

BobCAD-CAM Technical Support 13528 Prestige Pl Suite 102 Tampa, FL 33635

### Multi Axis Mill/Router Post Request Form

Phone: (727) 489-0003 Fax: (727) 442-9264

Page **1** of **3** 

Revision 4: 06/2021

Email: support@bobcad.com

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** 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.



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## Multi Axis Mill/Router Post Request Form

Machine Kinematics				
Machine Type¹:	Machine Configuration:	Horizontal	Vertical Metric	
Number of Axes:	Measurement Unit:	Imperial		
Max. Spindle Speed:	Max. Feed-Rate:			

	Linear Axes Configuration							
Axis	Moving This Axis Moves		Trave	l Limit <sup>2</sup>				
AXIS	Head	Table	Min	Max				
Х								
Υ								
Z								

Rotary Axes Configuration												
Axis				Travel Limit (degrees) <sup>3</sup>		Rotation Axis <sup>4</sup>		Axis Prefix <sup>5</sup>		Direction of		
	Head	Table	Min	Max						Rotation <sup>6</sup>		
1 <sup>st</sup>					Х	Υ	Z	Α	В	С	Pos	Neg
2 <sup>nd</sup>					Х	Υ	Z	Α	В	С	Pos	Neg

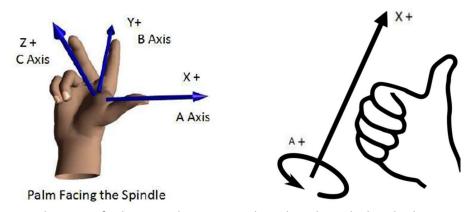


Figure 1: Positive directions for linear and rotary axes based on the right-hand rule (The axes IDs used here may not be the prefix used in the G-Code but how we identify the rotary axis components for building your machine)

<sup>&</sup>lt;sup>1</sup> Examples of Machine Types include: Head/Head, Head/Table, Table/Table, Nutating Head/Head, etc. See page 3.

<sup>&</sup>lt;sup>2</sup> The min and max travel limits are measured from the center of the platter/table

<sup>&</sup>lt;sup>3</sup> Enter unlimited in the table if the rotational travel is not limited

<sup>&</sup>lt;sup>4</sup> The axis by which the rotation axis rotates around (See figure 1)

<sup>&</sup>lt;sup>5</sup> The prefix used in the NC (g-code) program to address the rotation axes

<sup>&</sup>lt;sup>6</sup> The direction of the rotation for the rotation axes (see figure 1).

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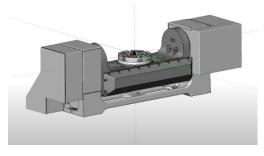
# Multi Axis Mill/Router Post Request Form

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

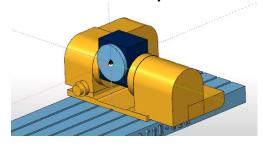
Location of the Center of Rotation (Pivot Length)<sup>1</sup>: X

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

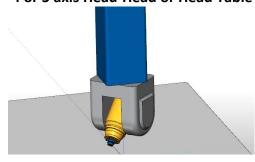
**Table-Table Trunnion** 



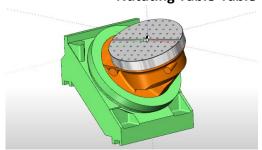
**Table-Table Tilt Rotary Unit** 



4 or 5 axis Head-Head or Head Table

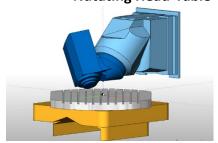


**Nutating Table-Table** 

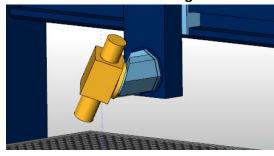


, Z

**Nutating Head-Table** 



**Nutating Head-Head** 



For other machine configurations please send an image of your machine to support@bobcad.com