

# CUSTOM POST-PROCESSOR DEVELOPMENT FORM



Manufacturing Software Consultancy

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CUSTOMER INFORMATION	
Company Name :	_____
Date :	_____
Contact Name :	_____
Address :	_____
	_____
	_____
Phone :	_____
Fax :	_____
E-mail :	_____

Office Use Only	
date sent :	_____
date returned :	_____
Purchase Order # :	_____
Post Type :	_____

**IMPORTANT:** Please make a photocopy of the completed form for your own records and return this original to CamSkill Limited at the above address.

POST-PROCESSOR INFORMATION PACKAGE	
<p>The following items are required in order for CamSkill to develop an accurate, quality post-processor. Use this section as a checklist to make sure that all of the requested information is included.</p> <p><i>In addition, Customers are invited to submit additional machine-specific data, diagrams or sketches (hand-drawn or otherwise) to facilitate a complete understanding of the machine tool. (see next page)</i></p>	
Tick box	DESCRIPTION
<input type="checkbox"/>	The Post-Processor Development Form must be completed in its entirety.
<input type="checkbox"/>	A copy of the NC programming manual that includes: tape format (letter addresses), a complete list of supported G & M codes, motion limits, feedrate data, linear and circular motion format, spindle data, tool data, holders, home positions, cutter compensation data, tool length compensation, threading data (lathe only), bar feed data (lathe only).
<input type="checkbox"/>	A copy of the machine diagram or schematic displaying the machine configuration and axes limits.
<input type="checkbox"/>	Copies of proven production NC programs which reflect the customer's programming habits, techniques and requirements.
<input type="checkbox"/>	In the case of special options listed in the Special Post-Processor Requirements, a customised CL-Data file generated by the CAD/CAM vendor demonstrating these special features.

## ADDITIONAL MATERIAL SUPPLIED BY CUSTOMER

CamSkill would be grateful if the Customer would indicate here the quantity and type of additional documentation supplied with this form.

Diagrams / Schematics*	Data Files / Program Files*	Manuals / Other documentation*

\* please indicate the nature of the documents, i.e. hard copy printout, on diskette, e-mail, etc.

## GENERAL MACHINE-TOOL INFORMATION

Mill     Lathe     Mill/Turn     Wire-EDM     Laser/Plasma  
 Punch     Hybrid Punch     Other : \_\_\_\_\_

Machine Manufacturer :

Machine Model :

Controller Manufacturer :

Controller Model :

Number of Axes :

Axes Configuration :

(i.e. X, Y, Z, etc.)

Indicate whether rotary axes are either table or head.

Comments :

## GENERAL HARDWARE / SOFTWARE INFORMATION

Computer System(s) :

OS and Version :

CAD/CAM CLfile generator :

(e.g. ProE, CADD5, CATIA)

Release Number :

Build Number :

Post-Processor Release :

Post-Processor Build :

Programming Units (Inches, MM, Both) :

Data Transmission (Electronic, Tape) :

Circular Interpolation Method (IJK and/or R) :

For lathe, programming method (Radius or Diameter) :

Comments :

## STANDARD POST-PROCESSOR REQUIREMENTS

All NC programs can be broken down into the following standard sections. Fill-out the sections that apply to the post-processor with examples (G&M Codes) from proven NC production programs. Provide comments where applicable.

### HEADER (Program Identification, date & time, comment sections, communications, etc.)

Blocks:

Comments:

### MACHINE STARTUP (Safe startup codes, work coordinate call, initialisation codes ,etc.)

Blocks:

Comments

**SUB-PROGRAMMING (Sub-program definition and callout)**

Blocks:

Comments:

**TOOL CHANGE (Home position, tool callout, work coordinate callout, spindle data, coolant output)**

Blocks:

Comments:

**TOOL LENGTH COMPENSATION (Show examples to initialise and cancel tool length compensation)**

Blocks:

Comments:

**CUTTER COMPENSATION (Show examples for cutter radius, diameter, or 3D compensation)**

Blocks:

Comments:

**MOTION AND FEED (Linear, circular, multi-axis, combined rapid moves, feedrate moves)**

Blocks:

Comments:

**CANNED CYCLES (Show examples of all canned cycles for this machine)**

Blocks:

Comments:

**MACHINE SHUTDOWN (Rewind, part offload, go home, cancel codes, end program, communications)**

Blocks:

Comments:

## **SPECIAL POST-PROCESSOR REQUIREMENTS**

Special features and options may be ordered with the post-processor and are subject to a technical review by CamSkill. Any additional charges communicated by CamSkill must be approved prior to post-processor development. A customised CL-Data file generated with User's CAD/CAM vendor demonstrating these special features must be submitted for post-processor development.

### **CONVERSATIONAL PROGRAMMING**

NO

YES (Provide copies of conversational programming )

### **TOOLING SUMMARY (ID, speed, feed, geometry, description, etc. )**

Blocks:

Comments:

### **PROBING CYCLES (Initialisation, Point, Boss, I.D., Plane, etc.)**

Blocks:

Comments:

### **SPECIAL CYCLES**

Blocks:

Comments:

**HIGH – SPEED MACHINING**

Blocks:

Comments:

**SPECIAL COOLANT, CLAMP, AIR CODES**

Blocks:

Comments:

**PALLET CHANGE CODES**

Blocks:

Comments:

**ARC FITTING**

Blocks:

Comments:

**SUB – SPINDLE PROGRAMMING (Turning Only)**

Blocks:

Comments:

**BAR – FEED SEQUENCES (Turning Only)**

Blocks:

Comments:

**OTHER**

Blocks:

Comments:

***ADDITIONAL COMMENTS / TECHNICAL INFORMATION\*\****

\*\* List any additional special requirements, comments or technical information specific to the development of the post-processor (please attach additional sheets as required).