# 'Off the Shelf Posts'

## Post Processor library
## Machining Centers 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.  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.

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.

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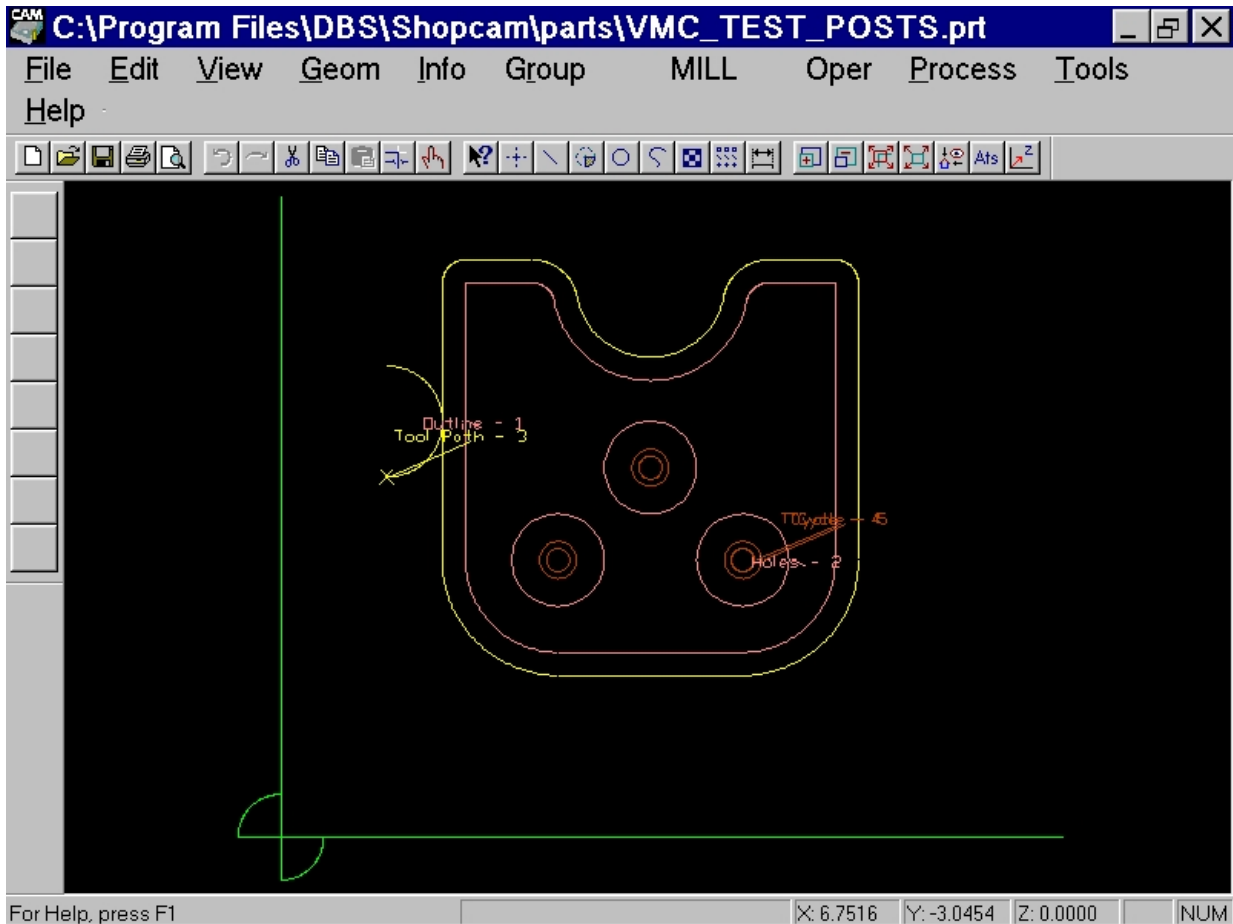
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# About the sample part

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



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

 The second and third operations are Center drill (cycle 81) and peck drill (cycle 83)

  The posts listed with: (Auto 1st T-POSITION? Not supported) were either written more than five years ago or the customer request that the the 1st tool position be forced out automatically. You should always check the [Auto 1st T-Position] box in the setup file and delete the X Y move at the 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.

# MILLS

Post name:                            &okk
Post Source                          &okk
Machine type:                     Mitshubishi Mill
Control:                                Meldas MO
Inch/Metric:                       Metric always
Circ interpolation:            Incremental IJ
Auto 1st T-POSITION?     yes
Canned drill cycles:           yes
Post programmer notes:     Source code looks good, post has error checking.

```
%
L 1
G71G80G90G40
G92Z50.0
G90

G0X14.554Y49.53S484M03M08
Z2.54
G1Z-3.099F5.0
G41D1X14.605F10.0
G3X22.225Y57.15I0.0J7.62
G1Y76.2
G2X25.4Y79.375I3.175J0.0
G1X34.504
G2X40.737Y74.239I0.0J-6.35
G3X50.8Y65.948I10.063J1.961
X60.863Y74.239I0.0J10.252
G2X67.096Y79.375I6.233J-1.214
G1X76.2
G2X79.375Y76.2I0.0J-3.175
G1Y38.1
G2X63.5Y22.225I-15.875J0.0
G1X38.1
G2X22.225Y38.1I0.0J15.875
G1Y57.15
G3X14.605Y64.77I-7.62J0.0
G1G40X14.554
G0Z2.54M09
G00Z50.0
G90

G0X251.155Y248.336S765M03
X63.5Y38.1
G81G98X63.5Y38.1R2.54Z-3.099F12.0
X38.1
X50.8Y50.8
G80
G00Z50.0
G90

G0X251.155Y248.336S888M03M08
X63.5Y38.1
G83G98X63.5Y38.1R2.54Z-3.099Q2.54F14.0
X38.1
X50.8Y50.8

G80
G00Z50.0
M30%
```

Post name:                  1050mc
Post Source                 1050mc
Machine type:               Generic VMC
Control:                    MARK CENTURY 1050MC
Inch/Metric:                Inch
Circ interpolation:         Incremental IJ
Auto 1st T-POSITION?        yes
Canned drill cycles:        yes
Post programmer notes:      Source code look good, has error checking.

```
$MC-TEST
 $2500ENDMILL
N0005G92X0Y0Z+001.0000
N0010G01X+000.5730Y+001.9500F100.00S048
4.M03
N0015Z+000.1000M08
N0020Z-000.1220F005.00
N0025G41D000000
N0030G01X+000.5750F010.00
N0035G03X+000.8750Y+002.2500I+000.0000J
+000.3000
N0040G01Y+003.0000
N0045G02X+001.0000Y+003.1250I+000.1250J
+000.0000
N0050G01X+001.3584
N0055G02X+001.6038Y+002.9228I+000.0000J
+000.2500
N0060G03X+002.0000Y+002.5964I+000.3962J
+000.0772
N0065X+002.3962Y+002.9228I+000.0000J+00
0.4036
N0070G02X+002.6416Y+003.1250I+000.2454J
+000.0478
N0075G01X+003.0000
N0080G02X+003.1250Y+003.0000I+000.0000J
+000.1250
N0085G01Y+001.5000
N0090G02X+002.5000Y+000.8750I+000.6250J
+000.0000
N0095G01X+001.5000
N0100G02X+000.8750Y+001.5000I+000.0000J
+000.6250
N0105G01Y+002.2500
N0110G03X+000.5750Y+002.5500I+000.3000J
+000.0000
N0115G40
N0120G01X+000.5730
N0125Z+000.1000F100.00
N0130M09
N0135Z+001.0000
N0140M00 $1250CENTER-DRILL
N0145G92Z+001.0000
N0150G01X+002.5000Y+001.5000F100.00S076
5.M03
N0155G81X+002.5000Y+001.5000Z-
000.1220R+000.1000F012.00
N0160X+001.5000Y+001.5000
N0165X+002.0000Y+002.0000
N0170G80
N0175G01Z+001.0000F100.00
N0180M00 $2000DRILL
N0185G92Z+001.0000M08
N0190G01X+002.5000Y+001.5000F100.00S088
8.M03
N0195G83X+002.5000Y+001.5000Z-
000.1220R+000.1000K+000.1000F014.00
N0200X+001.5000Y+001.5000
N0205X+002.0000Y+002.0000
N0210G80
N0215G01Z+000.1000F100.00
N0220G01 Z+001.0000
N0225X0Y0
N0230M30
%
```

Post name:            1050mcl
Post Source           1050mcl
Machine type:         VMC-150
Control:              MARK CENTURY 1050MCL
Inch/Metric:          Inch
Circ interpolation:              Incremental IJ
Auto 1st T-POSITION?  yes
Canned drill cycles:  yes
Post programmer notes:        Source code looks OK, somewhat customized (double nn on n-block seems unique).

```
%
N0005G90G80M03
NN0010G00S484T01M06
NN0015G04X0002
NN0020X000573H10
NN0025Y00195H11
NN0030G90M08
NN0035Z-0001D01
NN0040Z000122F005
NN0045G91
NN0050G01X
NN0055G90
NN0060G41D01X000575F010
NN0065G03X000875Y00225I0J0003
NN0070G01Y003
NN0075G02X001Y003125I000125J0
NN0080G01X0013584
NN0085G02X0016038Y0029228I0J-00025
NN0090G03X0023962Y0029228I0003962J00007
72
NN0095G02X0026416Y003125I0002454J-
0000478
NN0100G01X003
NN0105G02X003125Y003I0J-000125
NN0110G01Y0015
NN0115G02X0025Y000875I-000625J0
NN0120G01X0015
NN0125G02X000875Y0015I0J000625
NN0130G01Y00225
NN0135G03X000575Y00255I-0003J0
NN0140G01X000573
NN0145G00Z-0001
NN0150G40
NN0155M09
NN0160G90G80
NN0165G00Z0D00
NN0170M01
NN0175G90G80M03
NN0180G00S765T03M06
NN0185G04X0002
NN0190X0025H10
NN0195Y0015H11
NN0200G90
NN0205Z-0001D03
NN0210G81Z000122R-0001F012
NN0215X0015
NN0220X002Y002
NN0225G90G80
NN0230G00Z0D00
NN0235M01
NN0240G90G80M03
NN0245G00S888T04M06
NN0250G04X0002
NN0255X0025H10
NN0260Y0015H11
NN0265G90M08
NN0270Z-0001D04
NN0275G83Z000122R-0001Q0001F014
NN0280X0015
NN0285X002Y002
NN0290G90G80
NN0295G00Z-0001
NN0300G90G80M09
NN0305G00Z0D00
NN0310T01M06
NN0315G04X0002
NN0320M01
NN0325G00X009888Y009777
NN0330M30
%
```

| | |
|---|---|
| Post name: | 1630-hmc |
| Post Source | 1630-hmc |
| Machine type: | BURGMIESTER HMC |
| Control: | FANUC 6MB |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Highly customized, has a sub-routine output at the start. |

```
%(MC-TEST.C)
N10G99G28G91X0.0Y0.0Z0.0
N20G80G90G10L2P1X-11.0Y-13.0Z-24.0
N30G90B000
N40M71
N50G91G30Y0.0Z0.0
N60T01
N70M06
N80T03

(T01 1/4" ENDMILL 0.25)
N90G90G54
N100G0G94X.573Y1.95S484M03M38
N110G43Z1.0H01
N120Z.1
N130G1Z-.122F5.M08
N140G41X.575F10.D21
N150G3X.875Y2.25J.3
N160G1Y3.0
N170G2X1.0Y3.125I.125
N180G1X1.3584
N190G2X1.6038Y2.9228J-.25
N200G3X2.3962Y2.9228I.3962J.0772
N210G2X2.6416Y3.125I.2454J-.0478
N220G1X3.0
N230G2X3.125Y3.0J-.125
N240G1Y1.5
N250G2X2.5Y.875I-.625
N260G1X1.5
N270G2X.875Y1.5J.625
N280G1Y2.25
N290G3X.575Y2.55I-.3
N300G1G40X.573
N310G0Z.1M09
N320G00Z13.0M05
```

```
N330G80G30G91Y0.0Z0.0M01
N340T03
N350M06
N360T04

(T03 1/8" CENTER DRILL 0.125)
N370G90G54
N380G0G94X2.5Y1.5S765M03M38
N390G43Z1.0H03
N400G81Z-.122R.1F12.
N410X1.5
N420X2.0Y2.0
N430G80M09
N440G00Z13.0M05
N450G80G30G91Y0.0Z0.0M01
N460T04
N470M06
N480T01

(T04 DRILL 0.2)
N490G90G54
N500G0G94X2.5Y1.5S888M03M38
N510G43Z1.0H04
N520G83Z-.122R.1Q.1F14.M08
N530X1.5
N540X2.0Y2.0
N550G80
N560G0Z.1
N570G00G80Z13.0M05
N580G80G91G30Y0.0Z0.0M01
N590G80G91G28X0.0Y0.0Z0.0M09
N600G00G90B000M42
N610M72
N620M30
%
```

Post name:                        1632-hmc
Post Source                       1632-hmc
Machine type:                   KERNY & TRECKER HMC
Control:                           GEMINI MODULAR-D
Inch/Metric:                     Inch
Circ interpolation:             Incremental IJ
Auto 1st T-POSITION?       Not supported
Canned drill cycles:           yes
Post programmer notes:      Source code looks OK.

```
%
N10(IFT,L1200<>1.,(GOTO,1))
N20(TLD,S01T01P0.0,S02T02P0.0,S03T03P0.0)
N30(TLD,S04T04P0.0,S05T05P0.0,S06T06P0.0)
N40(TLD,S07T07P0.0,S08T08P0.0,S09T09P0.0)
N50(TLD,S10T10P0.0,S11T11P0.0,S12T12P0.0)
N60(TLD,S13T13P0.0,S14T14P0.0,S15T15P0.0)
N70(TLD,S16T16P0.0,S17T17P0.0,S18T18P0.0)
N80(TLD,S19T19P0.0,S20T20P0.0,S21T21P0.0)
N90(TLD,S22T22P0.0,S23T23P0.0,S24T24P0.0)
N100(TLD,S25T25P0.0,S26T26P0.0,S27T27P0.0)
N110(TLD,S28T28P0.0,S29T29P0.0,S30T30P0.0)
N120(PAR,L1200=L1200+1.)
N130M00
N140(LBL,1)
N150G40G70G90G94Z20.0F0M25
N160X9.888Y9.777M25
N170T01
N180M06

!T01 1/4" ENDMILL 0.25
N190G00G40G90G94X0.573Y1.95Z14.0F0S484M03T
03
N200G00Z0.1M08
N210G01Z-0.122F5.
N220G41X0.575F10.
N230G03X0.875Y2.25J0.3
N240G01Y3.0
N250G02X1.0Y3.125I0.125
N260G01X1.3584
N270G02X1.6038Y2.9228J-0.25
N280G03X2.3962Y2.9228I0.3962J0.0772
N290G02X2.6416Y3.125I0.2454J-0.0478
N300G01X3.0
N310G02X3.125Y3.0J-0.125
N320G01Y1.5
N330G02X2.5Y0.875I-0.625
N340G01X1.5
N350G02X0.875Y1.5J0.625
N360G01Y2.25
N370G03X0.575Y2.55I-0.3
N380G01G40X0.573
N390G00Z0.1
N400G00Z14.0F0M09

!T03 1/8" CENTER DRILL 0.125
N410G00G40G90G94X2.5Y1.5Z14.0F0S765M03T
04
N420G81R0.1Z-0.122F12.
N430G00X1.5M08
N440X2.0Y2.0
N450G80
N460G00Z14.0F0M09

!T04 DRILL 0.2
N470G00G40G90G94X2.5Y1.5Z14.0F0S888M03T
01
N480G83R0.1Z-0.122Q0.1F14.
N490G00X1.5M08
N500X2.0Y2.0
N510Z0.1
N520G80M09
N530G00Z14.0F0

N540X9.888Y9.777Z20.0M25
N550M00
N560M02
%
```

| | |
|---|---|
| Post name: | 2419-vmc |
| Post Source | 2419-vmc |
| Machine type: | BURGMIESTER VMC |
| Control: | GE 1050-MCL |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, has a coded spindle table(see help file). Error check for 1$^{st}$ position |

```
%

(T01 1/4" ENDMILL 0.25)
N10G00G80G90X0.573Y1.95S49T01M06
N20G43Z0.1D01M13
N30G01Z-0.122F0050
N40G41D21X0.575F0100
N50G03X0.875Y2.25J0.3
N60G01Y3.0
N70G02X1.0Y3.125I0.125
N80G01X1.3584
N90G02X1.6038Y2.9228J-0.25
N100G03X2.3962Y2.9228I0.3962J0.0772
N110G02X2.6416Y3.125I0.2454J-0.0478
N120G01X3.0
N130G02X3.125Y3.0J-0.125
N140G01Y1.5
N150G02X2.5Y0.875I-0.625
N160G01X1.5
N170G02X0.875Y1.5J0.625
N180G01Y2.25
N190G03X0.575Y2.55I-0.3
N200G01G40X0.573
N210G00Z0.1M09

(T03 1/8" CENTER DRILL 0.125)
N220G00G80G90X2.5Y1.5S62T03M06
N230G43Z0.1D03M13
N240G81R0.1Z-0.122F0120
N250X1.5
N260X2.0Y2.0
N270G00G80Z0.1M09

(T04 DRILL 0.2)
N280G00G80G90X2.5Y1.5S56T04M06
N290G43Z0.1D04M13
N300G83R0.1Z-0.122Q0.1F0140
N310X1.5
N320X2.0Y2.0
N330G00G80Z0.1M09

N340G00G80G90X0Y160000S56T01M06
N350M05
N360M30
%
```

Post name;                    2422-vmc
Post Source                   2422-vmc
Machine type:                 MILWAUKEE MATIC VMC
Control:                      GEMINI MODULAR-D
Inch/Metric:                  Inch
Circ interpolation:           Incremental IJ
Auto 1st T-POSITION?          yes
Canned drill cycles:          yes
Post programmer notes:        Source code looks OK. Highly custom, Error check 1st position

```
%
/N10G99
/N20(ZTB,P,D,T,H)
/N30(TLD,S1=T1D0.0P0.0,S2=T2D0.0P0.0,S3
=T3D0.0P0.0)
/N40(TLD,S4=T4D0.0P0.0,S5=T5D0.0P0.0,S6
=T6D0.0P0.0)
/N50(TLD,S7=T7D0.0P0.0,S8=T8D0.0P0.0,S9
=T9D0.0P0.0)
/N60(TLD,S10=T10D0.0P0.0,S11=T11D0.0P0.
0,S12=T12D0.0P0.0)
/N70(TLD,S13=T13D0.0P0.0,S14=T14D0.0P0.
0,S15=T15D0.0P0.0)
/N80(TLD,S16=T16D0.0P0.0,S17=T17D0.0P0.
0,S18=T18D0.0P0.0)
/N90(TLD,S19=T19D0.0P0.0,S20=T20D0.0P0.
0,S21=T21D0.0P0.0)
/N100(TLD,S22=T22D0.0P0.0,S23=T23D0.0P0
.0,S24=T24D0.0P0.0)
/N110(TLD,S25=T25D0.0P0.0,S26=T26D0.0P0
.0,S27=T27D0.0P0.0)
/N120(TLD,S28=T28D0.0P0.0,S29=T29D0.0P0
.0,S30=T30D0.0P0.0)

/N130G40G70G90G94Z20.0F0M25
/N140X9.888Y9.777
/N150M00
/N160(MSG,ARE ALL P'S CORRECT)
/N170M00
/N180(MSG,STANDARD PROGRAM FOLLOWS)
/N190M06T01
/N200M00
/N210(MSG,PLEASE TURN ON BLOCK DELETE)

N220(MSG,T01 1/4" ENDMILL 0.25)
N230G00G40G90G94Z7.0F0S484M03
N240G00X0.573Y1.95F0M08
N250Z0.1
N260G01Z-0.122F5.
N270G41X0.575F10.
N280G03X0.875Y2.25J0.3F10.
N290G01Y3.0F10.
N300G02X1.0Y3.125I0.125F10.
N310G01X1.3584F10.
```

```
N320G02X1.6038Y2.9228J-0.25F10.
N330G03X2.3962Y2.9228I0.3962J0.0772F10.
N340G02X2.6416Y3.125I0.2454J-0.0478F10.
N350G01X3.0F10.
N360G02X3.125Y3.0J-0.125F10.
N370G01Y1.5F10.
N380G02X2.5Y0.875I-0.625F10.
N390G01X1.5F10.
N400G02X0.875Y1.5J0.625F10.
N410G01Y2.25F10.
N420G03X0.575Y2.55I-0.3F10.
N430G01G40X0.573F10.
N440G00Z0.1F0
N450G00Z14.0F0M09
N460X10.0Y4.0
N470M06T03

N480(MSG,T03 1/8" CENTER DRILL 0.125)
N490G00G40G90G94Z7.0F0S765M03
N500G00X2.5Y1.5F0M08
N510G81R0.1Z-0.122
N520X1.5
N530X2.0Y2.0
N540G80
N550G00Z14.0F0M09
N560X10.0Y4.0
N570M06T04

N580(MSG,T04 DRILL 0.2)
N590G00G40G90G94Z7.0F0S888M03
N600G00X2.5Y1.5F0M08
N610G83R0.1Z-0.122Q0.1
N620X1.5
N630X2.0Y2.0
N640Z0.1
N650G80M09
N660G00Z14.0F0

N670X9.888Y9.777Z20.0M25
N680M00
N690M02
%
```

| Post name: | 2423-vmc |
|---|---|
| Post Source | 2423-vmc |
| Machine type; | Giddings & Lewis VMC |
| Control: | Numeripath CNC 800 |
| Inch/Metric; | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. Error check for feedrate and 1st position |

```
%
 (T01 1/4" ENDMILL 0.25)
 N1G00G90X0.573Y1.95U0.V0.S484T01H01M08M03
 N2Z0.1
 N3G01Z-0.122F5.0
 N4G41X0.575H1F10.0
 N5G03X0.875Y2.25I0.0J0.3
 N6G01Y3.0
 N7G02X1.0Y3.125I0.125J0.0
 N8G01X1.3584
 N9G02X1.6038Y2.9228I0.0J-0.25
 N10G03X2.3962Y2.9228I0.3962J0.0772
 N11G02X2.6416Y3.125I0.2454J-0.0478
 N12G01X3.0
 N13G02X3.125Y3.0I0.0J-0.125
 N14G01Y1.5
 N15G02X2.5Y0.875I-0.625J0.0
 N16G01X1.5
 N17G02X0.875Y1.5I0.0J0.625
 N18G01Y2.25
 N19G03X0.575Y2.55I-0.3J0.0
 N20G40G01X0.573
 N21G00Z0.1

 (T03 1/8" CENTER DRILL 0.125)
 N22G00G90X2.5Y1.5S765T03H03M03
 N23G81R0.1Z-0.122K0.1
 N24X1.5F12.0
 N25X2.0Y2.0
 N26G80

 (T04 DRILL 0.2)
 N27G00G90X2.5Y1.5S888T04H04M08M03
 N28G83R0.1Z-0.122K0.1
 N29X1.5F14.0
 N30X2.0Y2.0
 N31G80H00M09
 N32G00X60.Y-5.U0.V0.T1H0M05M02
%
```

Post name:                3bcnc
Post Source                3bcnc
Machine type:              Generic Mill
Control:                   Devlieg Dynapath Delta 60
Inch/Metric:               Inch
Circ interpolation:        event type
Auto 1st T-POSITION?       yes
Canned drill cycles:       no
Post programmer notes:     Mild custom, must edit the E-word.

```
:XXXX (PART # REV DATE HERE)
(XXXX     )$
N0005(T)XXXXXXXXXXXXXXXXXXXXX$
N0010(T)PART # AND DESCRIPTION HERE$
N0015(T)REVISION HERE$
N0020(T)XXXXXXXXXXXXXXXXXXXXXX$$
N0025(T)***TOOL CHANGE TO T1***$
N0030(9)M3S484E??H1$
N0035(0)X0.573Y1.95$
N0040(0)W0.0$
N0045(0)Z0.1$
N0050(9)M8G0$
N0055(1)Z-0.122F5.C0$
N0060(1)X0.575F10.C1$
N0065(2)X0.875Y2.25I0.575J2.25D1C1$
N0070(1)Y3.0C1$
N0075(2)X1.0Y3.125I1.0J3.0D0C1$
N0080(1)X1.3584C1$
N0085(2)X1.6038Y2.9228I1.3584J2.875D0C1$
N0090(2)X2.3962I2.0J3.0D1C1$
N0095(2)X2.6416Y3.125I2.6416J2.875D0C1$
N0100(1)X3.0C1$
N0105(2)X3.125Y3.0I3.0J3.0D0C1$
N0110(1)Y1.5C1$
N0115(2)X2.5Y0.875I2.5J1.5D0C1$
N0120(1)X1.5C1$
N0125(2)X0.875Y1.5I1.5J1.5D0C1$
N0130(1)Y2.25C1$
N0135(2)X0.575Y2.55I0.575J2.25D1C1$
N0140(1)X0.573C0$
N0145(0)Z0.1G0$
N0150(9)M9$
N0155(M)P1$
N0160(9)M0$
N0165(9)***TOOL CHANGE TO T3***$
N0170(9)M3S765E??H3$
N0175(0)X2.5Y1.5G0$
N0180(0)W0.0$
N0185(0)X2.5Y1.5Z-0.122F12.G01I0.1$
N0190(0)X1.5Y1.5$
N0195(0)X2.0Y2.0$
N0200(M)P1$
N0205(9)M0$
N0210(9)***TOOL CHANGE TO T4***$
N0215(9)M3S888E??H4$
N0220(0)X2.5Y1.5G0$
N0225(9)M8$
N0230(0)W0.0$
N0235(0)X2.5Y1.5Z-0.122F14.K0.1G03I0.1$
N0240(0)X1.5Y1.5$
N0245(0)X2.0Y2.0$
N0250(9)M9$
N0255(M)P1$
N0260(9)M30$
END
```

Post name:                    4x-fan10
Post Source                 4x-fan10
Machine type:             4-Axis Mill
Control:                     Fanuc 10M
Inch/Metric:              Inch
Circ interpolation:        Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:      yes
Post programmer notes:    Source looks good, has 4-axis support.

```
%
O0(MC-TEST)
N1(T1 0.25 ENDMILL)S484T03M03
N1G0G90X.573Y1.95
N2G43Z.1H01M8
N3G1Z-.122F5.0
N4G41X.575F10.0
N5G3X.875Y2.25I.0J.3
N6G1Y3.0
N7G2X1.0Y3.125I.125J.0
N8G1X1.3584
N9G2X1.6038Y2.9228I.0J-.25
N10G3X2.3962I.3962J.0772
N11G2X2.6416Y3.125I.2454J-.0478
N12G1X3.0
N13G2X3.125Y3.0I.0J-.125
N14G1Y1.5
N15G2X2.5Y.875I-.625J.0
N16G1X1.5
N17G2X.875Y1.5I.0J.625
N18G1Y2.25
N19G3X.575Y2.55I-.3J.0
N20G1G40X.573
N21G0Z.1M09
N22G28G91Z0
N23M01
N24M06
```

```
N3(T3 0.125 CENTER DRILL)S765T04M03
N25G0G90X9.888Y9.777
N26X2.5Y1.5
N27G43Z1.0H03M8
N28G81G98Z-.122R.1P0F12.0
N29X1.5
N30X2.0Y2.0
N31G80M09
N32G28G91Z0
N33M01
N34M06

N4(T4 0.2 DRILL)S888T01M03
N35G0G90X9.888Y9.777
N36X2.5Y1.5
N37G43Z1.0H04M8
N38G83G98Z-.122R.1Q.1F14.0
N39X1.5
N40X2.0Y2.0
N41G80M09
N42G28G91Z0
N43G28Y0
N44M01
N45M30
%
```

Post name:              Ab-7320
Post Source             Ab-7320
Machine type:           Generic HMC
Control:                Allen Bradley 7320
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK, mild customization.

```
%                              N0135 G00 G40 Z-.1
N0005 B0                       N0140 G00 H00 Z0 W15.
N0010 G92 X0 Y0
                               N0145 (T03 1/8" CENTER DRILL 0.125)
N0015 (T01 1/4" ENDMILL 0.25)  N0150 T0100 M06
N0020 G00 W15.                 N0155 X2.5 Y1.5 S765 W5. H03 T0004
N0025 H00 Z0                   N0160 Z-.1
N0030 X.573 Y1.95 S484 W5. H01 T0003  N0165 M03 G81 F12. Z.122 R-.1
N0035 Z-.1                     N0170 X1.5 K.1
N0040 M03 G01 Z.122 F5.        N0175 X2.0 Y2.0 K.1
N0045 G41 D01                  N0180 G80
N0050 X.575 F10.               N0185 G00 H00 Z0 W15.
N0055 G03 X.875 Y2.25 J.3
N0060 G01 Y3.0                 N0190 (T04 DRILL 0.2)
N0065 G02 X1.0 Y3.125 I.125    N0195 T0300 M06
N0070 G01 X1.3584              N0200 X2.5 Y1.5 S888 W5. H04 T0000
N0075 G02 X1.6038 Y2.9228 J-.25  N0205 Z-.1
N0080 G03 X2.3962 Y2.9228 I.3962 J.0772  N0210 M03 G83 F14. Z.122 R-.1 K.1
N0085 G02 X2.6416 Y3.125 I.2454 J-.0478  N0215 X1.5 K.1
N0090 G01 X3.0                 N0220 X2.0 Y2.0 K.1
N0095 G02 X3.125 Y3.0 J-.125   N0225 G80
N0100 G01 Y1.5                 N0230 G00 H00 Z0 W15.
N0105 G02 X2.5 Y.875 I-.625    N0235 T0400 M06
N0110 G01 X1.5                 N0240 X.573 Y1.95
N0115 G02 X.875 Y1.5 J.625     N0245 M30
N0120 G01 Y2.25
N0125 G03 X.575 Y2.55 I-.3
N0130 G01 X.573
```

Post name:                 Ab8200
Post Source                Ab8200
Machine type:              Generic VMC
Control:                   Allen Bradley 8200
Inch/Metric:               Inch
Circ interpolation:        Incremental IJ
Auto 1st T-POSITION?       Not supported
Canned drill cycles:       no
Post programmer notes:     Source code looks OK; outputs G45 Z0 regardless of the r-plane.

```
%
N10G00G17G40G90G94

(T01 1/4 ENDMILL 0.25)
N20T01M01
N30G00X0.573Y1.95S484M03
N40Z0.1M7
N50G01Z-0.122F5.
N60G41D01X0.575F10.
N70G03X0.875Y2.25J0.3
N80G01Y3.0
N90G02X1.0Y3.125I0.125
N100G01X1.3584
N110G02X1.6038Y2.9228J-0.25
N120G03X2.3962Y2.9228I0.3962J0.0772
N130G02X2.6416Y3.125I0.2454J-0.0478
N140G01X3.0
N150G02X3.125Y3.0J-0.125
N160G01Y1.5
N170G02X2.5Y0.875I-0.625
N180G01X1.5
N190G02X0.875Y1.5J0.625
N200G01Y2.25
N210G03X0.575Y2.55I-0.3
N220G01G40D00X0.573
N230G00Z0.1
N240Z1.0H00M09
N250M01

(T03 1/8 CENTER DRILL 0.125)
N260T03M01
N270G00X2.5Y1.5S765M03
N280X1.5
N290X2.0Y2.0H00M09
N300M01

(T04 DRILL 0.2)
N310T04M01
N320G00X2.5Y1.5S888M03
N330X1.5
N340X2.0Y2.0
N350Z0.1H00M09
N360M01

( END )
N370M30
%
```

| | |
|---|---|
| Post name: | Ab-8400 |
| Post Source | Ab-8400 |
| Machine type: | Hartford Mill |
| Control: | Allen Bradley Series B8400 MP/Bandit IV |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Highly customized |

```
%%

N1G90
N2G99
N3G0Z0O0
N4G0X0.Y0.Z0.
N5G92X0.Y0.
N6T01;=ENDMILL_0.25_DIA.
N7G0X0.573Y1.95
N8Z0.1O1M13S484
N9G1Z-0.122F5.0
N10G41
N11X0.575F10.0
N12G3X0.875Y2.25I0.575J2.25
N13G1Y3.0
N14G2X1.0Y3.125I1.0J3.0
N15G1X1.3584
N16G2X1.6038Y2.9228I1.3584J2.875
N17G3X2.3962I2.0J3.0
N18G2X2.6416Y3.125I2.6416J2.875
N19G1X3.0
N20G2X3.125Y3.0I3.0J3.0
N21G1Y1.5
N22G2X2.5Y0.875I2.5J1.5
N23G1X1.5
N24G2X0.875Y1.5I1.5J1.5
N25G1Y2.25
N26G3X0.575Y2.55I0.575J2.25
N27G40

N28G1X0.573
N29G0Z0.1
N30M9
N31G0Z0O0M19
N32M1G0Z0O0
N33T03;=CENTER_DRILL_0.125_DIA.
N34G0X2.5Y1.5
N35Z0.1O3M13S765
N36G81X2.5Y1.5R0.1Z-0.122F12.0P1
N37X1.5Y1.5
N38X2.0Y2.0
N39G80
N40M9
N41G0Z0O0M19
N42M1G0Z0O0
N43T04;=DRILL_0.2_DIA.
N44G0X2.5Y1.5
N45Z0.1O4M13S888
N46G83X2.5Y1.5R0.1Z-
0.122F14.0I0.1W0.01P1
N47X1.5Y1.5
N48X2.0Y2.0
N49G80
N50M9
N51G0Z0O0M19
N52M1
N53M30
%%
```

| Post name: | Ab-ban2 |
| Post Source | Ab-ban2 |
| Machine type: | Generic VMC |
| Control: | Allen Bradley Bandit Level 2 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | no |
| Post programmer notes: | Old control, outputs "/" for rapids |

```
< MC-TEST  Fri Apr 06 10:55:11 2001'

N005G90
N010T00
N015/Z1.
N020/X9.888/Y9.777
N025M06
N030T10101
N035M03
N040/X0.573/Y1.95M08
N045/Z0.1
N050F5.
N055Z-0.122
N060G41
N065F10.
N070X0.575
N075X0.875Y2.25I0.575J2.25
N080Y3.
N085X1.Y3.125I1.J3.
N090X1.3584
N095X1.6038Y2.9228I1.3584J2.875
N100X2.Y2.5964I2.J3.
N105X2.3962Y2.9228I2.J3.
N110X2.6416Y3.125I2.6416J2.875
N115X3.
N120X3.125Y3.I3.J3.
N125Y1.5
N130X2.5Y0.875I2.5J1.5
N135X1.5
N140X0.875Y1.5I1.5J1.5
N145Y2.25
N150X0.575Y2.55I0.575J2.25
N155G40
N160X0.573
N165/Z0.1 M09

N170/Z1.
N175/X9.888/Y9.777
N180T00
N185M06
N190T0303
N195M03
N200/X2.5/Y1.5
N205/Z0.1
N210F12.
N215Z-0.222/T0.1G81
N220/X2.5/Y1.5
N225/X1.5
N230/X2./Y2.
N235G80
N240/Z1.
N245/X9.888/Y9.777
N250T00
N255M06
N260T0404
N265M03
N270/X2.5/Y1.5M08
N275/Z0.1
N280F14.
N285Z-0.222/T0.1G83
N290/X2.5/Y1.5
N295/X1.5
N300/X2./Y2.
N305G80
N310/Z0.1
N315G80
N320M05
N325M02
```

Post name:                 Acra-850
Post Source                Acra-850
Machine type:              Cincinnati Sabre
Control:                   Cincinnati 850
Inch/Metric:               Inch
Circ interpolation:        Absolute IJ
Auto 1st T-POSITION?       yes
Canned drill cycles:       yes
Post programmer notes:     Good post, supports inch and metric, has error checking and A-axis indexing support.

```
%
:G90G0M6T01G70
M1
(MSG, ACRA-850 MC-TEST)
(MSG, Fri Apr 06 11:03:40 2001')
(MSG, T1 0.25 ENDMILL)
X0.573Y1.95S484M3
Z0.1M8
G01Z-0.122F5.0
G41X0.575F10.0
G03X0.875Y2.25I0.575J2.25
G01Y3.0
G02X1.0Y3.125I1.0J3.0
G01X1.3584
G02X1.6038Y2.9228I1.3584J2.875
G03X2.0Y2.5964I2.0J3.0
X2.3962Y2.9228I2.0J3.0
G02X2.6416Y3.125I2.6416J2.875
G01X3.0
G02X3.125Y3.0I3.0J3.0
G01Y1.5
G02X2.5Y0.875I2.5J1.5
G01X1.5
G02X0.875Y1.5I1.5J1.5
G01Y2.25
G03X0.575Y2.55I0.575J2.25
G01G40X0.573
G00Z0.1M5
:G0M6T03G70
M1
(MSG, T3 0.125 CENTER DRILL)
X2.5Y1.5S765M3
Z0.1
G81R0.1Z-0.222F12.0
X1.5
X2.0Y2.0
G80M5
:G0M6T04G70
M1
(MSG, T4 0.2 DRILL)
X2.5Y1.5S888M3
Z0.1M8
G83R0.1Z-0.222K0.1F14.0
X1.5
X2.0Y2.0
G80
Z0.1M09
M2
%
```

| | |
|---|---|
| Post name: | Acra-8d |
| Post Source | Acra-8d |
| Machine type: | Cintimatic 7VT-1000 Mill |
| Control: | Acramatic 8-D |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Other notes; | Source code looks good. |

```
H005G78X+05730Y+19500W01
N010G79X+05750F100
N015G03X+08750Y+22500I+05750J+22500
N020G79Y+30000F100
N025G02X+10000Y+31250I+10000J+30000
N030G79X+13584F100
N035G02X+16038Y+29228I+13584J+28750
N040G03X+20000Y+25964I+20000J+30000
N045X+23962Y+29228I+20000J+30000
N050G02X+26416Y+31250I+26416J+28750
N055G79X+30000F100
N060G02X+31250Y+30000I+30000J+30000
N065G79Y+15000F100
N070G02X+25000Y+08750I+25000J+15000
N075G79X+15000F100
N080G02X+08750Y+15000I+15000J+15000
N085G79Y+22500F100
N090G03X+05750Y+25500I+05750J+22500
N095G79X+05730F100
N100G78
N105G80M06
H110G81X+98880Y+97770W03
N115X+25000Y+15000
N120X+15000
N125X+20000Y+20000
N130G80M06
H135G83X+98880Y+97770W04
N140X+25000Y+15000
N145X+15000
N150X+20000Y+20000
N155
N160G80M06
N165M02
```

Post name:              Acraloc
Post Source             Acraloc
Machine type:           Generic Mill
Control:                Acraloc
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Mild customization, hardcode Z.060 at toolchanges.

```
 :0001
N100G90G00X0.573Y1.95T1
G43H01M03S69M42
Z0.1M8
G01Z-0.122F5.
G41D1X0.575F10.
G03X0.875Y2.25J0.3
G01Y3.0
G02X1.0Y3.125I0.125
G01X1.3584
G02X1.6038Y2.9228J-0.25
G03X2.3962I0.3962J0.0772
G02X2.6416Y3.125I0.2454J-0.0478
G01X3.0
G02X3.125Y3.0J-0.125
G01Y1.5
G02X2.5Y0.875I-0.625
G01X1.5
G02X0.875Y1.5J0.625
G01Y2.25
G03X0.575Y2.55I-0.3
G01G40X0.573
G00Z0.1M09
G80G49Z0.060

N300G90G00X2.5Y1.5T3
G43H03M03S19M41
G81G98R0.1Z-0.122F12.
X1.5
X2.0Y2.0
G80
G80G49Z0.060

N400G90G00X2.5Y1.5T4
G43H04M03S22M41
G83G98R0.1Z-0.122Q0.1F14.
X1.5M8
X2.0Y2.0
G80M09
G80G49Z0.060
M30
%
#< END OF MC-TEST >
```

Post name:            Acra-pq
Post Source           Acra-pq
Machine type:         Cincinnati 10V
Control:              Acramatic
Inch/Metric:          Inch
Circ interpolation:   Absolute
Auto 1st T-POSITION?  yes
Canned drill cycles:  yes
Post programmer notes: Uses P-Q vectors for cutter compensation.

```
%
O1 G70 T01 M06
N2 G90
N3 G00 X5730 Y19500 S484 T03 M13
N4 Z-10000
N5 G01 Z-12220 F50 M7
N6 X5750 Y19500 P0 Q10000 F100
N7 G03 X8750 Y22500 I5750 J22500 P-
10000 Q0
N8 G01 X8750 Y30000 P-10000 Q0
N9 G02 X10000 Y31250 I10000 J30000 P0
Q10000
N10 G01 X13584 Y31250 P0 Q10000
N11 G02 X16038 Y29228 I13584 J28750
P9815 Q1912
N12 G03 X20000 Y25964 I20000 J30000 P0
Q10000
N13 X23962 Y29228 I20000 J30000 P-9815
Q1912
N14 G02 X26416 Y31250 I26416 J28750 P0
Q10000
N15 G01 X30000 Y31250 P0 Q10000
N16 G02 X31250 Y30000 I30000 J30000
P10000 Q0
N17 G01 X31250 Y15000 P10000 Q0
N18 G02 X25000 Y8750 I25000 J15000 P0
Q-10000
N19 G01 X15000 Y8750 P0 Q-10000
N20 G02 X8750 Y15000 I15000 J15000 P-
10000 Q0
N21 G01 X8750 Y22500 P-10000 Q0
N22 G03 X5750 Y25500 I5750 J22500 P0 Q-
10000
N23 G01 X5730 Y25500
N24 G00 Z-10000
N25 G80 R0 M09
O26 G70 T03 M06
N27 G90
N28 G81 X25000 Y15000 Z-1000 R-10000
F120 S765 T04 M13
N29 G80 R0
N30 G81 R-11000
N31 G80 R0
```

```
N32 G81 Z-220 R-12000
N33 G80 R0
N34 G81 X15000 Z-1000 R-10000
N35 G80 R0
N36 G81 R-11000
N37 G80 R0
N38 G81 Z-220 R-12000
N39 G80 R0
N40 G81 X20000 Y20000 Z-1000 R-10000
N41 G80 R0
N42 G81 R-11000
N43 G80 R0
N44 G81 Z-220 R-12000
N45 G80 R0 M09
O46 G70 T04 M06
N47 G90
N48 G83 X25000 Y15000 Z-1000 R-10000
F140 S888 M13
N49 G80 R0
N50 G83 R-11000
N51 G80 R0
N52 G83 Z-220 R-12000
N53 G80 R0
N54 G83 X15000 Z-1000 R-10000 M8
N55 G80 R0
N56 G83 R-11000
N57 G80 R0
N58 G83 Z-220 R-12000
N59 G80 R0
N60 G83 X20000 Y20000 Z-1000 R-10000
N61 G80 R0
N62 G83 R-11000
N63 G80 R0
N64 G83 Z-220 R-12000
N65 G80 R0
N66 G83 Z-10000 Z-1000 R-10000
N67 G80 R0
N68 G83 R-11000
N69 G80 R0
N70 G83 Z-220 R-12000
N71 G80 R0
N72 G80 R0 M09
N73Y97770M02
%
```

Post name:              Acro-fan
Post Source             Acro-fan
Machine type:           Acroloc Horizontal Mill
Control:                Fanuc
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Highly customized, 3 digit canned drill cycles.

```
O0001
N10
N20(T1 0.25 DIA ENDMILL)
N30M8
N40G90G54G0S484T1M3
N50G100X9.888Y9.777H21D41B0.0Z1.0/U1.0
N60X0.573Y1.95
N70G1Z0.1/U0.1F0.0
N80Z-0.122/U-0.122F5.0
N90G41D31X0.575F10.0
N100G3X0.875Y2.25J0.3
N110G1Y3.0
N120G2X1.0Y3.125I0.125
N130G1X1.358
N140G2X1.604Y2.923J-0.25
N150G3X2.396I0.396J0.077
N160G2X2.642Y3.125I0.245J-0.048
N170G1X3.0
N180G2X3.125Y3.0J-0.125
N190G1Y1.5
N200G2X2.5Y0.875I-0.625
N210G1X1.5
N220G2X0.875Y1.5J0.625
N230G1Y2.25
N240G3X0.575Y2.55I-0.3
N250G1G40X0.573
N260G0Z0.1/U0.1
N270
N280G100H0D0
N290M1
N300
N310
N320(T3 0.125 DIA CENTER DRILL)
N330M8
N340G90G54G0S765T3M3
N350G100X9.888Y9.777Z1.0/U1.0H23D43B0.0Z1.0/U
1.0
N360X2.5Y1.5
N370G181R0.1Z-0.122/U-0.122F12.0
N380X1.5
N390X2.0Y2.0
N400G67
N410
N420G100H0D0
N430M1
N440
N450
N460(T4 0.2 DIA DRILL)
N470M8
N480G90G54G0S888T4M3
N490G100X9.888Y9.777H24D44B0.0Z1.0/U1.0
N500G0X2.5Y1.5
N510G183R0.1Z-0.122/U-0.122Q0.1F14.0
N520X1.5
N530X2.0Y2.0
N540G67
N550
N560G100H0D0
N570
N580G100B315.0H1
N590T1(UNLOAD PARTS)
N600M30
%
#< END OF MC-TEST >
```

| Post name: | Ajv-25 |
| Post Source | Ajv-25 |
| Machine type: | Mazak Mill |
| Control: | |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles; | yes |
| Post programmer notes: | Source code looks OK |

```
<  MC-TEST  Fri Apr 06 11:06:58
2001'O0000
N1G90G17G54T01
N2M06T00
N3G91G28Z0
 (T1 0.25 ENDMILL)
N4G90S484M03
N5X0.573Y1.95
N6G90G45Z1.H01M08T03
N7Z0.1
N8G01Z-0.122F5.
N9G41X0.575F10.
N10G03X0.875Y2.25J0.3
N11G01Y3.
N12G02X1.Y3.125I0.125
N13G01X1.3584
N14G02X1.6038Y2.9228J-0.25
N15G03X2.3962I0.3962J0.0772
N16G02X2.6416Y3.125I0.2454J-0.0478
N17G01X3.
N18G02X3.125Y3.J-0.125
N19G01Y1.5
N20G02X2.5Y0.875I-0.625
N21G01X1.5
N22G02X0.875Y1.5J0.625
N23G01Y2.25
N24G03X0.575Y2.55I-0.3
N25G01G40X0.573
```

```
N26G00Z0.1
N27M09
N28G00G28Z1.M06T01
N29G91G28Z0
 (T3 0.125 CENTER DRILL)
N30G90S765M03
N31X2.5Y1.5
N32G90G45Z1.H03M08T04
N33G81G98X2.5Y1.5Z-0.122R0.1F12.
N34X1.5
N35X2.Y2.
N36G80
N37M09
N38G00G28Z1.M06T03
N39G91G28Z0
 (T4 0.2 DRILL)
N40G90S888M03
N41G00X2.5Y1.5
N42G90G45Z1.H04M08T00
N43G83G98X2.5Y1.5Z-0.122Q0.1R0.1F14.
N44X1.5
N45X2.Y2.
N46G80M09
N47G91G28X0Y0Z1.M05
N48M06T04
N49M30
%
<   END    >
```

```
Post name:              an-1100
Post Source             an-1100
Machine type:           GenericVMC
Control:                Anilam Series 1100
Inch/Metric:            Inch
Circ interpolation:     conversational
Auto 1st T-POSITION?    yes
Canned drill cycles:    no
Post programmer notes:  Source code looks good, has error checking.


 Dim Abs
 Rapid        Z 0.0000 Tool# 0
 Rapid        X 9.8880 Y 9.7770
 Tool# 1
 * T1 1/4" ENDMILL 0.25
 Rapid        X 0.5730 Y 1.9500
 Rapid        Z 0.1000
 Line         Z -0.1220 Feed 5.0
 Line         X 0.5750 Y 1.9500 ToolComp Left Feed 10.0
 Arc Ccw      X 0.8750 Y 2.2500 XCenter 0.0000 YCenter 0.3000
 Line         X 0.8750 Y 3.0000
 Arc Cw       X 1.0000 Y 3.1250 XCenter 0.1250 YCenter 0.0000
 Line         X 1.3584 Y 3.1250
 Arc Cw       X 1.6038 Y 2.9228 XCenter 0.0000 YCenter -0.2500
 Arc Ccw      X 2.3962 Y 2.9228 XCenter 0.3962 YCenter 0.0772
 Arc Cw       X 2.6416 Y 3.1250 XCenter 0.2454 YCenter -0.0478
 Line         X 3.0000 Y 3.1250
 Arc Cw       X 3.1250 Y 3.0000 XCenter 0.0000 YCenter -0.1250
 Line         X 3.1250 Y 1.5000
 Arc Cw       X 2.5000 Y 0.8750 XCenter -0.6250 YCenter 0.0000
 Line         X 1.5000 Y 0.8750
 Arc Cw       X 0.8750 Y 1.5000 XCenter 0.0000 YCenter 0.6250
 Line         X 0.8750 Y 2.2500
 Arc Ccw      X 0.5750 Y 2.5500 XCenter -0.3000 YCenter 0.0000
 Line         X 0.5730 Y 2.5500 ToolComp Off
 Rapid        Z 0.1000
 Rapid        Z 0.0000 Tool# 0
 Rapid        X 9.8880 Y 9.7770
 Tool# 3
 * T3 1/8" CENTER DRILL 0.125
 BasicDrill   ZDepth -0.1220 StartHgt 0.1000 Feed 12.0
 Rapid        X 2.5000 Y 1.5000
 Rapid        X 1.5000 Y 1.5000
 Rapid        X 2.0000 Y 2.0000
 DrillOff
 Rapid        Z 0.0000 Tool# 0
 Rapid        X 9.8880 Y 9.7770
 Tool# 4
 * T4 DRILL 0.2
 PeckDrill    ZDepth -0.1220 StartHgt 0.1000 Peck 0.1000 Feed 14.0
 Rapid        X 2.5000 Y 1.5000
 Rapid        X 1.5000 Y 1.5000
 Rapid        X 2.0000 Y 2.0000
 DrillOff
 Rapid        Z 0.0000 Tool# 0
 Rapid        X 9.8880 Y 9.7770
 EndMain
```

```
Post name:                an32k
Post Source               an32k
Machine type:             Generic VMC
Control:                  Anilam 3200
Inch/Metric:              Inch
Circ interpolation:  and R    conversational
Auto 1st T-POSITION?      yes
Canned drill cycles:      no
Post programmer notes:    Source code looks good.


 Dim Abs
 Rapid       Z 0.0000 Tool# 0
 Rapid       X 9.8880 Y 9.7770
 Tool# 1
 * T1 1/4" ENDMILL 0.25
 Rapid       X 0.5730 Y 1.9500
 Rapid       Z 0.1000
 Line        Z -0.1220 Feed 5.0
 Line        X 0.5750 Y 1.9500 ToolComp Left Feed 10.0
 Arc Ccw     X 0.8750 Y 2.2500 XCenter 0.0000 YCenter 0.3000
 Line        X 0.8750 Y 3.0000
 Arc Cw      X 1.0000 Y 3.1250 XCenter 0.1250 YCenter 0.0000
 Line        X 1.3584 Y 3.1250
 Arc Cw      X 1.6038 Y 2.9228 XCenter 0.0000 YCenter -0.2500
 Arc Ccw     X 2.3962 Y 2.9228 XCenter 0.3962 YCenter 0.0772
 Arc Cw      X 2.6416 Y 3.1250 XCenter 0.2454 YCenter -0.0478
 Line        X 3.0000 Y 3.1250
 Arc Cw      X 3.1250 Y 3.0000 XCenter 0.0000 YCenter -0.1250
 Line        X 3.1250 Y 1.5000
 Arc Cw      X 2.5000 Y 0.8750 XCenter -0.6250 YCenter 0.0000
 Line        X 1.5000 Y 0.8750
 Arc Cw      X 0.8750 Y 1.5000 XCenter 0.0000 YCenter 0.6250
 Line        X 0.8750 Y 2.2500
 Arc Ccw     X 0.5750 Y 2.5500 XCenter -0.3000 YCenter 0.0000
 Line        X 0.5730 Y 2.5500 ToolComp Off
 Rapid       Z 0.1000
 Rapid       Z 0.0000 Tool# 0
 Rapid       X 9.8880 Y 9.7770
 Tool# 3
 * T3 1/8" CENTER DRILL 0.125
 BasicDrill  ZDepth -0.1220 StartHgt 0.1000 Feed 12.0
 Rapid       X 2.5000 Y 1.5000
 Rapid       X 1.5000 Y 1.5000
 Rapid       X 2.0000 Y 2.0000
 DrillOff
 Rapid       Z 0.0000 Tool# 0
 Rapid       X 9.8880 Y 9.7770
 Tool# 4
 * T4 DRILL 0.2
 PeckDrill   ZDepth -0.1220 StartHgt 0.1000 Peck 0.1000 Feed 14.0
 Rapid       X 2.5000 Y 1.5000
 Rapid       X 1.5000 Y 1.5000
 Rapid       X 2.0000 Y 2.0000
 DrillOff
 Rapid       Z 0.0000 Tool# 0
 Rapid       X 9.8880 Y 9.7770
 EndMain
```

Post name:                Anilam
Post Source               Anilam
Machine type:             Generic VMC
Control:                  Anilam Crusader II
Inch/Metric:              Inch
Circ interpolation:       Absolute IJ
Auto 1st T-POSITION?      Not supported
Canned drill cycles:      yes
Post programmer notes:    Uses variables for drill cycles

```
%
N5G0G70G80G90
N10M1000
N15T0
N20G0Z0
N25X9.888Y9.777
N30T1
N35S0484
N40M3
N45G00X0.573Y1.95
N50Z0.1
N55G01Z-0.122F5.0
N60G41X0.575F10.0
N65G03X0.875Y2.25I0.575J2.25
N70G01Y3.0
N75G02X1.0Y3.125I1.0J3.0
N80G01X1.3584
N85G02X1.6038Y2.9228I1.3584J2.875
N90G03X2.3962Y2.9228I2.0J3.0
N95G02X2.6416Y3.125I2.6416J2.875
N100G01X3.0
N105G02X3.125Y3.0I3.0J3.0
N110G01Y1.5
N115G02X2.5Y0.875I2.5J1.5
N120G01X1.5
N125G02X0.875Y1.5I1.5J1.5
N130G01Y2.25
N135G03X0.575Y2.55I0.575J2.25
N140G01G40X0.573
N145G00Z0.1
N150T0
N155G0Z0
N160X9.888Y9.777
N165T3
N170S0765
N175M3
N180G00X2.5Y1.5
N185G29LV20=12.0
N190G29LV21=0.1
N195G29LV24=0.1
N200G81
N205Z-0.122
N210X2.5Y1.5
N215X1.5
N220X2.0Y2.0
N225G80
N230T0
N235G0Z0
N240X9.888Y9.777
N245T4
N250S0888
N255M3
N260G00X2.5Y1.5
N265G29LV20=14.0
N270G29LV21=0.1
N275G29LV23=0.1
N280G29LV24=0.1
N285G83
N290Z-0.122
N295X2.5Y1.5
N300X1.5
N305X2.0Y2.0
N310G80
N315M2000
N320T0
N325G0Z0
N330X9.888Y9.777
N335G29E
%
```

| Post name: | Anilam-m |
|---|---|
| Post Source | Anilam-m |
| Machine type: | Generic Mill |
| Control: | Anilam Series M |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Doesn't use S-code. |

```
#%
N0G0G70G90G17
N10T0
N20Z0
N30X9.888Y9.777
N40T1
N50G0X0.573Y1.95
N60Z0.1
N70F5.0
N80G1Z-0.122
N90F10.0
N100G41
N110X0.575
N120G3X0.875Y2.25I0.575J2.25
N130G1Y3.0
N140G2X1.0Y3.125I1.0J3.0
N150G1X1.3584
N160G2X1.6038Y2.9228I1.3584J2.875
N170G3X2.3962Y2.9228I2.0J3.0
N180G2X2.6416Y3.125I2.6416J2.875
N190G1X3.0
N200G2X3.125Y3.0I3.0J3.0
N210G1Y1.5
N220G2X2.5Y0.875I2.5J1.5
N230G1X1.5
N240G2X0.875Y1.5I1.5J1.5
N250G1Y2.25
N260G3X0.575Y2.55I0.575J2.25
N270G40
N280G1X0.573
N290G0Z0.1
N300T0
N310Z0
N320X9.888Y9.777
N330T3
N340G0X2.5Y1.5
N350G29LV20=12.0
N360G29LV21=0.1
N370G29LV24=0.1
N380G81
N390Z-0.122
N400X2.5Y1.5
N410X1.5
N420X2.0Y2.0
N430G80
N440T0
N450Z0
N460X9.888Y9.777
N470T4
N480G0X2.5Y1.5
N490G29LV20=14.0
N500G29LV21=0.1
N510G29LV23=0.1
N520G29LV24=0.1
N530G83
N540Z-0.122
N550X2.5Y1.5
N560X1.5
N570X2.0Y2.0
N580G80
N590T0
N600Z0
N610G29E
#%
```

| Post name: | anl-1400 |
|---|---|
| Post Source | anl-1400 |
| Machine type: | Generic Mill |
| Control: | Anilam Crusader II |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks Ok, mild customization. |

```
G0 G17 G40 G70 G80 G90
T0 Z0
X9.888 Y9.777
T1  * ENDMILL 0.25
M3
S0484 M8
G0 X0.573 Y1.95
Z0.1
G1 Z-0.122 F5.0
G41 X0.575 F10.0
G3 X0.875 Y2.25 I0.0 J0.3
G1 Y3.0
G2 X1.0 Y3.125 I0.125 J0.0
G1 X1.3584
G2 X1.6038 Y2.9228 I0.0 J-0.25
G3 X2.3962 Y2.9228 I0.3962 J0.0772
G2 X2.6416 Y3.125 I0.2454 J-0.0478
G1 X3.0
G2 X3.125 Y3.0 I0.0 J-0.125
G1 Y1.5
G2 X2.5 Y0.875 I-0.625 J0.0
G1 X1.5
G2 X0.875 Y1.5 I0.0 J0.625
G1 Y2.25
G3 X0.575 Y2.55 I-0.3 J0.0
G1 G40 X0.573
G0 Z0.1
M5
M9
```

```
T0 Z0
X9.888 Y9.777
T3  * SPOTTING DRILL 0.125
M3
S0765 M8
G0 X2.5 Y1.5
G81 Z-0.122 R0.1 F12.0
X2.5 Y1.5
X1.5
X2.0 Y2.0
G80
M5
M9
T0 Z0
X9.888 Y9.777
T4  * DRILL 0.2
M3
S0888 M8
G0 X2.5 Y1.5
G83 Z-0.122 R0.1 F14.0 I0.1
X2.5 Y1.5
X1.5
X2.0 Y2.0
G80
M5
M9
T0 Z0
X9.888 Y9.777
M2
```

Post name:                  anl-3300
Post Source                 anl-3300
Machine type:               Generic Mill
Control:                    Anilam 3300
Inch/Metric:                Inch
Circ interpolation:         Absolute IJ
Auto 1st T-POSITION?        yes
Canned drill cycles:        yes
Post programmer notes:      Source code looks good.

```
N10 O01                         N340 M9
N20 G70                         N350 T0
N30 G17                         N360 G0 Z0
N40 G90                         N370 X9.888 Y9.777
N50 T0                          N380 T3
N60 G0 Z0                       N390  * SPOTTING DRILL 0.125
N70 X9.888 Y9.777               N400 M3
N80 T1                          N410 G00 X2.5 Y1.5
N90  * ENDMILL 0.25             N420 G81 Z-0.122 R0.1 F12.0
N100 M3                         N430 X2.5 Y1.5
N110 G00 X0.573 Y1.95           N440 X1.5
N120 Z0.1                       N450 X2.0 Y2.0
N130 G01 Z-0.122 F5.0           N460 G80
N140 G41 X0.575 F10.0           N470 M5
N150 G03 X0.875 Y2.25 I0.575 J2.25    N480 M9
N160 G01 Y3.0                   N490 T0
N170 G02 X1.0 Y3.125 I1.0 J3.0        N500 G0 Z0
N180 G01 X1.3584                N510 X9.888 Y9.777
N190 G02 X1.6038 Y2.9228 I1.3584 J2.875   N520 T4
N200 G03 X2.3962 Y2.9228 I2.0 J3.0    N530  * DRILL 0.2
N210 G02 X2.6416 Y3.125 I2.6416 J2.875    N540 M3
N220 G01 X3.0                   N550 G00 X2.5 Y1.5
N230 G02 X3.125 Y3.0 I3.0 J3.0        N560 G83 Z-0.122 R0.1 F14.0 I0.1
N240 G01 Y1.5                   N570 X2.5 Y1.5
N250 G02 X2.5 Y0.875 I2.5 J1.5        N580 X1.5
N260 G01 X1.5                   N590 X2.0 Y2.0
N270 G02 X0.875 Y1.5 I1.5 J1.5        N600 G80
N280 G01 Y2.25                  N610 M5
N290 G03 X0.575 Y2.55 I0.575 J2.25    N620 M9
N300 G40                        N630 T0
N310 G01 X0.573                 N640 G0 Z0
N320 G00 Z0.1                   N650 X9.888 Y9.777
N330 M5                         N660 M2
```

| Post name: | Anl5300m |
|---|---|
| Post Source | Anl5300m |
| Machine type: | Generic Mill |
| Control: | Anilam 5300 |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. |

```
N10 O01
N20 G70
N30 G17
N40 G90
N50 T0
N60 G0 Z0
N70 X9.888 Y9.777
N80 T1
N90  * ENDMILL 0.25
N100 M3
N110 G00 X0.573 Y1.95
N120 Z0.1
N130 G01 Z-0.122 F5.0
N140 G41 X0.575 F10.0
N150 G03 X0.875 Y2.25 I0.575 J2.25
N160 G01 Y3.0
N170 G02 X1.0 Y3.125 I1.0 J3.0
N180 G01 X1.3584
N190 G02 X1.6038 Y2.9228 I1.3584 J2.875
N200 G03 X2.3962 Y2.9228 I2.0 J3.0
N210 G02 X2.6416 Y3.125 I2.6416 J2.875
N220 G01 X3.0
N230 G02 X3.125 Y3.0 I3.0 J3.0
N240 G01 Y1.5
N250 G02 X2.5 Y0.875 I2.5 J1.5
N260 G01 X1.5
N270 G02 X0.875 Y1.5 I1.5 J1.5
N280 G01 Y2.25
N290 G03 X0.575 Y2.55 I0.575 J2.25
N300 G40
N310 G01 X0.573
N320 G00 Z0.1
N330 M5
```

```
N340 M9
N350 T0
N360 G0 Z0
N370 X9.888 Y9.777
N380 T3
N390  * SPOTTING DRILL 0.125
N400 M3
N410 G00 X2.5 Y1.5
N420 G81 Z-0.122 R0.1 F12.0
N430 X2.5 Y1.5
N440 X1.5
N450 X2.0 Y2.0
N460 G80
N470 M5
N480 M9
N490 T0
N500 G0 Z0
N510 X9.888 Y9.777
N520 T4
N530  * DRILL 0.2
N540 M3
N550 G00 X2.5 Y1.5
N560 G83 Z-0.122 R0.1 F14.0 I0.1
N570 X2.5 Y1.5
N580 X1.5
N590 X2.0 Y2.0
N600 G80
N610 M5
N620 M9
N630 T0
N640 G0 Z0
N650 X9.888 Y9.777
N660 M2
```

| Post name: | Band-ii |
| Post Source | Band-ii |
| Machine type: | Wells Index |
| Control: | Bandit II |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. |

```
#< MC-TEST  Mon Apr 09 09:19:29 2001'
%
N5G90
N10T00
N15G98
N20M06
N25T0101
N30X0.573Y1.95M03
N35Z0.1
N40F5.
N45Z-0.122M07
N50G41
N55F10.
N60X0.575
N65X0.875Y2.25I0.575J2.25
N70Y3.
N75X1.Y3.125I1.J3.
N80X1.3584
N85X1.6038Y2.9228I1.3584J2.875
N90X2.Y2.5964I2.J3.
N95X2.3962Y2.9228I2.J3.
N100X2.6416Y3.125I2.6416J2.875
N105X3.
N110X3.125Y3.I3.J3.
N115Y1.5
N120X2.5Y0.875I2.5J1.5
N125X1.5
N130X0.875Y1.5I1.5J1.5
N135Y2.25
N140X0.575Y2.55I0.575J2.25
N145G40
N150X0.573
N155Z0.1

N160Z1.M09
N165X9.888Y9.777
N170T00
N175G98
N180M06
N185T0303
N190X9.888Y9.777M03
N195X2.5Y1.5
N200/Z0.1
N205F12.
N210Z0.222/T.1
N215G81
N220X1.5Z1.
N225X2.Y2.
N230G80
N235X9.888Y9.777M08
N240T00
N245G98
N250M06
N255T0404
N260X9.888Y9.777M03
N265X2.5Y1.5
N270/Z0.1
N275F14.
N280Z/0.222Z0.1
N285G83
N290X1.5Z1.M08
N295X2.Y2.
N300G80
N305M05
N310M02
%
#< END OF MC-TEST >#
```

| Post name: | Bandit-1 |
|---|---|
| Post Source | Bandit-1 |
| Machine type: | Wells Index |
| Control: | Bandit 1 |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK |

```
#<MC-TEST  Mon Apr 09 09:20:07 2001'
N001&G70
N002M03
N003M07
N004G90
N005T101
N006/X0.573/Y1.95
N008/Z0.1
N009
N009F5.0
N010Z-0.122
N011X0.575
N012F10.0
N013X0.875Y2.25/Y2.25
N016Y3.
N017X1.Y3.125/X1.
N020X1.3584
N021X1.6038Y2.9228
N023X2.Y2.5964/X2./Y3.
N027X2.3962Y2.9228/Y3.
N030X2.6416Y3.125/X2.6416
N033X3.
N034X3.125Y3.
N036Y1.5
N037X2.5Y0.875
N039X1.5
N040X0.875Y1.5/Y1.5
N043Y2.25
N044X0.575Y2.55
N046X0.573
```

```
N047/Z0.1
N048/Z1.
N049/X9.888/Y9.777
N051T00
N052M06
N053T303
N054/X9.888/Y9.777
N056/X2.5/Y1.5
N058/Z0.1G81
N060/Z0.1
N061/X1.5
N062/X2./Y2.
N064G80
N065
N065/X9.888/Y9.777
N067T00
N068M06
N069T404
N070/X9.888/Y9.777
N072/X2.5/Y1.5
N074/Z-0.122Z0.1G83
N077/Z0.1
N078/X1.5
N079/X2./Y2.
N081G80
N082T00
N083M09
N084M05
N085M02
#<  END OF MC-TEST >
```

| | |
|---|---|
| Post name: | bandit-4 |
| Post Source | bandit-4 |
| Machine type: | Generic Mill |
| Control: | Allen Bradley Bandit 4 |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK |

```
;MC-TEST
N1  ; 0.25 1/4 ENDMILL
N2G45O11;FIXTURE OFFSET
N3O1;TOOL LENGTH OFFSET
N4G00X0.573Y1.95
N5Z0.1
N6G01Z-0.122F5.0
N7G41
N8X0.575F10.0
N9G03X0.875Y2.25I0.575J2.25
N10G01Y3.
N11G02X1.Y3.125I1.J3.
N12G01X1.3584
N13G02X1.6038Y2.9228I1.3584J2.875
N14G03X2.3962I2.J3.
N15G02X2.6416Y3.125I2.6416J2.875
N16G01X3.
N17G02X3.125Y3.I3.J3.
N18G01Y1.5
N19G02X2.5Y0.875I2.5J1.5
N20G01X1.5
N21G02X0.875Y1.5I1.5J1.5
N22G01Y2.25
N23G03X0.575Y2.55I0.575J2.25
N24G40
N25G01X0.573
N26G00Z0.1
```

```
N27Z1.
N28G40
N29O00
N30  ; 0.125 1/8 SPOTTING DRILL
N31O3;TOOL LENGTH OFFSET
N32G00X2.5Y1.5
N33G00Z0.15
N34G81Z-0.122R0.1X2.5Y1.5F12.
N35X1.5
N36X2.Y2.
N37G80
N38Z1.
N39G40
N40O00
N41  ; 0.2 DRILL
N42O4;TOOL LENGTH OFFSET
N43G00X2.5Y1.5
N44G00Z0.15
N45G83Z-0.122R0.1X2.5Y1.5I0.1J0.075K0.01F14.
N46X1.5
N47X2.Y2.
N48G80
N49Z1.
N50G40
N51G45O0
N52X9.888Y9.777
N53M02
%
```

| | |
|---|---|
| Post name: | Bd-4000 |
| Post Source | Bd-4000 |
| Machine type: | Bostomatic VMC |
| Control: | Bd-4000 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Spindle speed is a percentage, has error checking. |

```
% MC-TEST

G90
G1X9.888Y9.777Z1.R
S10T1M3
G48R
G1X0.573Y1.95R
Z0.1R
M8
Z-0.122F5.
G41X0.575F10.
G3X0.875Y2.25I0.575J2.25
G1Y3.
G2X1.Y3.125I1.J3.
G1X1.3584
G2X1.6038Y2.9228I1.3584J2.875
G3X2.Y2.5964I2.J3.
X2.3962Y2.9228I2.J3.
G2X2.6416Y3.125I2.6416J2.875
G1X3.
G2X3.125Y3.I3.J3.
G1Y1.5
G2X2.5Y0.875I2.5J1.5
G1X1.5
G2X0.875Y1.5I1.5J1.5
G1Y2.25
G3X0.575Y2.55I0.575J2.25
G1G40X0.573
Z0.1R
Z1.R
G49R
```

```
M5
M9
/M0
T3M6
N2
X9.888Y9.777
S10T3M3
G48R
G1X2.5Y1.5R
X1.5R
X2.Y2.R
Z1.R
G49R
M5
/M0
T4M6
N3
X9.888Y9.777
S10T4M3
G48R
G1X2.5Y1.5R
X1.5R
X2.Y2.R
Z0.1R
Z1.R
G49R
M5
M9
/M0
T1M6
M30
```

Post name:              Boss10
Post Source             Boss10
Machine type:           Bridgeport VMC
Control:                Boss-10
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, some customization, has error checking.

```
%
N5G00G17G40G80G90G70G75
N10X9.888Y9.777
N15T1M26
N20S484M03
N25G00X0.573Y1.95M07
N30Z0.1
N35G01Z-0.122F5.
N40G41X0.575F10.
N45G03X0.875Y2.25I0.575J2.25
N50G01Y3.
N55G02X1.Y3.125I1.J3.
N60G01X1.3584
N65G02X1.6038Y2.9228I1.3584J2.875
N70G03X2.Y2.5964I2.J3.
N75X2.3962Y2.9228I2.J3.
N80G02X2.6416Y3.125I2.6416J2.875
N85G01X3.
N90G02X3.125Y3.I3.J3.
N95G01Y1.5
N100G02X2.5Y0.875I2.5J1.5
N105G01X1.5
N110G02X0.875Y1.5I1.5J1.5
N115G01Y2.25
N120G03X0.575Y2.55I0.575J2.25
N125G01G40X0.573
```

```
N130G00Z0.1
N135Z1.
N140X9.888Y9.777
N145T3M26
N150S765M03
N155G00X2.5Y1.5M09
N160Z0.1
N165G81X2.5Y1.5Z0.222F12.
N170X1.5
N175X2.Y2.
N180G80
N185Z1.
N190X9.888Y9.777
N195T4M26
N200S888M03
N205G00X2.5Y1.5M08
N210Z0.1
N215G83X2.5Y1.5Z0.222Z0.1F14.
N220X1.5
N225X2.Y2.
N230G80
N235G00Z0.1
N240Z1.M25
N245M02
E
```

Post name:                      Boss-10m
Post Source                Boss-10m
Machine type:            Bridgeport VMC-800
Control:                       Boss-10
Inch/Metric:              Inch
Circ interpolation:       Absolute IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:      yes
Post programmer notes:   Source code looks OK, has some customized codes.

```
G0G90G17G70;(VMC800)
T1M6;(0.25 DIA. ENDMILL)
S484M03
G00X0.573Y1.95M07
Z0.1
G01Z-0.122F5.
G41X0.575F10.
G03X0.875Y2.25I0.575J2.25
G01Y3.
G02X1.Y3.125I1.J3.
G01X1.3584
G02X1.6038Y2.9228I1.3584J2.875
G03X2.Y2.5964I2.J3.
X2.3962Y2.9228I2.J3.
G02X2.6416Y3.125I2.6416J2.875
G01X3.
G02X3.125Y3.I3.J3.
G01Y1.5
G02X2.5Y0.875I2.5J1.5
G01X1.5
G02X0.875Y1.5I1.5J1.5
G01Y2.25
G03X0.575Y2.55I0.575J2.25
G01G40X0.573
G00Z0.1
Z1.
G0G90G17G70
T3M6;(0.125 DIA. CENTER DRILL)
S765M03
G00X2.5Y1.5M09
Z0.1
G81X2.5Y1.5Z0.222F12.
X1.5
X2.Y2.
G80
Z1.
G0G90G17G70
T4M6;(0.2 DIA. DRILL)
S888M03
G00X2.5Y1.5M08
Z0.1
G83X2.5Y1.5Z0.222Z0.1F14.
X1.5
X2.Y2.
G80
G00Z0.1
M22
```

| | |
|---|---|
| Post name: | boss-5 |
| Post Source | boss-5 |
| Machine type: | Bridgeport Series II |
| Control: | Boss 5 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Other notes | Source code looks good, has error checking. |

```
%
N01 G70 G75 G90
N02 G0 T1 M6
N03 G0 X0.573 Y1.95
N04 S484 M3
N05 Z0.1
N06 G1 Z-0.122 F5.0
N07 G41 X0.575 Y1.95 F10.0
N08 G3 X0.875 Y2.25 I0.575 J2.25
N09 G1 Y3.
N10 G2 X1. Y3.125 I1. J3.
N11 G1 X1.3584
N12 G2 X1.6038 Y2.9228 I1.3584 J2.875
N13 G3 X2.3962 Y2.9228 I2. J3.
N14 G2 X2.6416 Y3.125 I2.6416 J2.875
N15 G1 X3.
N16 G2 X3.125 Y3. I3. J3.
N17 G1 Y1.5
N18 G2 X2.5 Y0.875 I2.5 J1.5
N19 G1 X1.5
N20 G2 X0.875 Y1.5 I1.5 J1.5
N21 G1 Y2.25
N22 G3 X0.575 Y2.55 I0.575 J2.25
N23 G1 X0.573
N24 G0 Z0.1
N25 M5
N26 G0 T3 M6
N27 G0 X2.5 Y1.5
N28 S765 M3
N29 Z0.1
N30 G81 Z0.222 F12.0
N31 X1.5
N32 X2. Y2.
N33 G80
N34 M5
N35 G0 T4 M6
N36 G0 X2.5 Y1.5
N37 S888 M3
N38 Z0.1
N39 G83 Z0.222 Z0.2 Z0.1 F14.0
N40 X1.5
N41 X2. Y2.
N42 G80
N43 G0 Z0.1
N44 M05 M2
E
```

| Post name: | Boss5-mc |
|---|---|
| Post Source | Boss5-mc |
| Machine type: | Bridgeport Series II |
| Control: | Boss 5 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. |

```
%
N05G0G90G80X9.888Y9.777T1M6
N10G75
N15G0X.573Y1.95
N20Z.1
N25G1Z-.122F50
N30G41X.575Y1.95F100
N35G3X.875Y2.25I.575J2.25
N40G1Y3.
N45G2X1.Y3.125I1.J3.
N50G1X1.3584
N55G2X1.6038Y2.9228I1.3584J2.875
N60G3X2.3962Y2.9228I2.J3.
N65G2X2.6416Y3.125I2.6416J2.875
N70G1X3.
N75G2X3.125Y3.I3.J3.
N80G1Y1.5
N85G2X2.5Y.875I2.5J1.5
N90G1X1.5
N95G2X.875Y1.5I1.5J1.5
N100G1Y2.25
N105G3X.575Y2.55I.575J2.25
N110G1G40X.573
N115G0Z.1
N120Z1.

N125G0G90T3M6
N130G0X2.5Y1.5
N135Z.1
N140G81Z.222F120
N145X1.5
N150X2.Y2.
N155G80
N160G0Z1.

N165G0G90T4M6
N170G0X2.5Y1.5
N175Z.1
N180G83Z.222Z.2Z.1F140
N185X1.5
N190X2.Y2.
N195G80
N200G0Z.1
N205G0Z1.
N210G0G90X9.888Y9.777M2
E
```

