Post Processor Training Guide
For use with Fusion CAM, Inventor CAM, HSMWorks
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1 Introduction to Post Processors

1.1 Scope
This manual is intended for those who wish to make their own edits to existing post processors. The scope of the manual covers everything you will need to get started; an introduction to the recommended editor (Autodesk Fusion 360 Post Processor Editor), a JavaScript overview (the language of Autodesk post processors), in-depth coverage of the callback functions (onOpen, onSection, onLinear, etc.), and a lot more information useful for working with the Autodesk post processor system.

It is expected that you have some programming experience and are knowledgeable in the requirements of the machine tool that you will be creating a post processor for.

1.2 What is a Post Processor?
A post processor, sometimes simply referred to as a "post", is the link between the CAM system and your CNC machine. A CAM system will typically output a neutral intermediate file that contains information about each toolpath operation like tool data, type of operation (drilling, milling, turning, etc.), and tool center line data. This intermediate file is fed into the post processor where it's translated into the language that a CNC machine understands. In most cases this language is a form of ISO/EIA standard G-code, even though some controls have their own proprietary language or use a more conversational language. All examples in this manual uses the ISO/EIA G-code format.

<table>
<thead>
<tr>
<th>CAM Intermediate Toolpath</th>
<th>Post Processor</th>
</tr>
</thead>
<tbody>
<tr>
<td>303: onRapid(3.6811023622047245, -1.395629530816007, 0.236204724409448)</td>
<td>function onRapid(x, y, z) { var x = x(Output format_x); var y = y(Output format_y); var z = z(Output format_z); writeBlock5(MotionModel format(0), x, y, z); feedOutput.reset(); }</td>
</tr>
<tr>
<td>304: onRapid(3.6811023622047245, -1.395629530816007, 0.236204724409448)</td>
<td></td>
</tr>
<tr>
<td>305: onMovement(MOVEMENT_Lead_In)</td>
<td></td>
</tr>
<tr>
<td>305: onLinear(3.6811023622047245, -1.395629530816007, 0, 0.236204724409448)</td>
<td></td>
</tr>
<tr>
<td>306: onMovement(FINISH_CUT)</td>
<td></td>
</tr>
<tr>
<td>306: onLinear(3.6811023622047245, -1.395629530816007, 0, 0.236204724409448)</td>
<td></td>
</tr>
<tr>
<td>G-code File</td>
<td></td>
</tr>
<tr>
<td>N35 G00 X3.6811 Y1.3956 Z0.2362047244</td>
<td></td>
</tr>
<tr>
<td>N35 G01 Z0 F39.37</td>
<td></td>
</tr>
<tr>
<td>N35 X-3.6811</td>
<td></td>
</tr>
</tbody>
</table>

If you would like a bit more information on the G-code format the CNC Handbook contains a lot of useful information including a further explanation of the G-code format in Chapter 5 CNC Programming Language.

Though most controls recognize the G-code format the machine configuration can be different and some codes could be supported on one machine and not another, or the codes could be interpreted differently, for example one machine may support circular interpolation while another requires linear moves to cut the circle, which is why you will probably need a separate post processor for each of your machine tools.
1.3 Finding a Post Processor

The first step in creating a post processor is to find an existing post that comes close to matching your requirements and start with that post processor as a seed. You will never create a post processor from scratch. You will find all the generic posts created by Autodesk on our online Post Library. From here you can search for the machine you are looking for by the machine type, the manufacturer of the machine or control, or by post processor name.

![Post Library for Autodesk Fusion 360](image)

Other places to check for a post processor include the HSM Post Processor Forum or HSM Post Processor Ideas.

It is possible that Autodesk has already created a post processor for your machine, but has not officially released it yet. These posts are considered to be in Beta mode and are awaiting testing from the community before placing into production. You can visit the HSM Post Processor Ideas site and search for your post here. This site contains post processor requests from users and links to the posts that are in Beta mode. You can search for your machine and/or controller to see if there is a post processor available.
Searching For a Post Processor on Ideas or the Forum

If your post processor is not found, then you should search the HSM Post Processor Forum using the same method you used on the HSM Post Processor Ideas site. The Post Processor Forum is used by the HSM community to ask questions and help each other out. It is possible that another user has created a post to run your machine.

