**The world's first one page postprocessor:**

The sample below is a complete 4 axis mill format template.

Formatting PostHASTE is just like editing an NC program: simply edit the template's NC code sequences to show how you want your NC programs to look.

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### Section 1 - Letter formatting

- **O >4** (O can be up to 4 digits.)
- **N >4**
- **G >2** (G can be up to 2 digits.)
- **X ->3.>4** (All these letters are formatted to allow a minus sign, then up to 3 digits before the decimal, and up to 4 digits after.)
- **Y ->3.>4**
- **Z ->3.>4**
- **I ->3.>4**
- **J ->3.>4**
- **Q ->3.>4**
- **R ->3.>4**
- **P ->3.>4**
- **A ->4.>4** Limit -8000 8000 (For Rotary axis.)
- **F >3.1**
- **K ->3.>4**
- **H >2**
- **D >2**
- **T >2**
- **M >2**
- **S >4**

### Section 2 - Miscellaneous parameters

- **ModalGs 0 1 2 3 73 74 76 80 81 82 83 84 85**
- **Sequence#s N 0 1 1** Char, Freq, Inc., First
- **HCode X** (Axis letters.)
- **VCode Y**
- **Dcode Z**
- **FeedCode F**
- **Feed G1** (Motion G codes.)
- **Rapid G0**
- **Cw G2**
- **Ccw G3**
- **CtrCode I J** (Circle info... )
- **CtrIncremental? Y**
- **Comment ( )** (Comment start / end.)
- **Spindle 3 4 5** (M codes: Cw, Ccw, Off )
- **Coolant 8 9 7** (M codes: On, Off, Mist.)
- **DComp 41 42 40** (G codes: Left, Right, Off )
- **RotaryFeed F[InvTime]** Rotary feed rate
- **FeedType G 95 94 93** IPR, IPM, InvTime

### Section 3 - The NC code sequences

(First, the sequences for program startup, tool changes, rotary rapid [index] moves, cutter diameter compensation and program end...)

**StartCode**

```
O[Program#]
G91
G28 X2 Y-2 Z-2
G90
End
```

**1stToolChange**

```
M[Cool]
End
```

**ToolChange** (Secondary tool changes.)

```
M9
G28 G49 Z0 S100
M[Cool]
End
```

**Index X** (How to rapid w/ rotary motion.)

```
G0 Z[RPlane]
Z[D]
End
```

**Infeed** (Apply cuttercomp)

```
G1 Z[D] F[Plunge]
end
```

**Outfeed** (Remove cuttercomp)

```
G1 G40 X[H] Y[V]
Z[D]
end
```

**EndCode**

```
G0 G28 G49 Z0 S100
G28 G91 X0 Y0 A0 T[Tool1] M6
G90 M30
End
```

(Now, the code for the drilling cycles...)

**Drill** - Feed in, rapid out.

```
G81 X[H] Y[V] Z[D] R[Vclear] F[FRate]
end cancel
```

**Peck** - Peck Drill (full tretract)

```
end cancel
```

**ChipBreak** - Peck Drill (partial tretract)

```
end cancel
```

**Tap** - Tapping.

```
G84 X[H] Y[V] Z[D] R[Vclear] F[FRate]
end cancel
```

**LTap** - L. handed tapping.

```
G74 X[H] Y[V] Z[D] R[Vclear] F[FRate]
end cancel
```

**Ream** - Feed in, rapid out.

```
G85 X[H] Y[V] Z[D] R[Vclear] F[FRate]
end cancel
```

**Bore** - Feed in, stop, rapid out.

```
G86 X[H] Y[V] Z[D] R[Vclear] F[FRate]
end cancel
```

**Back** - Back bore cycle.

```
G87 X[H] Y[V] Z[D] R[Vclear] F[FRate]
end cancel
```

**Cancel** (Code used to cancel the drill cycles.)

```
G80
end
```

Note: 3 axis formats are exactly the same except they don’t have the code shown in **italics** (most notably, the Index sequence and RotAngle variable)
3 axis milling formats

