

HURCO®

Fusion Post Processor Information

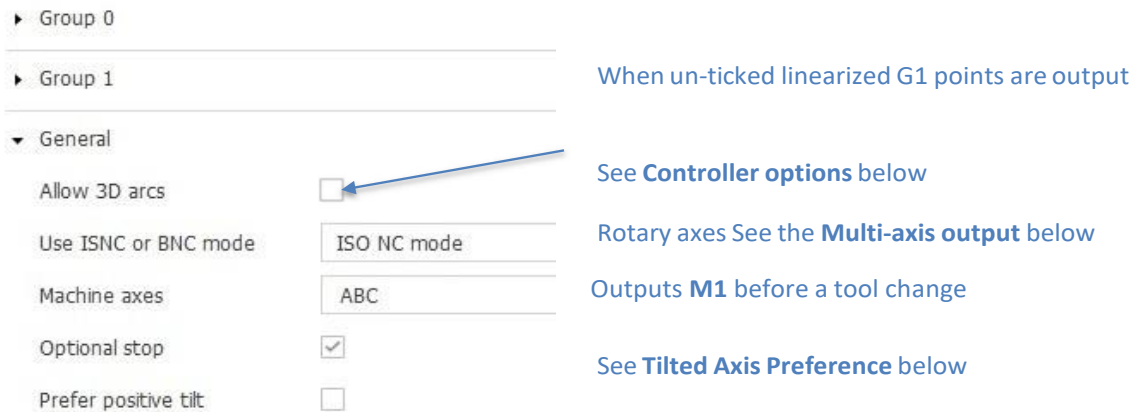
Hurco post processors information for Fusion 360

There are currently 2 Hurco Milling post processors available in the Fusion 360 post library.

1. Generic post **Hurco.cps** which supports both ISNC (ISO NC mode) and BNC (Basic NC mode).
2. Generic post **Hurco3d.cps** for older 3-axis HURCO machines with optional 4th axis.

When an **NC Program** is created in Fusion 360 there are **Post properties** that can be set to influence the output of the NC code

Post properties



Controller options

ISNC or BNC is a specific property for **Hurco** NC programming dialects (refer to WinMax Mill NC Programming manual for more details).

Multi-axis output

The **Machine axes** option is used to select which rotary axis are on the machine (typically AC, BC or AB configuration and the post will then output the appropriate clamping codes).

Rotary Axis	ON	OFF
A axis	M32	M33
B axis	M34	M35
C axis	M12	M13

Tilted Axis Preference

M200 is used to select the Tilt Axis Preference direction for simultaneous 5-axis contouring in an NC program. A positive Tilt Axis Preference will keep the B axis between 0 to +90 degrees using P1

A negative Tilt Axis Preference will keep the B axis between -90 to 0 degrees using P2

The generic post is set to output in **Vector mode** which is independent from the rotary axis configuration of the machine.



NC code extract for continuous 5 axis Vector output shown below

```
N16 M128  
N17 G0 G8.2 X1.873 Y-31.4 Z15. I0.05062 J0.094729 K0.994215  
  
N18 G43.4  
N19 M200 P2  
N20 G1 X1.873 Y-31.4 Z15. I0.05062 J0.094729 K0.994215 F5000.  
N21 X1.873 Y-31.4 Z-17.642 I0.05062 J0.094729 K0.994215
```

Reach to us via [HSM Post Processor Forum - Autodesk Community](#) if you have any issues.