**You should always take care when running output from a post processor for the first time on your machine, no matter where the post processor comes from.** Even though the post processor refers to your exact name, it may be setup for options that your machine does not have or the output may not be in the exact format that you are used to running on the machine.

**1.4 Downloading and Installing a Post Processor**

Once you find the post processor that closely matches your machine you will need to download it and install it in a common folder on your computer. If you are working on a network with others then this should be in a networked folder so everyone in your company has access to the same library of post processors.
When using Fusion 360 it is recommended that you enable cloud posts and place it in your Asset Library. This way post processors, tool libraries, and templates will be synched across devices and users at a company.
Once you have uploaded your post(s) to the Cloud Library you can access these from Fusion 360. You do this by pressing the Setup button in the Post Process dialog and selecting your post from the dropdown menu.
In all cases you will want to avoid placing posts in the production install folder as these can be overwritten when HSM is updated. Downloading your posts to a separate folder means that you can reduce your list of post processors that show up in the Post Process dialog to those that you use in your shop.

### 1.5 Creating/Modifying a Post Processor

Once you find a post processor that is close, but not exact to the requirements of your machine you will need to make modifications to it. The good news is, all of posts are open source and can be modified without limitation to create the post you need. You have a few options for making the modifications.

1. Make the modifications yourself using this manual as a guide and by asking for assistance from the HSM community on the [HSM Post Processor Forum](#).
2. Visit [HSM Post Processor Ideas](#) and create a request for a post processor for your machine. Other users can vote for your request for Autodesk to create and add your post to our library.
3. Contact one of our CAM partners who offer post customization services. These partners can be found on the HSM Post Processor Forum at the top of the page.

No matter which method you decide to use to create your post processor, you should have enough information available to define the requirements, which includes as much of the following as you can gather.

1. A post processor (.cps) that will be used as the seed post.
2. Sample NC code that has run on your machine.
3. The machine/control make and model.
4. The type of machine (mill, lathe, mill/turn, waterjet, etc.).
5. The machine configuration, including linear axes, rotary axes setup, etc.
6. A programming manual for your machine/control.
1.6 Testing your Post Processor – Benchmark Parts

When testing your post processor, you will need a part with cutting operations to post against. We have created standard benchmark parts for this specific purpose. These parts cover the most common scenarios you will come across when testing a post processor and are available for HSMWorks, Inventor CAM, and Fusion 360 CAM. They are available in both metric and inch format for all three CAM systems. There are five different benchmark parts.

- Milling
- Turning and Mill/Turn
- Stock Transfers
- Waterjet-Laser-Plasma
- Probing

You can visit the Autodesk Manufacturing Lounge for more information on the benchmark parts.

1.6.1 Locating the Benchmark Parts

The benchmark parts are available to all users of Autodesk CAM and can be accessed in the Samples folder for each product.

![Image of HSMWorks Sample Parts]

HSMWorks Sample Parts
C:\Program Files\HSMWorks\examples
Inventor CAM Sample Parts
C:\Users\Public\Public Documents\Autodesk\Inventor CAM\Examples

Fusion 360 CAM
Select the Data Panel and Double Click on CAM Samples

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1.6.2 Milling Benchmark Part

The milling benchmark parts include the following strategies.

- 2D
- Drilling
- Coolant codes
- Manual NC commands
- 3+2 5-axis
- 5-axis simultaneous
1.6.3 Mill/Turn Benchmark Part

The mill/turn benchmark parts contain the following strategies.

- Primary and Secondary spindle operations
- Turning
- Axial milling
- Radial milling
- 5-axis milling
### 1.6.4 Stock Transfer Benchmark Part

The stock transfer benchmark part contains the following strategies.

- Primary and Secondary spindle operations
- Simple part transfer
- Part transfer with cutoff

![Stock Transfer Benchmark Part](image)

The Waterjet-Laser-Plasma benchmark part contains the following strategies.

