

Postprocessor design criteria for MillMaster pro and TurnMaster pro

Many CAD/CAM programs already support MicroKinetics CNC machines. With thousands of MicroKinetics CNC machines delivered, CAD/CAM software vendors find it beneficial to include a post processor with their software.

If your CAD/CAM software does not have a MicroKinetics post, you or the CAD/CAM vendor may use the following information to set one up.

Generally our format is very similar to the Bridgeport Boss 4 or Boss 5 command set. Here are the relevant information you will need to use to make your own post.

G&M codes

Each command must be at the beginning of a new line. Multiple G & M code may not be on the same line.

N sequence Numbers

No N sequence numbers should be generated.

Comment Character

The comment character is the "/". Any text on this line following this character is ignored.

Center Coordinates

The I, J, and K coordinates specifying the center are always relative (i.e. incremental)

Modal Coordinates

The X Y Z coordinates are modal. (i.e. no need to specify them if the last position is where it needs to stay)

Leading zeros

Leading zeros on G and M commands are not required. I.e. G1 is the same as G01.

Leading/trailing zeros on coordinates

Leading Zeros or trailing zeros are not needed on coordinates

Number Format

Number format is up to 4 digits left of the decimal point and up to 6 digits right of the decimal point. Using a minimum of 5 digits of precision right of the decimal point is recommended.

Feed Rate

The feed rate is in tenths of inches per minute. I.e. F100 is 10 inches per minute.

Rotary Axis

The rotary axis is specified as the A axis. The number following the "A" command is in degrees. The speed of the rotary table when moving simultaneously with a linear command is proportioned to the longest linear move axis as necessary. When the rotary table is commanded by itself, the speed is set with the V command. The number following the V is in revolutions per minute (RPM).