

How to Get Your GibbsCAM Post Processor Modified

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

1. Mark-up a g-code program with comments turned on) ([watch video tutorial](#))
2. Create a Pack and Go (.gcpkg) using the file that was used to create the g-code ([watch video tutorial](#))
3. Send an email with your request and the above files attached to the GibbsCAM Post Dept. at post@gibbscam.com and cc 3DATUM at posts@3datum.com . **Include your company name and the machine make and model in the subject line.**

If your file is too large to attach to an email, contact the GibbsCAM Post Department at (805) 523-0004 for an upload link.

When modifying the program highlight the changes by using different color fonts and adding notes:

Removed words or codes in red

Moved words or codes in blue

Added words or codes in green

*** remove this line

*** move this command to this location

*** add this code in this location

Example:

```
G28U0.W0.          *** Add this line here - all instances
N58G99M41         *** Remove G99
N59G54
N60G97S500M3T0404
N61G0X6.6Z.1826M8
N62Z.2908
N63X6.3
N64G76P010060Q10R.001      *** move this line here
N65G76X6.0548Z-1.75I0.P886Q150F.1575      *** make single line canned cycle
G76X6.0548Z-1.75D150P4A30.K.0886F.1574M24      *** delete this line
N66G0X6.6N67Z.1826
N68M9
N69 X20.Z10.05 G28U0.W0 M5      *** Remove X, Z and change to G28U0.W0
```

To create a Pack and Go file:

- File Tab
- Exchange Tab
- Click **Pack and Go**

(Watch a video tutorial for how to create a Pack and Go file [here](#).)

