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 federate 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).