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EXAMPLE FANUC 3 AXIS POST PROCESSOR PROGRAM

```
%
O0100(ESEMPIO_FANUC3)
G0 G17 G40 G49 G80 G90
( FLATTENING )
T20 M6
G0 G90 G54 X-108.202 Y1.192 S650 M3
G43 H20 Z50. T4
Z5.
G1 Z0. F500.
X118.211
G0 Z50.
M5
( CONTOUR FINISHING )
T4 M6
G0 G90 G54 X10.505 Y-41.977 S2200 M3
G43 H4 Z25. M7 T26
Z5.
G1 Z-6. F600.
G41 D4 Y-36.477 F1200.
G3 X5.005 Y-30.977 I-5.5 J0.
G1 X-36.702
G2 X-41.702 Y-25.977 I0. J5.
G1 Y28.36
G2 X-36.702 Y33.36 I5. J0.

G1 X46.711
G2 X51.711 Y28.36 I0. J-5.
G1 Y-25.977
G2 X46.711 Y-30.977 I-5. J0.
G1 X5.005
X4.005
G3 X-1.495 Y-36.477 I0. J-5.5
G1 G40 Y-41.977
G0 Z25.
M5
M9
( DRILLING )
T26 M6
G0 G90 G54 X46.711 Y28.36 S1950 M3
G43 H26 Z5. M8 T20
G99 G73 Z-10. R5. Q2. F400.
X-36.702 Y1.192
X5.005 Y-25.977
G80
M5
M9
M30
%
```

EXAMPLE HAAS 3-AXIS POST PROCESSOR PROGRAM

```
%
O0100 ( EXAMPLE_HAAS3 )
G0 G17 G40 G49 G80 G90
( FLATTENING )
T20 M6 ( FACER D.65 )
G0 G90 G54 X-108.202 Y1.192 S650 M3
G43 H20 Z50. T4
Z5.
G1 Z0. F500.
X118.211
G0 Z50.
( CONTOUR FINISHING )
M5
T4 M6 ( TIP D.10 )
G0 G90 G54 X10.505 Y-41.977 S2200 M3
G43 H4 Z25. M7 T26
Z5.
G1 Z-6. F600.
G41 D4 Y-36.477 F1200.
G3 X5.005 Y-30.977 R5.5
G1 X-36.702
G2 X-41.702 Y-25.977 R5.
G1 Y28.36
G2 X-36.702 Y33.36 R5.
G1 X46.711
G2 X51.711 Y28.36 R5.

G1 Y-25.977
G2 X46.711 Y-30.977 R5.
G1 X5.005
X4.005
G3 X-1.495 Y-36.477 R5.5
G1 G40 Y-41.977
G0 Z25.
( DRILLING )
M9
M5
T26 M6 ( TIP D.4 )
G0 G90 G54 X46.711 Y28.36 S1950 M3
G43 H26 Z50. M8 T20
Z5.
G73 Z-10. R5. Q2. F400.
X-36.702 Y1.192
X5.005 Y-25.977
G80
Z50.
M5
M9
G90
M30
%
```