Aciera
AC Output
Acramatic 2100
Acramatic 8 (NO V offsets)
ACTRON III
Allen Bradley 8400
Allen-Bradley 4500
Anilam
Anilam 1100 Series
Anilam Crusader II Second Run
ANILAM Crusader Series M - EVENT STYLE
Anilam with 2 tools
Anilam with up to 10 tools
Bandit 1 (Summit Dana Level 3)
Bandit 4
Bandit II
Bandit II w/ Hasbach - Absolute
Bandit II w/ Hasbach - incremental
Bandit III
Bostonomatic
Bridgeport 300
Bridgeport Boss 3.
Bridgeport Boss 5
Bridgeport Boss 7.2
Bridgeport BOSS 8
Bridgeport Boss 9.
Bridgeport Boss 9 - M26 style Tool change
Bridgeport Series 1 w/ A-Ha Retrofit.
Bridgeport TNC-151
Bridgeport VX3
BX
CAT-I
CAT-II
Centroid
Centurion 4
CENTURION 4
Centurion 5
Cincinnati
Command (Courtesy Gerry Traicoff 6/97)
Cincinnati 220 Tab-Sequential (columnar)
Format
Cincinnati Milacron 850MC SX
Cincinnati Milacron 950MC B Axis Indexing
Cincinnati AC-8 (60 cam positions)
Columnar ("tab-sequential") Output
Deckel
Deckel FP 4NC UNIVERSAL MILL (HOR.)
Deckel FP 4NC - Vertical head
Deckel with Dialog II Control
DeVileg
Dynac 2400 Conversational
Dynatite M24 4000 / 4400 (no rotary)
Dynatite M24 4000 / 4400 4 axis (full rotary interpolation)
Dynatite M4 4 axis 2400 / 4400
Dynapath Generic
Dynapath (Using "Event" codes)
Dynapath 10 ("Event" codes, Arcs Abs, G83 peck)
Dynapath 10; no Work offset. (Arcs Abs, G83 peck)
Dynapath 20 (Rockwell - Abs Arc Ctr lJ)
Dynapath 5 Event
Dynapath 5 (Using "G" Codes),
Dynapath Control
Dynapath Delta 20 Conversational
Dynapath Delta 20 EIA
Dynapath Delta 30 1-16-96
Dynapath Delta 30 Conversational 9-4-96
Dynapath Delta 30 Conversational, Tree
Dynapath Delta 50
Dynapath, Tree Mill
Excel with Fanuc Control
Fadal
FADAL
Fadal Format 1
FADAL WITH "E" OFFSETS
FADAL WITHOUT "E" OFFSETS
Fagor
Fagor 700, Sacsen Horizontal
Fanuc (Anilam?)
Fanuc (Generic - 3 axis)
Fanuc (Subs 1st - by Line #)
Fanuc (Subs Last - by Sub #)
Fanuc 0C
Fanuc 0M
Fanuc 0M for G&L
Fanuc 10M
Fanuc 11M
Fanuc 11M with Toolchanges
Fanuc 11M without Toolchanges (Single tool programs)
Fanuc 11m, Dahlish
Fanuc 3000C
Fanuc 5
Fanuc 6M, HC-500
Fanuc, Hillyer
Fanuc, Kasuga
GE 1050 (2 1/2 axis MILL)
GE 2000
GE 550 (2 1/2 axis MILL)
GE Mark Century
HAAS
HAAS VF series vertical mill
HAAS VF-0 , . Inc. 8/5/96
Heidenhain 2500 with Automatic tool change and MB9
Heidenhain 2500 with Automatic tool change no MB9
Heidenhain 2500 with manual tool change and MB9
Heidenhain 2500 with manual tool change no MB9
Heidenhain 2500 with manual tool change and MB9
Heidenhain 2500 with manual tool change no MB9
Heidenhain 2500 with manual tool change and MB9
Heidenhain 2500 with manual tool change no MB9
Heidenhain TNC 151 Conversational
Heidenhain TNC 155 (ISO/DIN format)
Heidenhain TNC 2500 Standard G-Code
Heidenhain TNC 351 Conversational
Heidenhain TNC 415 Conversational Sub Program
Heidenhain TNC 415 Standard G-Code
Hurco
HURCO 30 Mill Post
Huroco ULTIMAX 3
Huroco Ultimax NC V1.x
HURCO, A.O. Smith
Intercon M Series, Supermax Machining Center
Japax
K&T Mill
K&T MM600 D-17 (3 AXIS - INCH mode)
KAM 650
KV1000
KV500
Maho XY Plane (G17)
Maho XY Plane (G18)
Maho XZ Plane (G18)
MAX III V1.x
Mazak M2 control
Mazak M32
Mazak M32 iso
Mazak M32 Vertical Bridge Crane
Mazak V41
MC 65
MVC
MG Torch
Milltronics Centurion V
Milltronics post for Centurion 1
Milltronics post for Centurion 5
Milltronics with toolchanges
Milltronics without toolchanges
Mitsubishi Meldas, Okk
Mitsubishi 520
Mitsubishi M0
Mitsubishi M550
Mitsubishi Wire H Series
Milk
Okuma OSP 7000 Vertical Mill
Okuma OSP5000
OKUMA OSP5000
PCV
ProtoTRAK
ProtoTRAK AGE 2 Format
ProtoTRAK AGE 3 format
ProtoTrak for Plastic Parts
ProtoTrak Inch
ProtoTRAK MX-2
ProtoTRAK Plus
ROLAND CAMM-3
Sharnoa Tiger 4
Shizukawa 300C
SPECTRAIGHT
Thermwood 2 axis gantry style router
Thermwood Model 70
Tiger 4 (2 line Arcs: G11, then G12/13) (CWCode)
Tiger 5
Tree Mill
Ultra
VICTOR
Victor 3M
Willem-Macodel Multi-Spindle
X, Y Z ONLY!
Yasano 2000G
Yasano 80M
Yasano MX3
Yasano, Mori Seiki
Yasnac LX1, Mori SL-1A - Optional Cutoff.
YASNAC LX3, HITEC-TURN 40