Post name:              Boss-6
Post Source             Boss-6
Machine type:           Bridgeport
Control:                Boss 6
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK.

```
%
N05G0G90G80X9.888Y9.777T1M6
N10G75
N15S484
N20G0X.573Y1.95
N25Z.1
N30G1Z-.122F5.
N35G41X.575Y1.95F10.
N40G3X.875Y2.25I.575J2.25
N45G1Y3.
N50G2X1.Y3.125I1.J3.
N55G1X1.3584
N60G2X1.6038Y2.9228I1.3584J2.875
N65G3X2.3962Y2.9228I2.J3.
N70G2X2.6416Y3.125I2.6416J2.875
N75G1X3.
N80G2X3.125Y3.I3.J3.
N85G1Y1.5
N90G2X2.5Y.875I2.5J1.5
N95G1X1.5
N100G2X.875Y1.5I1.5J1.5
N105G1Y2.25
N110G3X.575Y2.55I.575J2.25

N115G1G40X.573
N120G0Z.1
N125Z1.
N130G0G90G80X2.5Y1.5T3M6
N135S765
N140Z.1
N145G81X2.5Y1.5Z.222F12.
N150X1.5F12.
N155X2.Y2.
N160G80
N165G0Z1.
N170G0G90G80X2.5Y1.5T4M6
N175S888
N180Z.1
N185G83X2.5Y1.5Z.222Z.2Z.1F14.
N190X1.5F14.
N195X2.Y2.
N200G80
N205G0Z1.
N210G74
N215G0G90X9.888Y9.777Z.1M2
E
```

Post name:              Boss6-mc
Post Source:            Boss6-mc
Machine type:           Bridgeport Series II
Control:                Boss 6
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.

```
%
N05G0G90G80X9.888Y9.777T1M6
N10G75
N15S484
N20G0X.573Y1.95
N25Z.1
N30G1Z-.122F5.
N35G41X.575Y1.95F10.
N40G3X.875Y2.25I.575J2.25
N45G1Y3.
N50G2X1.Y3.125I1.J3.
N55G1X1.3584
N60G2X1.6038Y2.9228I1.3584J2.875
N65G3X2.3962Y2.9228I2.J3.
N70G2X2.6416Y3.125I2.6416J2.875
N75G1X3.
N80G2X3.125Y3.I3.J3.
N85G1Y1.5
N90G2X2.5Y.875I2.5J1.5
N95G1X1.5
N100G2X.875Y1.5I1.5J1.5
N105G1Y2.25
N110G3X.575Y2.55I.575J2.25
N115G1G40X.573
N120G0Z.1
N125Z1.

N130G0G90G80Z.1T3M6
N135S765
N140G0X2.5Y1.5
N145Z.1
N150G81X2.5Y1.5Z.222F12.
N155X1.5F12.
N160X2.Y2.
N165G80
N170G0Z1.

N175G0G90G80Z.1T4M6
N180S888
N185G0X2.5Y1.5
N190Z.1
N195G83X2.5Y1.5Z.222Z.2Z.1F14.
N200X1.5F14.
N205X2.Y2.
N210G80
N215G0Z.1
N220G0Z1.
N225G0G90X9.888Y9.777M2
E
```

Post name:              boss7-mc
Post Source:            boss7-mc
Machine type:           Bridgeport Series II
Control:                Boss 6
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, has error checking.

```
%
N05G0G90G80X0.Y0.T1M6
N10G75
N15S484
N20G0X.573Y1.95
N25Z.1
N30G1Z-.122F5.
N35G41X.575Y1.95F10.
N40G3X.875Y2.25I.575J2.25
N45G1Y3.
N50G2X1.Y3.125I1.J3.
N55G1X1.3584
N60G2X1.6038Y2.9228I1.3584J2.875
N65G3X2.3962Y2.9228I2.J3.
N70G2X2.6416Y3.125I2.6416J2.875
N75G1X3.
N80G2X3.125Y3.I3.J3.
N85G1Y1.5
N90G2X2.5Y.875I2.5J1.5
N95G1X1.5
N100G2X.875Y1.5I1.5J1.5
N105G1Y2.25
N110G3X.575Y2.55I.575J2.25
N115G1G40X.573
N120G0Z.1
N125Z1.

N130G0G90G80Z.1T3M6
N135S765
N140G0X2.5Y1.5
N145Z.1
N150G81X2.5Y1.5Z.222F12.
N155X1.5F12.
N160X2.Y2.
N165G80
N170G0Z1.

N175G0G90G80Z.1T4M6
N180S888
N185G0X2.5Y1.5
N190Z.1
N195G83X2.5Y1.5Z.222Z.2Z.1F14.
N200X1.5F14.
N205X2.Y2.
N210G80
N215G0Z.1
N220G0Z1.
N225G0G90X0.Y0.M2
E
```

Post name:              boss-9m
Post Source             boss-9m
Machine type:           Bridgeport VMC-800
Control:                Boss 9
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, has error checking.

```
G0G90G17G70;'VMC800'
N100T1M6;'0.25 DIA. ENDMILL'
S484M03
G00X0.573Y1.95
Z0.1M08
G01Z-0.122F5.
G41X0.575F10.
G03X0.875Y2.25I0.575J2.25
G01Y3.
G02X1.Y3.125I1.J3.
G01X1.3584
G02X1.6038Y2.9228I1.3584J2.875
G03X2.Y2.5964I2.J3.
X2.3962Y2.9228I2.J3.
G02X2.6416Y3.125I2.6416J2.875
G01X3.
G02X3.125Y3.I3.J3.
G01Y1.5
G02X2.5Y0.875I2.5J1.5
G01X1.5
G02X0.875Y1.5I1.5J1.5
G01Y2.25
G03X0.575Y2.55I0.575J2.25
G01G40X0.573
```

```
G00Z0.1
Z1.
M01
G0G90G17G70
N200T3M6;'0.125 DIA. CENTER DRILL'
S765M03
G00X2.5Y1.5
Z0.1M08
G81X2.5Y1.5Z0.222F12.
X1.5
X2.Y2.
G80
Z1.
M01
G0G90G17G70
N300T4M6;'0.2 DIA. DRILL'
S888M03
G00X2.5Y1.5
Z0.1M08
G83X2.5Y1.5Z0.222Z0.1F14.
X1.5
X2.Y2.
G80
G00Z0.1M09
M22
```

| | |
|---|---|
| Post name: | Brg-dx32 |
| Post Source | Brg-dx32 |
| Machine type: | Bridgeport VMC |
| Control: | Boss-DX32 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, some customization, has error checking. |

```
%
:1;MC-TEST
N1G00G17G40G80G90G70G75
N100T1M6;T1 0.25 EM
N2M03S484
N3G00X.573Y1.95
N4Z.1
N5M08
N6G01Z-.122F5.0
N7G41X.575F10.0
N8G03X.875Y2.25I.575J2.25
N9G01Y3.0
N10G02X1.0Y3.125I1.0J3.0
N11G01X1.3584
N12G02X1.6038Y2.9228I1.3584J2.875
N13G03X2.0Y2.5964I2.0J3.0
N14X2.3962Y2.9228I2.0J3.0
N15G02X2.6416Y3.125I2.6416J2.875
N16G01X3.0
N17G02X3.125Y3.0I3.0J3.0
N18G01Y1.5
N19G02X2.5Y.875I2.5J1.5
N20G01X1.5
N21G02X.875Y1.5I1.5J1.5
N22G01Y2.25
N23G03X.575Y2.55I.575J2.25
N24G01G40X.573
N25G00Z.1
N300T3M6;T3 0.125 CENTER DRILL
N26M03S765
N27G00X2.5Y1.5
N28Z.1
N29G81X2.5Y1.5Z.222F12.0
N30X1.5
N31X2.0Y2.0
N32G80
N400T4M6;T4 0.2 DRILL
N33M03S888
N34G00X2.5Y1.5
N35Z.1
N36G83X2.5Y1.5Z.222Z.1F14.0
N37X1.5
N38X2.0Y2.0
N39G80
N40G00Z.1
N41M09
N42Z1.0
N43M22
```

| | |
|---|---|
| Post name: | brgprt-i |
| Post Source | brgprt-i |
| Machine type: | Bridgeport Mill |
| Control: | Series 1 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Mild customization, has error checking. |

```
;MC-TEST

DC1
~~~~~~~~~~~~~~~~%
N0001G90M25
N1001T01M06
N1002G00X0.573Y1.95S484M3
N1003Z0.1
N1004G01Z-0.122F5.
N1005G41X0.575F10.
N1006G03X0.875Y2.25I0.575J2.25
N1007G01Y3.0
N1008G02X1.0Y3.125I1.0J3.0
N1009G01X1.3584
N1010G02X1.6038Y2.9228I1.3584J2.875
N1011G03X2.3962I2.0J3.0
N1012G02X2.6416Y3.125I2.6416J2.875
N1013G01X3.0
N1014G02X3.125Y3.0I3.0J3.0
N1015G01Y1.5
N1016G02X2.5Y0.875I2.5J1.5
N1017G01X1.5
N1018G02X0.875Y1.5I1.5J1.5
N1019G01Y2.25
N1020G03X0.575Y2.55I0.575J2.25
```

```
N1021G01
N1022G0040X0.573
N1023G00Z0.1
N1024M25
N1025Z1.0
N1026T03M06
N1027G00X2.5Y1.5S765M3
N1028G81Z-0.122R0.1
N1029X1.5
N1030X2.0Y2.0
N1031G80
N1032M25
N1033T04M06
N1034G00X2.5Y1.5S888M3
N1035G83Z-0.122R0.1I0.1J0.075K0.01
N1036X1.5
N1037X2.0Y2.0
N1038G80
N1039M25
N1040M02

    %

DC1
```

Post name:                    brother
Post Source                   brother
Machine type:                 Brother VMC
Control:                      Brother
Inch/Metric:                  Inch
Circ interpolation:           Incremental IJ
Auto 1st T-POSITION?          yes
Canned drill cycles:          yes
Post programmer notes:        Source code looks Ok, has error checking.

```
%
O0001 (MC-TEST)
 T1 G100 (0.25 1/4 ENDMILL)
 G00 G90 G54 X0.573 Y1.95 S484 M03
 G43 H01 Z0.1 M08
 G01 Z-0.122 F5.0
 G41 D01 X0.575 F10.0
 G03 X0.875 Y2.25 I0.0 J0.3
 G01 Y3.0
 G02 X1.0 Y3.125 I0.125 J0.0
 G01 X1.3584
 G02 X1.6038 Y2.9228 I0.0 J-0.25
 G03 X2.3962 Y2.9228 I0.3962 J0.0772
 G02 X2.6416 Y3.125 I0.2454 J-0.0478
 G01 X3.0
 G02 X3.125 Y3.0 I0.0 J-0.125
 G01 Y1.5
 G02 X2.5 Y0.875 I-0.625 J0.0
 G01 X1.5
 G02 X0.875 Y1.5 I0.0 J0.625
 G01 Y2.25
 G03 X0.575 Y2.55 I-0.3 J0.0
 G01 G40 X0.573
 G00 Z0.1
 M09
 M01
 T3 G100 (0.125 1/8 CENTER DRILL)
 G00 G90 G54 X2.5 Y1.5 S765 M03
 G43 H03 Z0.1
 G81 X2.5 Y1.5 Z-0.122 R0.1 F12.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 M01
 T4 G100 (0.2 DRILL)
 G00 G90 G54 X2.5 Y1.5 S888 M03
 G43 H04 Z0.1 M08
 G83 X2.5 Y1.5 Z-0.122 R0.1 Q0.1 F14.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 G00 Z0.1
 M01
 T1 G100
 M30
%
```

Post name:              Brpt-1
Post Source             Brpt-1
Machine type:           Bridgeport Series 1
Control:                Bridgeport
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK.

```
#< MC-TEST  Mon Apr 09 09:29:37 2001'%
:0000
N5G0G90X9.888Y9.777T1M6
N10S484
N15G0X0.573Y1.95
N20Z0.1
N25G1Z-0.122F50
N30G41X0.575F100
N35G3G99X0.875Y2.25I0.J0.3
N40G1Y3.
N45G2G99X1.Y3.125I0.125J0.
N50G1X1.3584
N55G2G99X1.6038Y2.9228I0.J0.25
N60G3G99X2.Y2.5964I0.3962J0.0772
N65G99X2.3962Y2.9228I0.J0.4036
N70G2G99X2.6416Y3.125I0.2454J0.0478
N75G1X3.
N80G2G99X3.125Y3.I0.J0.125
N85G1Y1.5
N90G2G99X2.5Y0.875I0.625J0.
N95G1X1.5
N100G2G99X0.875Y1.5I0.J0.625
N105G1Y2.25
N110G3G99X0.575Y2.55I0.3J0.
N115G1G40X0.573
N120G0Z0.1
N125X9.888Y9.777M9T3M6
N130S765
N135G0X9.888Y9.777
N140X2.5Y1.5
N145Z0.1
N150G81X2.5Z0.222F120
N155X1.5
N160X2.Y2.
N165G80
N170X9.888Y9.777T4M6
N175S888
N180G0X9.888Y9.777
N185X2.5Y1.5
N190Z0.1
N195G83X2.5Z0.222Z0.1F140
N200X1.5
N205X2.Y2.
N210Z0.1
N215G80M02
E
```

| Post name: | cent-5 |
| Post Source | cent-5 |
| Machine type: | Milltronics |
| Control: | Centurion 5 |
| Inch/Metric: | Inch |
| Circ interpolation: and R | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, has error checking. |

```
#< MC-TEST  Mon Apr 09 09:29:37 2001'%
:0000
N5G0G90X9.888Y9.777T1M6
N10S484
N15G0X0.573Y1.95
N20Z0.1
N25G1Z-0.122F50
N30G41X0.575F100
N35G3G99X0.875Y2.25I0.J0.3
N40G1Y3.
N45G2G99X1.Y3.125I0.125J0.
N50G1X1.3584
N55G2G99X1.6038Y2.9228I0.J0.25
N60G3G99X2.Y2.5964I0.3962J0.0772
N65G99X2.3962Y2.9228I0.J0.4036
N70G2G99X2.6416Y3.125I0.2454J0.0478
N75G1X3.
N80G2G99X3.125Y3.I0.J0.125
N85G1Y1.5
N90G2G99X2.5Y0.875I0.625J0.
N95G1X1.5
N100G2G99X0.875Y1.5I0.J0.625
N105G1Y2.25
N110G3G99X0.575Y2.55I0.3J0.
N115G1G40X0.573
N120G0Z0.1
N125X9.888Y9.777M9T3M6
N130S765
N135G0X9.888Y9.777
N140X2.5Y1.5
N145Z0.1
N150G81X2.5Z0.222F120
N155X1.5
N160X2.Y2.
N165G80
N170X9.888Y9.777T4M6
N175S888
N180G0X9.888Y9.777
N185X2.5Y1.5
N190Z0.1
N195G83X2.5Z0.222Z0.1F140
N200X1.5
N205X2.Y2.
N210Z0.1
N215G80M02
E
```

| Post name: | cent-6sl |
|---|---|
| Post Source | cent-6sl |
| Machine type: | Milltronics |
| Control: | Centurion 6SL |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, mild customization. |

```
O0001
(MC-TEST)
 G20 G90
N100 G70 G50 G69 H0
 T1(1/4 0.25 ENDMILL)
 G0 G32
 G40 G80 M5
 X0 Y0
 M6
 G0 X.573 Y1.95
 M9
 M8
 S484 M3
 D1 G43 H1
 Z.1
 G1 Z-.122 F5.
 G41 X.575 F10.
 G3 X.875 Y2.25 J.3
 G1 Y3.0
 G2 X1.0 Y3.125 I.125
 G1 X1.3584
 G2 X1.6038 Y2.9228 J-.25
 G3 X2.3962 Y2.9228 I.3962 J.0772
 G2 X2.6416 Y3.125 I.2454 J-.0478
 G1 X3.0
 G2 X3.125 Y3.0 J-.125
 G1 Y1.5
 G2 X2.5 Y.875 I-.625
 G1 X1.5
 G2 X.875 Y1.5 J.625
 G1 Y2.25
 G3 X.575 Y2.55 I-.3
```

```
 G1 G40 X.573
 G0 Z.1
N300 G70 G50 G69 H0
 T3(1/8 0.125 CENTER DRILL)
 G0 G32
 G40 G80 M5 M9
 X0 Y0
 M6
 G0 X2.5 Y1.5
 S765 M3
 D3 G43 H3
 G81 F12. R.1 Z-.122 G99
 X1.5
 X2.0 Y2.0
 G80
N400 G70 G50 G69 H0
 T4( 0.2 DRILL)
 G0 G32
 G40 G80 M5
 X0 Y0
 M6
 G0 X2.5 Y1.5
 M9
 M8
 S888 M3
 D4 G43 H4
 G83 F14. Q.1 D.01 V.05 R.1 Z-.122 G99
 X1.5
 X2.0 Y2.0
 G80
 G0 Z.1 M9
 G32
(END OF O0001)
```

Post name:                   centroid
Post Source                  centroid
Machine type:                Centroid M-40 Mill
Control:                     CNC 3
Inch/Metric:                 Inch
Circ interpolation:          Absolute IJ
Auto 1st T-POSITION?         yes
Canned drill cycles:         yes
Post programmer notes:       Source code looks good.

```
 : MC-TEST  Mon Apr 09 09:31:35 2001'
G90G17G40
T1M6
:Tool 1 Width 0.25  ENDMILL
G43H1M25
M03S484
M8S484M3
G0X0.573Y1.95
Z0.1
G1F0
Z-0.122F5
G41D1
X0.575F10
G3X0.875Y2.25I0.575J2.25
G1Y3.0
G2X1.0Y3.125I1.0J3.0
G1X1.3584
G2X1.6038Y2.9228I1.3584J2.875
G3X2.3962Y2.9228I2.0J3.0
G2X2.6416Y3.125I2.6416J2.875
G1X3.0
G2X3.125Y3.0I3.0J3.0
G1Y1.5
G2X2.5Y0.875I2.5J1.5
G1X1.5
G2X0.875Y1.5I1.5J1.5
G1Y2.25
G3X0.575Y2.55I0.575J2.25
G40
G1X0.573
G0Z0.1
G49M25
```

```
X9.888Y9.777
T3M6
:Tool 3 Width 0.125  CENTER DRILL
G43H3M25
M03S765S765M3
G0X9.888Y9.777
X2.5Y1.5
Z0.1
G81G99
X2.5Y1.5Z-0.122R0.1F12
X1.5
X2.0Y2.0
G49M25
X9.888Y9.777
T4M6
:Tool 4 Width 0.2  DRILL
G43H4M25
M03S888
M8S888M3
G0X9.888Y9.777
X2.5Y1.5
Z0.1
G83G99
X2.5Y1.5Z-0.122R0.1F14
X1.5
X2.0Y2.0
G80
Z0.1
M5
M9
M2
```

Post name:              Cin-2100
Post Source             Cin-2100
Machine type:           Cincinnati Sabre MC
Control:                Cincinnati Acramatic 2100-E
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Highly customized

```
:(MSG, "PART: MC-TEST.VNC DATE:  Mon
Apr 09 09:33:14 2001'" )
(MSG, "TOOL 1: 0.25 DIA. ENDMILL" )
:G17G70G90G0T1M6
G0X0.573Y1.95Z1.0S484M3
M8
Z0.1
G1Z-0.122F5.0
G41G1X0.575F10.0
G3X0.875Y2.25I0.575J2.25
G1Y3.0
G2X1.0Y3.125I1.0J3.0
G1X1.3584
G2X1.6038Y2.9228I1.3584J2.875
G3X2.0Y2.5964I2.0J3.0
X2.3962Y2.9228I2.0J3.0
G2X2.6416Y3.125I2.6416J2.875
G1X3.0
G2X3.125Y3.0I3.0J3.0
G1Y1.5
G2X2.5Y0.875I2.5J1.5
G1X1.5
G2X0.875Y1.5I1.5J1.5
G1Y2.25
G3X0.575Y2.55I0.575J2.25
G40G1X0.573
G0Z0.1
M1
(MSG, "OPERATION 1:  " )
(MSG, "WORKGROUP" )
(MSG, "TOOL 3: 0.125 DIA. CENTER DRILL" )
:G17G70G90G0T3M6
G0X2.5Y1.5Z1.0S765M3
G81R0.1Z-0.222F12.0
X1.5
X2.0Y2.0
G80
G0Z1.
M1
(MSG, "OPERATION 2:  " )
(MSG, "WORKGROUP" )
(MSG, "TOOL 4: 0.2 DIA. DRILL" )
:G17G70G90G0T4M6
G0X2.5Y1.5Z1.0S888M3
M8
G83R0.1Z-0.222K0.1J13F14.0
X1.5
X2.0Y2.0
G80
G0Z1.
G0Z1.
G0G98Y20.Z15.
M2
```

| Post name: | cin2100k |
|---|---|
| Post Source | cin2100k |
| Machine type: | Cincinnati Sabre 750 |
| Control: | Cincinnati Acramatic 2100 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. Mild custom Some hardcoding |

```
:(PGM, NAME="MC-TEST.VNC", ID="0",
TYPE="A2100_274")
:1 G17 G70 G90 G94 G97 G0 T1M6
(MSG, TOOL 1: 0.25 DIA. ENDMILL )
 G0 X0.573 Y1.95 Z1.0 S484M3 H1
 M8
 Z0.1
 G1 Z-0.122 F5.0
 G41 G1 X0.575 F10.0
 G3 X0.875 Y2.25 I0.575 J2.25
 G1 Y3.0
 G2 X1.0 Y3.125 I1.0 J3.0
 G1 X1.3584
 G2 X1.6038 Y2.9228 I1.3584 J2.875
 G3 X2.0 Y2.5964 I2.0 J3.0
 X2.3962 Y2.9228 I2.0 J3.0
 G2 X2.6416 Y3.125 I2.6416 J2.875
 G1 X3.0
 G2 X3.125 Y3.0 I3.0 J3.0
 G1 Y1.5
 G2 X2.5 Y0.875 I2.5 J1.5
 G1 X1.5
 G2 X0.875 Y1.5 I1.5 J1.5
 G1 Y2.25
 G3 X0.575 Y2.55 I0.575 J2.25
```

```
 G40 G1 X0.573
 G0 Z0.1
 M1
:2 G17 G70 G90 G94 G97 G0 T3M6
(MSG, TOOL 3: 0.125 DIA. CENTER DRILL )
 G0 X2.5 Y1.5 Z1.0 S765M3 H1
 G81 R0.1 Z-0.222 F12.0
 X1.5
 X2.0 Y2.0
 G80
 G0 Z1.
 M1
:3 G17 G70 G90 G94 G97 G0 T4M6
(MSG, TOOL 4: 0.2 DIA. DRILL )
 G0 X2.5 Y1.5 Z1.0 S888M3 H1
 M8
 G83 R0.1 Z-0.222 K0.1 J13 F14.0
 X1.5
 X2.0 Y2.0
 G80
 G0 Z1.
 G0 Z1.
 G0 Z5.
 G0 Z5.
 G28 P4
 M02
```

| Post name: | Cin-4ax |
|---|---|
| Post Source | Cin-4ax |
| Machine type: | Cincinnati Sabre 750 |
| Control: | Cincinnati Acramatic 850SX |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, has a rotary table with inverse feedrate. Mild custom |

```
 :Q1
 (MSG, MC-TEST)
 (MSG,)

 (MSG, T1 0.25 ENDMILL)
 :1T01M6
N1G00X0.573Y1.95S484M13
N2Z0.1
N3G01Z-0.122F5.0
N4G41X0.575F10.0
N5G03X0.875Y2.25I0.575J2.25
N6G01Y3.0
N7G02X1.0Y3.125I1.0J3.0
N8G01X1.3584
N9G02X1.6038Y2.9228I1.3584J2.875
N10G03X2.0Y2.5964I2.0J3.0
N11X2.3962Y2.9228I2.0J3.0
N12G02X2.6416Y3.125I2.6416J2.875
N13G01X3.0
N14G02X3.125Y3.0I3.0J3.0
N15G01Y1.5
N16G02X2.5Y0.875I2.5J1.5
N17G01X1.5
N18G02X0.875Y1.5I1.5J1.5
N19G01Y2.25
N20G03X0.575Y2.55I0.575J2.25
N21G01G40X0.573
```

```
N22G00Z0.1
N23Z1.0
N24(CLS,L1)
N25M01

 (MSG, T3 0.125 CENTER DRILL)
 :3T03M6
N26G00X9.888Y9.777S765M03
N27X2.5Y1.5
N28G81R0.1Z-0.222F12.0
N29X1.5
N30X2.0Y2.0
N31G80
N32(CLS,L1)
N33M01

 (MSG, T4 0.2 DRILL)
 :4T04M6
N34G00X9.888Y9.777S888M13
N35X2.5Y1.5
N36G83R0.1Z-0.222K0.1F14.0
N37X1.5
N38X2.0Y2.0
N39G80
N40(CLS,L1)
N41M00
N42G11L-1
^@
```

```
Post name:              Cin850mc
Post Source             Cin850
Machine type:           Cincinnati Sabre 750MC
Control:                Cincinnati Acramatic 850
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK, mild customization.
```

```
%
:Q01
:T01M6
:1(MSG, LEFT VICE H01)
N2(MSG,  1/4 0.25 ENDMILL  T01)
N3H01G0X0.573Y1.95Z1.0S484M3
N4M8
N5Z0.1
N6G1Z-0.122F5.0
N7(MSG, CUTTER COMP.)
N8G41X0.575F10.0
N9G3X0.875Y2.25I0.575J2.25
N10G1Y3.0
N11G2X1.0Y3.125I1.0J3.0
N12G1X1.3584
N13G2X1.6038Y2.9228I1.3584J2.875
N14G3X2.3962I2.0J3.0
N15G2X2.6416Y3.125I2.6416J2.875
N16G1X3.0
N17G2X3.125Y3.0I3.0J3.0
N18G1Y1.5
N19G2X2.5Y0.875I2.5J1.5
N20G1X1.5
N21G2X0.875Y1.5I1.5J1.5
N22G1Y2.25
N23G3X0.575Y2.55I0.575J2.25
N24G1G40X0.573
N25G0Z0.1
N26G00Z1.0M9
N27M1

:T03M6
N28(MSG, LEFT VICE H01)
N29(MSG,  1/8 0.125 CENTER DRILL  T03)
N30H01G0X2.5Y1.5Z1.0S765M3
N31G81R0.1Z-0.222F12.0
N32X1.5
N33X2.0Y2.0
N34G80
N35G00Z1.0
N36M1

:T04M6
N37(MSG, LEFT VICE H01)
N38(MSG,  0.2 DRILL  T04)
N39H01G0X2.5Y1.5Z1.0S888M3
N40M8
N41G83J1R0.1Z-0.222K0.1F14.0
N42X1.5
N43X2.0Y2.0
N44G80
N45G00Z1.0M05
N46G98G0X35.00Y19.50Z25.00
N47M0
N48G98G0X5.00Y19.50Z25.00
N49M0
/N50M02
N51G11L-01
N52
%
```

| | |
|---|---|
| Post name: | Cin850sx |
| Post Source | Cin850sx |
| Machine type: | Cincinnati Sabre 750 |
| Control: | Cincinnati Acramatic 850SX |
| Inch/Metric: | Inch |
| Circ interpolation: | P-word for radius |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, has axis indexing. |

```
%
:G70G90G0T01M6
N0010(MSG, T1 0.25 ENDMILL)
N0020(MSG, MC-TEST)
N0030(MSG, Mon Apr 09 09:35:30 2001')
N0040G00X0.573Y1.95S484M3
N0050Z0.1M8
N0060G01Z-0.122F5.0
N0070G41X0.575F10.0
N0080G03X0.875Y2.25P0.3
N0090G01Y3.0
N0100G02X1.0Y3.125P0.125
N0110G01X1.3584
N0120G02X1.6038Y2.9228P0.25
N0130G03X2.0Y2.5964P0.4036
N0140X2.3962Y2.9228P0.4036
N0150G02X2.6416Y3.125P0.25
N0160G01X3.0
N0170G02X3.125Y3.0P0.125
N0180G01Y1.5
N0190G02X2.5Y0.875P0.625
N0200G01X1.5
N0210G02X0.875Y1.5P0.625
N0220G01Y2.25
N0230G03X0.575Y2.55P0.3
```

```
N0240G01G40X0.573
N0250G00Z0.1M09
:G0T03M6
N0260(MSG, T3 0.125 CENTER DRILL)
N0270M01
N0280G00X9.888Y9.777S765M3
N0290X2.5Y1.5
N0300Z0.1
N0310G81R0.1Z-0.222F12.0
N0320X1.5
N0330X2.0Y2.0
N0340G80
:G0T04M6
N0350(MSG, T4 0.2 DRILL)
N0360M01
N0370G00X9.888Y9.777S888M3
N0380X2.5Y1.5
N0390Z0.1M8
N0400G83J1R0.1Z-0.222K0.1F14.0
N0410X1.5
N0420X2.0Y2.0
N0430G80M09
N0440M2M26
%
```

Post name:              Cin900mc
Post Source             Cin900mc
Machine type:           Cincinnati T-10 Machining Center
Control:                Cincinnati Acramatic 900
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, mild customization, has B-axis support.

```
%                                              N20G3X05750Y25500I05750J22500
(MSG,000001-)                                  N21G1G40X05730
(MSG,)                                         N22G0Z01000
(MSG,OPERATION )                               N23G00Z10000M9
(MSG,REV. )                                    N24M1
(MSG,CINCINNATI T10  )
(MSG,DNC# 1.TAP)                               O25G0T3M6
O1G0T1M6                                        (MSG, TOOL 3 -  1/8 0.125 CENTER DRILL)
 (MSG, TOOL 1 -  1/4 0.25 ENDMILL)             O26G0X25000Y15000B0H1S765T4M3
O2G0X05730Y19500B0H1S484T3M3M8                 N27G81X25000Y15000R01000Z-02220F120
N3Z01000                                       N28X15000
N4G1Z-01220F050                                N29X20000Y20000
N5G41X05750F100                                N30G80
N6G3X08750Y22500I05750J22500                   N31G00Z10000
N7G1Y30000                                     N32M1
N8G2X10000Y31250I10000J30000
N9G1X13584                                     O33G0T4M6
N10G2X16038Y29228I13584J28750                   (MSG, TOOL 4 -  0.2 DRILL)
N11G3X23962I20000J30000                        O34G0X25000Y15000B0H1S888T1M3M8
N12G2X26416Y31250I26416J28750                  N35G83X25000Y15000R01000Z-02220K01000F140
N13G1X30000                                    N36X15000
N14G2X31250Y30000I30000J30000                  N37X20000Y20000
N15G1Y15000                                     N38G80
N16G2X25000Y08750I25000J15000                  N39G00Z10000M05
N17G1X15000                                    N40M02
N18G2X08750Y15000I15000J15000                  %
N19G1Y22500
```

```
:T1M6
 (MSG, "TOOL 1: 0.25 DIA. ENDMILL" )
G90S484M13
G0H1X0Y0Z1.0H1
G0X0.573Y1.95
M8
Z0.1
G1Z-0.122F5.0
G41G1X0.575F10.0
G3X0.875Y2.25I0.575J2.25
G1Y3.0
G2X1.0Y3.125I1.0J3.0
G1X1.3584
G2X1.6038Y2.9228I1.3584J2.875
G3X2.0Y2.5964I2.0J3.0
X2.3962Y2.9228I2.0J3.0
G2X2.6416Y3.125I2.6416J2.875
G1X3.0
G2X3.125Y3.0I3.0J3.0
G1Y1.5
G2X2.5Y0.875I2.5J1.5
G1X1.5
G2X0.875Y1.5I1.5J1.5
G1Y2.25
G3X0.575Y2.55I0.575J2.25
G40G1X0.573
G0Z0.1
Z1.0
:T3M6
M1
```

```
(MSG, "TOOL 3: 0.125 DIA. CENTER DRILL"
)
G90S765M13
G0H1X0Y0Z1.0H1
G0X2.5Y1.5
Z0.1
G81Z-0.122R0.1F12.0
X1.5
X2.0Y2.0
G80
G0Z2.
:T4M6
M1

(MSG, "TOOL 4: 0.2 DIA. DRILL" )
G90S888M13
G0H1X0Y0Z1.0H1
G0X2.5Y1.5
M8
Z0.1
G83Z-0.122R0.1J13K0.0F14.0
X1.5
X2.0Y2.0
G80
G0Z2.
G0G98X10.Y20.
M5
:T1M6
M2
%
```

| Post name: | Cinc950m |
| Post Source | Cinc950m |
| Machine type: | Cincinnati Maxim-630 |
| Control: | Cincinnati Acramatic 950MC |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, highly customized, has full rotary and indexing. |

```
%
:5G70G90
N10(MSG, MC-TEST)
N15(MSG,PN-MC-TEST)
N20(MSG, NEW PROGRAM-DELETE THIS LINE
ONCE RUNNING)
N25(MSG, TOOL 1 -  1/4 0.25 ENDMILL D-
1)
:30G0T1M6
:35G0X0.573Y1.95Z1.0B0.0S484M03D1H1M8
N40G0T3
N45Z0.1
N50G1Z-0.122F5.0
N55G41X0.575F10.0
N60G3X0.875Y2.25I0.575J2.25
N65G1Y3.0
N70G2X1.0Y3.125I1.0J3.0
N75G1X1.3584
N80G2X1.6038Y2.9228I1.3584J2.875
N85G3X2.3962I2.0J3.0
N90G2X2.6416Y3.125I2.6416J2.875
N95G1X3.0
N100G2X3.125Y3.0I3.0J3.0
N105G1Y1.5
N110G2X2.5Y0.875I2.5J1.5
N115G1X1.5
N120G2X0.875Y1.5I1.5J1.5
N125G1Y2.25
N130G3X0.575Y2.55I0.575J2.25
N135G1G40X0.573
N140G0Z0.1
N145G00Z1.0M9
N150(MSG, TOOL 3 -  1/8 0.125 CENTER
DRILL D-1)
:155G0T3M6
:160G0X2.5Y1.5Z1.0B0.0S765M03D1H1
N165G0T4
N170G81X2.5Y1.5R0.1Z-0.122F12.0
N175X1.5
N180X2.0Y2.0
N185G80
N190G00Z1.0
N195(MSG, TOOL 4 -  0.2 DRILL D-1)
:200G0T4M6
:205G0X2.5Y1.5Z1.0B0.0S888M03D1H1M27
N210G0T4
N215G83X2.5Y1.5R0.1Z-0.122K0.1F14.0
N220X1.5
N225X2.0Y2.0
N230G80
N235Z0.1
N240G00Z1.0M05
N245M2M52
%
```

Post name:              cinc-fnc
Post Source             cinc-fnc
Machine type:           Cincinnati Milacron Arrow
Control:                CPS Ltd. FNC
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK, has error checking.

```
G55 G40 G70 G90                              Z1.0
 M6 T1 G0  (1/4 0.25 ENDMILL)
 G43 H1 S484 M13                             G55 G40 G70 G90
 X.573 Y1.95                                 M6 T3 G0  (1/8 0.125 CENTER DRILL)
 Z.1                                         G43 H3 S765 M13
 G1 Z-.122 F5.0                              X2.5 Y1.5
 G41                                         G81 G98 X2.5 Y1.5 Z-.122 R.1 F12.0
 X.575 F10.0                                 X1.5
 G3 X.875 Y2.25 I.0 J.3                      X2.0 Y2.0
 G1 Y3.0                                     G80
 G2 X1.0 Y3.125 I.125 J.0                    G40
 G1 X1.3584                                  G0 Z1.0
 G2 X1.6038 Y2.9228 I.0 J-.25
 G3 X2.3962 I.3962 J.0772                    G55 G40 G70 G90
 G2 X2.6416 Y3.125 I.2454 J-.0478            M6 T4 G0  (0.2 DRILL)
 G1 X3.0                                     G43 H4 S888 M13
 G2 X3.125 Y3.0 I.0 J-.125                   X2.5 Y1.5
 G1 Y1.5                                     G83 G98 X2.5 Y1.5 Z-.122 R.1 Q.1 F14.0
 G2 X2.5 Y.875 I-.625 J.0                    X1.5
 G1 X1.5                                     X2.0 Y2.0
 G2 X.875 Y1.5 I.0 J.625                     G80
 G1 Y2.25                                    Z.1
 G3 X.575 Y2.55 I-.3 J.0                     G0 Z2.0
 G1 X.573                                    G53 X9.888 Y9.777
 G0 Z.1                                      M30
 G40
```

| | |
|---|---|
| Post name: | Cin-sabr |
| Post Source | Cin-sabr |
| Machine type: | Cincinnati Sabre |
| Control: | Acramatic 850 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. |

```
:0001G70G90G17G0T01M6
N0010G00X0.573Y1.95S484M3
N0020Z0.1
N0030G01Z-0.122F5.0M7
N0040G41X0.575F10.0
N0050G03X0.875Y2.25I0.575J2.25
N0060G01Y3.0
N0070G02X1.0Y3.125I1.0J3.0
N0080G01X1.3584
N0090G02X1.6038Y2.9228I1.3584J2.875
N0100G03X2.0Y2.5964I2.0J3.0
N0110X2.3962Y2.9228I2.0J3.0
N0120G02X2.6416Y3.125I2.6416J2.875
N0130G01X3.0
N0140G02X3.125Y3.0I3.0J3.0
N0150G01Y1.5
N0160G02X2.5Y0.875I2.5J1.5
N0170G01X1.5
N0180G02X0.875Y1.5I1.5J1.5
N0190G01Y2.25
N0200G03X0.575Y2.55I0.575J2.25
N0210G01G40X0.573
N0220G00Z0.1
:0230G0T03M6
N0240G00X9.888Y9.777S765M3M9
N0250X2.5Y1.5
N0260G81R0.1Z-0.222F12.0
N0270X1.5
N0280X2.0Y2.0
N0290G80
:0300G0T04M6
N0310G00X9.888Y9.777S888M3M8
N0320X2.5Y1.5
N0330G83R0.1Z-0.222K0.1F14.0
N0340X1.5
N0350X2.0Y2.0
N0360G80
N0370G00Z0.1
N0380M02
%
```

Post name:                 cnc-7
Post Source                cnc-7
Machine type:              Centroid M-40 Mill
Control:                   CNC 3
Inch/Metric:               Inch
Circ interpolation:        Absolute IJ
Auto 1st T-POSITION?       Not supported
Canned drill cycles:       yes
Post programmer notes:     Source code looks OK.

