc |
| Machine type: | Yasnac |
| Control: | Seicos M-III |
| IN/MM output: | Both |
| Abso/Incr: | R-word for radius |
| X Axis: | Diameter |
| Programmer's notes: | This is a dealer's standard post. |

```
%
O0012
(Tc-posts.TAP)
N01G50S4000
N02G28U0
N03G28W0
N04M01

N100T0100M40  (T01 RR TURNING)
G96S675M03
G00X1.7576Z0.0688M08
G01Z-0.0313F0.008
Z-0.7838
G02X1.8271Z-0.8864R0.1688
G01X2.6587Z-1.4297
G03X2.6715Z-1.4487R0.0313
G01X2.6715Z-2.7333
G03X2.6669Z-2.7451R0.0313
G01X2.0715Z-3.4723
Z-3.7285
G02X2.509Z-3.9473R0.2188
G01X3.0543Z-3.9473
G00X3.2543
Z0.0688
G97G30U0W0M09
M01

N300T0300M40  (T03 DRILL)
G97S777M03
G00X0.0Z0.2M08
G83R0.1Z-0.75P0300Q0F0.01
G97G30U0W0M09
M01

N200T0200M40  (T02 RR THREADING)
G97S567M03
G00X3.721Z-1.1447M08
X2.5515Z-1.2792
G32Z-2.9253F.04545
G00X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253F.04545
G00X3.721
Z-1.1447
X2.5515Z-1.2792
G32Z-2.9253F.04545
G00X3.721
Z-1.1447
G97G30U0W0M09
M01

M05
G28U0W0

M30
%
#
```