

# 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).