```
: MC-TEST  Mon Apr 09 09:40:33 2001'       X9.888Y9.777
G90G17G40                                   T3M6
T1M6                                        :Tool 3 Width 0.125  CENTER DRILL
:Tool 1 Width 0.25  ENDMILL                 G43H3M25
G43H1M25                                    M03S765S765M3
M03S484                                     G0X9.888Y9.777
M8S484M3                                    X2.5Y1.5
G0X0.573Y1.95                               Z0.1
Z0.1                                        G81G99
G1F0                                        X2.5Y1.5Z-0.122R0.1F12
Z-0.122F5                                   X1.5
G41D1                                       X2.0Y2.0
X0.575F10                                   G49M25
G3X0.875Y2.25I0.575J2.25                    X9.888Y9.777
G1Y3.0                                      T4M6
G2X1.0Y3.125I1.0J3.0                        :Tool 4 Width 0.2  DRILL
G1X1.3584                                    G43H4M25
G2X1.6038Y2.9228I1.3584J2.875               M03S888
G3X2.3962Y2.9228I2.0J3.0                     M8S888M3
G2X2.6416Y3.125I2.6416J2.875                 G0X9.888Y9.777
G1X3.0                                       X2.5Y1.5
G2X3.125Y3.0I3.0J3.0                         Z0.1
G1Y1.5                                       G83G99
G2X2.5Y0.875I2.5J1.5                         X2.5Y1.5Z-0.122R0.1F14
G1X1.5                                       X1.5
G2X0.875Y1.5I1.5J1.5                         X2.0Y2.0
G1Y2.25                                      G80
G3X0.575Y2.55I0.575J2.25                     Z0.1
G40                                          M5
G1X0.573                                     M9
G0Z0.1                                       M2
G49M25
```

| Post name: | comet |
|---|---|
| Post Source | comet |
| Machine type: | Comet |
| Control: | Mitsubishi |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, customized, has 4-axis support. |

```
%
O1 (MC-TEST)
G91G28Z0
N100(T01 1/4" ENDMILL 0.25)
M06T1
G54G90G00G40X.573Y1.95S484M03
M08
G43Z.1H01
G01Z-.122F5.
G41X.575F10.D21
G03X.875Y2.25J.3
G01Y3.0
G02X1.0Y3.125I.125
G01X1.3584
G02X1.6038Y2.9228J-.25
G03X2.3962Y2.9228I.3962J.0772
G02X2.6416Y3.125I.2454J-.0478
G01X3.0
G02X3.125Y3.0J-.125
G01Y1.5
G02X2.5Y.875I-.625
G01X1.5
G02X.875Y1.5J.625
G01Y2.25
G03X.575Y2.55I-.3
G01G40X.573
G00Z.1M09
G91G28Z0M19
M05
```

```
N300(T03 1/8" CENTER DRILL 0.125)
M06T3
G54G90G00G40X2.5Y1.5S765M03
G43Z.1H03
G99G81Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
G91G28Z0M19
M05

N400(T04 DRILL 0.2)
M06T4
G54G90G00G40X2.5Y1.5S888M03
M08
G43Z.1H04
G99G83Z-.122R.1Q.1F14.
X1.5
X2.0Y2.0
G80
G00Z.1
G00Z1.0M09
G91G28Z0M19
G28Y0
G90
M30
%
```

Post name: Comet520
Post Source Comet520
Machine type: Comet Mill
Control: Mitsubishi Meldas 520
Inch/Metric: Inch
Circ interpolation: Incremental IJ
Auto 1st T-POSITION? yes
Canned drill cycles: yes
Post programmer notes: Source code looks good, has error checking, minor customization.

```
%                                              M01
O1
 (MC-TEST  Mon Apr 09 09:43:18 2001')          N333 M06 T03
N111 M06 T01                                    G90
 G90                                            (T03-0.125-CENTER DRILL)
 (T01-0.25-ENDMILL)                             G00 G43 X2.5 Y1.5 Z1.0 H03
 G00 G43 X.573 Y1.95 Z1.0 H01 M8                S765 M03
 S484 M03                                       G81 G98 X2.5 Y1.5 Z-.122 R.1 F12.
 Z.1                                            X1.5
 G01 Z-.122 F5.                                 X2.0 Y2.0
 G41 X.575 F10. D01                             G80
 G03 X.875 Y2.25 J.3                            G0 G49 Z0. H00 M5
 G01 Y3.0                                       G53 Y0.
 G02 X1.0 Y3.125 I.125                          M01
 G01 X1.3584
 G02 X1.6038 Y2.9228 J-.25                      N444 M06 T04
 G03 X2.3962 Y2.9228 I.3962 J.0772              G90
 G02 X2.6416 Y3.125 I.2454 J-.0478              (T04-0.2-DRILL)
 G01 X3.0                                       G00 G43 X2.5 Y1.5 Z1.0 H04 M8
 G02 X3.125 Y3.0 J-.125                         S888 M03
 G01 Y1.5                                       G83 G98 X2.5 Y1.5 Z-.122 R.1 Q.1 F14.
 G02 X2.5 Y.875 I-.625                          X1.5
 G01 X1.5                                       X2.0 Y2.0
 G02 X.875 Y1.5 J.625                           G80
 G01 Y2.25                                      G00 Z.1 M09
 G03 X.575 Y2.55 I-.3                           G0 G49 Z0. H00 M5
 G01 G40 X.573                                  G53 Y0
 G00 Z.1 M09                                    M30
 G0 G49 Z0. H00 M5                             %
 G53 Y0.
```

| Post name: | Deckel |
|---|---|
| Post Source | Deckel |
| Machine type: | Deckel Mill |
| Control: | FP4NC |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Highly customized. |

```
%

($P01/0000)

N0001 G00 X-98880 Y-97770 Z+10000 T01

N0002 G00 X-5730 Y-19500 S+484

N0003 G00 Z+1000 D+01

N0004 G01 Z-1220 D+01 F127.

N0005 G01 G41 D+51 G47 A+1000 X-5750 Y-
19500 F254. G61 M61

N0006 G03 X-8750 Y-22500 I+0 J-3000

N0007 G01 Y-30000

N0008 G02 X-10000 Y-31250 I-1250 J+0

N0009 G01 X-13584

N0010 G02 X-16038 Y-29228 I+0 J+2500

N0011 G03 X-23962 Y-29228 I-3962 J-0772

N0012 G02 X-26416 Y-31250 I-2454 J+0478

N0013 G01 X-30000

N0014 G02 X-31250 Y-30000 I+0 J+1250

N0015 G01 Y-15000

N0016 G02 X-25000 Y-8750 I+6250 J+0

N0017 G01 X-15000

N0018 G02 X-8750 Y-15000 I+0 J-6250

N0019 G01 Y-22500

N0020 G03 X-5750 Y-25500 I+3000 J+0

N0021 G40 G47 A+1000

N0022 G01 X-5730
```

```
N0023 G00 Z+1000 D+01

N0024 G00 Z+10000

N0025 G00 X-98880 Y-97770 Z+10000 T03

N0026 G00 X-25000 Y-15000 S+765 M09

N0027 G00 Z+1000 D+03 S+765

N0028 G81 F30480 S+765 Z-1220

N0029 G00 X-15000

N0030 G81 F30480 S+765 Z-1220

N0031 G00 X-20000 Y-20000

N0032 G81 F30480 S+765 Z-1220

N0033 G00 Z+10000

N0034 G00 X-98880 Y-97770 Z+10000 T04

N0035 G00 X-25000 Y-15000 S+888 M08

N0036 G00 Z+1000 D+04 S+888

N0037 G83 F35560 S+888 Z-1220 Z+1000 Z-100

N0038 G00 X-15000

N0039 G83 F35560 S+888 Z-1220 Z+1000 Z-100

N0040 G00 X-20000 Y-20000

N0041 G83 F35560 S+888 Z-1220 Z+1000 Z-100

N0042 G00 Z+1000

N0043 G00 Z+10000

N0044 M02


?

0000
```

Post name:              Dyna
Post Source             Dyna
Machine type:           GenericVMC
Control:                Bendix System 20
Inch/Metric:            Inch
Circ interpolation:     event
Auto 1st T-POSITION?    Yes
Canned drill cycles:    event
Post programmer notes:  Source code looks OK.

```
~~~~~~~~~~~~~~~~~~~~~~
N0005(9)M6T1$
N0010(9)M3S484$
N0015(0)X0.573Y1.95$
N0020(0)Z0.1$
N0025(9)M7$
N0030(1)Z-0.122F5.C0$
N0035(1)X0.575F10.C1$
N0040(2)X0.875Y2.25I0.575J2.25D1C1$
N0045(1)Y3.C1$
N0050(2)X1.Y3.125I1.J3.D0C1$
N0055(1)X1.3584C1$
N0060(2)X1.6038Y2.9228I1.3584J2.875D0C1$
N0065(2)X2.3962I2.J3.D1C1$
N0070(2)X2.6416Y3.125I2.6416J2.875D0C1$
N0075(1)X3.C1$
N0080(2)X3.125Y3.I3.J3.D0C1$
N0085(1)Y1.5C1$
N0090(2)X2.5Y0.875I2.5J1.5D0C1$
N0095(1)X1.5C1$
N0100(2)X0.875Y1.5I1.5J1.5D0C1$
N0105(1)Y2.25C1$
N0110(2)X0.575Y2.55I0.575J2.25D1C1$
N0115(1)X0.573C0$
N0120(0)Z0.1$
N0125(9)M6T3$
N0130(9)M3S765$
N0135(0)X9.888Y9.777$
N0140(0)X2.5Y1.5$
N0145(0)X2.5Y1.5Z-0.122F12.G1W0.1$
N0150(0)X1.5Y1.5$
N0155(0)X2.Y2.$
N0160(9)M6T4$
N0165(9)M3S888$
N0170(0)X9.888Y9.777$
N0175(0)X2.5Y1.5$
N0180(0)X2.5Y1.5Z-0.122F14.K0.1G3W0.1$
N0185(0)X1.5Y1.5$
N0190(0)X2.Y2.$
N0195(9)M30$
END$
```

| Post name: | Dyna-50M |
|---|---|
| Post Source | Dyna-50M |
| Machine type: | Generic Mill |
| Control: | Dynapath System 50 |
| Inch/Metric: | Inch |
| Circ interpolation: | event |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | event |
| Post programmer notes: | Source code looks good, mild customization. |

```
 (MC-TEST)$
 N0001(E)M06$
 N0002(E)M08$
 N0003(E)M03E1$
 N0004(T) T1 1/4 0.25 ENDMILL$
 N0005(E)X0.573Y1.95H1D1$
 N0006(E)G00Z0.1$
 N0007(E)Z-0.122F5.$
 N0008(E)X0.575F10.C1$
 N0009(E)G03X0.875Y2.25I0.575J2.25F10.$
 N0010(E)Y3.$
 N0011(E)G02X1.Y3.125I1.J3.F10.$
 N0012(E)X1.3584$
 N0013(E)G02X1.6038Y2.9228I1.3584J2.875F
 10.$
 N0014(E)G03X2.3962I2.J3.F10.$
 N0015(E)G02X2.6416Y3.125I2.6416J2.875F1
 0.$
 N0016(E)X3.$
 N0017(E)G02X3.125Y3.I3.J3.F10.$
 N0018(E)Y1.5$
 N0019(E)G02X2.5Y0.875I2.5J1.5F10.$
 N0020(E)X1.5$
 N0021(E)G02X0.875Y1.5I1.5J1.5F10.$
 N0022(E)Y2.25$
 N0023(E)G03X0.575Y2.55I0.575J2.25F10.$
 N0024(E)X0.573C0$
 N0025(E)G00Z0.1$
 N0026(E)M06$
 N0027(E)M08$
 N0028(E)M03E1$
 N0029(T) T3 1/8 0.125 CENTER DRILL$
 N0030(E)X2.5Y1.5H3D3$
 N0031(E)G00Z0.1$
 N0032(E)G81X2.5Y1.5Z-0.122R0.1F12.$
 N0033(E)X1.5Y1.5$
 N0034(E)X2.Y2.$
 N0035(E)G80Z0.1$
 N0036(E)M06$
 N0037(E)M08$
 N0038(E)M03E1$
 N0039(T) T4 0.2 DRILL$
 N0040(E)X2.5Y1.5H4D4$
 N0041(E)G00Z0.1$
 N0042(E)G83X2.5Y1.5Z-0.122R0.1K0.1F14.$
 N0043(E)X1.5Y1.5$
 N0044(E)X2.Y2.$
 N0045(E)G80Z0.1$
 N0046(E)Z0.1$
 N0047(E)G80Z0.1$
 N0048(E)M06$
 N0049(E)M30$
 END$
```

Post name:            dyna-mit
Post Source           dyna-mit
Machine type:         Dyna Mechtronics VMC
Control:              Mitsubushi Meldas
Inch/Metric:          Inch
Circ interpolation:   Incremental IJ
Auto 1st T-POSITION?  yes
Canned drill cycles:  yes
Post programmer notes:  Source code looks good, has some error checking

```
%                                      N125 G0 Z0.1 M09
O0001                                  N130 G28 Z0.0
 (MC-TEST)                             N135 T3 M06
N5 G90 G80 G17 G40                     (1/8" CENTER DRILL)
N10 T1 M06                             N140 S765 M3
 (1/4" ENDMILL)                        N145 G54
N15 S484 M3                            N150 G0 G90 X2.5 Y1.5
N20 G54                                N155 G43 Z0.1 H3
N25 G0 G90 X0.573 Y1.95                N160 G81 Z-0.122 R0.1 F12.0
N30 G43 Z0.1 M08 H1                    N165 X1.5
N35 G1 Z-0.122 F5.0                    N170 X2.0 Y2.0
N40 G41 D01 X0.575 F10.0               N175 G80
N45 G3 X0.875 Y2.25 I0.0 J0.3          N180 G28 Z0.0
N50 G1 Y3.0                            N185 T4 M06
N55 G2 X1.0 Y3.125 I0.125 J0.0         (0.2 DRILL)
N60 G1 X1.3584                         N190 S888 M3
N65 G2 X1.6038 Y2.9228 I0.0 J-0.25     N195 G54
N70 G3 X2.3962 Y2.9228 I0.3962 J0.0772 N200 G0 G90 X2.5 Y1.5
N75 G2 X2.6416 Y3.125 I0.2454 J-0.0478 N205 G43 Z0.1 H4 M08
N80 G1 X3.0                            N210 G83 Z-0.122 R0.1 Q0.1 F14.0
N85 G2 X3.125 Y3.0 I0.0 J-0.125        N215 X1.5
N90 G1 Y1.5                            N220 X2.0 Y2.0
N95 G2 X2.5 Y0.875 I-0.625 J0.0        N225 G80
N100 G1 X1.5                           N230 G0 Z0.1 M09
N105 G2 X0.875 Y1.5 I0.0 J0.625        N235 G28 Z0.0
N110 G1 Y2.25                          N240 G30 Y0.0
N115 G3 X0.575 Y2.55 I-0.3 J0.0        N245 M30
N120 G1 G40 X0.573                     %
```

| Post name: | Ecocut |
|---|---|
| Post Source | Ecocut |
| Machine type: | Sharmann Mill |
| Control: | Sinumerik 8M/8MC |
| Inch/Metric: | Both |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks Ok, customized coolant, inch-metric support |

```
%0
N100 G0 G70 G90 G95
N110 L6 T01(T01 ENDMILL 0.25)
N120 M03 S484 F0.0 T03
N130 G0 G55 X0.573 Y1.95 M58 M08
N140 G43 D01 Z1.0
N150 G1 Z0.1 F5.0
N160 Z-0.122 F10.0
N170 G41 D101 X0.575 Y1.95
N180 G3 X0.875 Y2.25 I0.0 J0.3
N190 G1 Y3.0
N200 G2 X1.0 Y3.125 I0.125 J0.0
N210 G1 X1.3584
N220 G2 X1.6038 Y2.9228 I0.0 J-0.25
N230 G3 X2.3962 I0.3962 J0.0772
N240 G2 X2.6416 Y3.125 I0.2454 J-0.0478
N250 G1 X3.0
N260 G2 X3.125 Y3.0 I0.0 J-0.125
N270 G1 Y1.5
N280 G2 X2.5 Y0.875 I-0.625 J0.0
N290 G1 X1.5
N300 G2 X0.875 Y1.5 I0.0 J0.625
N310 G1 Y2.25
N320 G3 X0.575 Y2.55 I-0.3 J0.0
N330 G1 G40 X0.573 Y2.55
N340 G1 Z0.1 F5.0
N350 M9
N360 L6 T03(T03 CENTER DRILL 0.125)
N370 M03 S765 F12.0 T04
N380 G0 G55 X9.888 Y9.777
N390 X2.5 Y1.5
N400 G43 D03 Z1.0
N410 G81 R02 0.1 R03 -0.122 R10 1.0 R11 3
N420 X1.5
N430 X2.0 Y2.0
N440 G80
N450 L6 T04(T04 DRILL 0.2)
N460 M03 S888 F14.0 T98
N470 G0 G55 X9.888 Y9.777 M51 M08
N480 X2.5 Y1.5
N490 G43 D04 Z1.0
N500 G83 R02 0.1 R03 -0.122 R00 0 R01 0.1 R05 0.1 R10 1.0 R11 3
N510 X1.5
N520 X2.0 Y2.0
N530 G80
N540 G0 Z0.1
N550 M09 M05
N560 M02
%
```

| Post name: | Eks-gn1 |
|---|---|
| Post Source | Eks-gn1 |
| Machine type: | Ekstrom Carlson |
| Control: | GN 7M |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. Forces 4 decimal places |

```
#< MC-TEST  Mon Apr 09 09:47:05 2001'
:5G70G90G00G17G40G80M05
N10T01M06
N15G00G90G17X.5730Y1.9500F0.M03
N20G44D01Z.1000
N25G01Z-.1220F5.
N30G41D09X.5750F10.
N35G03X.8750Y2.2500I.0000J.3000
N40G01Y3.0000
N45G02X1.0000Y3.1250I.1250J.0000
N50G01X1.3584
N55G02X1.6038Y2.9228I.0000J-.2500
N60G03X2.3962I.3962J.0772
N65G02X2.6416Y3.1250I.2454J-.0478
N70G01X3.0000
N75G02X3.1250Y3.0000I.0000J-.1250
N80G01Y1.5000
N85G02X2.5000Y.8750I-.6250J.0000
N90G01X1.5000
N95G02X.8750Y1.5000I.0000J.6250
N100G01Y2.2500
N105G03X.5750Y2.5500I-.3000J.0000
N110G01G40X.5730
N115G00Z.1000
N120G44D00Z.0000
N125X9.8880Y9.7770Z1.0000F12.
:130T03M06
N135G00G90G17X2.5000Y1.5000F12.M03
N140G44D03Z.1000
N145G81R2.1000R3-.1220
N150X1.5000
N155X2.0000Y2.0000
N160G80
N165G44D00Z.0000
N170X9.8880Y9.7770F14.
:175T04M06
N180G00G90G17X2.5000Y1.5000F14.M03
N185G44D04Z.1000
N190G83R2.1000R3-.1220R8.1000R9-.375R53.2200
N195X1.5000
N200X2.0000Y2.0000
N205G80
N210M30
%#<END OF MC-TEST>~~
```

Post name:              Emco-m2
Post Source             Emco-m2
Machine type:           Emcotronics M2 Mill
Control:
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK.

```
%0001
N10  G70
N20  T0101
N30  G00
N40  G54
N50  X0.573 Y1.95 Z1.0 S484 M03
N60  Z0.1 M08
N70  G01 Z-0.122 F500
N80  G41 D31 X0.575 F1000
N90  G03 X0.875 Y2.25 I0.0 J0.3
N100  G01 Y3.0
N110  G02 X1.0 Y3.125 I0.125 J0.0
N120  G01 X1.3584
N130  G02 X1.6038 Y2.9228 I0.0 J-0.25
N140  G03 X2.3962 Y2.9228 I0.3962 J0.0772
N150  G02 X2.6416 Y3.125 I0.2454 J-0.0478
N160  G01 X3.0
N170  G02 X3.125 Y3.0 I0.0 J-0.125
N180  G01 Y1.5
N190  G02 X2.5 Y0.875 I-0.625 J0.0
N200  G01 X1.5
N210  G02 X0.875 Y1.5 I0.0 J0.625
N220  G01 Y2.25
N230  G03 X0.575 Y2.55 I-0.3 J0.0
N240  G01 G40 X0.573
N250  G00 Z0.1
N260  T0303
N270  G00
N280  G54
N290  X2.5 Y1.5 S765 M03
N300  G98 G81 R0.1 Z-0.122 F1200 M08
N310  X1.5
N320  X2.0 Y2.0
N330  G80
N340  T0404
N350  G00
N360  G54
N370  X2.5 Y1.5 S888 M03
N380  G98 G83 R0.1 Z-0.122 Q0.1 F1400 M08
N390  X1.5
N400  X2.0 Y2.0
N410 G80
N420  M30
```

Post name:              enac-ii
Post Source             enac-ii
Machine type:           Enshu 650VX
Control:                Enac-1
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Custom subroutines 'M98P1000' at toolchange.

```
%
O1 (MC-TEST)
M98P1000  (1/4 0.25 ENDMILL)
T3
G90G54
G0X.573Y1.95S484M03
G43Z1.0H01M8
Z.1
G1Z-.122F5.0
G41X.575F10.0
G3X.875Y2.25I.0J.3
G1Y3.0
G2X1.0Y3.125I.125J.0
G1X1.3584
G2X1.6038Y2.9228I.0J-.25
G3X2.3962I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0I.0J-.125
G1Y1.5
G2X2.5Y.875I-.625J.0
G1X1.5
G2X.875Y1.5I.0J.625
G1Y2.25
G3X.575Y2.55I-.3J.0
G40
G1X.573
G0Z.1

M9
M98P1000  (1/8 0.125 CENTER DRILL)
T4
G90G54
G0X2.5Y1.5S765M03
G43Z1.0H03
G98G81Z-.122R0.1F12.0
X1.5
X2.0Y2.0
G80
M98P1000  (0.2 DRILL)
T1
G90G54
G0X2.5Y1.5S888M03
G43Z1.0H04M51
G98G83Z-.122R0.1Q.1F14.0
X1.5
X2.0Y2.0
G80
M50
G4
M05
G91G28Z0
G28X0Y0
G90
M30
%
```

Post name:              excel-21
Post Source             excel-21
Machine type:           Excell VMC
Control:                Fanuc 15M
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, has error checking

```
%                                      N130 G00 G49
O0001                                  N135 G91 G30 Z0
 (MC-TEST)                             N140 G90
N5 G00 G17 G40 G80 G98 G90 G20         N145 X10.0 Y0.0
N10 G91 G30 Z0                         N150 T03 M06(1/8 0.125 CENTER DRILL)
N15 G00 G90 G54 X10.0 Y0.0             N155 G0 X2.5 Y1.5 S765 M03
N20 T01 M06(1/4 0.25 ENDMILL)          N160 G43 Z1.0 H3
N25 G0 X.573 Y1.95 S484 M03            N165 G81 Z-.122 R.1 F12.
N30 G43 Z.1 H1                         N170 X1.5
N35 G1 Z-.122 F5. M08                  N175 X2.0 Y2.0
N40 G41 D31 X.575 F10.                 N180 G80
N45 G3 X.875 Y2.25 J.3                 N185 G00 G49
N50 G1 Y3.0                            N190 G91 G30 Z0
N55 G2 X1.0 Y3.125 I.125               N195 G90
N60 G1 X1.3584                         N200 X10.0 Y0.0
N65 G2 X1.6038 Y2.9228 J-.25           N205 T04 M06( 0.2 DRILL)
N70 G3 X2.3962 Y2.9228 I.3962 J.0772   N210 G0 X2.5 Y1.5 S888 M03
N75 G2 X2.6416 Y3.125 I.2454 J-.0478   N215 G43 Z1.0 H4 M08
N80 G1 X3.0                            N220 G83 Z-.122 R.1 Q.1 F14.
N85 G2 X3.125 Y3.0 J-.125              N225 X1.5
N90 G1 Y1.5                            N230 X2.0 Y2.0
N95 G2 X2.5 Y.875 I-.625               N235 G80
N100 G1 X1.5                           N240 G0 Z.1 M9
N105 G2 X.875 Y1.5 J.625               N245 G00 G49
N110 G1 Y2.25                          N250 G91 G30 Z0.0
N115 G3 X.575 Y2.55 I-.3               N255 G90
N120 G1 G40 X.573                      N260 M30
N125 G0 Z.1 M09                        %
```

Post name:              Ex-sx1
Post Source             Ex-sx1
Machine type:           Bridgeport
Control:                EZ Trak SX
Inch/Metric:            Inch
Circ interpolation: R   Conversational
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK.

```
 0000 EZTRAK|SX 1 MODE|INCH
 0010 RAPID ABS X9.888 Y9.777 Z1.00
 0020 RAPID ABS X0.573 Y1.95 Z1.00
 0030 COMP|ON LFT D0 X0.575 Y1.95 Z0.10 Z-0.122 P0 F10
 0040 ARC|CNTRPT ABS CCW X0.875 Y2.25 Z-0.122 XC0.575 YC2.25 F10
 0050 LINE ABS X0.875 Y3.00 Z-0.122 F10
 0060 ARC|CNTRPT ABS CW X1.00 Y3.125 Z-0.122 XC1.00 YC3.00 F10
 0070 LINE ABS X1.3584 Y3.125 Z-0.122 F10
 0080 ARC|CNTRPT ABS CW X1.6038 Y2.9228 Z-0.122 XC1.3584 YC2.875 F10
 0090 ARC|CNTRPT ABS CCW X2.3962 Y2.9228 Z-0.122 XC2.00 YC3.00 F10
 0100 ARC|CNTRPT ABS CW X2.6416 Y3.125 Z-0.122 XC2.6416 YC2.875 F10
 0110 LINE ABS X3.00 Y3.125 Z-0.122 F10
 0120 ARC|CNTRPT ABS CW X3.125 Y3.00 Z-0.122 XC3.00 YC3.00 F10
 0130 LINE ABS X3.125 Y1.50 Z-0.122 F10
 0140 ARC|CNTRPT ABS CW X2.50 Y0.875 Z-0.122 XC2.50 YC1.50 F10
 0150 LINE ABS X1.50 Y0.875 Z-0.122 F10
 0160 ARC|CNTRPT ABS CW X0.875 Y1.50 Z-0.122 XC1.50 YC1.50 F10
 0170 LINE ABS X0.875 Y2.25 Z-0.122 F10
 0180 ARC|CNTRPT ABS CCW X0.575 Y2.55 Z-0.122 XC0.575 YC2.25 F10
 0190 LINE ABS X0.573 Y2.55 Z-0.122 F10
 0200 COMP|OFF Z1.00
 0210 RAPID ABS X9.888 Y9.777 Z1.00
 0220 AUXFUN T3 M6
 0230 DR|PT ABS X2.50 Y1.50 Z0.10
 0240 DR|PT ABS X1.50 Y1.50 Z0.10
 0250 DR|PT ABS X2.00 Y2.00 Z0.10
 0260 RAPID ABS X9.888 Y9.777 Z1.00
 0270 AUXFUN T4 M6
 0280 DR|PT ABS X2.50 Y1.50 Z0.10
 0290 DR|PT ABS X1.50 Y1.50 Z0.10
 0300 DR|PT ABS X2.00 Y2.00 Z0.10
 0310 RAPID ABS X9.888 Y9.777 Z1.00
 0320 AUXFUN T1 M6
```

Post name:              Ez-trac
Post Source             Ez-trac
Machine type:           Brideport
Control:                EZ Trak SX
Inch/Metric:            Inch
Circ interpolation: R   Conversational
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK.


```
 0000 EZTRAK|SX 1 MODE|INCH
 0010 RAPID ABS X9.888 Y9.777 Z1.00
 0020 RAPID ABS X0.573 Y1.95 Z1.00
 0030 COMP|ON LFT D0 X0.575 Y1.95 Z0.10 Z-0.122 P0 F10
 0040 ARC|CNTRPT ABS CCW X0.875 Y2.25 Z-0.122 XC0.575 YC2.25 F10
 0050 LINE ABS X0.875 Y3.00 Z-0.122 F10
 0060 ARC|CNTRPT ABS CW X1.00 Y3.125 Z-0.122 XC1.00 YC3.00 F10
 0070 LINE ABS X1.3584 Y3.125 Z-0.122 F10
 0080 ARC|CNTRPT ABS CW X1.6038 Y2.9228 Z-0.122 XC1.3584 YC2.875 F10
 0090 ARC|CNTRPT ABS CCW X2.3962 Y2.9228 Z-0.122 XC2.00 YC3.00 F10
 0100 ARC|CNTRPT ABS CW X2.6416 Y3.125 Z-0.122 XC2.6416 YC2.875 F10
 0110 LINE ABS X3.00 Y3.125 Z-0.122 F10
 0120 ARC|CNTRPT ABS CW X3.125 Y3.00 Z-0.122 XC3.00 YC3.00 F10
 0130 LINE ABS X3.125 Y1.50 Z-0.122 F10
 0140 ARC|CNTRPT ABS CW X2.50 Y0.875 Z-0.122 XC2.50 YC1.50 F10
 0150 LINE ABS X1.50 Y0.875 Z-0.122 F10
 0160 ARC|CNTRPT ABS CW X0.875 Y1.50 Z-0.122 XC1.50 YC1.50 F10
 0170 LINE ABS X0.875 Y2.25 Z-0.122 F10
 0180 ARC|CNTRPT ABS CCW X0.575 Y2.55 Z-0.122 XC0.575 YC2.25 F10
 0190 LINE ABS X0.573 Y2.55 Z-0.122 F10
 0200 COMP|OFF Z1.00
 0210 RAPID ABS X9.888 Y9.777 Z1.00
 0220 AUXFUN T3 M6
 0230 DR|PT ABS X2.50 Y1.50 Z0.10
 0240 DR|PT ABS X1.50 Y1.50 Z0.10
 0250 DR|PT ABS X2.00 Y2.00 Z0.10
 0260 RAPID ABS X9.888 Y9.777 Z1.00
 0270 AUXFUN T4 M6
 0280 DR|PT ABS X2.50 Y1.50 Z0.10
 0290 DR|PT ABS X1.50 Y1.50 Z0.10
 0300 DR|PT ABS X2.00 Y2.00 Z0.10
 0310 RAPID ABS X9.888 Y9.777 Z1.00
 0320 AUXFUN T1 M6
```

| Post name: | Ez-trak |
|---|---|
| Post Source | Ez-trak |
| Machine type: | Bridgeport |
| Control: | EZ Trak |
| Inch/Metric: | Inch |
| Circ interpolation: | Conversational |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | No |
| Post programmer notes: | Source code looks OK, Old EZ-TRAK output type |

```
  PN1 G20
 N001  G100 X9.888A Y9.777A;
 N002  G100 X0.573A Y1.95A;
 N003  G101 XB0.573A YB1.95A XE0.575A YE1.95A F10.0 TC1 D0 CR0 T01;
 N004  G103 XB0.575A YB1.95A XE0.875A YE2.25A XC0.575A YC2.25A F10.0 TC1 D0 CR0 T01;
 N005  G101 XB0.875A YB2.25A XE0.875A YE3.0A F10.0 TC1 D0 CR0 T01;
 N006  G102 XB0.875A YB3.0A XE1.0A YE3.125A XC1.0A YC3.0A F10.0 TC1 D0 CR0 T01;
 N007  G101 XB1.0A YB3.125A XE1.3584A YE3.125A F10.0 TC1 D0 CR0 T01;
 N008  G102 XB1.3584A YB3.125A XE1.6038A YE2.9228A XC1.3584A YC2.875A F10.0 TC1 D0 CR0
 T01;
 N009  G103 XB1.6038A YB2.9228A XE2.3962A YE2.9228A XC2.0A YC3.0A F10.0 TC1 D0 CR0 T01;
 N010  G102 XB2.3962A YB2.9228A XE2.6416A YE3.125A XC2.6416A YC2.875A F10.0 TC1 D0 CR0
 T01;
 N011  G101 XB2.6416A YB3.125A XE3.0A YE3.125A F10.0 TC1 D0 CR0 T01;
 N012  G102 XB3.0A YB3.125A XE3.125A YE3.0A XC3.0A YC3.0A F10.0 TC1 D0 CR0 T01;
 N013  G101 XB3.125A YB3.0A XE3.125A YE1.5A F10.0 TC1 D0 CR0 T01;
 N014  G102 XB3.125A YB1.5A XE2.5A YE0.875A XC2.5A YC1.5A F10.0 TC1 D0 CR0 T01;
 N015  G101 XB2.5A YB0.875A XE1.5A YE0.875A F10.0 TC1 D0 CR0 T01;
 N016  G102 XB1.5A YB0.875A XE0.875A YE1.5A XC1.5A YC1.5A F10.0 TC1 D0 CR0 T01;
 N017  G101 XB0.875A YB1.5A XE0.875A YE2.25A F10.0 TC1 D0 CR0 T01;
 N018  G103 XB0.875A YB2.25A XE0.575A YE2.55A XC0.575A YC2.25A F10.0 TC1 D0 CR0 T01;
 N019  G101 XB0.575A YB2.55A XE0.573A YE2.55A F10.0
 N020  G100 X2.5A Y1.5A;
 N021  G100 X1.5A Y1.5A;
 N022  G100 X2.0A Y2.0A;
 N023  G100 X2.5A Y1.5A;
 N024  G100 X1.5A Y1.5A;
 N025  G100 X2.0A Y2.0A;
 %
```

Post name:                 fadal-h
 Post Source               fadal-h
Machine type:              Fadal VMC
Control:                   Fadal
Inch/Metric:               Inch
Circ interpolation:        Incremental IJ
Auto 1st T-POSITION?       yes
Canned drill cycles:       yes
Post programmer notes:     Customized with rotary support.


```
%                                          N270 G0 Z1.0
N10O1 (MC-TEST)                            N280 M5 M9
N20 M6 T1  (1/4 0.25 ENDMILL T01)          N290 M6 T3  (1/8 0.125 CENTER DRILL T03)
N30 M1                                     N300 M1
N40 G0 G90 M3 S484                         N310 G0 G90 M3 S765
N50 G0 X.573 Y1.95                         N320 G0 X2.5 Y1.5
N60 Z1.0 H1                                N330 Z1.0 H3
N70 M8                                     N340 G81 G98 X2.5 Y1.5 Z-.122 R00.1 F12.0
N80 Z.1                                    N350 X1.5
N90 G1 Z-.122 F5.0                         N360 X2.0 Y2.0
N100 G41 X.575 F10.0                       N370 G80
N110 G3 X.875 Y2.25 I.0 J.3                N380 M5
N120 G1 Y3.0                               N390 M6 T4  (0.2 DRILL T04)
N130 G2 X1.0 Y3.125 I.125 J.0              N400 M1
N140 G1 X1.3584                            N410 G0 G90 M3 S888
N150 G2 X1.6038 Y2.9228 I.0 J-.25          N420 G0 X2.5 Y1.5
N160 G3 X2.3962 I.3962 J.0772              N430 Z1.0 H4
N170 G2 X2.6416 Y3.125 I.2454 J-.0478      N440 M8
N180 G1 X3.0                               N450 G83 G98 X2.5 Y1.5 Z-.122 R00.1 Q.1 F14.0
N190 G2 X3.125 Y3.0 I.0 J-.125             N460 X1.5
N200 G1 Y1.5                               N470 X2.0 Y2.0
N210 G2 X2.5 Y.875 I-.625 J.0              N480 G80 M9
N220 G1 X1.5                               N490 M6 T1
N230 G2 X.875 Y1.5 I.0 J.625               N500 Y4.
N240 G1 Y2.25                              N510 M0
N250 G3 X.575 Y2.55 I-.3 J.0               N520 M2
N260 G1 G40 X.573                          %
```

| | |
|---|---|
| Post name: | Fadal-m |
| Post Source | Fadal-m |
| Machine type: | Fadal VMC |
| Control: | Fadal |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, has 4-axis support and error checking |

```
< MC-TEST  Mon Apr 09 09:52:41 2001'
%
O0 (MC-TEST)
N10 G0 G90 G17 G40 G80 G98
N20 T1 M6  (1/4 0.25 ENDMILL T01)
N30 G0 G90 X.573 Y1.95 E1
N40 S484 M3
N50 G43 Z.1 H1 D1
N60 M8
N70 G1 Z-.122 F5.0
N80 G41 X.575 F10.0
N90 G3 X.875 Y2.25 I.0 J.3
N100 G1 Y3.0
N110 G2 X1.0 Y3.125 I.125 J.0
N120 G1 X1.3584
N130 G2 X1.6038 Y2.9228 I.0 J-.25
N140 G3 X2.3962 I.3962 J.0772
N150 G2 X2.6416 Y3.125 I.2454 J-.0478
N160 G1 X3.0
N170 G2 X3.125 Y3.0 I.0 J-.125
N180 G1 Y1.5
N190 G2 X2.5 Y.875 I-.625 J.0
N200 G1 X1.5
N210 G2 X.875 Y1.5 I.0 J.625
N220 G1 Y2.25
N230 G3 X.575 Y2.55 I-.3 J.0
N240 G1 G40 X.573
N250 G0 Z.1

N260 M5 M9
N270 T3 M6  (1/8 0.125 CENTER DRILL T03)
N280 G0 G90 X9.888 Y9.777 E1
N290 S765 M3
N300 X2.5 Y1.5
N310 G43 Z1.0 H3
N320 M8
N330 G81 G98 X2.5 Y1.5 Z-.122 R.1 P0 F12.0
N340 X1.5
N350 X2.0 Y2.0
N360 G80
N370 M5 M9
N380 T4 M6  (0.2 DRILL T04)
N390 G0 G90 X9.888 Y9.777 E1
N400 S888 M3
N410 X2.5 Y1.5
N420 G43 Z1.0 H4
N430 M8
N440 G83 G98 X2.5 Y1.5 Z-.122 R.1 Q.1 F14.0
N450 X1.5
N460 X2.0 Y2.0
N470 G80
N480 Z.1
N490 M5 M9
N500 G0 G49 Z0.0
N510 G90 X0 Y0 E24
N520 M2
%
```

| | |
|---|---|
| Post name: | fadlvmc |
| Post Source | fadlvmc |
| Machine type: | Fadal VMC |
| Control: | Fadal |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, has error checking, custom comments, 4-axis support. |

```
%
O0001 (MC-TEST)
(DWG. )
( )
(FILE# )
(PROGRAMMED BY  )
(*************************)
 T01 M06  (1/4" 0.25 ENDMILL)
 G00 G90 G54 X.573 Y1.95 S484 M03
 G43 Z.1 H1 M8
 G01 Z-.122 F5.0
 G41 D51 X.575 F10.0
 G03 X.875 Y2.25 I.0 J.3
 G01 Y3.0
 G02 X1.0 Y3.125 I.125 J.0
 G01 X1.3584
 G02 X1.6038 Y2.9228 I.0 J-.25
 G03 X2.3962 Y2.9228 I.3962 J.0772
 G02 X2.6416 Y3.125 I.2454 J-.0478
 G01 X3.0
 G02 X3.125 Y3.0 I.0 J-.125
 G01 Y1.5
 G02 X2.5 Y.875 I-.625 J.0
 G01 X1.5
 G02 X.875 Y1.5 I.0 J.625
 G01 Y2.25
 G03 X.575 Y2.55 I-.3 J.0
 G01 G40 X.573
 G00 Z1.0 M09
 M5
```

```
G91 G28 Z0.0 M19
M1

T03 M06  (1/8" 0.125 CENTER DRILL)
G00 G90 G54 X2.5 Y1.5 S765 M03
G43 Z1.0 H03
G81 G98 X2.5 Y1.5 Z-.122 R.1 F12.0
X1.5
X2.0 Y2.0
G80
G00 Z1.0
M5
G91 G28 Z0.0 M19
M1

T04 M06  (0.2 DRILL)
G00 G90 G54 X2.5 Y1.5 S888 M03
G43 Z1.0 H04 M8
G83 G98 X2.5 Y1.5 Z-.122 R.1 Q.1 F14.0
X1.5
X2.0 Y2.0
G80
Z.1
G40 M9
M5
G91 G28 Z0 M19
G91 G28 Y0
M30
%
```

| | |
|---|---|
| Post name: | Fan-11mc |
| Post Source | Fan-11mc |
| Machine type: | Okuma Howa |
| Control: | Fanuc 11M |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
%
O0001( MC-TEST )
N5G00G17G40G80G98G90G20
N10G54
N15T01M06 (T01 1/4" ENDMILL 0.25)
N20T03
N25G00X.573Y1.95S484M03
N30G45Z1.0H1
N35M08
N40Z.1
N45G01Z-.122F5.
N50G41X.575F10.D31
N55G03X.875Y2.25J.3
N60G01Y3.0
N65G02X1.0Y3.125I.125
N70G01X1.3584
N75G02X1.6038Y2.9228J-.25
N80G03X2.3962I.3962J.0772
N85G02X2.6416Y3.125I.2454J-.0478
N90G01X3.0
N95G02X3.125Y3.0J-.125
N100G01Y1.5
N105G02X2.5Y.875I-.625
N110G01X1.5
N115G02X.875Y1.5J.625
N120G01Y2.25
N125G03X.575Y2.55I-.3
N130G01G40X.573
N135G00Z.1M09
N140G00Z5.
N145G28Z8.
N150G28Y0
N155M01
N160T03M06 (T03 1/8" CENTER DRILL
0.125)
N165T04
N170G00X2.5Y1.5S765M03
N175G45Z1.0H3
N180G81Z-.122R.1F12.
N185X1.5
N190X2.0Y2.0
N195G80
N200G00Z5.
N205G28Z8.
N210G28Y0
N215M01
N220T04M06 (T04 DRILL 0.2)
N225T01
N230G00X2.5Y1.5S888M03
N235G45Z1.0H4
N240M08
N245G83Z-.122R.1Q.1F14.
N250X1.5
N255X2.0Y2.0
N260G80
N265G00Z.1
N270G00Z5.M09
N275G28Z8.
N280G28Y0
N285M30
%
```

| | |
|---|---|
| Post name: | fan-15m |
| Post Source | fan-15m |
| Machine type: | NTC TMC-40V |
| Control: | Fanuc 15M |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, has error checking. |

```
%
O0001( MC-TEST )
G20G0G40T01M6
N1G0G40( 1/4" ENDMILL 0.25)
T03
G0G54G80G90X.573Y1.95S484M03
G43Z1.0H1.0M8
Z.1
G1Z-.122F5.
G41X.575D21.0F10.
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
G2X.875Y1.5J.625
G1Y2.25
G3X.575Y2.55I-.3
G1G40X.573
G0Z.1
G01.0M9
G28G91Z0M19
M6
```

```
M1

N3G0G40( 1/8" CENTER DRILL 0.125)
T04
G0G54G80G90X2.5Y1.5S765M03
G45Z1.0H3
G81Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
G01.0
G28G91Z0M19
M6
M1

N4G0G40( DRILL 0.2)
T01
G0G54G80G90X2.5Y1.5S888M03
G45Z1.0H4M8
G83Z-.122R.1Q.1F14.
X1.5
X2.0Y2.0
G80
G0Z.1
G00Z5.M9
G28G91Z0Y0M19
M6
M30
%
```

Post name:              Fan-3000
Post Source             Fan-3000
Machine type:           Matsuura VMC
Control:                Fanuc 3000C
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks Ok, mild customization.