- Waterjet
- Laser
- Plasma
- Lead in/out
- Radius compensation
1.6.5 Probing Benchmark Part

The Probing benchmark part contains the following strategies.

- Various probing cycles
2 Autodesk Post Processor Editor

Since Fusion 360, Inventor CAM, and HSMWorks post processors are text-based JavaScript code, they can be edited with any text editor that you are familiar with. There are various editors in the marketplace that have been optimized for working with programming code such as JavaScript. We recommend Visual Studio Code with the Autodesk Fusion 360 Post Processor Utility extension. Using this editor provides the following benefits when working with Autodesk post processors.

- Color coding
- Automatic closing and matching of parenthesis and brackets
- Automatic indentation
- Intelligent code completion
- Automatic syntax checking
- Function List
- Run the post processor directly from editor
- Match the output NC file line to the post processor command that created it

2.1 Installing the Autodesk Post Processor Editor

Before you can use the VSC editor you will need to install it. The easiest way is to visit the Autodesk Fusion 360 Post Processor Utility page in the Visual Studio Marketplace, where you can download VSC and then the Autodesk Fusion 360 Post Processor Utility extension. Please note that the Visual Studio Code site changes quite frequently, so the directions/pictures in this section might not be exactly what you see on the screen, but the installation steps should still be similar.
This link will take you to the Visual Studio Code installation page. Select the correct version for your operating system.

Installing the Windows Version of Visual Studio Code

This will download an installation program that you can run to do the actual install. Left click on the installation program to execute it.

Click the Executable to Install VSC

Follow the instructions displayed on the screen to finish the installation. You should select the defaults for all questions, though you may want to make this the default code editor and add it to the Windows Explorer file context menu.
Selecting Installation Options

You can choose to startup the Visual Studio Code editor automatically after it is installed. Once the editor is opened you can install the Autodesk Fusion 360 Post Processor Utility by opening the Extensions view in the left pane and searching for Autodesk. Select the Autodesk Fusion 360 Post Processor Utility to install it.
Instaling the Autodesk Fusion 360 Post Processor Extension

After installing the Autodesk Fusion 360 Post Processor Utility extension you will want to exit the VSC editor and then restart it so that the extension is initialized. You are now ready to start editing Autodesk post processors.

2.2 Autodesk Post Processor Settings

After installing the Autodesk Post Processor editor you will want to setup the editor to match your preferences. Open the settings file by selecting File->Preferences->Settings. This section will describe some of the most popular settings, but feel free to explore other settings at your leisure to find any that you may want to change. The User Settings can also be displayed by using the Ctrl+Comma shortcut.

Displaying the Editor Settings

The settings will be displayed in a separate tab. You can now search for individual settings using the Search bar. To display the Autodesk Fusion 360 Post Processor Utility settings type in hsm in the search bar.
Modifying the Editor Settings

There is a description that explains the setting making it easy for you to make the changes.

The following table provides a list of some of the more common settings and their descriptions.