2 axis lathe formats

Cincinnati
Citizen F10 Screw machine
Cummings Ultra-Slide (NC Electronics Controller)
Daewoo / Fanuc OT
EZ-Path II
Fadal post for turning on vertical center
Fagor 600T Lathe
Fanuc 0T
Fanuc 0T w/ B axis ("straight code" for Ream, Drill, & Peck)
Fanuc 0T w/ B axis (uses canned cycles)
Fanuc 0T, Enco - G76 Threading (ITT)
Fanuc 0T, Enco - G76 Threading - Using Cutoff. (ITT)
Fanuc 0T, Mori Partner 100 - G76 Threading (No cutoff)
Fanuc 10T
FANUC 10T, HITEC-TURN 25S
Fanuc 5T
Fanuc 5T - (Longhand' Drill cycles)
Fanuc 5T, Pratt & Whitney Star-Turn
Fanuc 6T - (For controls that have no 'Drill cycles')
Fanuc 6T
Fanuc 6T, 10T, 11T - Mori - Using Cutoff. (ITT)
Fanuc 6T, 10T, 11T - Mori (ITT)
Fanuc 6T, Miyano - Using Cutoff. (ITT)
GE 550 / LeBlond (Incremental)
GE 550 Abs
GE 550 Inc
GE 550T - Tool lengths (Z05555) must be edited!
GE 550T with Bar feed. (Tool lengths (Z05555) must be edited!)
Hitachi Seiki Lathe
Ikegai Fanuc 5T
Mitsubishi L0
Mitsubishi Meldas 500L
Mitsubishi Meldas 500L w/ Cutoff cycle
Mori-Seiki (used as chuckers).
Mori-Seiki SL25
Mori-Seiki w/ Stock stop @ beginning.
Pro-Light Lathe
Yasano 2000B
Yasano LX1, Mori SL-1A - Optional Cutoff.
YASINAC LX3, HITEC-TURN 40

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