

Post Processor Request Form

Due to the complexity and wide variety of machines and controls, we ask that you complete the relevant areas of the following forms when requesting a post processor for a given machine. Completion of the relevant forms will allow us to keep the turnaround time of your request to a minimum. Often times, post assistance is delayed due to a lack of information and/or specifications needed to complete the process. Other times we are overwhelmed with extraneous data which takes large amounts of time to sort through only to find that the information really needed was not supplied.

To help us provide the best service possible, please complete only those pages that pertain to your given machine type. **It is very beneficial for each post request to include complete "G-code" and "M-code" lists and canned cycle information (if applicable). Sample NC code files with examples of start of file, tool changes, coolant on/off, cutter compensation, arcs and canned cycles will also assist in reducing development and testing time.** We may contact you if more information is required to process your request.

In most cases we can accurately quote custom post processor development through informal discussion/communication; however, we require the completion of this form along with a purchase order prior to starting the development process. The typical turnaround time for a custom post processor is 2-3 weeks from the completion date of this form and purchase order. The delivered product may still require additional post edits, included with the custom development, which will require testing and feedback on your end. These subsequent edits will fall under the post modification process.

QTE will deliver a post processor along with posted code from one of our standard sample parts to test the functionality and accuracy of the post. It is the customer's responsibility to review and test the code for accuracy prior to running in the machine. Any changes needed need to be documented and provided to QTE per the post modification process.

Please return the completed form to posts@qtemfg.com or fax to 636-300-0561.

Key Company Information:

Sim Number: _____ Mastercam Version: _____

Company Name: _____

Contact Name: _____ Title: _____

Address: _____

Phone: _____ - _____ - _____

Email: _____



Mill Post Specific Information

Note: If you do not know the answers to certain questions, contact your machine tool dealer.

Machine Make/Model: _____

Machine Control Make/Model (i.e. Fanuc 18m): _____

Age of Machine: _____

Is an experienced programmer for this machine available for questions? Yes No

Are programming manuals available for this machine/control? Yes No

Are copies of proven programs available for features required? Yes No

Machine type: Horizontal Vertical Number of axis: 2 3 4 5

4th axis information: Full Rotary Indexer None Axis of rotation (if applicable): X Y Z

5 Axis machines: *Complete 5 Axis Specific Page*

Tables: Single Dual Multiple Heads: Single Dual Multiple

What is the axis layout of the machine? (Please provide a diagram of the machine with clear labeling of each axis and its limits... If necessary take a picture and provide markup as needed)

Lathe Post Specific

Note: If you do not know the answers to certain questions, contact your machine tool dealer.

Machine Make/Model: _____

Machine Control Make/Model (i.e. Fanuc 18t): _____

Age of Machine: _____

Is an experienced programmer for this machine available for questions? Yes No

Are programming manuals available for this machine/control? Yes No

Are copies of proven programs available for features required? Yes No

Machine type: Horizontal Vertical Spindle types: Single 1 Sub Multiple Sub

Multi-axis: C-Axis Y-Axis B-Axis (check all that apply)

Number of turrets: ____ Turret Orientation: Top Bottom Both (multiple turrets)

Programmed tailstock? Yes No Parts catcher? Yes No

Loader system? Yes No Bar feed? Yes No

What is the axis layout of the machine? (Please provide a diagram of the machine with clear labeling of each axis and its limits... If necessary take a picture and provide markup as needed)

Wire Post Specific

Note: If you do not know the answers to certain questions, contact your machine tool dealer.

Machine Make/Model: _____

Machine Control Make/Model (i.e. Sodick A280L): _____

Age of Machine: _____

Is an experienced programmer for this machine available for questions? Yes No

Are programming manuals available for this machine/control? Yes No

Are copies of proven programs available for features required? Yes No

Number of Axis: 2 4

Single or Twin Wire: Single Twin

Wire thread/cut type: Manual Auto

What is the axis layout of the machine? (Please provide a diagram of the machine with clear labeling of each axis and its limits... If necessary take a picture and provide markup as needed)

Router Post Specific

Note: If you do not know the answers to certain questions, contact your machine tool dealer.

