

The world's first one page postprocessor:

PostHASTE

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.

<p>name Haas 4 axis Vertical machining center</p>		
<p>- Section 1 - Letter formatting -</p>	<p>- Section 3 - The NC code sequences -</p>	
<p>O >4 (O can be up to 4 digits.) N >4 G >2 (G can be up to 2 digits.)</p>	<p>(First, the sequences for program startup, tool changes, rotary rapid [index] moves, cutter diameter compensation and program end...)</p>	<p>(Now, the code for the drilling cycles...)</p>
<p>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</p>	<p>StartCode O[Program#] G91 G28 X2 Y-2 Z-2 G90 End</p>	<p>Drill - Feed in, rapid out. G81 X[H] Y[V] Z[D] R[Vclear] F[FRate] end cancel</p>
<p>A ->4.>4 Limit -8000 8000 (For Rotary axis.)</p>	<p>1stToolChange N[Block] T[Tool] M6 G0 G40 G80 G[Work] X[H] Y[V] A[RotAngle] G43 Z[D] H[Lcomp] M[Direct] S[Speed] M[Cool] End</p>	<p>Peck - Peck Drill (full retract) G83 X[H] Y[V] Z[D] Q[VBite] R[Vclear] F[FRate] end cancel</p>
<p>F >3.1 K ->3.>4 H >2 D >2 T >2 M >2 S >4</p>	<p>ToolChange (Secondary tool changes.) M9 G28 G49 Z0 S100 N[Block] T[Tool] M6 G0 G40 G80 G[Work] X[H] Y[V] A[RotAngle] G43 Z[D] H[Lcomp] M[Direct] S[Speed] M[Cool] End</p>	<p>ChipBreak - Peck Drill (partial retract) G73 X[H] Y[V] Z[D] Q[VBite] R[Vclear] F[FRate] end cancel</p>
<p>- Section 2 - Miscellaneous parameters -</p>	<p>Index X (<i>How to rapid w/ rotary motion.</i>) G0 Z[RPlane] G[Work] X[H] Y[V] A[RotAngle] Z[D] End</p>	<p>Tap - Tapping. G84 X[H] Y[V] Z[D] R[Vclear] F[FRate] end cancel</p>
<p>ModalGs 0 1 2 3 73 74 76 80 81 82 83 84 85 Sequence#s N 0 1 1 Char, Freq, Inc., First</p>	<p>Infeed (Apply cuttercomp) G1 Z[D] F[Plunge] G[Side] X[H] Y[V] D[DComp] F[FRate] end</p>	<p>LTap - L. handed tapping. G74 X[H] Y[V] Z[D] R[Vclear] F[FRate] end cancel</p>
<p>HCode X (Axis letters.) VCode Y Dcode Z FeedCode F</p>	<p>Outfeed (Remove cuttercomp) G1 G40 X[H] Y[V] Z[D] end</p>	<p>Ream - Feed in, rapid out. G85 X[H] Y[V] Z[D] R[Vclear] F[FRate] end cancel</p>
<p>Feed G1 (Motion G codes.) Rapid G0 Cw G2 Ccw G3</p>	<p>EndCode G0 G28 G49 Z0 S100 G28 G91 X0 Y0 A0 T[Tool1] M6 G90 M30 End</p>	<p>Bore - Feed in, stop, rapid out. G86 X[H] Y[V] Z[D] R[Vclear] F[FRate] end cancel</p>
<p>CtrCode I J (Circle info...) CtrIncremental? Y</p>		<p>Back - Back bore cycle. G87 X[H] Y[V] Z[D] R[Vclear] F[FRate] end cancel</p>
<p>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)</p>		<p>Cancel (Code used to cancel the drill cycles.) G80 end</p>
<p>RotaryFeed F[InvTime] Rotary feed rate FeedType G 95 94 93 IPR, IPM, InvTime</p>		

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)

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3 axis milling formats

Aciera
ACL Output
Acramatic 2100
Acromatic 8 (NO V offsets!)
ACTRION 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
Bostomatic
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
Cincinnati (Courtesy Gerry Traicoff 6/97)
Cincinnati 220 Tab-Sequential (columnar)
Format
Cincinnati Milacron 850MC SX
Cincinnati Milacron 950MC B Axis Indexing
CintiMatic 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
DeVlieg
Dyna 2400 Conversational
DynaMite 2400 / 4400 (no rotary)
DynaMite 2400 / 4400 4 axis (full rotary
interpolation)
DynaMite 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 I,J)
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 8050, Sacem 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, Dahlih
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 M90
Heidenhain 2500 with Automatic tool
change no M90
Heidenhain 2500 with manual tool change
and M90
Heidenhain 2500 with manual tool change
no M90
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
Hurco ULTIMAX 3
Hurco Ultimix III 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

Kuraki Mill Post

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
MCV
MG Torch
Milltronics Centurion V
Milltronics post for Centurion 1
Milltronics post for Centurion 5
Milltronics with toolchanges
Milltronics without toolchanges
Mistubishi Meldas, Okk
Mitsubishi 520
Mitsubishi M0
Mitsubishi M550
Mitsubishi Wire H Series
Okk Mill
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
Sharno Tiger 4
Shizuoka 3000C
SIEMENS 810M
Spectralight
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
Willemin-Macodel Multi-Spindle
X,Y,Z ONLY!
Yasnac 2000G
Yasnac I80M
Yasnac MX3
Yasnac, Mori Seiki

2 axis lathe formats

Cincinnati
Citizen F10 Screw machine
Cummings Ultra-Slide (NC Electronics
Controller)
Daewoo / Fanuc 0T
EZ-Path II
Fadal post for turning on vertical center
Fagor 800T Lathe
Fanuc 0T
Fanuc 0T w/ B axis ("straight code" for
Ream, Drill, & Peck)
Fanuc 0T w/ B axis (uses Canned cycles)
Fanuc 0T, Emco - G76 Threading (ITT)
Fanuc 0T, Emco - G76 Threading - Using
Cutoff. (ITT)
Fanuc 0T, Mori Partner 100 - G76
Threading (No Cut-off)
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
(Z5555) must be edited!)
Hitachi Seiki Lathe
Ikegai Fanuc 5T
Mitsubishi L0
Mitsubishi Meldas 500L
Mitsubishi Meldas 500L w/ Cutoff cycle
Mori-Seiki (used as chucker).
Mori-Seiki SL25
Mori-Seiki w/ Stock stop @ beginning.
Pro-Light Lathe
Yasnac 2000B
Yasnac LX1, Mori SL-1A - Optional
Cutoff.
YASNAC LX3, HITEC-TURN 40

...And more...

**4 and 5 axis mills, Mill/Turns
Punch Presses, WaterJet,
Flame, Laser & Plasma cutters!**

Wire EDM formats

Agie EDM 2 Axis
Charmilles EDM 2 Axis
Charmilles EDM 4 Axis
Elox EDM 2 Axis
Elox EDM 4 Axis
Generic EDM

Japax EDM
Japax EDM 4 Axis
Mitsubishi 4 Axis
Mitsubishi H Series EDM
Sodick EDM
Sodick EDM 4 Axis

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