```
%                                      N140 G01 G40 X5730
N005 G00 G40 G80                       N145 G00 Z1000 M09
N010 G91 G45 X-0 H62                   N150 G91 G28 Z0 M05
N015 G92 X0                            N155 G90 T03 M06
N020 G91 G45 Y-0 H63                   N160 G00 X25000 Y15000 S63 M03
N025 G92 Y0                            N165 G91 G45 Z-0 H03
N030 G90 T01 M06                       N170 G92 Z0
N035 M08                               N175 G90
N040 G91 G45 Z-0 H01                   N180 G81 X25000 Y15000 R0 Z-1220 F1200
N045 G92 Z0                            N185 X15000
N050 G90                               N190 X20000 Y20000
N055 G01 Z-1220 F500                   N195 G80
N060 X5750 S59 M03                     N200 G91 G28 Z0 M05
N065 G03 X8750 Y22500 J3000 F1000 D25  N205 G90 T04 M06
N070 G01 Y30000                        N210 G00 X25000 Y15000 S65 M03
N075 G02 X10000 Y31250 I1250           N215 M08
N080 G01 X13584                        N220 G91 G45 Z-0 H04
N085 G02 X16038 Y29228 J-2500          N225 G92 Z0
N090 G03 X23962 Y29228 I3962 J772      N230 G90
N095 G02 X26416 Y31250 I2454 J-478     N235 G83 X25000 Y15000 R0 Z-1220 Q1000
N100 G01 X30000                        F1400
N105 G02 X31250 Y30000 J-1250          N240 X15000
N110 G01 Y15000                        N245 X20000 Y20000
N115 G02 X25000 Y8750 I-6250           N250 G80
N120 G01 X15000                        N255 G00 Z50000 M09
N125 G02 X8750 Y15000 J6250            N260 G91 G28 X0 Y0 Z0 M05
N130 G01 Y22500                        N265 M30
N135 G03 X5750 Y25500 I-3000           %
```

```
% (TOOL #01 = 0.25 DIA ENDMILL)              N145 G00 G92 X0 Y0 Z0
N005 G00 G92 X0 Y0 Z0                        N150 G91 G45 Z-0 H03
N010 G91 G45 Z-0 H01                         N155 S765 M03
N015 S484 M03                                N160 G90 G80 G99 T03
N020 G90 G80 G99 T01                         N165 G00 X25000 Y15000 M17
N025 M08                                     N170 G99 G81 X25000 Y15000 R0 Z-1220
N030 G00 Z1000                               F1200
N035 G01 Z-1220 F500                         N175 X15000
N040 X5750 M17                               N180 X20000 Y20000
N045 G03 X8750 Y22500 J3000 F1000 D25        N185 G80
N050 G01 Y30000                              N190 G91 G28 Z0 M18
N055 G02 X10000 Y31250 I1250                 N195 G28 X0 Y0
N060 G01 X13584                              N200 G45 T03 M06
N065 G02 X16038 Y29228 J-2500                  (TOOL #04 = 0.2 DIA DRILL)
N070 G03 X23962 Y29228 I3962 J772            N205 G00 G92 X0 Y0 Z0
N075 G02 X26416 Y31250 I2454 J-478           N210 G91 G45 Z-0 H04
N080 G01 X30000                              N215 S888 M03
N085 G02 X31250 Y30000 J-1250                N220 G90 G80 G99 T04
N090 G01 Y15000                              N225 G00 X25000 Y15000 M17
N095 G02 X25000 Y8750 I-6250                 N230 M08
N100 G01 X15000                              N235 G99 G83 X25000 Y15000 R0 Z-1220
N105 G02 X8750 Y15000 J6250                  Q1000 F1400
N110 G01 Y22500                              N240 X15000
N115 G03 X5750 Y25500 I-3000                 N245 X20000 Y20000
N120 G01 G40 X5730                           N250 G80 M09
N125 G00 Z1000 M09                           N255 G80 G91 G28 Z0 M18
N130 G91 G28 Z0 M18                          N260 G28 X0 Y0
N135 G28 X0 Y0                               N265 G45 T04 M06
N140 G45 T01 M06                             N270 M30
  (TOOL #03 = 0.125 DIA CENTER DRILL)        %
```

| | |
|---|---|
| Post name: | fan-6mb |
| Post Source | fan-6mb |
| Machine type: | Generic Mill |
| Control: | Fanuc 6MB |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
O0001
N10G0G80G90G17G49G40
N15T3
N20G54
N25G43Z1.0H1S484M03M08
N30G1Z0.1F0.
N35Z-0.122F5.
N40G41D31X0.575F10.
N45G3X0.875Y2.25J0.3
N50G1Y3.0
N55G2X1.0Y3.125I0.125
N60G1X1.3584
N65G2X1.6038Y2.9228J-0.25
N70G3X2.3962I0.3962J0.0772
N75G2X2.6416Y3.125I0.2454J-0.0478
N80G1X3.0
N85G2X3.125Y3.0J-0.125
N90G1Y1.5
N95G2X2.5Y0.875I-0.625
N100G1X1.5
N105G2X0.875Y1.5J0.625
N110G1Y2.25
N115G3X0.575Y2.55I-0.3
N120G1G40X0.573
N125G0Z0.1
N130G91G28Z0M09
N135G80G90
N140M1
N145M6
```

```
N150G0G80G90G17G49G40
N155T4
N160G54
N165G43Z1.0H3
N170X2.5Y1.5S765M03M08
N175G98G81R0.1Z-0.122F12.
N180X1.5
N185X2.0Y2.0
N190G80
N195G91G28Z0M09
N200G80G90
N205M1
N210M6
N215G0G80G90G17G49G40
N220T1
N225G54
N230G43Z1.0H4
N235X2.5Y1.5S888M03M08
N240G98G83R0.1Z-0.122Q0.1F14.
N245X1.5
N250X2.0Y2.0
N255G80
N260G91G28Z0M09
N265G28X0Y0
N270G80G90
N275M1
N280M30
%
#< END OF MC-TEST >
```

| Post name: | Fan-7m |
|---|---|
| Post Source | Fan-7m |
| Machine type: | GenericHMC |
| Control: | GN 7M |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK. |

```
#< MC-TEST  Mon Apr 09 11:47:29 2001'
:5G70G90G00G17G40G80M05
N10T01M06
N15G00G90G17G44D01Z.1000F0.M03
N20G01Z-.1220F5.M07
N25G41D09X.5750F10.
N30G03X.8750Y2.2500I.0000J.3000
N35G01Y3.0000
N40G02X1.0000Y3.1250I.1250J.0000
N45G01X1.3584
N50G02X1.6038Y2.9228I.0000J-.2500
N55G03X2.3962I.3962J.0772
N60G02X2.6416Y3.1250I.2454J-.0478
N65G01X3.0000
N70G02X3.1250Y3.0000I.0000J-.1250
N75G01Y1.5000
N80G02X2.5000Y.8750I-.6250J.0000
N85G01X1.5000
N90G02X.8750Y1.5000I.0000J.6250
N95G01Y2.2500
N100G03X.5750Y2.5500I-.3000J.0000
N105G01G40X.5730
N110G00Z.1000
N115Z1.0000F12.M09
N120Y1.9500
:125T03M06
N130G00G90G17X2.5000Y1.5000F12.M03
N135G44D03Z.1000
N140G81R2.1000R3-.1220
N145X1.5000
N150X2.0000Y2.0000
N155G80
N160X.5730Y1.9500F14.M08
:165T04M06
N170G00G90G17X2.5000Y1.5000F14.M03
N175G44D04Z.1000
N180G83R2.1000R3-.1220R8.1000R9-.375R53.2200
N185X1.5000M08
N190X2.0000Y2.0000
N195G80
N200M30
%#<END OF MC-TEST>~~
```

Post name:                     Fan-omc
Post Source                 Fan-omc
Machine type:              Excell VMC
Control:                        Fanuc OM
Inch/Metric:               Inch
Circ interpolation:  and R     R-word for Radius
Auto 1st T-POSITION?       yes
Canned drill cycles:        yes
Post programmer notes:     Source code looks good.

```
%
O000001
(MC-TEST)
 G91 G30 Z0
N1 M06 T1(1/4 0.25 ENDMILL)
 G0 G43 Z.1 H1 M8
 G1 Z-.122 F5.
 G41 G90 G54 X.575 F10. D11 T3
 S484 M03
 G3 X.875 Y2.25 J.3
 G1 Y3.0
 G2 X1.0 Y3.125 I.125
 G1 X1.3584
 G2 X1.6038 Y2.9228 J-.25
 G3 X2.3962 Y2.9228 I.3962 J.0772
 G2 X2.6416 Y3.125 I.2454 J-.0478
 G1 X3.0
 G2 X3.125 Y3.0 J-.125
 G1 Y1.5
 G2 X2.5 Y.875 I-.625
 G1 X1.5
 G2 X.875 Y1.5 J.625
 G1 Y2.25
 G3 X.575 Y2.55 I-.3
 G1 G40 X.573
 G0 Z.1
 M9
 M5
 G91 G30 Z0
 M01
N2 M06 T3(1/8 0.125 CENTER DRILL)
 G0 G90 G54 X2.5 Y1.5 T4
 S765 M03
 G43 Z1.0 H3
 G81 Z-.122 R.1 F12.
 X1.5
 X2.0 Y2.0
 G80
 M5
 G91 G30 Z0
 M01
N3 M06 T4( 0.2 DRILL)
 G0 G90 G54 X2.5 Y1.5 T1
 S888 M03
 G43 Z1.0 H4 M8
 G83 Z-.122 R.1 Q.1 F14.
 X1.5
 X2.0 Y2.0
 G80
 G0 Z.1 M9
 G91 G30 Z0 Y0
 G90
 M30
%
```

Post name:              Fanuc10m
Post Source             Fanuc10m
Machine type:           Dah Lin MCV-1020
Control:                Fanuc 10M
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK.

```
< MC-TEST  Mon Apr 09 11:48:32 2001' %
O1(T1 0.25 ENDMILL)
N1G54G00G90G17G40G80
N2G43Z1.0H1S484M03
N3Z0.1T3
N4G1Z-0.122F5.M08
N5(COMP = DIFF. BETWEEN 0.250 DIA. &
ACTUAL TD)
N6G41D1X0.575F10.
N7G3X0.875Y2.25J0.3
N8G1Y3.0
N9G2X1.0Y3.125I0.125
N10G1X1.3584
N11G2X1.6038Y2.9228J-0.25
N12G3X2.3962I0.3962J0.0772
N13G2X2.6416Y3.125I0.2454J-0.0478
N14G1X3.0
N15G2X3.125Y3.0J-0.125
N16G1Y1.5
N17G2X2.5Y0.875I-0.625
N18G1X1.5
N19G2X0.875Y1.5J0.625
N20G1Y2.25
N21G3X0.575Y2.55I-0.3
N22G1G40X0.573
N23G0Z0.1M09
N24G0Z1.0
N25G28G91Z0

N26G90G49H0
N27M6(T3 0.125 CENTER DRILL)
N28G54G00G90G17G40G80
N29X2.5Y1.5S765M03
N30G43Z1.0H3
N31G81G99R0.1Z-0.122F12.T4M08
N32X1.5
N33X2.0Y2.0
N34G80M09
N35G0Z1.0
N36G28G91Z0
N37G90G49H0
N38M6(T4 0.2 DRILL)
N39G54G00G90G17G40G80
N40X2.5Y1.5S888M03
N41G43Z1.0H4
N42G83G99R0.1Z-0.122Q0.1F14.T1M08
N43X1.5
N44X2.0Y2.0
N45G80
N46G0Z0.1M09
N47G0Z1.0
N48G28G91Z0
N49G90G49H0
N50M06
N51M30
%
< END OF MC-TEST >
```

Post name:                 fanuc-om
Post Source                fanuc-om
Machine type:              Saeilo Mach 3A VMC
Control:                   Fanuc OM
Inch/Metric:               Inch
Circ interpolation:        Incremental IJ
Auto 1st T-POSITION?       yes
Canned drill cycles:       yes
Post programmer notes:     Source code looks OK.

```
%
:0001(MC-TEST)
N0010 G00 G20 G40 G49 G54 P25 G80 G90
G69
 G28 G91 Y0 Z0
 M90 B0
 G65 P9018 A2.

N0020 G00 G20 G40 G54 P25 G80 G90
 T1(1/4 0.25 ENDMILL)
 G00 X.573 Y1.95
 S484 M03
 G43 Z.1 H1 M8
 G01 Z-.122 F5.
 G41 X.575 F10. D101
 G03 X.875 Y2.25 J.3
 G01 Y3.0
 G02 X1.0 Y3.125 I.125
 G01 X1.3584
 G02 X1.6038 Y2.9228 J-.25
 G03 X2.0 Y2.5964 I.3962 J.0772
 X2.3962 Y2.9228 J.4036
 G02 X2.6416 Y3.125 I.2454 J-.0478
 G01 X3.0
 G02 X3.125 Y3.0 J-.125
 G01 Y1.5
 G02 X2.5 Y.875 I-.625
 G01 X1.5
 G02 X.875 Y1.5 J.625
 G01 Y2.25
 G03 X.575 Y2.55 I-.3
 G01 G40 X.573
 G00 Z.1
```

```
 G00 Z1.0
 G28 G91 Z0 M09
 G49 G90

N0030 G00 G20 G40 G54 P25 G80 G90
 T3(1/8 0.125 CENTER DRILL)
 G00 X2.5 Y1.5
 S765 M03
 G43 Z1.0 H3
 G81 G98 Z-.122 R.1 F12.
 X1.5
 X2.0 Y2.0
 G80
 G00 Z1.0
 G28 G91 Z0
 G49 G90

N0040 G00 G20 G40 G54 P25 G80 G90
 T4( 0.2 DRILL)
 G00 X2.5 Y1.5
 S888 M03
 G43 Z1.0 H4 M8
 G83 G98 Z-.122 R.1 Q.1 F14.
 X1.5
 X2.0 Y2.0
 G80
 G00 Z.1
 G00 Z1.0
 G28 G91 Z0 M09
 G49 G90 M05
 M60
 M99
%
```

Post name:              fan-yang
Post Source             fan-yang
Machine type:           Yang-Eagle VMC
Control:                Fanuc
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.

```
%                                          N130 G91 G28 Z0
O000001                                    N135 M06 T3(1/8 0.125 CENTER DRILL)
 (MC-TEST)                                 N140 M01
N5 M06 T1(1/4 0.25 ENDMILL)                N145 G90 G54 G80 G40 G17 G49
N10 M01                                    N150 G0 X2.5 Y1.5 T4
N15 G90 G54 G80 G40 G17 G49                N155 S765 M03
N20 G0 G43 Z.1 H1 M8                        N160 G43 Z1.0 H3
N25 G1 Z-.122 F5.                          N165 G81 G98 Z-.122 R.1 F12.
N30 G41 X.575 F10. D11 T3                  N170 X1.5
N35 S484 M03                               N175 X2.0 Y2.0
N40 G3 X.875 Y2.25 J.3                     N180 G80
N45 G1 Y3.0                                N185 G91 G28 Z0
N50 G2 X1.0 Y3.125 I.125                   N190 M06 T4( 0.2 DRILL)
N55 G1 X1.3584                             N195 M01
N60 G2 X1.6038 Y2.9228 J-.25               N200 G90 G54 G80 G40 G17 G49
N65 G3 X2.3962 Y2.9228 I.3962 J.0772       N205 G0 X2.5 Y1.5 T1
N70 G2 X2.6416 Y3.125 I.2454 J-.0478       N210 S888 M03
N75 G1 X3.0                                N215 G43 Z1.0 H4 M8
N80 G2 X3.125 Y3.0 J-.125                  N220 G83 G98 Z-.122 R.1 Q.1 F14.
N85 G1 Y1.5                                N225 X1.5
N90 G2 X2.5 Y.875 I-.625                   N230 X2.0 Y2.0
N95 G1 X1.5                                N235 G80
N100 G2 X.875 Y1.5 J.625                   N240 G0 Z.1 M9
N105 G1 Y2.25                              N245 G91 G28 Z0 Y0
N110 G3 X.575 Y2.55 I-.3                   N250 G90
N115 G1 G40 X.573                          N255 M30
N120 G0 Z.1                                %
N125 M9
```

Post name:                      fan-mx3
Post Source                     fan-mx3
Machine type:                   Matsurra MX3 Machining Center
Control:
Inch/Metric:                    Inch
Circ interpolation:             Incremental IJ
Auto 1st T-POSITION?            yes
Canned drill cycles:            yes
Post programmer notes:          Source code looks Ok, has 4-axis support.

```
%
O0001
T1M6  (1/4" 0.25 ENDMILL)
G0G90G54A0.X.573Y1.95S484M3T3
G43Z.1H1M8
G1Z-.122F5.
X.575F10.
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
G2X.875Y1.5J.625
G1Y2.25
G3X.575Y2.55I-.3
G1X.573
G0Z.1
G0Z1.0M9
G49Z0M19
M1
T3M6  (1/8" 0.125 CENTER DRILL)
G0G90G54A0.X2.5Y1.5S765M3T4
G43Z.1H3M8
G81Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
G0Z1.0M9
G49Z0M19
M1
T4M6  (0.2 DRILL)
G0G90G54A0.X2.5Y1.5S888T1
G43Z.1H4M8
G83Z-.122R.1Q.1F14.
X1.5
X2.0Y2.0
G80
G0Z1.0M9
G49Z0M19
T1M6
M30
%
```

Post name:                  fidia-f1
Post Source                 fidia-f1
Machine type:               Ramband 1 VMC
Control:                    Fidia-F1
Inch/Metric:                Inch
Circ interpolation: R       R for Radius
Auto 1st T-POSITION?        Not supported
Canned drill cycles:        yes
Post programmer notes:      Source code looks good, mild customization.

```
N10 G90
N12 M03
N14 G00 X9.888 Y9.777 Z1.
N16 G00 X0.573 Y1.95
N18 G00 Z0.1
N20 G01 Z-0.122 F500
N22 G41 T01
N24 X0.575 F1000
N26 G03 X0.875 Y2.25 R0.3
N28 G01 Y3.
N30 G02 X1. Y3.125 R0.125
N32 G01 X1.3584
N34 G02 X1.6038 Y2.9228 R0.25
N36 G03 X2. Y2.5964 R0.4036
N38 G03 X2.3962 Y2.9228 R0.4036
N40 G02 X2.6416 Y3.125 R0.25
N42 G01 X3.
N44 G02 X3.125 Y3. R0.125
N46 G01 Y1.5
N48 G02 X2.5 Y0.875 R0.625
N50 G01 X1.5
N52 G02 X0.875 Y1.5 R0.625
N54 G01 Y2.25
N56 G03 X0.575 Y2.55 R0.3
N58 G40 T
N60 G01 X0.573
N62 G00 Z0.1
N64 G00 Z1. M5
N66 G90
N68 M03
N70 G00 X9.888 Y9.777 Z1.
N72 G00 X2.5 Y1.5
N74 G81 Z0.1 P Q-0.122 E0.1 F1200
N76 G00 X1.5
N78 G00 X2. Y2.
N80 G80
N82 G90
N84 M03
N86 G00 X9.888 Y9.777 Z1.
N88 G00 X2.5 Y1.5
N90 G83 Z0.1 P Q-0.122 F1400
N92 G00 X1.5
N94 G00 X2. Y2.
N96 G80
N98 G00 Z1.
N100 M02
#
```

Post name:                    ge2000-m
Post Source                ge2000-m
Machine type:             Generic Mill
Control:                       GE 2000
Inch/Metric:               Inch
Circ interpolation:        Incremental IJ
Auto 1st T-POSITION?     yes
Canned drill cycles:       yes
Post programmer notes:    Source code looks good, has error checking.

```
(ID,PROG,0001,MC-TEST)
N0010 G90 M03 !(0.25 ENDMILL)
N0020 G00 X.573 Y1.95 T01 M06 S484
N0030 Z.1 D01 M08
N0040 G01 Z-.122 F5.
N0050 G41 P5=0
N0060 X.575 F10.
N0070 G03 X.875 Y2.25 I.0 J.3
N0080 G01 Y3.0
N0090 G02 X1.0 Y3.125 I.125 J.0
N0100 G01 X1.3584
N0110 G02 X1.6038 Y2.9228 I.0 J-.25
N0120 G03 X2.0 Y2.5964 I.3962 J.0772
N0130 G03 X2.3962 Y2.9228 I.0 J.4036
N0140 G02 X2.6416 Y3.125 I.2454 J-.0478
N0150 G01 X3.0
N0160 G02 X3.125 Y3.0 I.0 J-.125
N0170 G01 Y1.5
N0180 G02 X2.5 Y.875 I-.625 J.0
N0190 G01 X1.5
N0200 G02 X.875 Y1.5 I.0 J.625
N0210 G01 Y2.25
N0220 G03 X.575 Y2.55 I-.3 J.0
N0230 G40 G01 X.573
N0240 G00 Z.1
N0250 G40 M09

N0260 G90 M03 !(0.125 CENTER DRILL)
N0270 G00 X2.5 Y1.5 T03 M06 S765
N0280 G81 Z-.122 R.1 F12. D03
N0290 X1.5
N0300 X2.0 Y2.0

N0310 G90 M03 !(0.2 DRILL)
N0320 G00 X2.5 Y1.5 T04 M06 S888
N0330 G83 Z-.122 R.1 F14. P1=.1 D04 M08
N0340 X1.5
N0350 X2.0 Y2.0
N0360
N0370 G00 M06
N0380 M09
N0390 M30
N0400(END,PROG)
```

| Post name: | H25-6mb |
|---|---|
| Post Source | H25-6mb |
| Machine type: | H25 Horizontal Mill |
| Control: | Fanuc 6MB |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
:0001
N10G91G40G80G28G00X0Y0Z0T01
N15G92X9.888Y9.777Z1.0 (T1 0.25
ENDMILL)
N20T00M06
N25G0G90X0.573Y1.95S484M39M03
N30G43Z0.1T03H01M08
N35G1Z-0.122F5.
N40G41D31X0.575F10.
N45G3X0.875Y2.25J0.3
N50G1Y3.0
N55G2X1.0Y3.125I0.125
N60G1X1.3584
N65G2X1.6038Y2.9228J-0.25
N70G3X2.3962I0.3962J0.0772
N75G2X2.6416Y3.125I0.2454J-0.0478
N80G1X3.0
N85G2X3.125Y3.0J-0.125
N90G1Y1.5
N95G2X2.5Y0.875I-0.625
N100G1X1.5
N105G2X0.875Y1.5J0.625
N110G1Y2.25
N115G3X0.575Y2.55I-0.3
N120G1G40X0.573
```

```
N125G0Z0.1
N130M09
N135G91G40G28Y0Z0M05
N140T01M06 (T3 0.125 CENTER DRILL)
N145G0G90X2.5Y1.5S765M39M03
N150G43Z0.1T04H04
N155G99G81R0.1Z-0.122F12.
N160X1.5
N165X2.0Y2.0
N170G80
N175G91G40G28Y0Z0M05
N180T03M06 (T4 0.2 DRILL)
N185G0G90X2.5Y1.5S888M39M03
N190G43Z0.1T00H04M08
N195G99G83R0.1Z-0.122Q0.1F14.
N200X1.5
N205X2.0Y2.0
N210G80
N215M09
N220G91G40G28Y0Z0M05
N225T04M06
N230G91G28X0
N235G90
N240M30
%
```

Post name: haas-4ax
Post Source: haas-4ax
Machine type: Haas VMC
Control: Haas w/4-Axis
Inch/Metric: Inch
Circ interpolation: Incremental IJ
Auto 1st T-POSITION? yes
Canned drill cycles: yes
Post programmer notes: Source code looks good, has full 4-axis support with indexing.

```
%                                          N25 M01
O0001 (MC-TEST)                            N26 T3 M06 (0.125 1/8 CENTER DRILL)
N1 T1 M06 (0.25 1/4 ENDMILL)               N27 G00 G90 G54 X2.5 Y1.5 S765 M03
N2 G00 G90 G54 X0.573 Y1.95 S484 M03        N28 X2.5 Y1.5
N3 X0.573 Y1.95                            N29 G43 H03 Z0.1
N4 G43 H01 Z0.1 M08                        N30 G81 Z-0.122 R0.1 F12.0
N5 G01 Z-0.122 F5.0                        N31 X1.5
N6 G41 D01 X0.575 F10.0                     N32 X2.0 Y2.0
N7 G03 X0.875 Y2.25 I0.0 J0.3              N33 G80
N8 G01 Y3.0                                N34 M01
N9 G02 X1.0 Y3.125 I0.125 J0.0             N35 T4 M06 (0.2 DRILL)
N10 G01 X1.3584                            N36 G00 G90 G54 X2.5 Y1.5 S888 M03
N11 G02 X1.6038 Y2.9228 I0.0 J-0.25         N37 X2.5 Y1.5
N12 G03 X2.3962 Y2.9228 I0.3962 J0.0772     N38 G43 H04 Z0.1 M08
N13 G02 X2.6416 Y3.125 I0.2454 J-0.0478     N39 G83 Z-0.122 R0.1 Q0.1 F14.0
N14 G01 X3.0                               N40 X1.5
N15 G02 X3.125 Y3.0 I0.0 J-0.125           N41 X2.0 Y2.0
N16 G01 Y1.5                               N42 G80
N17 G02 X2.5 Y0.875 I-0.625 J0.0           N43 G00 Z0.1
N18 G01 X1.5                               N44 G00 Z1.0
N19 G02 X0.875 Y1.5 I0.0 J0.625            N45 G91 G28 Z0
N20 G01 Y2.25                              N46 G28 Y0
N21 G03 X0.575 Y2.55 I-0.3 J0.0            N47 M01
N22 G01 G40 X0.573                         N48 T1 M06
N23 G00 Z0.1                               N49 M30
N24 M09                                    %
```

| Post name: | haas-d&d |
| Post Source | haas-d&d |
| Machine type: | Haas VMC |
| Control: | Haas |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
%
O0001 (MC-TEST)
N1 G91 G28 G00 G80 G40 Z0
 T1 M06 (0.25 1/4 ENDMILL)
 G00 G54 G90 X0.573 Y1.95 S484 M03
 G43 Z1.0 H01 M08
 Z0.1
 G01 Z-0.122 F5.0
 G41 D01 X0.575 F10.0
 G03 X0.875 Y2.25 I0.0 J0.3
 G01 Y3.0
 G02 X1.0 Y3.125 I0.125 J0.0
 G01 X1.3584
 G02 X1.6038 Y2.9228 I0.0 J-0.25
 G03 X2.3962 Y2.9228 I0.3962 J0.0772
 G02 X2.6416 Y3.125 I0.2454 J-0.0478
 G01 X3.0
 G02 X3.125 Y3.0 I0.0 J-0.125
 G01 Y1.5
 G02 X2.5 Y0.875 I-0.625 J0.0
 G01 X1.5
 G02 X0.875 Y1.5 I0.0 J0.625
 G01 Y2.25
 G03 X0.575 Y2.55 I-0.3 J0.0
 G01 G40 X0.573
 G00 Z0.1
 M09
N3 G91 G28 G00 Z0 M19
 T3 M06 (0.125 1/8 CENTER DRILL)
 G00 G54 G90 X2.5 Y1.5 S765 M03
 G43 Z1.0 H03
 G81 X2.5 Y1.5 Z-0.122 R0.1 F12.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
N4 G91 G28 G00 Z0 M19
 T4 M06 (0.2 DRILL)
 G00 G54 G90 X2.5 Y1.5 S888 M03
 G43 Z1.0 H04 M08
 G83 X2.5 Y1.5 Z-0.122 R0.1 Q0.1 F14.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 G00 Z0.1
 G00 G91 G28 Y0 Z0 M19
 G90
 M30
%
```

Post name:              haas-kd
Post Source             haas-kd
Machine type:           Haas
Control:                Haas
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK

```
%
O0001 ("MC-TEST")
 T1 M06 (0.25 1/4 ENDMILL)
 S484 M03
 G0 G43 G54 G90 X0.573 Y1.95 Z6.0 H01 M8
 Z0.1
 G1 Z-0.122 F5.0
 G41 D01 X0.575 F10.0
 G3 X0.875 Y2.25 I0.0 J0.3
 G1 Y3.0
 G2 X1.0 Y3.125 I0.125 J0.0
 G1 X1.3584
 G2 X1.6038 Y2.9228 I0.0 J-0.25
 G3 X2.3962 Y2.9228 I0.3962 J0.0772
 G2 X2.6416 Y3.125 I0.2454 J-0.0478
 G1 X3.0
 G2 X3.125 Y3.0 I0.0 J-0.125
 G1 Y1.5
 G2 X2.5 Y0.875 I-0.625 J0.0
 G1 X1.5
 G2 X0.875 Y1.5 I0.0 J0.625
 G1 Y2.25
 G3 X0.575 Y2.55 I-0.3 J0.0
 G1 G40 X0.573
 G0 Z0.1
 Z6.0 M9
 G91 G28 Z0
 T3 M06 (0.125 1/8 CENTER DRILL)
 S765 M03
 G0 G43 G54 G90 X2.5 Y1.5 Z6.0 H03
 G81 X2.5 Y1.5 Z-0.122 R0.1 F12.0
 X1.5
 X2.0 Y2.0
 G80
 G0 Z6.0
 G91 G28 Z0
 T4 M06 (0.2 DRILL)
 S888 M03
 G0 G43 G54 G90 X2.5 Y1.5 Z6.0 H04 M8
 G83 X2.5 Y1.5 Z-0.122 R0.1 Q0.1 F14.0
 X1.5
 X2.0 Y2.0
 G80
 G0 Z0.1
 G0 Z6.0 M9
 G91 G28 Z0 Y0
 M30
%
```

| Post name: | haas-mc2 |
|---|---|
| Post Source | haas-mc2 |
| Machine type: | Haas VMC |
| Control: | Haas |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, mild customization. |

```
%
O0001 (MC-TEST)
 T1 M06 (0.25 1/4 ENDMILL)
 G00 G90 G54 X0.573 Y1.95 S484 M03
 M08
 G43 H01 Z0.1
 G01 Z-0.122 F5.0
 G41 D01 X0.575 F10.0
 G03 X0.875 Y2.25 I0.0 J0.3
 G01 Y3.0
 G02 X1.0 Y3.125 I0.125 J0.0
 G01 X1.3584
 G02 X1.6038 Y2.9228 I0.0 J-0.25
 G03 X2.3962 Y2.9228 I0.3962 J0.0772
 G02 X2.6416 Y3.125 I0.2454 J-0.0478
 G01 X3.0
 G02 X3.125 Y3.0 I0.0 J-0.125
 G01 Y1.5
 G02 X2.5 Y0.875 I-0.625 J0.0
 G01 X1.5
 G02 X0.875 Y1.5 I0.0 J0.625
 G01 Y2.25
 G03 X0.575 Y2.55 I-0.3 J0.0
 G01 G40 X0.573
 G00 Z1.0
 M09
```

```
 M01
 T3 M06 (0.125 1/8 CENTER DRILL)
 G00 G90 G54 X2.5 Y1.5 S765 M03
 G43 H03 Z0.1
 G81 X2.5 Y1.5 Z-0.122 R0.1 F12.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 M01
 T4 M06 (0.2 DRILL)
 G00 G90 G54 X2.5 Y1.5 S888 M03
 M08
 G43 H04 Z0.1
 G83 X2.5 Y1.5 Z-0.122 R0.1 Q0.1 F14.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 G00 Z0.1
 G00 Z1.0
 G91 G28 Z0
 G28 Y0
 M01
 T1 M06
 M30
%
```

| Post name: | haas-sub |
| Post Source | haas-sub |
| Machine type: | Haas VMC |
| Control: | Haas w/Subroutines |
| Inch/Metric: | Inch |
| Circ interpolation: and R | R-word for Radius |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Highly customized, has subroutine call support, error checking. |

```
%
O0001 (MC-TEST)
 T1 M06 (0.25 1/4 ENDMILL)
 M08
 G00 G90 G54 X0.573 Y1.95 S484 M03
 G43 H01 Z0.1
 G01 Z-0.122 F5.0
 G41 D01 X0.575 F10.0
 G03 X0.875 Y2.25 R0.3
 G01 Y3.0
 G02 X1.0 Y3.125 R0.125
 G01 X1.3584
 G02 X1.6038 Y2.9228 R0.25
 G03 X2.0 Y2.5964 R0.4036
 X2.3962 Y2.9228 R0.4036
 G02 X2.6416 Y3.125 R0.25
 G01 X3.0
 G02 X3.125 Y3.0 R0.125
 G01 Y1.5
 G02 X2.5 Y0.875 R0.625
 G01 X1.5
 G02 X0.875 Y1.5 R0.625
 G01 Y2.25
 G03 X0.575 Y2.55 R0.3
 G01 G40 X0.573
 G00 Z0.1
 G00 G80 Z1.0 M09
 M01
 T3 M06 (0.125 1/8 CENTER DRILL)
 M08
 G00 G90 G54 X2.5 Y1.5 S765 M03
 G43 H03 Z0.1
 G81 X2.5 Y1.5 Z-0.122 R0.1 F12.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80 Z0.1
 G00 G80 Z1.0 M09
 M01
 T4 M06 (0.2 DRILL)
 M08
 G00 G90 G54 X2.5 Y1.5 S888 M03
 G43 H04 Z0.1
 G83 X2.5 Y1.5 Z-0.122 R0.1 Q0.1 F14.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80 Z0.1
 M30
%
```

Post name:              Haas-vmc
Post Source             Haas-vmc
Machine type:           Haas VMC
Control:                Haas
Inch/Metric:            Inch
Circ interpolation:  and R    R-word for Radius
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.

```
%
O0001
 T1 M06 (0.25 1/4 ENDMILL)
 G00 G90 G54 X0.573 Y1.95 S484 M03
 G43 H01 Z0.1 M08
 G01 Z-0.122 F5.0
 G41 D01 X0.575 F10.0
 G03 X0.875 Y2.25 R0.3
 G01 Y3.0
 G02 X1.0 Y3.125 R0.125
 G01 X1.3584
 G02 X1.6038 Y2.9228 R0.25
 G03 X2.3962 R0.4036
 G02 X2.6416 Y3.125 R0.25
 G01 X3.0
 G02 X3.125 Y3.0 R0.125
 G01 Y1.5
 G02 X2.5 Y0.875 R0.625
 G01 X1.5
 G02 X0.875 Y1.5 R0.625
 G01 Y2.25
 G03 X0.575 Y2.55 R0.3
 G01 G40 X0.573
 G00 Z0.1
 M09
 T3 M06 (0.125 1/8 CENTER DRILL)
 G00 G90 G54 X2.5 Y1.5 S765 M03
 G43 H03 Z0.1
 G81 X2.5 Y1.5 Z-0.122 R0.1 F12.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 T4 M06 (0.2 DRILL)
 G00 G90 G54 X2.5 Y1.5 S888 M03
 G43 H04 Z0.1 M08
 G83 X2.5 Y1.5 Z-0.122 R0.1 Q0.1 F14.0
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 G00 Z0.1
 G91 G28 Y0 Z0
 T1 M06
 M30
%
```

