GROUND SUPPORT
NUMERICAL CONTROL SYSTEMS
805-529-2827

PostHASTE upgrade Information for GibbsCAM Users

The following information is for upgrading a current 'GibbsCAM basic release version' of Ground Support's PostHASTE to support more advanced machine tool functions.

In order to use any PostHASTE upgrade, you must have the corresponding GibbsCAM software functionality - as indicated in the tables below.

For example, to use PostHASTE 4 axis Simultaneous (rotary) machining upgrade, you must already have a licensed version of GibbsCAM (4 axis) Rotary Mill. (Purchase GibbsCAM upgrades through your local GibbsCAM dealer.)

The upgrade choices are listed in order of increasing complexity. When an upgrade is purchased, it includes the items listed above it in the **same** table. For example, an Advanced Mill upgrade includes 4th axis indexing and 4 axis rotary Mill capabilities as well.

PostHASTE Upgrades*

PostHASTE Milling Upgrades	GibbsCAM product required
4 axis (rotary) indexing	Simple Positioning
Multiple 3 axis setups or 4 axis indexing using coordinate systems (CS)	Advanced Mill
4 axis Simultaneous (rotary) machining	Rotary Mill
Multiple 3 axis setups or 5 axis indexing	Advanced Mill
5 axis indexing and simultaneous machining	Productec 5 axis plug-in

PostHASTE Turning and Mill-Turn Upgrades	GibbsCAM product required
Include threading canned cycles	Basic turning
Include rough and finish canned cycles	Basic turning
3 or 4 axis Mill/Turn (XZC or XYZC axes)	MillTurn
5 axis Mill/Turn (additional B rotating axis)	MillTurn

- **NOTE:** Please contact Ground Support for pricing information. (805-529-2827)

- **Formatting service** is also available from Ground Support (or your participating Gibbs Dealer) at an additional charge; for a firm quote, please send a working sample program for your machine along with a matching VNC file (with tool paths).

'Upgrading an Upgrade' $(100 Upgrade Fee)

When purchasing a second upgrade (for the same system), a credit is applied for any previous upgrade purchases LESS $100