EXAMPLE HEIDENAIN 3-AXIS POST PROCESSOR PROGRAM

```
0 BEGIN PGM ESEMPIO_HEIDENAIN3 MM
1 BLK FORM 0.1 Z X0 Y0 Z0
2 BLK FORM 0.2 X0 Y0 Z0
; SPIANATURA
3 CYCL DEF 247 IMPOSTAZIONE ORIGINE ~
  Q339=1 ; ORIGINE PEZZO
4 TOOL CALL 20 Z S650 ; SFACCIATORE D.65
5 TOOL DEF 4
6 L X-108.202 Y1.192 R0 FMAX M3
7 L Z50 R0 FMAX
8 L Z5 FMAX
9 L Z0 F500
10 L X118.211
11 L Z50 FMAX
; CONTORNATURA DI FINITURA
12 TOOL CALL 4 Z S2200 ; FLAT MILLING CUTTER
  D.10
13 TOOL DEF 26
14 L X10.505 Y-41.977 R0 FMAX M3
15 L Z25 R0 FMAX M7
16 L Z5 FMAX
17 L Z-6 F600
18 L Y-36.477 RL F1200
19 CC X5.005 Y-36.477
20 C X5.005 Y-30.977 DR+
21 L X-36.702
22 CC X-36.702 Y-25.977
23 C X-41.702 Y-25.977 DR-
24 L Y28.36
25 CC X-36.702 Y28.36
26 C X-36.702 Y33.36 DR-
27 L X46.711
28 CC X46.711 Y28.36
29 C X51.711 Y28.36 DR-
30 L Y-25.977
31 CC X46.711 Y-25.977
32 C X46.711 Y-30.977 DR-
33 L X5.005
34 L X4.005
35 CC X4.005 Y-36.477
36 C X-1.495 Y-36.477 DR+
37 L Y-41.977 R0
38 L Z25 FMAX
39 L M9
; FORATURA
40 TOOL CALL 26 Z S1950 ; TIP D.4
41 TOOL DEF 20
42 L X46.711 Y28.36 R0 FMAX M3
43 L Z50 R0 FMAX M8
44 L Z5 FMAX
45 CYCL DEF 203 FORATURA UNIVERSALE ~
  Q200=5 ;DISTANZA DI SICUREZZA ~
  Q201=-10 ;PROFONDITA' ~
  Q206=400 ;AVANZAMENTO IN PROF. ~
  Q202=2 ;PROF. INCREMENTO ~
  Q210=0 ;TEMPO ATTESA ~
  Q203=+0 ;COORDINATE SUPERFICIE ~
  Q204=5 ;SVINCOLO ~
  Q212=1.2 ;VALORE DA TOGLIERE ~
  Q213=0 ;ROTTURE TRUCIOLO ~
  Q205=1.2 ;PROF. MIN. ACCOSTAM. ~
  Q211=0 ;SOSTA SOTTO ~
  Q208=2000 ;INVERSIONE AVANZAMENTO ~
  Q256=0 ;RITIRO ROTT.TRUCIOLO
46 L X46.711 Y28.36 R0 FMAX M99
47 L X-36.702 Y1.192 R0 FMAX M99
48 L X5.005 Y-25.977 R0 FMAX M99
49 L Z50 FMAX
50 L M9
51 M30
52 END PGM ESEMPIO_HEIDENAIN3 MM
```

EXAMPLE HURCO 3-AXIS POST PROCESSOR PROGRAM

```
%
N1 ( EXAMPLE_HURCO3 )
( FLATTENING )
N2 G90
N3 M25
N4 T20 M6 ( DIAM 65 FACER D.65 )
N5 G54
N6 M03 S650
N7 G0 X-108.202 Y1.192
N8 G43 H20 Z50.
N9 G0 Z5.
N10 G1 Z0. F500
N11 X118.211
N12 G0 Z50.
( CONTOUR FINISHING )
N13 M25
N14 T4 M6 ( FLAT MILLING CUTTER D.10 )
N15 M03 S2200
N16 G0 X10.505 Y-41.977 M7
N17 G43 H4 Z25.
N18 G0 Z5.
N19 G1 Z-6. F600
N20 G41 D4 Y-36.477 F1200
N21 G3 X5.005 Y-30.977 I5.005 J-36.477
N22 G1 X-36.702
N23 G2 X-41.702 Y-25.977 I-36.702 J-25.977
N24 G1 Y28.36
N25 G2 X-36.702 Y33.36 I-36.702 J28.36
N26 G1 X46.711
N27 G2 X51.711 Y28.36 I46.711 J28.36
N28 G1 Y-25.977
N29 G2 X46.711 Y-30.977 I46.711 J-25.977
N30 G1 X5.005
N31 X4.005
N32 G3 X-1.495 Y-36.477 I4.005 J-36.477
N33 G1 G40 Y-41.977
N34 G0 Z25.
( DRILLING )
N35 M25
N36 T26 M6 ( TIP D.4 )
N37 M03 S1950
N38 G0 X46.711 Y28.36 M8
N39 G43 H26 Z50.
N40 G0 Z5.
N41 G83 X46.711 Y28.36 Z10. Z2. F400
N42 G0 Z50.
N43 X-36.702 Y1.192
N44 G0 Z5.
N45 G83 X-36.702 Y1.192 Z10. Z2. F400
N46 G0 Z50.
N47 X5.005 Y-25.977
N48 G0 Z5.
N49 G83 X5.005 Y-25.977 Z10. Z2. F400
N50 G0 Z50.
N51 G80
N52 M9
N53 M25
N54 M02
```