Post name:            Handyman
Post Source           Handyman
Machine type:         Handyman Mill
Control:              Bridgeport?
Inch/Metric:          Inch
Circ interpolation:   Incremental IJ
Auto 1st T-POSITION?  Not supported
Canned drill cycles:  yes
Post programmer notes: Source code looks good.

```
%
N001G70G75G17G90
N002G80
N003G0X.573Y1.95
N004G1Z.1F060
N005Z-.122F050
N006G41X.575Y1.95F100
N007G3I.575J2.25X.875Y2.25
N008G1X.875Y3.0
N009G2I1.0J3.0X1.0Y3.125
N010G1X1.3584Y3.125
N011G2I1.3584J2.875X1.6038Y2.9228
N012G3I2.0J3.0X2.3962Y2.9228
N013G2I2.6416J2.875X2.6416Y3.125
N014G1X3.0Y3.125
N015G2I3.0J3.0X3.125Y3.0
N016G1X3.125Y1.5
N017G2I2.5J1.5X2.5Y.875
N018G1X1.5Y.875
N019G2I1.5J1.5X.875Y1.5
N020G1X.875Y2.25
N021G3I.575J2.25X.575Y2.55
N022G1G40X.573Y2.55
N023Z.1F060
N024Z1.0
N025G0X9.888Y9.777
N026S0765M6T3
N027G0X9.888Y9.777
N028X2.5Y1.5
N029G81X2.5Y1.5Z-.122
N030X1.5Y1.5
N031X2.0Y2.0
N032G80
N033G0X9.888Y9.777
N034S0888M6T4
N035G0X9.888Y9.777
N036X2.5Y1.5
N037G83X2.5Y1.5Z-.122Z0.1
N038X1.5Y1.5
N039X2.0Y2.0
N040G80M02
E
```

Post name:              hard -omd
Post Source             hard-omd
Machine type:           Hardinge VMC 600II
Control:                Fanuc Series O-MD
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, mild customization, has error checking

```
O0001
N1G0G80G90G17G49G40
N15M6T1( 1/4" ENDMILL 0.25)
N20G54
N25X0.573Y1.95S484M03
N30G43Z1.0H1M08
N35Z0.1
N40G1Z-0.122F5.
N45G41D31X0.575F10.
N50G3X0.875Y2.25J0.3
N55G1Y3.0
N60G2X1.0Y3.125I0.125
N65G1X1.3584
N70G2X1.6038Y2.9228J-0.25
N75G3X2.3962I0.3962J0.0772
N80G2X2.6416Y3.125I0.2454J-0.0478
N85G1X3.0
N90G2X3.125Y3.0J-0.125
N95G1Y1.5
N100G2X2.5Y0.875I-0.625
N105G1X1.5
N110G2X0.875Y1.5J0.625
N115G1Y2.25
N120G3X0.575Y2.55I-0.3
N125G1G40X0.573
N130G0Z0.1M09
N135G91G28Z0
N140G80G90
```

```
N145M1
N3G0G80G90G17G49G40
N150M6T3( 1/8" CENTER DRILL 0.125)
N155G54
N160X2.5Y1.5S765M03
N165G43Z1.0H3M08
N170G98G81R0.1Z-0.122F12.
N175X1.5
N180X2.0Y2.0
N185G80M09
N190G91G28Z0
N195G80G90
N200M1
N4G0G80G90G17G49G40
N205M6T4( DRILL 0.2)
N210G54
N215X2.5Y1.5S888M03
N220G43Z1.0H4M08
N225G98G83R0.1Z-0.122Q0.1F14.
N230X1.5
N235X2.0Y2.0
N240G80M09
N245G91G28Z0
N250G28Y0
N255G80G90
N260M30
%
#< END OF MC-TEST >
```

```
Post name:                Hc-11mf
Post Source               Hc-11mf
Machine type:             Hicell HMC
Control:                  Fanuc 11MF
Inch/Metric:              Inch
Circ interpolation:       Incremental IJ
Auto 1st T-POSITION?      yes
Canned drill cycles:      yes
Post programmer notes:    Source code looks good, has B-axis indexing.  This is a dealer's standard post.
```

```
%
O0001(MC-TEST.TAP )                          N3T3M6(T03 1/8" CENTER DRILL 0.125)
N1T1M6(T01 1/4" ENDMILL 0.25)                N300G0G90G54S765T4M3
N100G0G90G54S484T3M3                         G0X2.5Y1.5
G0B0                                         G43Z.1H03
X.573Y1.95                                   G81G98Z-.122R.1F12.
G43Z.1H01M08                                 X1.5
G1Z-.122F5.                                  X2.0Y2.0
G41X.575F10.D31                              G0G80
G3X.875Y2.25J.3                              G91G30Z0M19
G1Y3.0                                       G30X0Y0
G2X1.0Y3.125I.125                            M1
G1X1.3584
G2X1.6038Y2.9228J-.25                        N4T4M6(T04 DRILL 0.2)
G3X2.3962Y2.9228I.3962J.0772                 N400G0G90G54S888T1M3
G2X2.6416Y3.125I.2454J-.0478                 G0X2.5Y1.5
G1X3.0                                       G43Z.1H04M08
G2X3.125Y3.0J-.125                           G83G98Z-.122R.1Q.1F14.
G1Y1.5                                       X1.5
G2X2.5Y.875I-.625                            X2.0Y2.0
G1X1.5                                       G0G80
G2X.875Y1.5J.625                             G0Z.1M09
G1Y2.25                                      G91G28Z0
G3X.575Y2.55I-.3                             M1
G1G40X.573
G0Z.1M09                                     G91G28X0Y0
G91G30Z0M19                                  G90M30
G30X0Y0                                      %
M1
```

| Post name: | Hcl-1917 |
| Post Source | Hcl-1917 |
| Machine type: | Hitachi MC |
| Control: | Seicos M-III |
| Inch/Metric: | Inch |
| Circ interpolation:  and R | R-word for Radius |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good.  This is a dealer's standard post. |

```
%
G18
N100(T01 1/4" ENDMILL 0.25)
G28V0H0M43
G00Z0.573Y1.95S484M13
G43X0.1H01
G01X-0.122F5.
G41D21Z0.575F10.
G03Z0.875Y2.25R0.3
G01Y3.0
G02Z1.0Y3.125R0.125
G01Z1.3584
G02Z1.6038Y2.9228R0.25
G03Z2.3962Y2.9228R0.4036
G02Z2.6416Y3.125R0.25
G01Z3.0
G02Z3.125Y3.0R0.125
G01Y1.5
G02Z2.5Y0.875R0.625
G01Z1.5
G02Z0.875Y1.5R0.625
G01Y2.25
G03Z0.575Y2.55R0.3
G01G40Z0.573
G00X0.1
G00G80X1M09
G30U0V0W0M45
M01
```

```
N300(T03 1/8" CENTER DRILL 0.125)
G28V0H0M43
G00Z2.5Y1.5S765M13
G43Z0.1H03
G81R0.1Z-0.122F12.
Z1.5
Z2.0Y2.0
G80
G00G80X1M09
G30U0V0W0M45
M01

N400(T04 DRILL 0.2)
G28V0H0M43
G00Z2.5Y1.5S888M13
G43Z0.1H04
G83R0.1Z-0.122Q0.1F14.
Z1.5
Z2.0Y2.0
X0.1
G80
G00G80X1M09
G80M06T01
G49X0.Y2.
M30
%
```

Post name:              Heid155
Post Source             Heid155
Machine type:           Cincinnati Sabre
Control:                Heidenhain 155 G-Code
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, has error checking.

```
 % G70
 N10 T1 G17 S484
 N20 G00 G90 G40 X+0.573 Y+1.95 M13
 N30 Z+0.1
 N40 G01 Z-0.122 F5
 N50 G41 X+0.575 F10
 N60 I+0.575 J+2.25 G03 X+0.875 Y+2.25
 N70 G01 Y+3.0
 N80 I+1.0 J+3.0 G02 X+1.0 Y+3.125
 N90 G01 X+1.3584
 N100 I+1.3584 J+2.875 G02 X+1.6038 Y+2.9228
 N110 I+2.0 J+3.0 G03 X+2.0 Y+2.5964
 N120 I+2.0 J+3.0 G03 X+2.3962 Y+2.9228
 N130 I+2.6416 J+2.875 G02 X+2.6416 Y+3.125
 N140 G01 X+3.0
 N150 I+3.0 J+3.0 G02 X+3.125 Y+3.0
 N160 G01 Y+1.5
 N170 I+2.5 J+1.5 G02 X+2.5 Y+0.875
 N180 G01 X+1.5
 N190 I+1.5 J+1.5 G02 X+0.875 Y+1.5
 N200 G01 Y+2.25
 N210 I+0.575 J+2.25 G03 X+0.575 Y+2.55
 N220 G01 G40 X+0.573
 N230 G00 Z+0.1
 N240 Z+1.0 G38 M00
 N250 T3 G17 S765
 N260 G81 P01+0.1 P02-0.122 P03-0.122 P04 0 P05 12
 N270 G00 G90 G40 X+2.5 Y+1.5 Z+0.1 M13 G79
 N280 X+1.5 Y+1.5 G79
 N290 X+2.0 Y+2.0 G79
 N300 Z+1.0 G38 M00
 N310 T4 G17 S888
 N320 G83 P01+0.1 P02-0.122 P03+0.1 P04 0 P05 14
 N330 G00 G90 G40 X+2.5 Y+1.5 Z+0.1 M13 G79
 N340 X+1.5 Y+1.5 G79
 N350 X+2.0 Y+2.0 G79
 N360 M02
 N9999 % G70
```

| Post name: | Heid415 |
|---|---|
| Post Source | Heid415 |
| Machine type: | Cincinnati Sabre |
| Control: | Heidenhain 415 G-Code |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, has error checking. |

```
% MC-TEST G70
; HIED415 MC-TEST
;  Mon Apr 09 10:15:43 2001'
;T1 0.25 ENDMILL
N10 T1 G17 S484 M6
N20 M1
N30 G00 G90 G40 X+0.573 Y+1.95 M13
N40 Z+0.1
N50 G01 Z-0.122 F5
N60 G41 X+0.575 F10
N70 I+0.575 J+2.25 G03 X+0.875 Y+2.25
N80 G01 Y+3.0
N90 I+1.0 J+3.0 G02 X+1.0 Y+3.125
N100 G01 X+1.3584
N110 I+1.3584 J+2.875 G02 X+1.6038 Y+2.9228
N120 I+2.0 J+3.0 G03 X+2.0 Y+2.5964
N130 I+2.0 J+3.0 G03 X+2.3962 Y+2.9228
N140 I+2.6416 J+2.875 G02 X+2.6416 Y+3.125
N150 G01 X+3.0
N160 I+3.0 J+3.0 G02 X+3.125 Y+3.0
N170 G01 Y+1.5
N180 I+2.5 J+1.5 G02 X+2.5 Y+0.875
N190 G01 X+1.5
N200 I+1.5 J+1.5 G02 X+0.875 Y+1.5
N210 G01 Y+2.25
N220 I+0.575 J+2.25 G03 X+0.575 Y+2.55
N230 G01 G40 X+0.573
N240 G00 Z+0.1
N250 Z+1.0 M05
N260 T3 G17 S765 M6
N270 M1
;T3 0.125 CENTER DRILL
N280 G00 G90 G40 X+2.5 Y+1.5 M13
N290 G81 P01+0.1 P02-0.122 P03-0.122 P04 0 P05 12
N300 Z+0.1 G79
N310 X+1.5 Y+1.5 G79
N320 X+2.0 Y+2.0 G79
N330 Z+1.0 M05
N340 T4 G17 S888 M6
N350 M1
;T4 0.2 DRILL
N360 G00 G90 G40 X+2.5 Y+1.5 M13
N370 G83 P01+0.1 P02-0.122 P03+0.1 P04 0 P05 14
N380 Z+0.1 G79
N390 X+1.5 Y+1.5 G79
N400 X+2.0 Y+2.0 G79
N410 M2
% MC-TEST G70
```

| Post name: | Heid-415 |
| --- | --- |
| Post Source | Heid -415 |
| Machine type: | Generic VMC |
| Control: | Heidenhain 415 G-Code |
| Inch/Metric: | Inch |
| Circ interpolation: and R | R-word for Radius |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, has error checking.  This is a dealer's standard post. |

```
%1 G70
N1 T0 G17 G00 G40 G90 Z+1.0
N2 X10 Y10 M00 L+0.0 R+0.0
N3 X+0.573 Y+1.95 M03
N4 Z+0.1
N5 G01 Z-0.122 F5
N6 G41 X+0.575 F10
N7 G03 X+0.875 Y+2.25 R+0.3
N8 G01 Y+3.0
N9 G02 X+1.0 Y+3.125 R+0.125
N10 G01 X+1.3584
N11 G02 X+1.6038 Y+2.9228 R+0.25
N12 G03 X+2.0 Y+2.5964 R+0.4036
N13 X+2.3962 Y+2.9228 R+0.4036
N14 G02 X+2.6416 Y+3.125 R+0.25
N15 G01 X+3.0
N16 G02 X+3.125 Y+3.0 R+0.125
N17 G01 Y+1.5
N18 G02 X+2.5 Y+0.875 R+0.625
N19 G01 X+1.5
N20 G02 X+0.875 Y+1.5 R+0.625
N21 G01 Y+2.25
N22 G03 X+0.575 Y+2.55 R+0.3
N23 G01 G40 X+0.573
N24 G00 Z+0.1 M09
N25 T0 G17 G00 G40 G90 Z+1.0
N26 X10 Y10 M00 L+0.0 R+0.0
N27 X+9.888 Y+9.777 M03
N28 X+2.5 Y+1.5
N29 G81 P01+0.1 P02-0.122 P03-0.122 P04 0 P0512
N30 X+1.5 M99
N31 X+2.0 Y+2.0 M99
N32 T0 G17 G00 G40 G90 Z+1.0
N33 X10 Y10 M00 L+0.0 R+0.0
N34 X+9.888 Y+9.777 M03
N35 X+2.5 Y+1.5
N36 G83 P01+0.1 P02-0.122 P03+0.1 P04 0 P0514
N37 X+1.5 M99
N38 X+2.0 Y+2.0 M99
N39 T0 G00 Z+1.0
N40 X+2.0 Y+2.0 M02
N99999 %1 G70
```

Post name:          hicel-23
Post Source          hicel-23
Machine type:          Hitachi MC
Control:          Seicos L-III
Inch/Metric:          Inch
Circ interpolation:  and R          R-word for Radius
Auto 1st T-POSITION?          yes
Canned drill cycles:          yes
Post programmer notes:    Highly customized dealer's standard post.  This is a mill post for live tool milling on a Hicell Lathe

```
%
O0001(HICELL 23 - PROGRAM 0001)
(MC-TEST)

G50S2000
G30U0
G30U0V0W0H0M40
G80M45
G10P0Z9.888
(2ND ZERO POINT)
(X-  )
(Y-  )
M1

N5000 (ENGAGE C)
G0G28H0M43
G50C0.0
G145
M1

N100   ( LIVE X AXIS ENDMILL 0.25)
G30U0V0W0
T010100G19G23
G98M44
G97S484M13
G140
C0.0
Y-1.95Z0.573X1.0
X0.1M08
G01X-0.122F5.
G41Z0.575F10.
G03Y-2.25Z0.875R0.3
G01Y-3.0
G02Y-3.125Z1.0R0.125
G01Z1.3584
G02Y-2.9228Z1.6038R0.25
G03Y-2.5964Z2.0R0.4036
Y-2.9228Z2.3962R0.4036
G02Y-3.125Z2.6416R0.25
G01Z3.0
G02Y-3.0Z3.125R0.125
G01Y-1.5
G02Y-0.875Z2.5R0.625
G01Z1.5
G02Y-1.5Z0.875R0.625
G01Y-2.25
G03Y-2.55Z0.575R0.3
```

```
G01G40Z0.573
G00X0.1G40
G00X1.0M09
G80G30U0V0W0M45
M01

N300   ( LIVE X AXIS CENTER DRILL 0.125)
G30U0V0W0
T030300G19G23
G98M44
G97S765M13
G140
C0.0
Y-1.5Z2.5X1.0
G81R0.1X-0.122F12.
Z1.5
Y-2.0Z2.0
G80
G00X1.0
G80G30U0V0W0M45
M01

N400   ( LIVE X AXIS DRILL 0.2)
G30U0V0W0
T040400G19G23
G98M44
G97S888M13
G140
C0.0
Y-1.5Z2.5X1.0
G83R0.1X-0.122Q0.1P0F14.
Z1.5M08
Y-2.0Z2.0
G80
G00X1.0M09
G80G30U0V0W0M45

N5001 (DIS-ENGAGE C)
M45
G0G28H0M41
G143
M01
M12
/M99
M30
%
```

| Post name: | Hillyer |
|---|---|
| Post Source | Hillyer |
| Machine type: | Hillyer Mill |
| Control: | Allen Bradley 9260 |
| Inch/Metric: | Inch |
| Circ interpolation:  and R | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
%
O1
 (MC-TEST  Mon Apr 09 10:20:06 2001')
N111 G90 G92 X9.888 Y9.777 Z0.
 (T01-0.25-ENDMILL)
 G00 G43 X.573 Y1.95 Z1.0 H01 M8
 S484 M3
 Z.1
 G01 Z-.122 F5.
 G41 X.575 F10. D101
 G03 X.875 Y2.25 J.3
 G01 Y3.0
 G02 X1.0 Y3.125 I.125
 G01 X1.3584
 G02 X1.6038 Y2.9228 J-.25
 G03 X2.3962 Y2.9228 I.3962 J.0772
 G02 X2.6416 Y3.125 I.2454 J-.0478
 G01 X3.0
 G02 X3.125 Y3.0 J-.125
 G01 Y1.5
 G02 X2.5 Y.875 I-.625
 G01 X1.5
 G02 X.875 Y1.5 J.625
 G01 Y2.25
 G03 X.575 Y2.55 I-.3
 G01 G40 X.573
 G00 Z.1 M09
 G0 G49 Z0. H00 M5
 G91 G28 X0. Y0.
```

```
 M00

N333 G90 G92 X9.888 Y9.777 Z0.
 (T03-0.125-CENTER DRILL)
 G00 G43 X2.5 Y1.5 Z1.0 H03
 S765 M3
 G81 G98 X2.5 Y1.5 Z-.122 R.1 F12.
 X1.5
 X2.0 Y2.0
 G80
 Z1.0
 G0 G49 Z0. H00 M5
 G91 G28 X0. Y0.
 M00

N444 G90 G92 X9.888 Y9.777 Z0.
 (T04-0.2-DRILL)
 G00 G43 X2.5 Y1.5 Z1.0 H04 M8
 S888 M3
 G83 G98 X2.5 Y1.5 Z-.122 R.1 Q.1 F14.
 X1.5
 X2.0 Y2.0
 G80
 Z1.0 M09
 G0 G49 Z0. H00 M5
 G91 G28 X0 Y0
 M30
%
```

Post name:                  Hurco
Post Source                 Hurco
Machine type:               Hurco VMC
Control:                    Hurco Ultramax
Inch/Metric:                Inch
Circ interpolation:         Absolute  IJ
Auto 1st T-POSITION?        yes
Canned drill cycles:        yes
Post programmer notes:      Source code looks good.


```
%                                          N50 G0 Z.1 M9
N2 G70 G75 G90                             N52 M5
N4 G0 T01 M6                               N54 G0 M25
N6 G0 X.573 Y1.95                          N56 G0 T03 M6
N8 S484 M3                                 N58 G0 X2.5 Y1.5
N10 Z.1                                    N60 S765 M3
N12 G1 Z-.122 F5.0 M8                      N62 G0 Z.1
N14 G41 X.575 Y1.95 F10.0                  N64 G81 X2.5 Y1.5 Z.222 F12.0
N16 G3 X.875 Y2.25 I.575 J2.25             N66 X1.5
N18 G1 Y3.0                                N68 X2.0 Y2.0
N20 G2 X1.0 Y3.125 I1.0 J3.0               N70 G80
N22 G1 X1.3584                             N72 M5
N24 G2 X1.6038 Y2.9228 I1.3584 J2.875      N74 G0 M25
N26 G3 X2.0 Y2.5964 I2.0 J3.0              N76 G0 T04 M6
N28 X2.3962 Y2.9228 I2.0 J3.0              N78 G0 X2.5 Y1.5
N30 G2 X2.6416 Y3.125 I2.6416 J2.875       N80 S888 M3
N32 G1 X3.0                                N82 G0 Z.1
N34 G2 X3.125 Y3.0 I3.0 J3.0               N84 G83 X2.5 Y1.5 Z.222 Z.1 Z.1 F14.0 M8
N36 G1 Y1.5                                N86 X1.5
N38 G2 X2.5 Y.875 I2.5 J1.5                N88 X2.0 Y2.0
N40 G1 X1.5                                N90 G80 M9
N42 G2 X.875 Y1.5 I1.5 J1.5                N92 M5
N44 G1 Y2.25                               N94 G0 M25
N46 G3 X.575 Y2.55 I.575 J2.25             N96 M2
N48 G1 G40 X.573 Y2.55                     E
```

```
Post name:              Hurco-1
Post Source             Hurco-1
Machine type:           Hurco
Control:                Hurco
Inch/Metric:            Inch
Circ interpolation:     unsigned Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.
```

```
%
N0010 T1 M06
N0020 G90 S484 M03
N0030 G0 X0.573 Y1.95
N0040 M7
N0050 Z0.1
N0060 G1 Z-0.122 F5.0
N0070 G41 X0.575 F10.0
N0080 G3 X0.875 Y2.25 I0.575 J2.25
N0090 G1 Y3.0
N0100 G2 X1.0 Y3.125 I1.0 J3.0
N0110 G1 X1.3584
N0120 G2 X1.6038 Y2.9228 I1.3584 J2.875
N0130 G3 X2.0 Y2.5964 I2.0 J3.0
N0140 X2.3962 Y2.9228 I2.0 J3.0
N0150 G2 X2.6416 Y3.125 I2.6416 J2.875
N0160 G1 X3.0
N0170 G2 X3.125 Y3.0 I3.0 J3.0
N0180 G1 Y1.5
N0190 G2 X2.5 Y0.875 I2.5 J1.5
N0200 G1 X1.5
N0210 G2 X0.875 Y1.5 I1.5 J1.5
N0220 G1 Y2.25
N0230 G3 X0.575 Y2.55 I0.575 J2.25
N0240 G1 G40 X0.573
N0250 G0 Z0.1
N0260 M9
N0270 Z1.0
N0280 X9.888 Y9.777
N0290 T3 M06
N0300 G90 S765 M03
N0310 G0 X9.888 Y9.777
N0320 X2.5 Y1.5
N0330 G81 Z-0.122 F12.0
N0340 X1.5
N0350 X2.0 Y2.0
N0360 G80
N0370 G0 Z1.0
N0380 X9.888 Y9.777
N0390 T4 M06
N0400 G90 S888 M03
N0410 G0 X9.888 Y9.777
N0420 M8
N0430 X2.5 Y1.5
N0440 G83 Z-0.122 F14.0
N0450 X1.5
N0460 X2.0 Y2.0
N0470 G80
N0480 M9
N0490 M2
E
~
```

Post name:          Hurco-2
Post Source         Hurco-2
Machine type:       Hurco
Control:            Hurco
Inch/Metric:        Inch
Circ interpolation:  Absolute IJ
Auto 1st T-POSITION?  Not supported
Canned drill cycles:  yes
Post programmer notes:  Source code looks good, mild customization.

```
%                                      N0030 M25 F4.0
N0010 M25 F4.0                          T3 M06
 T1 M06                                 G90 S765 M03
 G90 S484 M03                           G0 X9.888 Y9.777
 G0 X0.573 Y1.95                        M8
 M8                                     X2.5 Y1.5
 Z0.1                                   G00 Z0.1
 G1 Z-0.122 F5.0                        G81 Z0.222 F12.0
 G41 X0.575 F10.0                       X1.5
 G3 X0.875 Y2.25 I0.575 J2.25           X2.0 Y2.0
 G1 Y3.0                                G80
 G2 X1.0 Y3.125 I1.0 J3.0               M9
 G1 X1.3584                             G0 Z1.0
 G2 X1.6038 Y2.9228 I1.3584 J2.875      X9.888 Y9.777
 G3 X2.0 Y2.5964 I2.0 J3.0             N0040 M25 F4.0
 X2.3962 Y2.9228 I2.0 J3.0              T4 M06
 G2 X2.6416 Y3.125 I2.6416 J2.875       G90 S888 M03
 G1 X3.0                                G0 X9.888 Y9.777
 G2 X3.125 Y3.0 I3.0 J3.0               M8
 G1 Y1.5                                X2.5 Y1.5
 G2 X2.5 Y0.875 I2.5 J1.5               G00 Z0.1
 G1 X1.5                                G83 Z0.222 Z0.1 Z0.1 F14.0
 G2 X0.875 Y1.5 I1.5 J1.5               X1.5
 G1 Y2.25                               X2.0 Y2.0
 G3 X0.575 Y2.55 I0.575 J2.25           G80
 G1 G40 X0.573                          M9
 G0 Z0.1                                M25
 M9                                     M2
 Z1.0                                  E
 X9.888 Y9.777                          ~
```

Post name:                 Hurco-mc
Post Source                Hurco-mc
Machine type:              Hurco VMC
Control:                   Hurco Ultramax
Inch/Metric:               Inch
Circ interpolation:        Absolute IJ
Auto 1st T-POSITION?       yes
Canned drill cycles:       yes
Post programmer notes:     Source code looks good, has inch-metric support.

```
%
N0010 G00G17G40G75G90
N0020 T01M06
N0030 G00X0.573Y1.95Z1.0S484M3
N0040 Z0.1
N0050 G01Z-0.122F5.0M08
N0060 G41X0.575Y1.95F10.0
N0070 G03X0.875Y2.25I0.575J2.25
N0080 G01Y3.0
N0090 G02X1.0Y3.125I1.0J3.0
N0100 G01X1.3584
N0110 G02X1.6038Y2.9228I1.3584J2.875
N0120 G03X2.0Y2.5964I2.0J3.0
N0130 X2.3962Y2.9228I2.0J3.0
N0140 G02X2.6416Y3.125I2.6416J2.875
N0150 G01X3.0
N0160 G02X3.125Y3.0I3.0J3.0
N0170 G01Y1.5
N0180 G02X2.5Y0.875I2.5J1.5
N0190 G01X1.5
N0200 G02X0.875Y1.5I1.5J1.5
N0210 G01Y2.25
N0220 G03X0.575Y2.55I0.575J2.25
N0230 G01G40X0.573Y2.55
N0240 G00Z0.1M09
N0250 G00Z1.0
N0260 T03M06
N0270 G00X2.5Y1.5Z1.0S765M3
N0280 G00Z0.1
N0290 G81X2.5Y1.5Z0.222F12.0
N0300 X1.5
N0310 X2.0Y2.0
N0320 G80
N0330 G00Z1.0
N0340 T04M06
N0350 G00X2.5Y1.5Z1.0S888M3
N0360 G00Z0.1
N0370 G83X2.5Y1.5Z0.222Z0.1Z0.1F14.0M08
N0380 X1.5
N0390 X2.0Y2.0
N0400 G80
N0410 G00Z0.1M09
N0420 T01M06
N0430 M02
%
```

| | |
|---|---|
| Post name: | hydra-3 |
| Post Source | hydra-3 |
| Machine type: | Moog Hydrapath-III VMC |
| Control: | |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, mild customization. |

```
((MC-TEST))
(UCO)
%
((
((
((
((
((
(UCI)
G70G17G90M9
G99X9.888Y9.777M9
((
((
N1T1M06
((T1 1/4" ENDMILL 0.25
G0X.573Y1.95S484M3(UFO,F1)
Z.1M8
G1Z-.122F5.
G41X.575F10.
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962Y2.9228I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
```

```
G2X.875Y1.5J.625
G1Y2.25
G3X.575Y2.55I-.3
G1G40X.573
G0Z.1M09
G0Z1.0
((
((
N3T3M06
((T3 1/8" CENTER DRILL 0.125
G0X2.5Y1.5S765M3(UFO,F1)
G81Z-.122R.1F12.M81
X1.5
X2.0Y2.0
G80M82
G0Z1.0
((
((
N4T4M06
((T4 DRILL 0.2
G0X2.5Y1.5S888M3(UFO,F1)
G83Z-.122R.1E.1F14.M81M8
X1.5
X2.0Y2.0
G80M82
G0Z.1M09
G0Z0.M25
M5M9(UFO,F0)(UTO,L0)
G0X9.888Y9.777
M2
%
```

| Post name: | Inger |
|---|---|
| Post Source | Inger |
| Machine type: | Ingersol Mill |
| Control: | |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | High customization, prompts for inch-metric output. |

```
 (MC-TEST.TAP)$
 (DESCRIPTION: )$
 G1$
 G15$
 G17$
 G40$
 G50$
 G71$
 G76$
 G90$
 G94$
 M05$
 M09$
 M48$
 M25$
 M62$
 M91$
 N5T1M16 (0.25 ENDMILL 1/4")$
 N10G1Z25.4F8000(CLEARANCE PLANE)$
 N15C-90$
 N20S484M3$
 N25M24$
 N30G01X14.554Y49.53F8000$
 N35Z2.54$
 N40G01Z-3.099F127.0$
 N45G41X14.605F254.0$
 N50G03X22.225Y57.15I0.0J7.62$
 N55G01Y76.2$
 N60G02X25.4Y79.375I3.175J0.0$
 N65G01X34.504$
 N70G02X40.737Y74.239I0.0J-6.35$
 N75G03X60.863I10.063J1.961$
 N80G02X67.096Y79.375I6.233J-1.214$
 N85G01X76.2$
 N90G02X79.375Y76.2I0.0J-3.175$
 N95G01Y38.1$
```

```
 N100G02X63.5Y22.225I-15.875J0.0$
 N105G01X38.1$
 N110G02X22.225Y38.1I0.0J15.875$
 N115G01Y57.15$
 N120G03X14.605Y64.77I-7.62J0.0$
 N125G01$
 N130G40X14.554$
 N135G01Z2.54F8000$
 N140Z25.4M09$
 N145T3M16 (0.125 CENTER DRILL 1/8")$
 N150G1Z25.4F8000(CLEARANCE PLANE)$
 N155C-90$
 N160S765M3$
 N165M24$
 N170G01X251.155Y248.336F8000$
 N175X63.5Y38.1$
 N180Z2.54$
 N185G81Z-3.099R2.54$
 N190X38.1$
 N195X50.8Y50.8$
 N200G80$
 N205T4M16 (0.2 DRILL)$
 N210G1Z25.4F8000(CLEARANCE PLANE)$
 N215C-90$
 N220S888M3$
 N225M24$
 N230G01X251.155Y248.336F8000$
 N235X63.5Y38.1$
 N240Z2.54$
 N245G83Z-3.099R2.54P2.54$
 N250X38.1$
 N255X50.8Y50.8$
 N260G80$
 N265G1Z25.4F8000$
 N270M2$
```

| | |
|---|---|
| Post name: | Ingersol |
| Post Source | Ingersol |
| Machine type: | Ingersol Mill |
| Control: | Allen Bradley 8200 |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, mild customization. |

```
%$
G70$
G90$
M06$
T$
M00$
(PART_MC-TEST)$
()$
(OPER_)$
()$
(STOCK_)$
M00$
N1G00Z35.4331$
N2G00X0.573Y1.950$
N3Z0.100$
N4G01Z-0.122F5.$
N5G41X0.575F10.$
N6G03X0.875Y2.250I0.000J0.300$
N7G01Y3.000$
N8G02X1.000Y3.125I0.125J0.000$
N9G01X1.3584$
N10G02X1.6038Y2.9228I0.000J-0.250$
N11G03X2.3962I0.3962J0.0772$
N12G02X2.6416Y3.125I0.2454J-0.0478$
N13G01X3.000$
N14G02X3.125Y3.000I0.000J-0.125$
N15G01Y1.500$
N16G02X2.500Y0.875I-0.625J0.000$
N17G01X1.500$
N18G02X0.875Y1.500I0.000J0.625$
N19G01Y2.250$
N20G03X0.575Y2.550I-0.300J0.000$
N21G01G40X0.573$
N22G00Z0.100$
N23Z1.000M05$
N24M01$
N25T$
N26G00X2.500Y1.500$
N27G81X2.500Y1.500Z1.000Q0.100R-
0.122F12.000$
N28G81X1.500$
N29G81X2.000Y2.000$
N30G80$
N31M01$
N32T$
N33G00X2.500Y1.500$
N34G83X2.500Y1.500Z1.000Q0.100R-
0.122F14.000P0.100$
N35G83X1.500$
N36G83X2.000Y2.000$
N37G80$
N38M00$
%$
```

| Post name: | Kira-omc |
|---|---|
| Post Source | Kira-omc |
| Machine type: | Kira-MC |
| Control: | Fanuc OMC |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good.  This is a dealer's standard post. |

```
%
O0001 (MC-TEST)
N1G0G91G28Z0M19
G30Z0
T1M6(T01 #01 1/4" ENDMILL 0.25)
G28Z0
N100G0G90G54S484M3
G0X.573Y1.95
G43Z.1H01M08
G1Z-.122F5.
G41X.575F10.D1
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962Y2.9228I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
G2X.875Y1.5J.625
G1Y2.25
G3X.575Y2.55I-.3
G1G40X.573
G0Z.1M09
G91G28Z0
M1

N3G0G91G28Z0M19
```

```
G30Z0
T3M6(T03 #03 1/8" CENTER DRILL 0.125)
G28Z0
N300G0G90G54S765M3
G0X2.5Y1.5
G43Z.1H03
G81G98Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
G91G28Z0
M1

N4G0G91G28Z0M19
G30Z0
T4M6(T04 #04 DRILL 0.2)
G28Z0
N400G0G90G54S888M3
G0X2.5Y1.5
G43Z.1H04M08
G83G98Z-.122R.1Q.1F14.
X1.5
X2.0Y2.0
G80
G0Z.1M09
G91G28Z0
M1

G91G28X0Y0
G90M30
%
```

| Post name: | Kitamura |
| Post Source | Kitamura |
| Machine type: | Kitamuura VMC |
| Control: | Seicos |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Highly customized, has support for G12 & G13 Helical |

```
%
O0001 (MC-TEST.TAP )
N1T1M6(T01 1/4" ENDMILL 0.25)
N100G0G90G54S484T3M3
M8
G43H01X0.573Y1.95Z1.
Z0.1
G1Z-0.122F5.
G41X0.575F10.D51
G3X0.875Y2.25J0.3
G1Y3.
G2X1.Y3.125I0.125
G1X1.3584
G2X1.6038Y2.9228J-0.25
G3X2.3962Y2.9228I0.3962J0.0772
G2X2.6416Y3.125I0.2454J-0.0478
G1X3.
G2X3.125Y3.J-0.125
G1Y1.5
G2X2.5Y0.875I-0.625
G1X1.5
G2X0.875Y1.5J0.625
G1Y2.25
G3X0.575Y2.55I-0.3
G1G40X0.573
G0Z0.1
G0Z1.M9
```

```
G91G28Z0
M1

N3T3M6(T03 1/8" CENTER DRILL 0.125)
N300G0G90G54S765T4M3
G43H03X2.5Y1.5Z1.
G81G99Z-0.122R0.1F12.
X1.5
X2.Y2.
G80Z1.
G91G28Z0
M1

N4T4M6(T04 DRILL 0.2)
N400G0G90G54S888T1M3
M8
G43H04X2.5Y1.5Z1.
G83G99Z-0.122R0.1Q0.1F14.
X1.5
X2.Y2.
G80
G0Z1.M9
G91G28Z0
M1

G90M30
%
```

| | |
|---|---|
| Post name: | Kit-FOM |
| Post Source | Kit-FOM |
| Machine type: | Generic VMC |
| Control: | Fanuc OM |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, mild customization, supports a custom tapping code. |

```
%
:0001 (MC-TEST)
(X0  )
(Y0  )
(Z0  )
N1T1M6(1/4 CARBIDE E.M.)
G0G90G54X.573Y1.95S484M03
G43Z1.0H1T3M8
Z.1
G1Z-.122F5.
G41X.575F10.D1
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962Y2.9228I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
G2X.875Y1.5J.625
G1Y2.25
G3X.575Y2.55I-.3
G1G40X.573
G0Z.1
```

```
M9
G0G80Z1.0
G91G28Z0
N3T3M6(1/8 CENTER DRILL)
G0G90G54X2.5Y1.5S765M03
G43Z1.0H3T4
G99G81Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
G0G80Z1.0
G91G28Z0
N4T4M6( 0.2 DRILL)
G0G90G54X2.5Y1.5S888M03
G43Z1.0H4T1M8
G99G83Z-.122R.1Q.1F14.
X1.5
X2.0Y2.0
G80
G0Z.1
M9
G0G80Z1.0
G91G28Z0
G30X0Y0
M6
M30
%
```

Post name:              Kitta
Post Source             Kitta
Machine type:           Kitamuura Machine Ctr
Control:                Fanuc 6MB
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.

```
0000
G00G17G28G40G49G90
N5G00G28H0Z0M09
N10G54
N15T01
M6
N20G00X9.888Y9.777
N25X0.573Y1.95S484M03
N30G43Z0.1H01M08
N35G01Z-0.122F5.
N40G41D31X0.575F10.
N45G03X0.875Y2.25I0.J0.3
N50G01Y3.
N55G02X1.Y3.125I0.125J0.
N60G01X1.3584
N65G02X1.6038Y2.9228I0.J-0.25
N70G03X2.3962I0.3962J0.0772
N75G02X2.6416Y3.125I0.2454J-0.0478
N80G01X3.
N85G02X3.125Y3.I0.J-0.125
N90G01Y1.5
N95G02X2.5Y0.875I-0.625J0.
N100G01X1.5
N105G02X0.875Y1.5I0.J0.625
N110G01Y2.25
N115G03X0.575Y2.55I-0.3J0.
N120G01G40X0.573
N125G00Z0.1
N130G00G28H0Z0M09
N135Z1.
N140X9.888Y9.777
N145T03
M6
N150X2.5Y1.5S765M03
N155G43Z0.1H03
N160G81G99Z-0.122R0.1F12.
N165X1.5
N170X2.Y2.
N175G80
N180G00G28H0Z0M09
N185X9.888Y9.777
N190T04
M6
N195X2.5Y1.5S888M03
N200G43Z0.1H04M08
N205G83G99Z-0.122Q0.1R0.1F14.
N210X1.5
N215X2.Y2.
N220G80
N225G00G28H0Z0M09
N230M30
%
```

```
#< MC-TEST  Mon Apr 09 10:28:04 2001'
N001G51X009888Y09777M07M06M18
N002G51X000573Y0195
N003G53Z0001
N004G55Z000122M17
N005G52G41X000575
N006G52X000875Y0225I00J003
N007G52Y03
N008G52X001Y03125I00125J00
N009G52X0013584
N010G51X0016038Y029228I00J-0025
N011G51X002Y025964I003962J000772
N012G52X0023962Y029228I00J004036
N013G52X0026416Y03125I002454J-000478
N014G52X003
N015G51X003125Y03I00J-00125
N016G51Y015
N017G51X0025Y00875I-00625J00
N018G52X0015
N019G52X000875Y015I00J00625
N020G52Y0225
N021G52X000575Y0255I-003J00
N022G52G40X000573
N023G53Z0001M18
N024G51X009888Y09777Z001M09M06M18
N025G51X0025Y015
N026G55Z000122M17
N027G53Z0M18
N028G52X0015
N029G55Z000122M17
N030G53Z0M18
N031G52X002Y02
N032G55Z000122M17
N033G53Z0M18
N034G51X009888Y09777M08M06M18
N035G51X0025Y015
N036G55Z000122M17
N037G53Z0M18
N038G52X0015
N039G55Z000122M17
N040G53Z0M18
N041G52X002Y02
N042G55Z000122M17
N043G53Z0M18
N044G53Z0001
N045G55Z000122M17
N046G53Z0M18
N047M30
%<END OF MC-TEST >#
```

Post name:                Mak-16m
Post Source               Mak-16m
Machine type:             Makino Graphic Mill
Control:                  Fanuc 16M
Inch/Metric:              Inch
Circ interpolation:       Incremental IJ
Auto 1st T-POSITION?      Not supported
Canned drill cycles:      yes
Post programmer notes:    Source code looks OK, mild customization.