<table>
<thead>
<tr>
<th>Setting</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Editor &gt; Minimap</td>
<td>Controls if the minimap is shown. The minimap is a small representation of the entire file displayed on the right side of the window and allows you to easily scroll through the file.</td>
</tr>
<tr>
<td>Editor: Font Size</td>
<td>Size of the editor font.</td>
</tr>
<tr>
<td>Editor: Font Weight</td>
<td>Weight (thickness) of the editor font.</td>
</tr>
<tr>
<td>Editor: Detect Indentation</td>
<td>Automatically detects the editor.tabSize and editor.insertSpaces settings when opening a file.</td>
</tr>
<tr>
<td>Editor: Insert Spaces</td>
<td>When checked, spaces will be inserted into the file when the tab key is pressed.</td>
</tr>
<tr>
<td>Editor: Tab Size</td>
<td>Sets the number of spaces a tab is equal to. The standard setting for Autodesk post processors is 2.</td>
</tr>
<tr>
<td>Editor &gt; Parameter Hints</td>
<td>Enables a pop-up that shows parameter documentation and style information as you type.</td>
</tr>
<tr>
<td>Editor: Auto Closing Brackets</td>
<td>Controls if the editor should automatically close brackets after opening them.</td>
</tr>
<tr>
<td>Extensions: Auto Check Update or Auto Updates</td>
<td>Automatically (check for) update extensions.</td>
</tr>
<tr>
<td>Files: Associations</td>
<td>Associates file types with a programming language. This must have &quot;*.cps&quot;: &quot;javascript&quot;</td>
</tr>
<tr>
<td>Setting</td>
<td>Description</td>
</tr>
<tr>
<td>---------------------------------------------</td>
<td>-----------------------------------------------------------------------------</td>
</tr>
<tr>
<td>Workbench: Color Theme</td>
<td>Defines the color theme for the editor. This setting can be changed using the File-&gt;Preferences-&gt;Color theme menu.</td>
</tr>
<tr>
<td>HSMPost Utility: Auto Update Function List</td>
<td>Updates the function list automatically, without the need for refreshing.</td>
</tr>
<tr>
<td>HSMPost Utility: Sort Function List Alphabetically</td>
<td>When checked the function list will be sorted. Unchecked will display the function names in the order that they are defined.</td>
</tr>
<tr>
<td>HSMPost Utility: Color Output</td>
<td>When checked, rapid, feedrate, and circular blocks will be displayed in color.</td>
</tr>
<tr>
<td>HSMPost Utility: Rapid Color</td>
<td>Color for rapid move blocks.</td>
</tr>
<tr>
<td>HSMPost Utility: Linear Color</td>
<td>Color for feedrate move blocks.</td>
</tr>
<tr>
<td>HSMPost Utility: Circular Color</td>
<td>Color for circular move blocks.</td>
</tr>
<tr>
<td>HSMPost Utility: Enable Auto Line Selection</td>
<td>Enables the automatic selection of the line in the post processor that generated the selected line in the output NC file.</td>
</tr>
<tr>
<td>HSMPost Utility: Output Units</td>
<td>Sets the desired output units when post processing</td>
</tr>
<tr>
<td>HSMPost Utility: Shorten Output Code</td>
<td>Limits the number of blocks output when posting, making it easier to navigate.</td>
</tr>
<tr>
<td>HSMPost Utility: Post On CNCSelection</td>
<td>When checked, post processing will occur as soon as a CNC file is selected.</td>
</tr>
<tr>
<td>HSMPost Utility: Post On Save</td>
<td>Automatically run the post processor when it is saved, only if the NC output file window is open.</td>
</tr>
</tbody>
</table>

**Commonly Changed User Settings**

### 2.3 Left Side Flyout

On the left side of the editor window is a tab that will open different flyout dialogs. The features contained in the flyout dialogs are quite beneficial while editing a post processor and are explained in this section. The *Source Control* flyout is not used when editing post processors and will not be discussed.
2.3.1 Explorer Flyout

The Explorer flyout contains expandable lists that are used to display the open editors, folders, variables, functions, and CNC selector. The arrow ► at the left of each entry is used to expand or collapse the list.