EXAMPLE MAKAZ 3-AXIS POST PROCESSOR PROGRAM

```
O00000100
N1 M6 T20 ( FACER D.65 )
T4
S650 F500 M3
( FLATTENING )
G0 G90 G54
G0 X-108.202 Y1.192
G43 H20 Z50
Z5
G1 Z0
X118.211
G0 Z50
N2 M6 T4 ( FLAT MILLING CUTTER D.10 )
T26
S2200 F1200 M3 M7
( CONTOUR FINISHING)
G0 G90 G54
G0 X10.505 Y-41.977
G43 H4 Z25
Z5
G1 Z-6 F600
G41 D4 Y-36.477 F1200
G3 X5.005 Y-30.977 I-5.5 J0.
G1 X-36.702
G2 X-41.702 Y-25.977 I0. J5.
G1 Y28.36
G2 X-36.702 Y33.36 I5. J0.
G1 X46.711
G2 X51.711 Y28.36 I0. J-5.
G1 Y-25.977
G2 X46.711 Y-30.977 I-5. J0.
G1 X5.005
X4.005
G3 X-1.495 Y-36.477 I0. J-5.5
G1 G40 Y-41.977
G0 Z25
M9
N3 M6 T26 ( TIP D.4 )
T20
S1950 F400 M3 M8
( DRILLING )
G0 G90 G54
G0 X46.711 Y28.36
G43 H26 Z50
Z5
G99 G73 X46.711 Y28.36 Z-10 R5 Q2
X-36.702 Y1.192
X5.005 Y-25.977
G0 G80
Z50
M9
M30
```

EXAMPLE SELCA 3-AXIS POST PROCESSOR PROGRAM

```
%
G17
[ FLATTENING
O1
T20 M6[SFACCIATORE D.65
S650 F500 M3
X-108.202 Y1.192 R
G49 K20
Z50 R
Z5 R
G1 Z0
G1 X118.211
Z50 R
M5
[ CONTOUR FINISHING
O1
T4 M6[FLAT MILLING CUTTER D.10
S2200 F1200 M3
X10.505 Y-41.977 R
G49 K4
Z25 R
M7
Z5 R
G1 Z-6 F600
G41
G1 Y-36.477 F1200
G3 X5.005 Y-30.977 I5.005 J-36.477
G1 X-36.702
G2 X-41.702 Y-25.977 I-36.702 J-25.977
G1 Y28.36
G2 X-36.702 Y33.36 I-36.702 J28.36
G1 X46.711
G2 X51.711 Y28.36 I46.711 J28.36
G1 Y-25.977
G2 X46.711 Y-30.977 I46.711 J-25.977
G1 X5.005
G1 X4.005
G3 X-1.495 Y-36.477 I4.005 J-36.477
G1 Y-41.977
G40
Z25 R
M5
M9
[ DRILLING
O1
T26 M6[TIP D.4
S1950 F400 M3
X46.711 Y28.36 R
G49 K26
Z50 R
M8
Z5 R
G83 Z-10 J5 Q5 I2
X46.711 Y28.36
X-36.702 Y1.192
X5.005 Y-25.977
G80
Z50 R
M5
M9
M30
%
```

EXAMPLE SIEMENS 3-AXIS POST PROCESSOR PROGRAM

```
MSG("ESEMPIO_SIEMENS3")
WORKPIECE(",",""BOX",112,0,0,-80,0,0,0)
G17 G40 G71 G90
G64
; SPIANATURA
G54
; DIAM.65 R.0 SFACCIATORE D.65
T20 M6
S650 M3 D1 F500
T4
G0 X-108.202 Y1.192
Z50
Z5
G1 Z0
X118.211
G0 Z50
; CONTORNATURA DI FINITURA
G54
; DIAM.10 R.0 FLAT MILLING CUTTER D.10
T4 M6
S2200 M3 D1 F1200
T26
G0 X10.505 Y-41.977
Z25 M7
Z5
G1 Z-6 F600
G41 Y-36.477 F1200
G3 X5.005 Y-30.977 I-5.5 J0
G1 X-36.702
G2 X-41.702 Y-25.977 I0 J5

G1 Y28.36
G2 X-36.702 Y33.36 I5 J0
G1 X46.711
G2 X51.711 Y28.36 I0 J-5
G1 Y-25.977
G2 X46.711 Y-30.977 I-5 J0
G1 X5.005
X4.005
G3 X-1.495 Y-36.477 I0 J-5.5
G1 G40 Y-41.977
G0 Z25
M9
; FORATURA
G54
; DIAM.4 R.0 TIP D.4
T26 M6
S1950 M3 D1 F400
T20
G0 X46.711 Y28.36
Z50 M8
Z5
MCALL CYCLE83 (5 ,0 ,5 ,-10 , , ,2 ,1.2 ,0 ,0 ,1,0,3 )
X46.711 Y28.36
X-36.702 Y1.192
X5.005 Y-25.977
MCALL
Z50
M9
M30
```