```
%
O0001(MC-TEST)
G91G28Z0
G49G90
T01(T01 1/4" ENDMILL 0.25)
M7
S484M03
G00G54G90X.573Y1.95
G43H01Z1.0
G05P1000
Z.1
G01Z-.122F5.
G41D21X.575F10.
G03X.875Y2.25J.3
G01Y3.0
G02X1.0Y3.125I.125
G01X1.3584
G02X1.6038Y2.9228J-.25
G03X2.3962I.3962J.0772
G02X2.6416Y3.125I.2454J-.0478
G01X3.0
G02X3.125Y3.0J-.125
G01Y1.5
G02X2.5Y.875I-.625
G01X1.5
G02X.875Y1.5J.625
G01Y2.25
G03X.575Y2.55I-.3
G01G40X.573
G00Z.1M9

G00G90Z1.0
G91G28Z0
G49G90
T03(T03 1/8" CENTER DRILL 0.125)
S765M03
G00G54G90X2.5Y1.5
G43H03Z1.0
G81Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
G00G90Z1.0
G91G28Z0
G49G90
T04(T04 DRILL 0.2)
M7
S888M03
G00G54G90X2.5Y1.5
G43H04Z1.0
G83Z-.122R.1Q.1F14.
X1.5
X2.0Y2.0
G80
G00Z.1
G00G90Z1.0
G05P0
G91G28Z0M09
M49
G90M99
%
```

| Post name: | Makino |
|---|---|
| Post Source | Makino |
| Machine type: | Makino VMC |
| Control: | Fanuc 11M |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, has inch-metric output support. |

```
%
O0001( MC-TEST )
G0G17G40G80G98G90G20
G55
N100T1M06  (T01 1/4" ENDMILL 0.25)
G0X.573Y1.95S484M03
G43Z1.0H1
Z.1
G1Z-.122F5.M08
G41X.575F10.D31
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
G2X.875Y1.5J.625
G1Y2.25
G3X.575Y2.55I-.3
G1G40X.573
G0Z.1M9
N300T3M06  (T03 1/8" CENTER DRILL 0.125)
G0X2.5Y1.5S765M03
G43Z1.0H3
G81G98Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
N400T4M06  (T04 DRILL 0.2)
G0X2.5Y1.5S888M03
G43Z1.0H4
G83G98Z-.122R.1Q.1F14.M08
X1.5
X2.0Y2.0
G80
G0Z.1M09
M6
M30
%
```

| Post name: | Mat-11M |
|---|---|
| Post Source | Mat-11M |
| Machine type: | Matsuura MC-760V |
| Control: | Fanuc 11M |
| Inch/Metric: | Both |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, mild customization, has inch-metric output support. |

```
%
O0000( MC-TEST )
N1000G17G20
N1005G40G49G54G80G90G94G99
N1010T3M00
 (T01 1/4" ENDMILL 0.25)
N1015G0G43X.573Y1.95Z1.0S484M03H1
N1020Z.1
N1025G1Z-.122F5.M08
N1030G41X.575F10.D50
N1035G3X.875Y2.25J.3
N1040G1Y3.0
N1045G2X1.0Y3.125I.125
N1050G1X1.3584
N1055G2X1.6038Y2.9228J-.25
N1060G3X2.3962I.3962J.0772
N1065G2X2.6416Y3.125I.2454J-.0478
N1070G1X3.0
N1075G2X3.125Y3.0J-.125
N1080G1Y1.5
N1085G2X2.5Y.875I-.625
N1090G1X1.5
N1095G2X.875Y1.5J.625
N1100G1Y2.25
N1105G3X.575Y2.55I-.3
N1110G1G40X.573
N1115G0Z.1M9
N1120G91G28Z0M29
N1125G90G49
N1130M01
N1135M06
N1140T4
 (T03 1/8" CENTER DRILL 0.125)
N1145G0G43X2.5Y1.5Z1.0S765M03H3
N1150G81Z-.122R.1F12.
N1155X1.5
N1160X2.0Y2.0
N1165G80
N1170G91G28Z0M29
N1175G90G49
N1180M01
N1185M06
N1190T1
 (T04 DRILL 0.2)
N1195G0G43X2.5Y1.5Z1.0S888M03H4
N1200G83Z-.122R.1Q.1F14.M08
N1205X1.5
N1210X2.0Y2.0
N1215G80
N1220G0Z.1M09
N1225G91G28X0Y0Z0M29
N1230G90M01
N1235G90M06
N1240M30
%
```

| | |
|---|---|
| Post name: | Mat-4ax |
| Post Source | Mat-4ax |
| Machine type: | Matsuura Mill |
| Control: | Mazatrol |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, mild customization for rotary support. |

```
%
O0001(MC-TEST)
G52
G92X0Y0Z0A0.0
N100T1M6(T01 1/4" ENDMILL 0.25)
G0G90G55X0.573Y1.95S484M03T3
G43Z0.1H1M8
G1Z-0.122F5.
G41D31X0.575F10.
G3X0.875Y2.25J0.3
G1Y3.0
G2X1.0Y3.125I0.125
G1X1.3584
G2X1.6038Y2.9228J-0.25
G3X2.3962I0.3962J0.0772
G2X2.6416Y3.125I0.2454J-0.0478
G1X3.0
G2X3.125Y3.0J-0.125
G1Y1.5
G2X2.5Y0.875I-0.625
G1X1.5
G2X0.875Y1.5J0.625
G1Y2.25
G3X0.575Y2.55I-0.3
G1G40X0.573
G0Z0.1

G0Z1.0M9
G49G53Z0X-15.M19
M1
N200T3M6(T03 1/8" CENTER DRILL 0.125)
G0G90G55X2.5Y1.5S765T4
G43Z0.1H3
G98G81R0.1Z-0.122F12.
X1.5
X2.0Y2.0
G0Z1.0M9
G49G53Z0X-15.M19
M1
N300T4M6(T04 DRILL 0.2)
G0G90G55X2.5Y1.5S888T1
G43Z0.1H4
G98G83R0.1Z-0.122Q0.1F14.
X1.5
X2.0Y2.0
G80
G0Z1.0M9
G49G53Z0Y0X-22.M19
M1
T1M6
M30
%
```

Post name:            Mat-yas
Post Source           Mat-yas
Machine type:         Matsuura MC-760VX
Control:              Yasnac
Inch/Metric:          Both
Circ interpolation:   Incremental IJ
Auto 1st T-POSITION?  Not supported
Canned drill cycles:  yes
Post programmer notes: Source code looks good.

```
%
O0000
 (MC-TEST)
N2G17G20
N4G40G49G54G80G90G99
N6T3M00(T01 1/4" ENDMILL 0.25)
N8G00G43X.573Y1.95Z1.0S484M03H1
N10Z.1
N12G01Z-.122F5.M08
N14G41X.575F10.D50
N16G03X.875Y2.25J.3
N18G01Y3.0
N20G02X1.0Y3.125I.125
N22G01X1.3584
N24G02X1.6038Y2.9228J-.25
N26G03X2.3962I.3962J.0772
N28G02X2.6416Y3.125I.2454J-.0478
N30G01X3.0
N32G02X3.125Y3.0J-.125
N34G01Y1.5
N36G02X2.5Y.875I-.625
N38G01X1.5
N40G02X.875Y1.5J.625
N42G01Y2.25
N44G03X.575Y2.55I-.3
N46G01G40X.573
N48G00Z.1M09
N50G91G28Z0
```

```
N52G90G49
N54M01
N56M06
N58T4(T03 1/8" CENTER DRILL 0.125)
N60G00G43X2.5Y1.5Z1.0S765M03H3
N62G81G98Z-.122R.1F12.
N64X1.5
N66X2.0Y2.0
N68G00Z1.
N70G80
N72G91G28Z0
N74G90G49
N76M01
N78M06
N80T1(T04 DRILL 0.2)
N82G00G43X2.5Y1.5Z1.0S888M03H4
N84G83G98Z-.122R.1Q.1F14.M07
N86X1.5
N88X2.0Y2.0
N90G00Z1.
N92G80
N94G00Z.1M09
N96G91G28Y0Z0
N98G90M01
N100G90M06
N102M30
%
```

| | |
|---|---|
| Post name: | Mat-yas1 |
| Post Source | Mat-yas1 |
| Machine type: | Matsuura MC-760V |
| Control: | Yasnac-1 |
| Inch/Metric: | Both |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, mild customization. |

```
(MACHINE: MATSURA MC-760V)
(PART NAME: )
(PART NUMBER: )
(REV NO.: )
(OPERATION: )
(DNC FILE: )
(MACHINE NUMBER: 404)

%
O1 (MC-TEST)
N1G91G80G40G17G98G00
N2G45X0D63
N3G45Y0D64
N4G92X0Y0
N5G90G00Y9.777
N6X9.888
N7M6

(1/4 0.25 ENDMILL T01)

N8G90G00X.573
N9Y1.95
N10G91G43Z0S484M3H1
N11G92Z1.0T3
N12G90Z.1
N13G01Z-.122F5.0
N14G41X.575D1F10.0
N15G03X.875Y2.25I.0J.3
N16G01Y3.0
N17G02X1.0Y3.125I.125J.0
N18G01X1.3584
N19G02X1.6038Y2.9228I.0J-.25
N20G03X2.3962I.3962J.0772
N21G02X2.6416Y3.125I.2454J-.0478
N22G01X3.0
N23G02X3.125Y3.0I.0J-.125
N24G01Y1.5
N25G02X2.5Y.875I-.625J.0
N26G01X1.5
N27G02X.875Y1.5I.0J.625
N28G01Y2.25
N29G03X.575Y2.55I-.3J.0
N30G40G01X.573
```

```
N31G00Z.1M09
N32G91G28Z0M19
N33G90G00Y9.777
N34X9.888
N35M6

(1/8 0.125 CENTER DRILL T03)

N36G90G00X2.5
N37Y1.5
N38G91G43Z0S765M3H3
N39G92Z1.0T4
N40G90G81X2.5Y1.5Z-.122R.1F12.0
N41X1.5
N42X2.0Y2.0
N43G80
N44G91G28Z0M19
N45G90G00Y9.777
N46X9.888
N47M6

(0.2 DRILL T04)

N48G90G00X2.5
N49Y1.5
N50G91G43Z0S888M3H4
N51G92Z1.0T1
N52G90G83X2.5Y1.5Z-.122R.1Q.1F14.0
N53X1.5
N54X2.0Y2.0
N55G80
N56Z.1
N57G91G28Z0M19
N58G90G00Y9.777
N59X9.888
N60M6


N61G91G28Z0M19
N62G28Y0
N63G28X0
N64G90
N65M30
%
```

Post name:              mat-yasn
Post Source             mat-yasn
Machine type:           Matsuura MC-710V
Control:                Yasnac
Inch/Metric:            Both
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks OK, highly customized, has hard coded X-10 at toolchange.

```
%
N5G90G92X0Y0Z0
N10G00X-10.0

N15T1M06
N20G00G90X.573Y1.95S484M03
N25G46Z1.0H1M8
N30Z.1
N35G01Z-.122F5.
N40G41X.575F10.D21
N45G03X.875Y2.25J.3
N50G01Y3.0
N55G02X1.0Y3.125I.125
N60G01X1.3584
N65G02X1.6038Y2.9228J-.25
N70G03X2.3962I.3962J.0772
N75G02X2.6416Y3.125I.2454J-.0478
N80G01X3.0
N85G02X3.125Y3.0J-.125
N90G01Y1.5
N95G02X2.5Y.875I-.625
N100G01X1.5
N105G02X.875Y1.5J.625
N110G01Y2.25
N115G03X.575Y2.55I-.3
N120G01G40X.573
N125G00Z.1
N130Z1.0M09
N135G46Z10.0H1
N140G28Z10.0
```

```
N145M01
N150G00X-10.0
N155T3M06
N160G00G90X2.5Y1.5S765M03
N165G46Z1.0H3
N170G81G98Z-.122R.1F12.
N175X1.5
N180X2.0Y2.0
N185G80G00
N190G00Z1.0
N195G46Z10.0H3
N200G28Z10.0

N205M01
N210G00X-10.0
N215T4M06
N220G00G90X2.5Y1.5S888M03
N225G46Z1.0H4M8
N230G83G98Z-.122R.1Q.1F14.
N235X1.5
N240X2.0Y2.0
N245G80G00
N250G00Z.1
N255G00Z1.0M09
N260G46Z10.0H4
N265G28Z10.0
N270G28X2.0Y2.0M5
N275M30
%
```

| Post name: | Maz-4ax |
| Post Source | Maz-4ax |
| Machine type: | Mazak |
| Control: | Mazatrol |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, has rotary support. |

```
%
O0001(MC-TEST)
N5(T01 1/4" ENDMILL 0.25)
N10G90G0X9.888Y0S484M03
N15X0.573Y1.95
N20Z0.1
N25G1Z-0.122F5.M08
N30G41D21X0.575F10.
N35G3X0.875Y2.25J0.3
N40G1Y3.0
N45G2X1.0Y3.125I0.125
N50G1X1.3584
N55G2X1.6038Y2.9228J-0.25
N60G3X2.3962I0.3962J0.0772
N65G2X2.6416Y3.125I0.2454J-0.0478
N70G1X3.0
N75G2X3.125Y3.0J-0.125
N80G1Y1.5
N85G2X2.5Y0.875I-0.625
N90G1X1.5
N95G2X0.875Y1.5J0.625
N100G1Y2.25
N105G3X0.575Y2.55I-0.3
N110G1G40X0.573
N115G0Z0.1M09
N120G91G28Z0
N125M1
N130M99
O0003
N135(T03 1/8" CENTER DRILL 0.125)
N140G0X9.888Y9.777Z1.0S765M03
N145X2.5Y1.5
N150G81G99R0.1Z-0.122F12.
N155X1.5
N160X2.0Y2.0
N165G80
N170G91G28Z0
N175M1
N180M99
O0004
N185(T04 DRILL 0.2)
N190G0X9.888Y9.777S888M03
N195X2.5Y1.5
N200G83G99R0.1Z-0.122Q0.1F14.
N205X1.5M08
N210X2.0Y2.0
N215G80
N220X0A0
N225M99
%
```

| Post name: | Mazatrol |
| --- | --- |
| Post Source | Mazatrol |
| Machine type: | Mazak |
| Control: | Mazatrol |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, has rotary support. |

```
%
O0000
N10G0G80G90G17G49G40
N15T01
N20M6
N25G0X0.573Y1.95M08S484M03
N30G43Z0.1H1
N35G1Z-0.122F5.
N40G41D21X0.575F10.
N45G3X0.875Y2.25J0.3
N50G1Y3.0
N55G2X1.0Y3.125I0.125
N60G1X1.3584
N65G2X1.6038Y2.9228J-0.25
N70G3X2.3962I0.3962J0.0772
N75G2X2.6416Y3.125I0.2454J-0.0478
N80G1X3.0
N85G2X3.125Y3.0J-0.125
N90G1Y1.5
N95G2X2.5Y0.875I-0.625
N100G1X1.5
N105G2X0.875Y1.5J0.625
N110G1Y2.25T3
N115G3X0.575Y2.55I-0.3
N120G1G40X0.573
N125G0Z0.1
N130G91G28Z0M09
N135M1
N140M6
N145G0G80G90G17G49G40T4
N150G0X9.888Y9.777Z1.0M08S765M03
N155X2.5Y1.5
N160G43Z0.1H3
N165G81G99R0.1Z-0.122F12.
N170X1.5Z1.0
N175X2.0Y2.0
N180G80
N185G91G28Z0M09
N190M1
N195M6
N200G0G80G90G17G49G40
N205G0X9.888Y9.777Z1.0M08S888M03
N210X2.5Y1.5
N215G43Z0.1H4
N220G83G99R0.1Z-0.122Q0.1F14.
N225X1.5Z1.0
N230X2.0Y2.0
N235G80
N240G91G28Z0M09
N245G28X0Y0
N250G90
N255M30
%
```

| Post name: | Maz-mit |
| Post Source | Maz-mit |
| Machine type: | Mazak |
| Control: | Mitsubishi |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
%
O1
G90T1
M1
G0G54
G0G90M3S484
X.573Y1.95M8
G43Z1.0H1
Z.1
G1Z-.122F5.
G41D41X.575F10.
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962Y2.9228I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
G2X.875Y1.5J.625
G1Y2.25
G3X.575Y2.55I-.3
G1G40X.573
```

```
G0Z1.0
M9
G90T3
M1
G0G90M3S765
X2.5Y1.5
G43Z1.0H3
G81G98X2.5Y1.5Z-.122R0.1F12.
X1.5
X2.0Y2.0
G80
G90T4
M1
G0G90M3S888
X2.5Y1.5M8
G43Z1.0H4
G83G98X2.5Y1.5Z-.122R0.1Q.1F14.
X1.5
X2.0Y2.0
G80
G0Z.1
M9
G90T1
G91G28X0Y0
M30
%
```

| | |
|---|---|
| Post name: | Meldas50 |
| Post Source | Meldas50 |
| Machine type: | Cincinnati 7VT 1000 |
| Control: | Meldas 50M |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
%                                          G00Z.1
O1 (MC-TEST)                               N3T03M06
G00G17G20G40G49G54G80G90                   ( 1/8" CENTER DRILL)
N1T01M06                                   S765M03
( 1/4" ENDMILL)                            G54G00X2.5Y1.5
S484M03                                    G43Z1.0H03
G54G00X.573Y1.95                           Z.1
G43Z1.0H01                                 G81Z-.122R.1F12.
Z.1M08                                     X1.5
G01Z-.122F5.                               X2.0Y2.0
G41X.575D01F10.                            G80
G03X.875Y2.25J.3                           N4T04M06
G01Y3.0                                     ( 0.2 DRILL)
G02X1.0Y3.125I.125                         S888M03
G01X1.3584                                 G54G00X2.5Y1.5
G02X1.6038Y2.9228J-.25                     G43Z1.0H04
G03X2.3962Y2.9228I.3962J.0772              Z.1M08
G02X2.6416Y3.125I.2454J-.0478              G83Z-.122R.1Q.1F14.
G01X3.0                                    X1.5
G02X3.125Y3.0J-.125                        X2.0Y2.0
G01Y1.5                                    G80
G02X2.5Y.875I-.625                         G00Z.1
G01X1.5                                    M09
G02X.875Y1.5J.625                          M05
G01Y2.25                                   G28Z0.0
G03X.575Y2.55I-.3                          M02
G01G40X.573                                %
```

| Post name: | Mighty |
| --- | --- |
| Post Source | Mighty |
| Machine type: | Comet Mill |
| Control: | Mitsubishi |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good.  This is a dealer's standard post. |

```
%
O1 (MC-TEST)
G91G28Z0
N100(T01 1/4" ENDMILL 0.25)
M6T1
G90G40G80G54
G00X.573Y1.95G43Z1.0H01S484M03
M08
Z.1
G01Z-.122F5.
G41X.575F10.D31
G03X.875Y2.25J.3
G01Y3.0
G02X1.0Y3.125I.125
G01X1.3584
G02X1.6038Y2.9228J-.25
G03X2.3962Y2.9228I.3962J.0772
G02X2.6416Y3.125I.2454J-.0478
G01X3.0
G02X3.125Y3.0J-.125
G01Y1.5
G02X2.5Y.875I-.625
G01X1.5
G02X.875Y1.5J.625
G01Y2.25
G03X.575Y2.55I-.3
G01G40X.573
G00Z.1M09
G91G28Z0M19
```

```
M01

N300(T03 1/8" CENTER DRILL 0.125)
M6T3
G90G40G80G54
G00X2.5Y1.5G43Z1.0H03S765M03
G99G81Z-.122R.1F12.
X1.5
X2.0Y2.0
G80
G91G28Z0M19
M01

N400(T04 DRILL 0.2)
M6T4
G90G40G80G54
G00X2.5Y1.5G43Z1.0H04S888M03
M08
G99G83Z-.122R.1Q.1F14.
X1.5
X2.0Y2.0
G80
G00Z.1
G00Z1.0M09
G91G28Z0M19
G91G28Y0
M01
M30
%
```

```
Post name:              mill-pwr
Post Source             mill-pwr
Machine type:           Macu-Rite Mill
Control:                Mill-Power
Inch/Metric:            Inch
Circ interpolation:
Auto 1st T-POSITION?    yes
Canned drill cycles:
Post programmer notes:  Source code looks good.
```

```
MillPWR Text File
; ProgramName     = "MC-TEST"
FormatVersion    = 1.2
DimensionUnits   = INCH
FeedRateUnits    = INCH
AngleFormat      = DEGREES
Steps            = 999

001 SET_TOOL
    Diam         = 0.250000 INCH
    Type         = "CARB ML"

002 LINE
    From.X       = 0.573000 ABS
    From.Y       = 1.950000 ABS
    To.X         = 0.575000 ABS
    To.Y         = 1.950000 ABS
    Depth        = -0.122000 ABS
    Offset       = LEFT
    Feed_Rate    = 10

003 ARC
    From.X       = 0.575000 ABS
    From.Y       = 1.950000 ABS
    To.X         = 0.875000 ABS
    To.Y         = 2.250000 ABS
    Depth        = -0.122000 ABS
    Radius       = 0.300000
    Direction    = CCW
    Offset       = LEFT
    Feed_Rate    = 10

004 LINE
    From.X       = 0.875000 ABS
    From.Y       = 2.250000 ABS
    To.X         = 0.875000 ABS
    To.Y         = 3.000000 ABS
    Depth        = -0.122000 ABS
    Offset       = LEFT
    Feed_Rate    = 10

005 ARC
    From.X       = 0.875000 ABS
    From.Y       = 3.000000 ABS
    To.X         = 1.000000 ABS
    To.Y         = 3.125000 ABS
```

```
    Depth        = -0.122000 ABS
    Radius       = 0.125000
    Direction    = CW
    Offset       = LEFT
    Feed_Rate    = 10

006 LINE
    From.X       = 1.000000 ABS
    From.Y       = 3.125000 ABS
    To.X         = 1.358429 ABS
    To.Y         = 3.125000 ABS
    Depth        = -0.122000 ABS
    Offset       = LEFT
    Feed_Rate    = 10

007 ARC
    From.X       = 1.358429 ABS
    From.Y       = 3.125000 ABS
    To.X         = 1.603815 ABS
    To.Y         = 2.922810 ABS
    Depth        = -0.122000 ABS
    Radius       = 0.250000
    Direction    = CW
    Offset       = LEFT
    Feed_Rate    = 10

008 ARC
    From.X       = 1.603815 ABS
    From.Y       = 2.922810 ABS
    To.X         = 2.000000 ABS
    To.Y         = 2.596366 ABS
    Depth        = -0.122000 ABS
    Radius       = 0.403635
    Direction    = CCW
    Offset       = LEFT
    Feed_Rate    = 10

009 ARC
    From.X       = 2.000000 ABS
    From.Y       = 2.596366 ABS
    To.X         = 2.396185 ABS
    To.Y         = 2.922810 ABS
    Depth        = -0.122000 ABS
    Radius       = 0.403635
    Direction    = CCW
    Offset       = LEFT
    Feed_Rate    = 10
```

```
010 ARC                                        016 ARC
    From.X       = 2.396185 ABS                     From.X       = 1.500000 ABS
    From.Y       = 2.922810 ABS                     From.Y       = 0.875000 ABS
    To.X         = 2.641571 ABS                     To.X         = 0.875000 ABS
    To.Y         = 3.125000 ABS                     To.Y         = 1.500000 ABS
    Depth        = -0.122000 ABS                    Depth        = -0.122000 ABS
    Radius       = 0.250000                         Radius       = 0.625000
    Direction    = CW                               Direction    = CW
    Offset       = LEFT                             Offset       = LEFT
    Feed_Rate    = 10                               Feed_Rate    = 10

011 LINE                                       017 LINE
    From.X       = 2.641571 ABS                     From.X       = 0.875000 ABS
    From.Y       = 3.125000 ABS                     From.Y       = 1.500000 ABS
    To.X         = 3.000000 ABS                     To.X         = 0.875000 ABS
    To.Y         = 3.125000 ABS                     To.Y         = 2.250000 ABS
    Depth        = -0.122000 ABS                    Depth        = -0.122000 ABS
    Offset       = LEFT                             Offset       = LEFT
    Feed_Rate    = 10                               Feed_Rate    = 10

012 ARC                                        018 ARC
    From.X       = 3.000000 ABS                     From.X       = 0.875000 ABS
    From.Y       = 3.125000 ABS                     From.Y       = 2.250000 ABS
    To.X         = 3.125000 ABS                     To.X         = 0.575000 ABS
    To.Y         = 3.000000 ABS                     To.Y         = 2.550000 ABS
    Depth        = -0.122000 ABS                    Depth        = -0.122000 ABS
    Radius       = 0.125000                         Radius       = 0.300000
    Direction    = CW                               Direction    = CCW
    Offset       = LEFT                             Offset       = LEFT
    Feed_Rate    = 10                               Feed_Rate    = 10

013 LINE                                       019 LINE
    From.X       = 3.125000 ABS                     From.X       = 0.575000 ABS
    From.Y       = 3.000000 ABS                     From.Y       = 2.550000 ABS
    To.X         = 3.125000 ABS                     To.X         = 0.573000 ABS
    To.Y         = 1.500000 ABS                     To.Y         = 2.550000 ABS
    Depth        = -0.122000 ABS                    Depth        = -0.122000 ABS
    Offset       = LEFT                             Offset       = LEFT
    Feed_Rate    = 10                               Feed_Rate    = 10

014 ARC                                        020 SET_TOOL
    From.X       = 3.125000 ABS                     Diam         = 0.125000 INCH
    From.Y       = 1.500000 ABS                     Type         = "PILOT DRL"
    To.X         = 2.500000 ABS
    To.Y         = 0.875000 ABS                 021 DRILL_POSITION
    Depth        = -0.122000 ABS                    Center.X     = 2.500000 ABS
    Radius       = 0.625000                         Center.Y     = 1.500000 ABS
    Direction    = CW                               Depth        = 1.000000 ABS
    Offset       = LEFT
    Feed_Rate    = 10                          022 DRILL_POSITION
                                                    Center.X     = 1.500000 ABS
015 LINE                                            Center.Y     = 1.500000 ABS
    From.X       = 2.500000 ABS                     Depth        = 1.000000 ABS
    From.Y       = 0.875000 ABS
    To.X         = 1.500000 ABS                 023 DRILL_POSITION
    To.Y         = 0.875000 ABS                     Center.X     = 2.000000 ABS
    Depth        = -0.122000 ABS                    Center.Y     = 2.000000 ABS
    Offset       = LEFT                             Depth        = 1.000000 ABS
    Feed_Rate    = 10
```

```
024 SET_TOOL                          026 DRILL_POSITION
    Diam         = 0.200000 INCH          Center.X     = 1.500000 ABS
    Type         = "DRILL"                Center.Y     = 1.500000 ABS
                                          Depth        = 1.000000 ABS
025 DRILL_POSITION
    Center.X     = 2.500000 ABS       027 DRILL_POSITION
    Center.Y     = 1.500000 ABS           Center.X     = 2.000000 ABS
    Depth        = 1.000000 ABS           Center.Y     = 2.000000 ABS
                                          Depth        = 1.000000 ABS
```

Post name:                      Mini-m
Post Source                   Mini-m
Machine type:                Mini
Control:                          Mini-M
Inch/Metric:                 Inch
Circ interpolation:           Incremental IJ
Auto 1st T-POSITION?      yes
Canned drill cycles:        yes
Post programmer notes:     Highly customized.

```
%
/MC-TEST
/post rev 032900
 G90
 G92 X9.888 Y9.777 Z1.0 A0
 G75
 M06 T1     /1-4 0.25 ENDMILL T01
 M03
 G00 X.573 Y1.95
 Z.1
 G01 Z-.122 F5.0
 X.575 F10.0
 G03 X.875 Y2.25 I.0 J.3
 G01 Y3.0
 G02 X1.0 Y3.125 I.125 J.0
 G01 X1.3584
 G02 X1.6038 Y2.9228 I.0 J-.25
 G03 X2.3962 I.39619 J.07719
 G02 X2.6416 Y3.125 I.24539 J-.04781
 G01 X3.0
 G02 X3.125 Y3.0 I.0 J-.125
 G01 Y1.5
 G02 X2.5 Y.875 I-.625 J.0
 G01 X1.5
 G02 X.875 Y1.5 I.0 J.625
 G01 Y2.25
 G03 X.575 Y2.55 I-.3 J.0
 G01 X.573
 G00 Z.1
 M25
 M06 T3     /1-8 0.125 CENTER DRILL T03
 M03
 G00 X2.5 Y1.5
 G81 X2.5 Y1.5 Z-.122
 X1.5
 X2.0 Y2.0
 G80
 M25
 M06 T4     /0.2 DRILL T04
 M03
 G00 X2.5 Y1.5
 G83 X2.5 Y1.5 Z-.122 K.1
 X1.5
 X2.0 Y2.0
 G80
 Z.1
 M25
 M02
%

%
```

| Post name: | mit-520m |
| --- | --- |
| Post Source | mit-520m |
| Machine type: | Comet Mill |
| Control: | Mitsubishi Meldas 520 |
| Inch/Metric: | Inch |
| Circ interpolation:  and R | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, has error checking. |

```
%
O1
 (MC-TEST)
N01 M06 T01(0.25-ENDMILL)
  G00 G90 G54 X.573 Y1.95 S484 M03
  G00 G43 Z1.0 H01 M8
  Z.1
  G01 Z-.122 F5.
  G41 X.575 F10. D01
  G03 X.875 Y2.25 J.3
  G01 Y3.0
  G02 X1.0 Y3.125 I.125
  G01 X1.3584
  G02 X1.6038 Y2.9228 J-.25
  G03 X2.3962 Y2.9228 I.3962 J.0772
  G02 X2.6416 Y3.125 I.2454 J-.0478
  G01 X3.0
  G02 X3.125 Y3.0 J-.125
  G01 Y1.5
  G02 X2.5 Y.875 I-.625
  G01 X1.5
  G02 X.875 Y1.5 J.625
  G01 Y2.25
  G03 X.575 Y2.55 I-.3
  G01 G40 X.573
  G00 Z.1 M09
  G0 G49 Z0. H00 M5
  G91 G28 X0. Y0.
N02 M06 T03(0.125-CENTER DRILL)
  G00 G90 G54 X2.5 Y1.5 S765 M03
  G00 G43 Z1.0 H03
  G81 G98 X2.5 Y1.5 Z-.122 R.1 F12.
  X1.5
  X2.0 Y2.0
  G80
  G0 G49 Z0. H00 M5
  G91 G28 X0. Y0.
N03 M06 T04(0.2-DRILL)
  G00 G90 G54 X2.5 Y1.5 S888 M03
  G00 G43 Z1.0 H04 M8
  G83 G98 X2.5 Y1.5 Z-.122 R.1 Q.1 F14.
  X1.5
  X2.0 Y2.0
  G80 M09
  G0 G49 Z0. H00 M5
  G91 G28 Z0 X0 Y0
  M30
%
```

Post name:                     Mon2000m
Post Source                    Mon2000m
Machine type:                  Generic Mill
Control:                       GE 2000
Inch/Metric:                   Inch
Circ interpolation:            Incremental IJ
Auto 1st T-POSITION?           yes
Canned drill cycles:           yes
Post programmer notes:         Source code looks Ok, has error checking.

```
 (ID,PROG,0001,MC-TEST)
 N0010 G90 M03 !(0.25 ENDMILL)
 N0020 G00 X.573 Y1.95 T01 M06 S484
 N0030 Z.1 D01 M08
 N0040 G01 Z-.122 F5.
 N0050 G41 P5=0
 N0060 X.575 F10.
 N0070 G03 X.875 Y2.25 I.0 J.3
 N0080 G01 Y3.0
 N0090 G02 X1.0 Y3.125 I.125 J.0
 N0100 G01 X1.3584
 N0110 G02 X1.6038 Y2.9228 I.0 J-.25
 N0120 G03 X2.0 Y2.5964 I.3962 J.0772
 N0130 G03 X2.3962 Y2.9228 I.0 J.4036
 N0140 G02 X2.6416 Y3.125 I.2454 J-.0478
 N0150 G01 X3.0
 N0160 G02 X3.125 Y3.0 I.0 J-.125
 N0170 G01 Y1.5
 N0180 G02 X2.5 Y.875 I-.625 J.0
 N0190 G01 X1.5
 N0200 G02 X.875 Y1.5 I.0 J.625
 N0210 G01 Y2.25
 N0220 G03 X.575 Y2.55 I-.3 J.0
 N0230 G40 G01 X.573
 N0240 G00 Z.1
 N0250 G40 M09

 N0260 G90 M03 !(0.125 CENTER DRILL)
 N0270 G00 X2.5 Y1.5 T03 M06 S765
 N0280 G81 Z-.122 R.1 F12. D03
 N0290 X1.5
 N0300 X2.0 Y2.0

 N0310 G90 M03 !(0.2 DRILL)
 N0320 G00 X2.5 Y1.5 T04 M06 S888
 N0330 G83 Z-.122 R.1 F14. P1=.1 D04 M08
 N0340 X1.5
 N0350 X2.0 Y2.0
 N0360
 N0370 G00 M06
 N0380 M09
 N0390 M30
 N0400(END,PROG)
```

| | |
|---|---|
| Post name: | Mon-5c |
| Post Source | Mon-5c |
| Machine type: | Monarch VMC 75 Mill |
| Control: | Bendix Dynapath 5C |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Highly customized, has inverted Z-axis rotary coded in RPM. |

```
#<MC-TEST  Mon Apr 09 10:50:55 2001'
N0010S34M03
N0020G00X9.888Y9.777T01M06                (1/4 0.25 ENDMILL T01)
N0030X.573Y1.95M07
N0040Z-.1D01
N0050G41D41             (D41 CUTTER COMP)
N0060G01Z.122F5.0
N0070G01X.575F10.0
N0080G03X.875Y2.25I0J.3
N0090G01Y3.0
N0100G02X1.0Y3.125I.125J0
N0110G01X1.3584
N0120G02X1.6038Y2.9228I0J.25
N0130G03X2.3962Y2.9228I.3962J.0772
N0140G02X2.6416Y3.125I.2454J.0478
N0150G01X3.0
N0160G02X3.125Y3.0I0J.125
N0170G01Y1.5
N0180G02X2.5Y.875I.625J0
N0190G01X1.5
N0200G02X.875Y1.5I0J.625
N0210G01Y2.25
N0220G03X.575Y2.55I.3J0
N0230G01X.573
N0240G00Z-.1
N0250G40
N0260Z-1.0M09
N0270G00X9.888Y9.777T03M06                (1/8 0.125 CENTER DRILL T03)
N0280S62M03
N0290X2.5Y1.5
N0300Z-.1D03
N0310G81R-.1Z.122F12.0
N0320X1.5
N0330X2.0Y2.0
N0340G00X9.888Y9.777T04M06                (0.2 DRILL T04)
N0350S63
N0360X2.5Y1.5M08
N0370Z-.1D04
N0380G83R-.1Z.122F14.0
N0390X1.5
N0400X2.0Y2.0
N0410M09
N0420G00X2.0Y2.0Z-.1M06
N0430M30
%
#< END OF MC-TEST >#
```

| Post name: | Mon-dyna |
|---|---|
| Post Source | Mon-dyna |
| Machine type: | Monarch VMC 150 |
| Control: | Dynapath |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK has coded spindle table. |

```
 (MC-TEST. TAP)
 N005 G90 M03( 0.25 ENDMILL)
 N010 G00 X000573 Y00195 S19 M06 T01
 N015 G86 R-0001 Z000122 F005 D01
 N020 G41 D21
 N025 G01 X000575 F010
 N030 G03 X000875 Y00225 I0000 J0003
 N035 G01 Y0030
 N040 G02 X0010 Y003125 I000125 J0000
 N045 G01 X0013584
 N050 G02 X0016038 Y0029228 I0000 J00025
 N055 G03 X0020 Y0025964 I0003962 J0000772
 N060 X0023962 Y0029228 I0000 J0004036
 N065 G02 X0026416 Y003125 I0002454 J0000478
 N070 G01 X0030
 N075 G02 X003125 Y0030 I0000 J000125
 N080 G01 Y0015
 N085 G02 X0025 Y000875 I000625 J0000
 N090 G01 X0015
 N095 G02 X000875 Y0015 I0000 J000625
 N100 G01 Y00225
 N105 G03 X000575 Y00255 I0003 J0000
 N110 G40
 N115 G01 X000573
 N120 G87 R-0001 Z-0001

 N125 G00 M06
 N130 G90 M03( 0.125 CENTER DRILL)
 N135 G00 X0025 Y0015 S19 M06 T03
 N140 G81 R-0001 Z000122 F012 D03
 N145 X0015
 N150 X0020 Y0020

