



How to Have 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 the following to the GibbsCAM Post Department:

- 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

Upload your .gcpkg file and marked-up file here – [GibbsCAM Post Dept File Upload Site](#)

Send an email and explain your request to - GibbsCAM.Posts@3DSystems.com

You will receive notification of receipt right away.

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

```
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
N10G1Z-.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-3.5922Y4.3813T.0232.T.019
```