

ExpertCAM Post Processor Installation Instructions

Configuring the ExpertCAM-Post.cfg File

This ExpertCAM-Posts.cfg file describes the post processors which will appear in the list in the Send To Control panel of ExpertCAM.

Each textbuffer TM_MACHINE_TOOL1 through TM_MACHINE_TOOL100 will define one entry in the list.

Define as many as you want, in the order you want them to appear. To use one of the post processors which are included in this kit, follow step 2 below.

The syntax to set a machine tool text buffer is:

```
set TM_MACHINE_TOOL<n> ((1) (2) (3) (4) (5) (6))
```

Where <n> is an integer value you supply starting at 1 and incrementing by 1 for each machine tool supported.

The 6 components of the set command are described below. The set of 6 components are enclosed in parentheses.

Each textbuffer definition (TM_MACHINE_TOOL1, TM_MACHINE_TOOL2,) has 6 components:

1. The name to show in the list in the panel. This can be any name you wish to see appear in the dialog. Remember to enclose the name in parentheses.
2. The name of the folder on disk that contains the post processor files.

For configurable post processors, this will be the name of the folder where the configuration file(s) for the post reside.

For custom post processors (*.exe), this is the name of the folder where the executable post processor is located.

Post processor folders for mill posts are located here:

```
C:\ProgramData\AMT Software\ExpertCAD\ExpertCAM Posts\MILL
```

For lathe posts:

```
C:\ProgramData\AMT Software\ExpertCAD\ExpertCAM Posts\LATHE
```

For flame posts:

```
C:\ProgramData\AMT Software\ExpertCAD\ExpertCAM Posts\FLAME
```

This component of the text buffer is the name of the folder name NOT the entire path. For example, if you wish to use the Fanuc6M mill post processor, this component would be: (Fanuc6M)

3. The name of the folder where the output of the post processor (tape file and, if requested, print file) should be placed. Use a full path name for this component. **Use the forward slash '/' to separate the components of the path not the '\' that Windows typically uses.** This component must be enclosed by parentheses. For example:

```
(C:/Users/Dewey/Documents)
```

4. The name of the extension you wish use for the tape file that the post processor will produce. For example, if you wish to use the extension '.cnc', this component would be:

```
(.cnc)
```

5. The type of post processor you are defining. This type tells ExpertCAM how to run the post processor. The type must be one of the following values:

```
CONFIGURABLE_MILL  
CONFIGURABLE_LATHE  
CONFIGURABLE_FLAME  
CONFIGURABLE_NIBBLE  
CUSTOM_MILL  
CUSTOM_LATHE  
CUSTOM_FLAME  
CUSTOM_NIBBLE
```

Post processors that use configuration files must use one of the types that begins with 'CONFIGURABLE' based on the machine type the post supports.

Post processors that use a program (.exe), must use one the types that begins with 'CUSTOM' based on the machine tool it supports.

6. Any additional parameters that must be sent to the post processor. For configurable post processors, this could be instructions to use additional configuration files. Common configuration files include macro files (.m) and event files (.e). An example might be the Boss6 mill post processor where we need to tell the post processor to use both the macro file and event file. This portion of the definition would be as follows:

```
(-e "$COMMON_APPDATA_PATH/ExpertCAM Posts/MILL/Boss6/Boss6.e" -m  
"$COMMON_APPDATA_PATH/ExpertCAM Posts/MILL/Boss6/Boss6.m")
```

It is common that a configurable post will have an event file (.e) and/or macro file (.m). Follow the syntax exactly as shown above to refer to a macro or event file.

Custom post processors usually do not have any optional parameters nevertheless you must specify an empty option field:

```
()
```

Example 1: A configurable mill post processor named "Fanuc 6M" in the post processor dialog, the configuration files in the folder "Fanuc6M" with the output from the post being written to the folder C:\temp. The output tape file will be given the extension '.fan'. This configurable post processor does not require any additional parameters to specify and event (.e) or macro (.m) file:

```
set TM_MACHINE_TOOL1 ((Fanuc 6M) Fanuc6M (C:/TEMP) (.fan) CONFIGURABLE_MILL ())
```

Example 2: A custom mill post processor named "Komo Router" in the post processor dialog. The custom post processor (Komo.exe) file is in the folder "Komo" with the output from the post being written to the folder C:\temp. The output tape file will be given the extension '.txt'. This custom post processor does not require any addition parameters:

```
set TM_MACHINE_TOOL2 ((Komo Router) Komo (C:/TEMP) (.txt) CUSTOM_MILL ())
```

Example 3: A configurable mill post processor with an event file (.e) and macro file (.m). Note that the set command is just 1 line in the configuration file; it appears as 3 lines here to fit to the paper size.

```
set TM_MACHINE_TOOL3 ((Boss 6) Boss6 (C:/TEMP) (.txt) CONFIGURABLE_MILL (-e  
"$COMMON_APPDATA_PATH/ExpertCAM Posts/MILL/Boss6/Boss6.e" -m  
"$COMMON_APPDATA_PATH/ExpertCAM Posts/MILL/Boss6/Boss6.m"))
```

Example 4: A configurable lathe post processor with an event (.e) file

```
set TM_MACHINE_TOOL4 ((Fanuc 3TC) (Fanuc3TC) (C:/TEMP) (.txt) (CONFIGURABLE_LATHE) (-e  
"$COMMON_APPDATA_PATH/ExpertCAM Posts/LATHE/fanuc3tc/fanuc3tc.e"))
```