 N155 G00 M06
 N160 G90 M03( 0.2 DRILL)
 N165 G00 X0025 Y0015 S19 M06 T04
 N170 G83 R-0001 Z000122 F014 D04 M08
 N175 X0015
 N180 X0020 Y0020
 N185 G80
 N190 G00 M06 X0 Y0 M09
 N195 M30
```

| | |
|---|---|
| Post name: | OK5000mc |
| Post Source | Ok5000mc |
| Machine type: | Okuma Mill |
| Control: | OSP500 M-G CNC |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
#< MC-TEST  Mon Apr 09 10:52:05 2001'       N25 G1 G40 X.573
N1 G15 H9                                    N26 G0 Z.100
N2 T1                                        N27 T3
N3 M6                                        N28 M6
N4 T3                                        N29 T4
N5 M3 S484                                   N30 M3 S765
N6 G0 X.573 Y1.950 M7                        N31 G0 X9.888 Y9.777 Z1.000
N7 G56 Z.100 H1                              N32 X2.500 Y1.500
N8 G1 Z-.122 F5.                             N33 G81 G56 Z-.122 R.100 F12. H3
N9 G41 D21 X.575 F10.                        N34 X1.500 Z1.000
N10 G3 X.875 Y2.250 I.000 J.300              N35 X2.000 Y2.000
N11 G1 Y3.000                                N36 G80
N12 G2 X1.000 Y3.125 I.125 J.000             N37 T4
N13 G1 X1.358                                N38 M6
N14 G2 X1.604 Y2.923 I.000 J-.250            N39 M3 S888
N15 G3 X2.396 I.396 J.077                    N40 G0 X9.888 Y9.777 M8
N16 G2 X2.642 Y3.125 I.245 J-.048            N41 X2.500 Y1.500
N17 G1 X3.000                                N42 G83 G56 Z-.122 R.100 Q.100 F14. H4
N18 G2 X3.125 Y3.000 I.000 J-.125            N43 X1.500 Z1.000
N19 G1 Y1.500                                N44 X2.000 Y2.000
N20 G2 X2.500 Y.875 I-.625 J.000             N45 G80
N21 G1 X1.500                                N46 M6
N22 G2 X.875 Y1.500 I.000 J.625              N47 M30
N23 G1 Y2.250                                %
N24 G3 X.575 Y2.550 I-.300 J.000             #<END OF MC-TEST>#
```

```
$OMC-TEST.MIN%                                    /M6
 G90 G80 G40 G0                                   M1
N10 /T1  ( T1 1/4 0.25 ENDMILL)                   /T4
 /M6                                              G15 H01
 M1                                               G90 G80 G40 G0
 /T3                                              M3 S765
 G15 H01                                          G0 X2.5 Y1.5
 G90 G80 G40 G0                                   G56 Z0.1 H3 M8
 M3 S484                                          G83 Z-0.122 R0.1 F12. M53
 G0 X0.573 Y1.95                                  X1.5
 G56 Z0.1 H1 M8                                   X2.0 Y2.0
 G1 Z-0.122 F5.                                   G80
 G41 D1 X0.575 F10.                              N30 /T4  ( T4 0.2 DRILL)
 G3 X0.875 Y2.25 I0.0 J0.3                        /M6
 G1 Y3.0                                          M1
 G2 X1.0 Y3.125 I0.125 J0.0                       /T1
 G1 X1.3584                                       G15 H01
 G2 X1.6038 Y2.9228 I0.0 J-0.25                   G90 G80 G40 G0
 G3 X2.3962 I0.3962 J0.0772                       M3 S888
 G2 X2.6416 Y3.125 I0.2454 J-0.0478               G0 X2.5 Y1.5
 G1 X3.0                                          G56 Z0.1 H4 M8
 G2 X3.125 Y3.0 I0.0 J-0.125                      G83 Z-0.122 R0.1 I0.1 J0.222 F14. M53
 G1 Y1.5                                          X1.5
 G2 X2.5 Y0.875 I-0.625 J0.0                      X2.0 Y2.0
 G1 X1.5                                          G80
 G2 X0.875 Y1.5 I0.0 J0.625                       M09
 G1 Y2.25                                         Z25.0
 G3 X0.575 Y2.55 I-0.3 J0.0                       X20.0 Y20.0
 G1 G40 X0.573                                    M30
 G0 Z0.1                                         %
N20 /T3  ( T3 1/8 0.125 CENTER DRILL)
```

Post name:                Osp-5020
Post Source               Osp-5020
Machine type:             Okuma Mill
Control:                  OSP-5020 CNC Control
Inch/Metric:              Inch
Circ interpolation:       Incremental IJ
Auto 1st T-POSITION?      Not supported
Canned drill cycles:      yes
Post programmer notes:    Source code look good.

```
$OMC-TEST.MIN%                              M1
 G90 G80 G40 G0                             N20 /T3  ( T3 1/8 0.125 CENTER DRILL)
N10 /T1  ( T1 1/4 0.25 ENDMILL)              /M6
 /M6                                         M1
 M1                                          /T4
 /T3                                         G15 H01
 G15 H01                                     G90 G80 G40 G0
 G90 G80 G40 G0                              M3 S765
 M3 S484                                     G0 X2.5 Y1.5
 G0 X0.573 Y1.95 M8                          G56 Z0.1 H3
 G56 Z0.1 H1                                 G83 Z-0.122 R0.1 F12. M53
 G1 Z-0.122 F5.                              X1.5
 G41 D1 X0.575 F10.                          X2.0 Y2.0
 G3 X0.875 Y2.25 I0.0 J0.3                   G80
 G1 Y3.0                                     M1
 G2 X1.0 Y3.125 I0.125 J0.0                  N30 /T4  ( T4 0.2 DRILL)
 G1 X1.3584                                   /M6
 G2 X1.6038 Y2.9228 I0.0 J-0.25              M1
 G3 X2.3962 I0.3962 J0.0772                   /T1
 G2 X2.6416 Y3.125 I0.2454 J-0.0478          G15 H01
 G1 X3.0                                     G90 G80 G40 G0
 G2 X3.125 Y3.0 I0.0 J-0.125                 M3 S888
 G1 Y1.5                                     G0 X2.5 Y1.5 M8
 G2 X2.5 Y0.875 I-0.625 J0.0                 G56 Z0.1 H4
 G1 X1.5                                     G83 Z-0.122 R0.1 I0.1 J0.222 F14. M53
 G2 X0.875 Y1.5 I0.0 J0.625                  X1.5
 G1 Y2.25                                    X2.0 Y2.0
 G3 X0.575 Y2.55 I-0.3 J0.0                  G80
 G1 G40 X0.573                               M30
 G0 Z0.1                                     %
 M09
```

| Post name: | Osp-7000 |
|---|---|
| Post Source | Osp-7000 |
| Machine type: | Okuma Mill |
| Control: | OSP-7000 |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good, mild customization. |

```
$MC-TEST%
O0000
(MC-TEST  Mon Apr 09 10:58:10 2001')
VZOFX[51]=15
VZOFY[51]=9
G80 G40 G90 G17 G0
G15 H0
N1 A0.0 M15
N2 T01 M6 (TOOL 1)
N3 T04
N4 CALL OSET TYPE=0 GL=0 REF=0 XOF=0
YOF=0 SOA=0 CHK=1
N5 G56 H200
N6 G0 G15 H1
N7 S484 M3
N8 G0 X0.573 Y1.95 Z0.1 M08
N9 G41 D1
N10 G1 X0.575 Z-0.122 F10.
N11 G3 X0.875 Y2.25 Z0.0 J0.3
N12 G1 Y3.0
N13 G2 X1.0 Y3.125 Z0.0 I0.125
N14 G1 X1.3584
N15 G2 X1.6038 Y2.9228 Z0.0 J-0.25
N16 G3 X2.3962 Y2.9228 Z0.0 I0.3962
J0.0772
N17 G2 X2.6416 Y3.125 Z0.0 I0.2454 J-
0.0478
N18 G1 X3.0
N19 G2 X3.125 Y3.0 Z0.0 J-0.125
N20 G1 Y1.5
N21 G2 X2.5 Y0.875 Z0.0 I-0.625
N22 G1 X1.5
N23 G2 X0.875 Y1.5 Z0.0 J0.625
N24 G1 Y2.25
N25 G3 X0.575 Y2.55 Z0.0 I-0.3
```

```
N26 G40
N27 G1 X0.573
N28 G0 Z1.0 M9
N29 M05
N30 CALL OVER
N31 M6 (TOOL 3)
N32 CALL OSET TYPE=0 GL=0 REF=0 XOF=0
YOF=0 SOA=0 CHK=1
N33 G56 H200
N34 G0 G15 H1
N35 S765 M3
N36 G0 X2.5 Y1.5
N37 G71 Z3.1
N38 G81 X2.5 Y1.5 Z-0.122 F12. R0.1 M53
N39 X1.5
N40 X2.0 Y2.0
N41 G80
N42 G80
N43 T04 M6 (TOOL 4)
N44 CALL OSET TYPE=0 GL=0 REF=0 XOF=0
YOF=0 SOA=0 CHK=1
N45 G56 H200
N46 G0 G15 H1
N47 S888 M3
N48 G0 X2.5 Y1.5 M08
N49 G71 Z3.1
N50 G83 X2.5 Y1.5 Z-0.122 F14. R0.1
Q0.1 M53
N51 X1.5
N52 X2.0 Y2.0
N53 G80
N54 G80
N55 G0 Z1.0 M9
N56 M02
%
```

Post name:                  Plm-1000
Post Source                 Plm-1000
Machine type:               PLM Training Mill
Control:                    PLM-1000
Inch/Metric:                Inch
Circ interpolation:         Incremental IJ
Auto 1st T-POSITION?        Not supported
Canned drill cycles:        yes
Post programmer notes:      Source code looks good.

```
%
N1T1
N2G0X.573Y1.95S484M3
N3Z.1
N4G1Z-.122F5.
N5X.575F10.
N6G3X.875Y2.25J2.25
N7G1Y3.0
N8G2X1.0Y3.125I1.0
N9G1X1.358
N10G2X1.604Y2.923J2.875
N11G3X2.396I2.0J3.0
N12G2X2.642Y3.125I2.642J2.875
N13G1X3.0
N14G2X3.125Y3.0J3.0
N15G1Y1.5
N16G2X2.5Y.875I2.5
N17G1X1.5
N18G2X.875Y1.5J1.5
N19G1Y2.25
N20G3X.575Y2.55I.575
N21G1X.573
N22G0Z.1
N23M00
N24T3
N25G0X2.5Y1.5S765M3
N26G81Z-.122R.1
N27X1.5F12.
N28X2.0Y2.0
N29G80
N30M00
N31T4
N32G0X2.5Y1.5S888M3
N33G83Z-.122R.1Q.1
N34X1.5F14.
N35X2.0Y2.0
N36G80
N37M2
```

Post name:            Proto-mc
Post Source           Proto-mc
Machine type:         Prototrac VMC
Control:              MX2 (Fanuc output
Inch/Metric:          Inch
Circ interpolation:   Incremental IJ
Auto 1st T-POSITION?  yes
Canned drill cycles:  yes
Post programmer notes: Source code looks good, has error checking.

```
%:MC-TEST.TXT                        N28G28Z0
N1G00G90G92X0Y0Z0                    N29M06
N2T1M16                              N30G00X2.5Y1.5S765M03
N3G00X.573Y1.95S484M03               N31G45H3Z0T4
N4G45H1Z0T3                          N32G81Z-.122R.1F12.
N5M08                                N33X1.5
N6Z.1                                N34G81Z-.122R.1F12.
N7G01Z-.122F5.                       N35X2.0Y2.0
N8G41X.575F10.D31                    N36G81Z-.122R.1F12.
N9G03X.875Y2.25I.0J.3                N37G80
N10G01Y3.0                           N38G28Z0
N11G02X1.0Y3.125I.125J.0             N39M06
N12G01X1.3584                        N40G00X2.5Y1.5S888M03
N13G02X1.6038Y2.9228I.0J-.25         N41G45H4Z0T1
N14G03X2.0Y2.5964I.3962J.0772        N42M08
N15X2.3962Y2.9228I.0J.4036           N43G83Z-.122R.1Q.1F14.
N16G02X2.6416Y3.125I.2454J-.0478     N44X1.5
N17G01X3.0                           N45G83Z-.122R.1Q.1F14.
N18G02X3.125Y3.0I.0J-.125            N46X2.0Y2.0
N19G01Y1.5                           N47G83Z-.122R.1Q.1F14.
N20G02X2.5Y.875I-.625J.0             N48G80
N21G01X1.5                           N49G00Z.1
N22G02X.875Y1.5I.0J.625              N50M09
N23G01Y2.25                          N51G28Z0
N24G03X.575Y2.55I-.3J.0              N52G28X0Y0M05
N25G01G40X.573                       N53M06
N26G00Z.1                            N54M30
N27M09                               %
```

```
%
O1
(HVMC 1)
(PART NO. MC-TEST)
(OPER)
(INITIAL ISSUE)
(-----------------)
(CHANGE / DATE / BY)

(INSTRUCTIONS)
G91G28Z0
G28X0Y0
G90
N1T1M06
(T1 1/4" ENDMILL 0.25)
T3
G0G54G90X.573Y1.95S484M03
G43Z1.0H1/M8
Z.1
G1Z-.122F5.
G41X.575F10.D1
G3X.875Y2.25J.3
G1Y3.0
G2X1.0Y3.125I.125
G1X1.3584
G2X1.6038Y2.9228J-.25
G3X2.3962Y2.9228I.3962J.0772
G2X2.6416Y3.125I.2454J-.0478
G1X3.0
G2X3.125Y3.0J-.125
G1Y1.5
G2X2.5Y.875I-.625
G1X1.5
G2X.875Y1.5J.625
G1Y2.25
```

```
G3X.575Y2.55I-.3
G1G40X.573
G0Z.1M09
G30G91G97Z0Y0
M01

N3T3M06
(T3 1/8" CENTER DRILL 0.125)
T4
G0G54G90X2.5Y1.5S765M03
G43Z1.0H3
G81G98Z-.122R.1L1F12.
X1.5
X2.0Y2.0
G80
G30G91G97Z0Y0
M01

N4T4M06
(T4 DRILL 0.2)
T0
G0G54G90X2.5Y1.5S888M03
G43Z1.0H4/M8
G83G98Z-.122R.1Q.1L1F14.
X1.5
X2.0Y2.0
G80
G0Z.1M09
G00Z1.0
G91G28Z0
G28X0Y0
G90
M30

%
```

| Post name: | Servo3 |
| Post Source | Servo3 |
| Machine type: | Mill/Router |
| Control: | Servo 3000 |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, mild customization. |

```
N5 (MC-TEST                                    N160 M25
N10 (                                          N165 G00 X2.5 Y1.5 F12. E12.
N15 (                                          (LOAD TOOL
N20 (                                          (T3 0.125 DIA. CENTER DRILL
N25 (                                          (
N30 G90                                        N170 T0
N35 G39 X-1.0 Y-6.0 I7.0 J13.0                 N175 M00
N40 G00 X.573 Y1.95                            N180 T03 M03 S765 M07 G99
(LOAD TOOL                                     N185 G04 [2]
(T1 0.25 DIA. ENDMILL                          N190 Z.1
(                                              N195 G81 D-.222 C.1 T.1
N45 T01 M03 S484 M07 G99                        N200 X2.5 Y1.5
N50 G04 [1]                                    N205 X1.5
N55 Z.1                                        N210 X2.0 Y2.0
N60 G01 Z-.122 F5. E5.                         N215 G80
N65 G41 X.575 F10. E10.                        N220 M25
N70 G03 X.875 Y2.25 I.0 J.3                    N225 G00 X2.5 Y1.5 F14. E14.
N75 G01 Y3.0                                   (LOAD TOOL
N80 G02 X1.0 Y3.125 I.125 J.0                  (T4 0.2 DIA. DRILL
N85 G01 X1.3584                                (
N90 G02 X1.6038 Y2.9228 I.0 J-.25             N230 T0
N95 G03 X2.3962 I.3962 J.0772                  N235 M00
N100 G02 X2.6416 Y3.125 I.2454 J-.0478        N240 T04 M03 S888 M07 G99
N105 G01 X3.0                                  N245 G04 [2]
N110 G02 X3.125 Y3.0 I.0 J-.125               N250 Z.1
N115 G01 Y1.5                                  N255 G83 D-.222 C.1 T.1 I.1
N120 G02 X2.5 Y.875 I-.625 J.0                N260 X2.5 Y1.5
N125 G01 X1.5                                  N265 X1.5
N130 G02 X.875 Y1.5 I.0 J.625                 N270 X2.0 Y2.0
N135 G01 Y2.25                                 N275
N140 G03 X.575 Y2.55 I-.3 J.0                 N280 G80
N145 G01                                       N285 M25
N150 G40 X.573                                 N290 T0
N155 G00 Z.1                                   N295 M30
```

Post name:             Shar-tig
Post Source            Shar-tig
Machine type:          Sharnoa Tiger
Control:               5/6
Inch/Metric:           Inch
Circ interpolation:    R-word for radius
Auto 1st T-POSITION?   Not supported
Canned drill cycles:   yes
Post programmer notes: Highly customized, has G4 D0 on sharp corners.

```
N10 G40 T1 M3 S484
N12 G0 X9.888 Y9.777 Z1.
N14 G0 X0.573 Y1.95
N16 Z0.1
N18 G1 Z-0.122 F5.
N20 G41 T1
N22 X0.575 F10.
N24 G3 X0.875 Y2.25 R0.3 M199
N26 G1 Y3.
N28 G2 X1. Y3.125 R0.125
N30 G4 D0
N32 G1 X1.3584
N34 G2 X1.6038 Y2.9228 R0.25 M199
N36 G4 D0
N38 G3 X2. Y2.5964 R0.4036
N40 X2.3962 Y2.9228 R0.4036 M199
N42 G4 D0
N44 G2 X2.6416 Y3.125 R0.25
N46 G1 X3.
N48 G2 X3.125 Y3. R0.125 M199
N50 G1 Y1.5
N52 G2 X2.5 Y0.875 R0.625
N54 G4 D0
N56 G1 X1.5
N58 G2 X0.875 Y1.5 R0.625 M199
```

```
N60 G4 D0
N62 G1 Y2.25
N64 G3 X0.575 Y2.55 R0.3 M199
N66 G40 T
N68 G4 D0
N70 G1 X0.573
N72 G0 Z0.1
N74 Z1. M5
N76 G40 T3 M3 S765
N78 G0 X9.888 Y9.777 Z1.
N80 G0 X2.5 Y1.5
N82 G81 Z0.1 P Q-0.122 E0.1 F12.
N84 X1.5
N86 X2. Y2.
N88 G80
N90 G40 T4 M3 S888
N92 G0 X9.888 Y9.777 Z1.
N94 G0 X2.5 Y1.5
N96 G83 Z0.1 P Q-0.122 F14.
N98 X1.5
N100 X2. Y2.
N102 G80
N104 Z1.
N106 G4 M2
#
```

Post name:              Shar-vmc
Post Source:            Shar-vmc
Machine type:           Sharnoa VMC
Control:
Inch/Metric:            Both
Circ interpolation: R   R-word for radius
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.

```
%
G4M6T1
G40T1
Z1.
G0X9.888Y9.777S484M3
M07
G0X0.573Y1.95
Z0.1
G1Z-0.122F5.
G41T1
X0.575F10.
G3X0.875Y2.25R0.3
G1Y3.
G2X1.Y3.125R0.125
G1X1.3584
G2X1.6038Y2.9228R0.25
G3X2.Y2.5964R0.4036
X2.3962Y2.9228R0.4036
G2X2.6416Y3.125R0.25
G1X3.
G2X3.125Y3.R0.125
G1Y1.5
G2X2.5Y0.875R0.625
G1X1.5
G2X0.875Y1.5R0.625
G1Y2.25
G3X0.575Y2.55R0.3
```

```
G40T
G1X0.573
G0Z0.1
Z1.
G4M6T3
G40T3
G0X9.888Y9.777S765M3
G0X2.5Y1.5
Z0.1
G81Z0.1Q-0.122P0.1F12.
X1.5
X2.Y2.
Z1.
G4M6T4
G40T4
G0X9.888Y9.777S888M3
M07
G0X2.5Y1.5
Z0.1
G81Z0.1Q-0.122E0.1W0.1P0.1F14.
X1.5E0.1W0.1
X2.Y2.E0.1W0.1
G80
Z1.
G40T0
M02
%
```

| | |
|---|---|
| Post name: | S-mazak |
| Post Source | s-mazak |
| Machine type: | Mazak VMC |
| Control: | Fanuc |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | yes |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks OK, mild customization, has error checking. |

```
%
O0001 (MC-TEST)

N1G80G90G40G49
N100G54
N101G91G28Z0
N102G28X0Y0
N103T01M06 (1/4" ENDMILL)
N104G38
N105G00G90X0.573Y1.95S484M03
N106Z1.0
N107M08
N108Z0.1
N109G01Z-0.122F5.0
N110G41D31X0.575F10.0
N111G03X0.875Y2.25I0.0J0.3
N112G01Y3.0
N113G02X1.0Y3.125I0.125J0.0
N114G01X1.3584
N115G02X1.6038Y2.9228I0.0J-0.25
N116G03X2.3962Y2.9228I0.3962J0.0772
N117G02X2.6416Y3.125I0.2454J-0.0478
N118G01X3.0
N119G02X3.125Y3.0I0.0J-0.125
N120G01Y1.5
N121G02X2.5Y0.875I-0.625J0.0
N122G01X1.5
N123G02X0.875Y1.5I0.0J0.625
N124G01Y2.25
N125G03X0.575Y2.55I-0.3J0.0
N126G01G40X0.573
N127G00Z0.1
N128M09
N129Z1.0
N130G91G28X0Y0Z0
N131M05
N132M01
```

```
N3G80G90G40G49
N133G54
N134G91G28Z0
N135G28X0Y0
N136T03M06 (1/8" CENTER DRILL)
N137G38
N138G00G90X2.5Y1.5S765M03
N139Z1.0
N140G81G99Z-0.122R0.1F12.0
N141X1.5
N142X2.0Y2.0
N143G80
N144G00Z1.0
N145G91G28X0Y0Z0
N146M05
N147M01

N4G80G90G40G49
N148G54
N149G91G28Z0
N150G28X0Y0
N151T04M06 (0.2 DRILL)
N152G38
N153G00G90X2.5Y1.5S888M03
N154Z1.0
N155M08
N156G83G99Z-0.122R0.1Q0.1F14.0
N157X1.5
N158X2.0Y2.0
N159G80
N160G00Z0.1
N161M09
N162G00Z1.0
N163G91G28X0Y0Z0
N164M05
N165M30
%
```

| | |
|---|---|
| Post name: | Solon |
| Post Source | Solon |
| Machine type: | Solon Mill |
| Control: | Sinumerik 850T |
| Inch/Metric: | Both |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
%0
 L6 T01
 M03 S484 G95 T03
 G0 G70 G55
 G43 D01 Z1.0
 G0 X0.573 Y1.95
 M51 M08
 Z0.1
 G1 Z-0.122 F5.0
 G41 D101 X0.575 Y1.95 F10.0
 G3 X0.875 Y2.25 I0.0 J0.3
 G1 Y3.0
 G2 X1.0 Y3.125 I0.125 J0.0
 G1 X1.3584
 G2 X1.6038 Y2.9228 I0.0 J-0.25
 G3 X2.3962 I0.3962 J0.0772
 G2 X2.6416 Y3.125 I0.2454 J-0.0478
 G1 X3.0
 G2 X3.125 Y3.0 I0.0 J-0.125
 G1 Y1.5
 G2 X2.5 Y0.875 I-0.625 J0.0
 G1 X1.5
 G2 X0.875 Y1.5 I0.0 J0.625
 G1 Y2.25
 G3 X0.575 Y2.55 I-0.3 J0.0
 G1 G41 D0 X0.573 Y2.55
 G0 Z0.1
 M9

 L6 T03
 M03 S765 G95 T04
 G0 G70 G55
 G43 D03 Z1.0
 G0 X9.888 Y9.777
 X2.5 Y1.5
 R01 0.1 R02 12. R03 -0.122 R10 1.0
 G81
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 L6 T04
 M03 S888 G95 T01
 G0 G70 G55
 G43 D04 Z1.0
 G0 X9.888 Y9.777
 M51 M08
 X2.5 Y1.5
 R01 0.1 R02 14. R03 -0.122 R00 5 R05 10 R10
01
 G83
 X1.5 Y1.5
 X2.0 Y2.0
 G80
 G0 Z0.1
 M09 M05
 M02
$
```

| | |
|---|---|
| Post name: | Spc-2 |
| Post Source | Spc-2 |
| Machine type: | Bostomatic VMC |
| Control: | SPC-2 |
| Inch/Metric: | Inch |
| Circ interpolation: | Absolute  IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | no |
| Post programmer notes: | Source code looks OK, mild customization, the RPM is a percentage of 4000. |

```
% MC-TEST                                          M5
                                                   M9
G90                                                /M0
G1X9.888Y9.777Z1.R                                 T3M6
S12T1M3                                            N2
G48R                                               X9.888Y9.777
G1X0.573Y1.95R                                     S19T3M3
Z0.1R                                              G48R
M8                                                 G1X2.5Y1.5R
Z-0.122F5.                                         X1.5R
G41X0.575F10.                                      X2.Y2.R
G3X0.875Y2.25I0.575J2.25                           Z1.R
G1X0.875Y3.                                        G49R
G2X1.Y3.125I1.J3.                                  M5
G1X1.3584Y3.125                                    /M0
G2X1.6038Y2.9228I1.3584J2.875                      T4M6
G3X2.Y2.5964I2.J3.                                 N3
X2.3962Y2.9228I2.J3.                               X9.888Y9.777
G2X2.6416Y3.125I2.6416J2.875                       S22T4M3
G1X3.Y3.125                                        G48R
G2X3.125Y3.I3.J3.                                  G1X2.5Y1.5R
G1X3.125Y1.5                                       X1.5R
G2X2.5Y0.875I2.5J1.5                               X2.Y2.R
G1X1.5Y0.875                                       Z0.1R
G2X0.875Y1.5I1.5J1.5                               Z1.R
G1X0.875Y2.25                                      G49R
G3X0.575Y2.55I0.575J2.25                           M5
G1G40X0.573Y2.55                                   M9
Z0.1R                                              /M0
Z1.R                                               T1M6
G49R                                               M30
```

Post name:              TNC-150
Post Source             TNC-150
Machine type:           Wells Index
Control:                Heidenhain 155
Inch/Metric:            Inch
Circ interpolation:     Absolute IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    no
Post programmer notes:  Source code looks OK.

```
%1 G70
N5 T0 G17 G00 G40 G90 Z+1.0
N10 X10 Y10 M05
N15 G99 T1 L+0.0 R+0.0 M00
N20 T1 G17 S484
N25 X+0.573 Y+1.95 M03
N30 Z+0.1
N35 G01 Z-0.122 F5 M07
N40 G41 X+0.575 F10
N45 I+0.575 J+2.25 G03 X+0.875 Y+2.25
N50 G01 Y+3.0
N55 I+1.0 J+3.0 G02 X+1.0 Y+3.125
N60 G01 X+1.3584
N65 I+1.3584 J+2.875 G02 X+1.6038 Y+2.9228
N70 I+2.0 J+3.0 G03 X+2.3962
N75 I+2.6416 J+2.875 G02 X+2.6416 Y+3.125
N80 G01 X+3.0
N85 I+3.0 J+3.0 G02 X+3.125 Y+3.0
N90 G01 Y+1.5
N95 I+2.5 J+1.5 G02 X+2.5 Y+0.875
N100 G01 X+1.5
N105 I+1.5 J+1.5 G02 X+0.875 Y+1.5
N110 G01 Y+2.25
N115 I+0.575 J+2.25 G03 X+0.575 Y+2.55
N120 G01 G40 X+0.573
N125 G00 Z+0.1
N130 T0 G17 G00 G40 G90 Z+1.0
N135 X10 Y10 M05
N140 G99 T3 L+0.0 R+0.0 M00
N145 T3 G17 S765
N150 X+9.888 Y+9.777 M03
N155 X+2.5 Y+1.5
N160 X+1.5
N165 X+2.0 Y+2.0
N170 T0 G17 G00 G40 G90 Z+1.0
N175 X10 Y10 M05
N180 G99 T4 L+0.0 R+0.0 M00
N185 T4 G17 S888
N190 X+9.888 Y+9.777 M03
N195 X+2.5 Y+1.5
N200 P83 P01+0.1 P02-0.122 P03+0.1 P04 0 P0514
N205 X+1.5 M99
N210 X+2.0 Y+2.0 M99
N215 T0 G00 Z+1.0
N220 X+2.0 Y+2.0 M02
N225%1 G70
```

Post name:              Tnc-415
Post Source             Tnc-415
Machine type:           Wontan Boring Mill
Control:                Heidenhain 415 G-Code
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.

```
%1 G70                                      N27 G00 Z0.1
N1 G51 T1                                   N28 Z1.0 M9
N2 T1                                       N29 T3
;(1/4 0.25 ENDMILL T01)                     ;(1/8 0.125 CENTER DRILL T03)
N3 G00 G90 M91 Z0                           N30 G00 G90 M91 Z0
N4 G51 T3                                   N31 G51 T4
N5 G17 S484 M3                              N32 G17 S765 M3
N6 G00 G40 G90 X0.573 Y1.95 W0              N33 G83 P01 -.05 P02 -0.122 P03 -0.122
N7 Z0.1 M8                                  P04 0 P05 120
N8 G01 Z-0.122 F50                          N34 G00 G40 G90 X2.5 Y1.5 W0
N9 G41 X0.575 F100                          N35 G00 Z0.1 M89
N10 I0.575 J2.25 G03 X0.875 Y2.25           N36 X1.5
N11 G01 Y3.0                                N37 X2.0 Y2.0 M99
N12 I1.0 J3.0 G02 X1.0 Y3.125               N38 Z1.0
N13 G01 X1.3584                             N39 T4
N14 I1.3584 J2.875 G02 X1.6038 Y2.9228      ;(0.2 DRILL T04)
N15 I2.0 J3.0 G03 X2.0 Y2.5964              N40 G00 G90 M91 Z0
N16 I2.0 J3.0 X2.3962 Y2.9228               N41 G17 S888 M3
N17 I2.6416 J2.875 G02 X2.6416 Y3.125       N42 G83 P01 -.05 P02 -0.122 P03 0.1 P04
N18 G01 X3.0                                0 P05 140 M8
N19 I3.0 J3.0 G02 X3.125 Y3.0               N43 G00 G40 G90 X2.5 Y1.5 W0
N20 G01 Y1.5                                N44 G00 Z0.1 M89
N21 I2.5 J1.5 G02 X2.5 Y0.875               N45 X1.5
N22 G01 X1.5                                N46 X2.0 Y2.0 M99
N23 I1.5 J1.5 G02 X0.875 Y1.5               N47 G00 Z1.0 M9
N24 G01 Y2.25                               N48 M91 W0 Z0
N25 I0.575 J2.25 G03 X0.575 Y2.55           N49 M2
N26 G01 G40 X0.573                          %1 G70
```

Post name:              Tree
Post Source             Tree
Machine type:           Tree Mill
Control:                Vickers
Inch/Metric:            Inch
Circ interpolation:     Incremental IJ
Auto 1st T-POSITION?    yes
Canned drill cycles:    yes
Post programmer notes:  Source code looks good, has error checking.

```
:G90 G0                                    :G90 G0
N10 T1 M06                                 N260 T3 M06
N20 M01                                    N270 M01
N30 G00 X0.573 Y1.95 S484 M3 Z10 H1        N280 G00 X2.5 Y1.5 S765 M3 Z10 H1
N40 Z0.1 O01 M08                           N290 Z0.1 O03
N50 G01 Z-0.122 F5.                        N300 G81 Z-0.122 R0.1 F12.
N60 X0.575 F10.                            N310 X1.5
N70 G03 X0.875 Y2.25 I0.0 J0.3             N320 X2.0 Y2.0
N80 G01 Y3.0                               N330 G80
N90 G02 X1.0 Y3.125 I0.125 J0.0            N340 G00 Z10.0 M05
N100 G01 X1.358                            :G90 G0
N110 G02 X1.604 Y2.923 I0.0 J-0.25         N350 T4 M06
N120 G03 X2.396 Y2.923 I0.396 J0.077       N360 M01
N130 G02 X2.642 Y3.125 I0.245 J-0.048      N370 G00 X2.5 Y1.5 S888 M3 Z10 H1
N140 G01 X3.0                              N380 Z0.1 O04 M08
N150 G02 X3.125 Y3.0 I0.0 J-0.125          N390 G83 Z-0.122 R0.1 D0.1 F14.
N160 G01 Y1.5                              N400 X1.5
N170 G02 X2.5 Y0.875 I-0.625 J0.0          N410 X2.0 Y2.0
N180 G01 X1.5                              N420 G80
N190 G02 X0.875 Y1.5 I0.0 J0.625           N430 G00 Z0.1
N200 G01 Y2.25                             N440 G00 Z10.0
N210 G03 X0.575 Y2.55 I-0.3 J0.0           N450 M09
N220 G01 X0.573                            N460 M26
N230 G00 Z0.1                              N470 X0 Y0
N240 Z10.0 M05                             N480 M02
N250 M09
```

| Post name: | Vm40mill |
| Post Source | Vm40mill |
| Machine type: | Hitachi-Seiki VM40 Vertical Mill |
| Control: | Lambda 10M |
| Inch/Metric: | Inch |
| Circ interpolation: | Incremental IJ |
| Auto 1st T-POSITION? | Not supported |
| Canned drill cycles: | yes |
| Post programmer notes: | Source code looks good. |

```
%
O1
(MC-TEST)
 G91 G28 Z0 M31
 G91 G28 X0 Y0
 G90
 M01

N1 T01 M06(1/4" ENDMILL) T3
 G90 G00 G54
 X.573 Y1.95 S484 M03
 G43 Z1.0 H01 M08
 Z.1
 G1 Z-.122 F5.
 G41 X.575 F10. D21
 G3 X.875 Y2.25 J.3
 G1 Y3.0
 G2 X1.0 Y3.125 I.125
 G1 X1.3584
 G2 X1.6038 Y2.9228 J-.25
 G3 X2.3962 Y2.9228 I.3962 J.0772
 G2 X2.6416 Y3.125 I.2454 J-.0478
 G1 X3.0
 G2 X3.125 Y3.0 J-.125
 G1 Y1.5
 G2 X2.5 Y.875 I-.625
 G1 X1.5
 G2 X.875 Y1.5 J.625
 G1 Y2.25
 G3 X.575 Y2.55 I-.3
 G1 G40 X.573
 G0 Z.1
 G00 Z1.0 M09
```

```
 G91 G30 Z0 M15
 G90 M01

N3 T03 M06(1/8" CENTER DRILL) T4
 G90 G00 G54
 X9.888 Y9.777 S765 M03
 X2.5 Y1.5
 G43 Z1.0 H03
 G81 G98 Z-.122 R.1 F12.
 X1.5
 X2.0 Y2.0
 G80
 G00 Z1.0
 G91 G30 Z0 M15
 G90 M01

N4 T04 M06(0.2 DRILL) T1
 G90 G00 G54
 X9.888 Y9.777 S888 M03
 X2.5 Y1.5
 G43 Z1.0 H04 M08
 G83 G98 Z-.122 R.1 Q.1 F14.
 X1.5
 X2.0 Y2.0
 G80
 G0 Z.1 M09
 M05
 G91 G28 Z0
 G91 G28 X0 Y0
 G90
 /
 M30
%
```

```
Post name:              V-pc2100
Post Source             V-pc2100
Machine type:           Tree VMC
Control:                Vickers PC2100
Inch/Metric:            Inch
Circ interpolation: R   P-word for radius
Auto 1st T-POSITION?    Not supported
Canned drill cycles:    yes
Post programmer notes:  Source code looks good.
```

```
 :G90
 M6 G40 T1
 S484 M3
 G0 X9.888 Y9.777 Z1.
 G0 X0.573 Y1.95
 Z0.1
 G1 Z-0.122 F5.
 G41 T1
 X0.575 F10.
 G3 X0.875 Y2.25 P0.3
 G1 Y3.
 G2 X1. Y3.125 P0.125
 G1 X1.3584
 G2 X1.6038 Y2.9228 P0.25
 G3 X2. Y2.5964 P0.4036
 X2.3962 Y2.9228 P0.4036
 G2 X2.6416 Y3.125 P0.25
 G1 X3.
 G2 X3.125 Y3. P0.125
 G1 Y1.5
 G2 X2.5 Y0.875 P0.625
 G1 X1.5
 G2 X0.875 Y1.5 P0.625
 G1 Y2.25
 G3 X0.575 Y2.55 P0.3
 G40 T
 G1 X0.573
 G0 Z0.1
 Z1. M5
 M6 G40 T3
 S765 M3
 G0 X9.888 Y9.777 Z1.
 G0 X2.5 Y1.5
 G81 Z0.1 P Q-0.122 E0.1 F12.
 X1.5
 X2. Y2.
 G80
 M6 G40 T4
 S888 M3
 G0 X9.888 Y9.777 Z1.
 G0 X2.5 Y1.5
 G83 Z0.1 P Q-0.122 F14.
 X1.5
 X2. Y2.
 G80
 Z1.
 M2
```

Post name:                 Vpr-mits
Post Source               Vpr-mits
Machine type:          Viper VMC
Control:                   Mitsu
Inch/Metric:             Inch
Circ interpolation:  and R     P-word for Radius
Auto 1st T-POSITION?      Not supported
Canned drill cycles:       yes
Post programmer notes:     Source code looks good, has error checking.

```
O0001 (MC-TEST)
G0G20G40G80G90
G91G28Z0.
T1M6 (1/4" ENDMILL)
G0G90G55X0.573Y1.95S484M3
G43Z1.0H1M8
Z0.1
G1Z-0.122F5.0
G41D31X0.575F10.0
G3X0.875Y2.25I0.0J0.3
G1Y3.0
G2X1.0Y3.125I0.125J0.0
G1X1.3584
G2X1.6038Y2.9228I0.0J-0.25
G3X2.3962Y2.9228I0.3962J0.0772
G2X2.6416Y3.125I0.2454J-0.0478
G1X3.0
G2X3.125Y3.0I0.0J-0.125
G1Y1.5
G2X2.5Y0.875I-0.625J0.0
G1X1.5
G2X0.875Y1.5I0.0J0.625
G1Y2.25
G3X0.575Y2.55I-0.3J0.0
G1G40X0.573
G0Z0.1
Z1.0M9
G91G28Z0.M19
X-4.
```

```
M1
N1
G0G20G40G80G90
G91G28Z0.M19
T3M6 (1/8" CENTER DRILL)
G0G90G55X2.5Y1.5S765M3
G43Z1.0H3
G81G99Z-0.122R0.1F12.0
X1.5
X2.0Y2.0
G80
G0Z1.0
G91G28Z0.M19
X-4.
M1
N2
G0G20G40G80G90
G91G28Z0.M19
T4M6 (0.2 DRILL)
G0G90G55X2.5Y1.5S888M3
G43Z1.0H4M8
G83G99Z-0.122R0.1Q0.1F14.0
X1.5
X2.0Y2.0
G80
G0Z1.0
G91G28Z0.Y0.M9
X-4.M19
M30
%
```