<table>
<thead>
<tr>
<th>List</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>OPEN EDITORS</td>
<td>Lists the files that are open in this instance of the VSC editor. Any files that have been changed, but not been saved will be marked with a bullet (*). The number of changed files that have not been saved is displayed in the Explorer icon.</td>
</tr>
<tr>
<td>NO FOLDERS OPEN</td>
<td>You can open a folder for quick access to all of the post processors in the folder. Expanding the folders will display the Open Folder button that can be used to open a folder. Clicking on a file in the open folder will automatically open it in the editor. Take note that if a folder is opened, then all opened files in the editor will first be closed and you will be prompted to save any that have been changed.</td>
</tr>
<tr>
<td>OUTLINE</td>
<td>Lists the functions defined in the post processor and the variables defined in each function. Expanding the function by pressing the arrow ► to the left of the function name will display the variables defined in the function. You can select any of the variables to go to the line where it is defined.</td>
</tr>
<tr>
<td>List</td>
<td>Description</td>
</tr>
<tr>
<td>-------------------</td>
<td>---------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>CNC SELECTOR</td>
<td>Contains the Autodesk intermediate files (*.cnc) that are available to the post processor from the VSC editor. This list is further explained in the Running/Debugging the Post section of this chapter.</td>
</tr>
<tr>
<td>FUNCTION LIST</td>
<td>Expanding the function list will display the functions defined in the active post processor. The functions will either be listed in alphabetical order or by the order they appear in the post processor depending on the HSMPost Utility: Sort Function List Alphabetically setting. You can select on a function in this list and the cursor will be placed at the beginning of this function in the editor window and while traversing through the post processor the function that the cursor is in will be marked with an arrow ►, making it easy for you to determine what function the active line is in.</td>
</tr>
<tr>
<td>POST PROPERTIES</td>
<td>Contains the Property Table for the post processor, similar to the Property Table displayed when running the post from CAM. This list is further explained in the Running/Debugging the Post section of this chapter.</td>
</tr>
<tr>
<td>VARIABLE LIST</td>
<td>Lists the variable types supported by the post processor, such as Array, Format, Vector, etc. It does not contain a list of variables defined in the post processor. Expanding the variable type by pressing the arrow ► to the left of it will display the functions associated with the variable type.</td>
</tr>
</tbody>
</table>

Explore Flyout Selections
2.3.2 Search Flyout

You can search for a text string in the current file or in all of the opened files. To search for the text string in the current file you should use the Find popup window accessed by pressing the \textit{Ctrl+F} keys.

As you type in a text string the editor will automatically display and highlight the next occurrence of the text in the file. The number of occurrences of the text string in the file will be displayed to the right of the text field. You can use the \textit{Enter} key to search for the next occurrence of the string or press the arrow keys to search forwards $\rightarrow$ and backwards $\leftarrow$ through the file. If you use the \textit{Enter} key, then the keyboard focus must be in the \textit{Find} field.

Using the Find Popup to Search for Text Strings
The *Search* flyout searches for a file in the opened files and in the files located in an open folder (refer to the *Explorer* flyout to see how to open a folder). The *Search* dialog will be displayed when you press the *Search* button.

**Search Flyout – Search for a Text String in Multiple Files**

Entering a text string to search for and then pressing the *Enter* key will display the files that contain the text string and the number of instances of the text string in each file. You can expand the file in the list by pressing the arrow key ► and each instance of the text string found in the selected file will be displayed. Clicking on one of the instances causes the editor to go to that line in the file and automatically open the file if it is not already opened. If you don't make any changes to the file and then select the text string in another file, then the first file will be closed before opening the next file. An unchanged file opened from the *Search* flyout will have its name italicized in the editor window.

**Searching for a Text String in the Opened Files**

There are options that are available when searching for text strings. These options are controlled using the icons in the *Search* dialog and *Find* popup.

<table>
<thead>
<tr>
<th>Icon</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td><img src="image" alt="Aa" /></td>
<td>When enabled, the case of the search string must be the same as the matching text string in the file.</td>
</tr>
<tr>
<td><img src="image" alt="Aa1" /></td>
<td>When enabled, the entire word of the matching text string in the file must be the same as search string. When disabled, it will search for the occurrence of the search string within words.</td>
</tr>
<tr>
<td><img src="image" alt=" " /></td>
<td>When enabled, the ‘*’ character can be used as a single character wildcard and the ‘*’ character can be used as a multi-character wildcard in the search string.</td>
</tr>
<tr>
<td>Icon</td>
<td>Description</td>
</tr>
<tr>
<td>------</td>
<td>-------------</td>
</tr>
<tr>
<td>➡️</td>
<td>Search forward in the file. In the Find popup only.</td>
</tr>
<tr>
<td>⬅️</td>
<td>Search backward in the file. In the Find popup only.</td>
</tr>
<tr>
<td>📝</td>
<td>Searches for the text string only in the selected text in the file. In the Find popup window only.</td>
</tr>
<tr>
<td>✗</td>
<td>Closes the Find popup window.</td>
</tr>
<tr>
<td>🔍</td>
<td>Refresh the results window. In the Search flyout only.</td>
</tr>
<tr>
<td>📷</td>
<td>Collapse all expanded files in the results window. In the Search flyout only.</td>
</tr>
<tr>
<td>⚤</td>
<td>Displays fields that allow you to include or exclude certain files from searches. In the Search flyout only.</td>
</tr>
<tr>
<td>📝✍️</td>
<td>Displays the Replace field, allowing you to replace the Search text with the Replace field text.</td>
</tr>
<tr>
<td>📝🔄</td>
<td>Replaces the current (highlighted) occurrence of the Search text with the Replace field text. Hitting the Enter key while in the Replace field performs the same replacement. In the Find popup window only.</td>
</tr>
<tr>
<td>📝🔄🔄</td>
<td>Replaces all occurrences of the Search text with the Replace field text. When initiated from the Search flyout, all occurrences of the text in all files listed in the Results window will be replaced.</td>
</tr>
</tbody>
</table>

