

## How to Get Your Post Modified

Follow the steps outlined below to ensure that your post processor is modified to your desired specifications.

Prepare the following files:

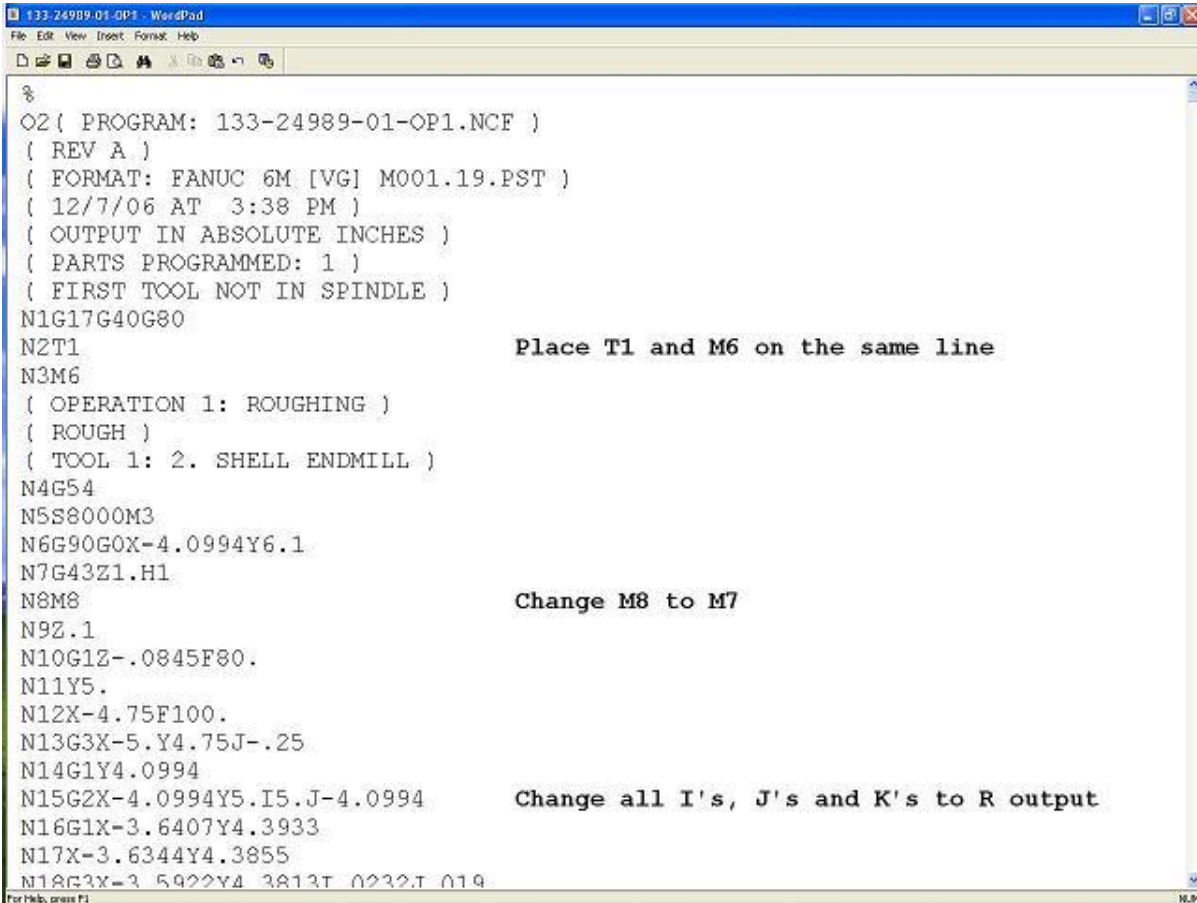
- One (1) marked-up g-code program (with comments turned on) ([watch video tutorial](#))
- One (1) .gcpkg (Pack and Go) file that was used to create the g-code program ([watch video tutorial](#))

If your post was purchased **before February 1, 2022**: Send an email with your request and the above files attached to: [posts@3datum.com](mailto:posts@3datum.com).

If your post was purchased **on or after February 1, 2022**: Send an email with your request and the above files attached to: [post@gibbscam.com](mailto:post@gibbscam.com) and cc [posts@3datum.com](mailto:posts@3datum.com) so that we can keep track of your requests.

If your file is too large to attach to an email, please contact us directly for an upload link: **412-737-5363**

The image below illustrates how the g-code program would be marked up in the desired manner.



The image shows a screenshot of a WordPad window titled "133-24989-01-OP1 - WordPad". The window contains a g-code program with several lines of code. Annotations are placed to the right of the code to indicate modifications. The code is as follows:

```

%
O2( PROGRAM: 133-24989-01-OP1.NCF )
( REV A )
( FORMAT: FANUC 6M [VG] M001.19.PST )
( 12/7/06 AT 3:38 PM )
( OUTPUT IN ABSOLUTE INCHES )
( PARTS PROGRAMMED: 1 )
( FIRST TOOL NOT IN SPINDLE )
N1G17G40G80
N2T1
N3M6
( OPERATION 1: ROUGHING )
( ROUGH )
( TOOL 1: 2. SHELL ENDMILL )
N4G54
N5S8000M3
N6G90G0X-4.0994Y6.1
N7G43Z1.H1
N8M8
N9Z.1
N10G1Z-.0845F80.
N11Y5.
N12X-4.75F100.
N13G3X-5.Y4.75J-.25
N14G1Y4.0994
N15G2X-4.0994Y5.I5.J-4.0994
N16G1X-3.6407Y4.3933
N17X-3.6344Y4.3855
N18G3X-3.5922Y4.3813T.0232.T.019.
  
```

Annotations in the image include:

- "Place T1 and M6 on the same line" pointing to lines N2T1 and N3M6.
- "Change M8 to M7" pointing to line N8M8.
- "Change all I's, J's and K's to R output" pointing to line N15G2X-4.0994Y5.I5.J-4.0994.