



How to Get Your Post Modified

Follow the steps outlined below to ensure that your post processor is modified to your desired specifications with minimum delay and expense.

Send an email to explain your request to: Post@GibbsCAM.com

Send the following as an attachment to your email:

- One (1) marked-up g-code program (with comments turned on)
- One (1) .gcpkg (Pack and Go) file that was used to create the g-code program
- Your contact information

If your email attachment is larger than 50MB, email Midwest CAM Solutions at support@midwestcamsolutions.com and we will send you a direct upload link. Or call us directly at **(877) 444-0982**.

The image below illustrates how the g-code program would be marked up in the desired manner.

The screenshot shows a WordPad window titled "133-24989-01-OP1 - WordPad". The window contains a g-code program with several lines of code and annotations. The annotations are: "Place T1 and M6 on the same line" next to lines N2T1 and N3M6; "Change M8 to M7" next to line N8M8; and "Change all I's, J's and K's to R output" next to line N15G2X-4.0994Y5.I5.J-4.0994. The g-code program includes header information such as program name, revision, format, date, and tool information, followed by various G-code and M-code lines.

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O2( PROGRAM: 133-24989-01-OP1.NCF )
( REV A )
( FORMAT: FANUC 6M [VG] M001.19.PST )
( 12/7/06 AT 3:38 PM )
( OUTPUT IN ABSOLUTE INCHES )
( PARTS PROGRAMMED: 1 )
( FIRST TOOL NOT IN SPINDLE )
N1G17G40G80
N2T1           Place T1 and M6 on the same line
N3M6
( OPERATION 1: ROUGHING )
( ROUGH )
( TOOL 1: 2. SHELL ENDMILL )
N4G54
N5S8000M3
N6G90G0X-4.0994Y6.1
N7G43Z1.H1
N8M8           Change M8 to M7
N9Z.1
N10G12-.0845F80.
N11Y5.
N12X-4.75F100.
N13G3X-5.Y4.75J-.25
N14G1Y4.0994
N15G2X-4.0994Y5.I5.J-4.0994  Change all I's, J's and K's to R output
N16G1X-3.6407Y4.3933
N17X-3.6344Y4.3855
N18G3X-3.6407Y4.3813T 0232.T 019
```