EXAMPLE FAGOR SELCA 3-AXIS POST PROCESSOR PROGRAM

```
G8000
G8585 X0 I0 Y0 J0 Z0 K0
G800001
( FLATTENING )
N1 T20M6(FACER D.65)
S650 F500 M3
G0 X-108.202 Y1.192
G8049 I32.5
G0 Z50
G0 Z5
G1 Z0
G1 X118.211
G0 Z50
M5
( CONTOUR FINISHING )
N2 T4M6(FLAT MILLING CUTTER D.10)
S2200 F1200 M3
G0 X10.505 Y-41.977
G8049 I5
M7
G0 Z25
G0 Z5
G1 Z-6 F600
G41
G1 Y-36.477 F1200
G3 X5.005 Y-30.977 I5.005 J-36.477
G1 X-36.702
G2 X-41.702 Y-25.977 I-36.702 J-25.977
G1 Y28.36
G2 X-36.702 Y33.36 I-36.702 J28.36

G1 X46.711
G2 X51.711 Y28.36 I46.711 J28.36
G1 Y-25.977
G2 X46.711 Y-30.977 I46.711 J-25.977
G1 X5.005
G1 X4.005
G3 X-1.495 Y-36.477 I4.005 J-36.477
G40
G1 Y-41.977
G0 Z25
M5
M9
( DRILLING )
N3 T26M6(TIP D.4)
S1950 F400 M3
G0 X46.711 Y28.36
G8049 I2
M8
G0 Z50
G0 Z5
G8083 Z-10 J5 I2 H5
X46.711 Y28.36
X-36.702 Y1.192
X5.005 Y-25.977
G8080
G0 Z50
M5
M9
M30
```

POSTPROCESSOR CUSTOMIZATION LIST.**POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE FANUC3_GENERIC.PST FILE**

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES.
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.

POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE HAAS3_GENERIC.PST FILE

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.

POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE HEIDENAIN3_GENERIC.PST FILE

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.
- TOOL RECALL DEFINITION WITH NUMBER OR NAME

POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE HURCO3_GENERIC.PST FILE

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.

POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE MAZAK3_GENERIC.PST FILE

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.

Continue.....

POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE SELCA3_GENERIC.PST FILE

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.
- DEFINE TYPE OF SELCA 1000/1200 OR 3045/4045
- DEFINE TYPE OF TOOL RADIUS CORRECTOR G49K... G49I...

POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE SIEMENS3_GENERIC.PST FILE

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.
- TOOL RECALL DEFINITION WITH NUMBER OR NAME

POSSIBLE CUSTOMIZATIONS TO BE MADE FOR THE USER BY EDITTING THE FAGOR3_GENERIC.PST FILE

- TURN ON/OFF NEXT TOOL PREP.
- ACTIVATE OR DEACTIVATE THE RELEASE AT THE END OF THE PROGRAM WITH RELATIVE Z, XY COORDINATES
- DEFINE THE IGNITION NAME N.3 REFRIGERANT TYPES.
- DEFINE EXTINGUISHMENT NAME N.3 REFRIGERANT TYPES.
- DEFINE TYPE OF TOOL RADIUS CORRECTOR G49K... G49I...

EXAMPLE OF POST-PROCESSOR USER PERSONALIZATION.

1st Phase: edit the postprocessor .PST file using the NOTEPAD editor

2nd Phase: enter the value 0 or 1 in the LIGHT BLUE fields

3rd Phase: enter the name of the refrigerant codes inside the quotation marks in the RED fields

4th Phase: enter the release coordinate values in the GREEN fields

```
#preselezione utensile / pre-stage tools - 0=OFF 1=ON
bldnxtool$ = 1

#refrigeranti on
sref1on      : "M8" #Refrigerante esterno / Coolant Flood - ON
sref2on      : "M8" #Refrigerante aria / Coolant Mist - ON
sref3on      : "M7" #Refrigerante interno / Coolant Tool - ON

#refrigeranti off
sref1off     : "M9" #Refrigerante esterno / Coolant Flood - OFF
sref2off     : "M9" #Refrigerante aria / Coolant Mist - OFF
sref3off     : "M9" #Refrigerante interno / Coolant Tool - OFF

#definizione richiamo utensile / tool recall definition - 0=NUMERO / NUMBER 1=NOME / FIRST NAME
tipo_cu = 0

#posizione fine programma M91 / position end program M91 - 0=NO 1=YES
svinc_end = 0

#coordinate fine programma M91 / coordinates end program M91
xfin = 0 #posizione svincolo finale X / position end program X
yfin = 0 #posizione svincolo finale Y / position end program Y
zfin = 0 #posizione svincolo finale Z / position end program Z
```

