



## 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: [postsupport@midwestcamsolutions.com](mailto:postsupport@midwestcamsolutions.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**, use [this form](#) to upload your file.

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" containing a g-code program. The program text is as follows:

```
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
N3M6
( OPERATION 1: ROUGHING )
( ROUGH )
( TOOL 1: 2. SHELL ENDMILL )
N4G54
N5S8000M3
N6G90G0X-4.0994Y6.1
N7G43Z1.H1
N8M8
N9Z.1
N10G1Z-.0845F80.
N11Y5.
N12X-4.75F100.
N13G3X-5.Y4.75J-.25
N14G1Y4.0994
N15G2X-4.0994Y5.I5.J-4.0994
N16G1X-3.6407Y4.3933
N17X-3.6344Y4.3855
N18G3X-3.5922Y4.3813T.0232.T.019
```

Annotations in the image include:

- "Place T1 and M6 on the same line" pointing to lines N2T1 and N3M6.
- "Change M8 to M7" pointing to line N8M8.
- "Change all I's, J's and K's to R output" pointing to lines N15G2X-4.0994Y5.I5.J-4.0994 and N13G3X-5.Y4.75J-.25.