Machine Make/Model: _____

Machine Control Make/Model (i.e. Xilog Plus): _____

Age of Machine: _____

Is an experienced programmer for this machine available for questions? Yes No

Are programming manuals available for this machine/control? Yes No

Are copies of proven programs available for features required? Yes No

Machine type: Horizontal Vertical Number of axis: 2 3 4 5

4th axis (rotary head) information: Full Rotary Indexer None Axis of rotation (if applicable): X Y Z

5 Axis machines: Complete 5 Axis Specific Page

Tables: Single Dual Multiple Fixed saw head: Yes No

Main Heads: Single Dual Multiple If multiple, number of heads: ____ Spacing: Fixed Adjustable

"Piggy back" heads: Yes No If yes, number of "piggy back" heads: ____

Vertical drill banks: Yes No If yes, number of spindles: ____

Horizontal drill blocks: Yes No If yes, number of spindles: ____

Horizontal routing blocks: Yes No If yes, number of spindles: ____

Aggregate Tooling: Yes No If Yes, Which Types? (Check all that apply)

Fixed right angle (No Tilt): 1 Way 1 Way - adjustable angle

2 Way 4 Way Saw head

Programmable C-axis: Fixed right angle Adjustable tilt

Saw head (no tilt) Saw head (adjustable tilt)

What is the axis layout of the machine? (Please provide a diagram of the machine with clear labeling of each axis and its limits... If necessary take a picture and provide markup as needed)

Please provide head layout information (dual or multi-head) and drill bank/block layout(s) (if applicable)...

5 Axis Machine Specific

Note: If you do not know the answers to certain questions, contact your machine tool dealer.

Machine Type:

Table/Table - Both rotary axis are located on the machine base and the spindle remains constant.

Head/Table - One axis tilts the spindle while the other rotary axis is located on the machine base.

Head/Head - Both rotary axis are located in the machine head and tilt the spindle.

Rotary Type:

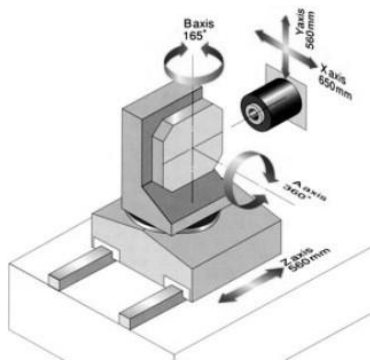
Standard: Rotary axis are perpendicular

Nutator: Rotary axis are **not** perpendicular

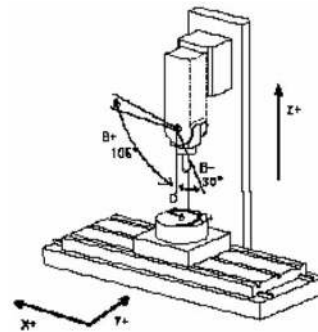
What is the axis layout of the machine?

Please provide a diagram of the machine with clear labeling of each axis and its limits Diagram must include signed axis movement (i.e. X+, Y+, Z+, A+, B+)

Examples...



(Diagram is nice but is missing signed movement direction...)



(Sketch provides good information but is difficult to read)

Axis information:

Primary Axis:

Axis of Rotation	0 Deg. Position (axis)				Rotation Limits
<input type="checkbox"/> X	<input type="checkbox"/> Z+	<input type="checkbox"/> Z-	<input type="checkbox"/> Y+	<input type="checkbox"/> Y-	_____
<input type="checkbox"/> Y	<input type="checkbox"/> Z+	<input type="checkbox"/> Z-	<input type="checkbox"/> X+	<input type="checkbox"/> X-	_____
<input type="checkbox"/> Z	<input type="checkbox"/> X+	<input type="checkbox"/> X-	<input type="checkbox"/> Y+	<input type="checkbox"/> Y-	_____

Rotation Direction (when viewed down axis of rotation plus to minus)

CW CCW
 Label (i.e. A, B or C): _

Secondary Axis:

Axis of Rotation	0 Deg. Position (axis)				Rotation Limits
<input type="checkbox"/> X	<input type="checkbox"/> Z+	<input type="checkbox"/> Z-	<input type="checkbox"/> Y+	<input type="checkbox"/> Y-	_____
<input type="checkbox"/> Y	<input type="checkbox"/> Z+	<input type="checkbox"/> Z-	<input type="checkbox"/> X+	<input type="checkbox"/> X-	_____
<input type="checkbox"/> Z	<input type="checkbox"/> X+	<input type="checkbox"/> X-	<input type="checkbox"/> Y+	<input type="checkbox"/> Y-	_____

Rotation Direction (when viewed down axis of rotation plus to minus)

CW CCW
 Label (i.e. A, B or C): _

Additional Notes

Please include any additional notes you feel we may need to process your request here: