



## Multi Axis Mill/Router Post Request Form

### Request Info

Date of Request:

BobCAD-CAM Version:

### Company (Customer) Info

Name:

Customer ID:

Phone:

Email:

### Machine Info

Make:

Model:

Year:

Serial No:

### Machine Manufacturer Info (If Known)

Contact Person:

Contact Phone:

### Controller Info

Make:

Model:

Acceptable NC file extension (i.e. txt, NC, MIN, etc.):

### Additional Info

The following request form covers all standard multi axis mill/router machines. In order to create a working post processor for your machine, it is important to provide the following information:

- 1) A working sample program that has been run on the machine and has the following information (if applicable):
  - a) An example of the start of program, end of the program, and at least two tool changes
  - b) Any special characters required at beginning and end of the program
  - c) Arc Moves
- 2) A list of drilling canned cycles, along with an example for each (if applicable)
- 3) A list of G&M codes accepted by the machine, along with their descriptions
- 4) The electronic copy of the programming manual

### Special Functions (non-standard features)

Non-standard features are any features in the controller that are not supported within the standard software interface and posting engine. Example of special functions for a mill/router machine include multiple heads, multiple tables, drill banks, piggyback heads, saw blade, vacuum system, programmable pneumatic stock alignment pins, high-speed machining, probing cycles, tool measurement macros, custom canned cycles, etc. If your machine has any non-standard feature that you would like integrated into your post processor, please contact [support@bobcad.com](mailto:support@bobcad.com) for the scripted post request form. If you are not sure a feature is standard, please describe it in a separate page and attach it to your post request. One of our technicians will contact you if the custom scripted form is required.



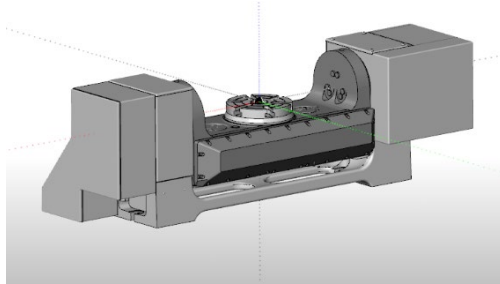
## Multi Axis Mill/Router Post Request Form

Center of Rotation / Pivot Length (Not required for 4x table rotary machines)

Location of the Center of Rotation (Pivot Length)<sup>1</sup>: X                   , Y                   , Z

Select the closest matching machine example below to learn how to find the center of rotation:

Table-Table Trunnion



Nutating Table-Table

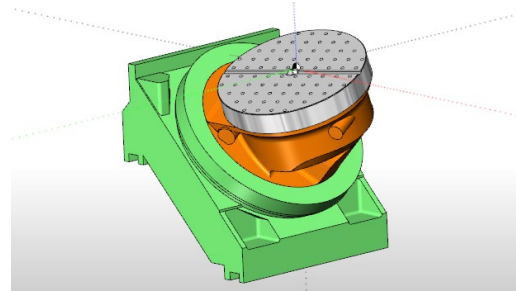
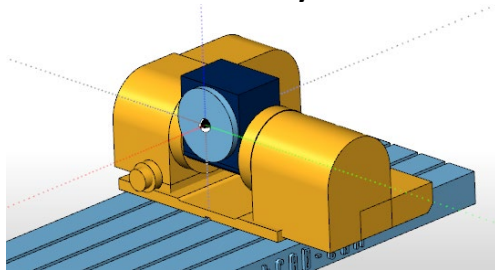
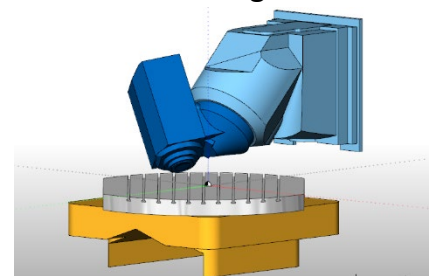


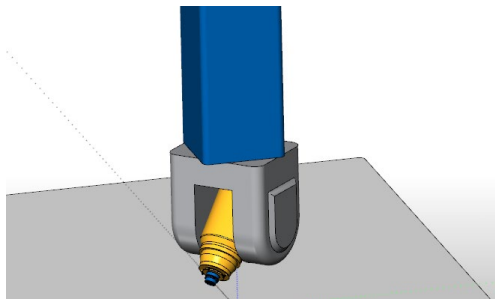
Table-Table Tilt Rotary Unit



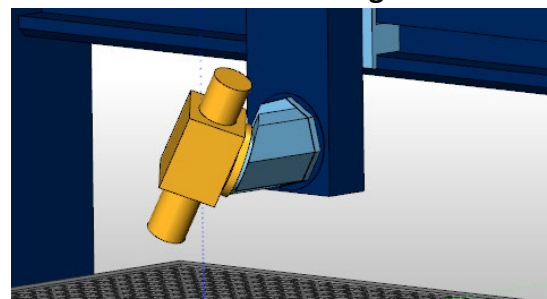
Nutating Head-Table



4 or 5 axis Head-Head or Head Table



Nutating Head-Head



For other machine configurations please send an image of your machine to  
[support@bobcad.com](mailto:support@bobcad.com)