### Search and Replace Options

**2.3.3 Bookmarks Flyout**

Okay, so the Bookmarks flyout is actually a Breakpoints flyout, but since JavaScript does not have an interactive debugger we are going to use it for adding bookmarks to the opened files. Placing the cursor to the left of the line number where you want to set a bookmark will display a red circle and then clicking at this position will add the bookmark.

To see the active bookmarks you can open the Bookmarks flyout and expand the BreakPoints window. You can then go directly to a line that is bookmarked by selecting that line in the Bookmarks flyout. Bookmarks set in all opened files will be displayed in the flyout and the file that the bookmark is set in will automatically be made the active window when the bookmark is selected.
2.3.4 Extensions Flyout

Visual Studio Code is an open source editor and there are many extensions that have been added to it by the community. For example, the Autodesk Fusion 360 Post Processor Utility is an extension to this editor. By opening the Extensions flyout you can see what extensions you have installed and what extensions have updates waiting for them.

If there is an *Update to x.x.x* button displayed with the extension you can press this button to install the latest version of the associated extension.

You can search the Visual Studio Marketplace for extensions that are beneficial for your editing style by typing in a name in the *Search Extensions in Marketplace* field. For example, if you want a more dedicated way to set bookmarks you can type in *bookmark* in this field and all extensions dealing with adding bookmarks will be displayed. You can press the green *Install* button to install the extension.

You can also search for extensions online at the [Visual Studio Marketplace](https://marketplace.visualstudio.com).

---

*Autodesk Post Processor Editor* 2-24

CAM Post Processor Guide 6/8/21
2.4 Autodesk Post Processor Editor Features

The Autodesk Post Processor editor has features to enhance the ease of editing of post processor JavaScript files. One example is the color coding of the text, variables are in one color, functions in another, JavaScript reserved words in yet another, and so on. The colors of each entity is based on the Workbench Color Theme setting.

This section will go over some of the more commonly used features. You are sure to discover other features as you use the editor.

2.4.1 Auto Completion

As you type the name of a variable or function you will notice a popup window that will show you previously used names that match the text as it is typed in. Selecting one of the suggestions by using the arrow keys to highlight the name and then the tab key to select it will insert that name into the spot where you are typing.

If the Editor: Parameter Hints setting is set to true, then when you type in the name of a function, including the opening parenthesis, you will be supplied the names of the function's arguments for reference.

2.4.2 Syntax Checking

If you have a syntax error while editing a file, the editor is smart enough to flag the error by incrementing the error count at the bottom left of the window footer and marking the problem in the file with a red squiggly line. You can open the Problems window by selecting the X in the window footer to see all lines that have a syntax error. Clicking on the line displaying the error will then take you directly to that line, so that you can resolve the error.

You can close the window by pressing on the X in the window footer or the X at the top right of the Problems window.
2.4.3 Hiding Sections of Code

You can hide code that is enclosed in braces {} by positioning the cursor to the right of the line number on the line with the opening brace and then pressing the [-] icon. The code can be expanded again by pressing the [+] icon. Note that the icons will not be displayed unless the cursor is placed in the area between the line number and the editing window.

2.4.4 Matching Brackets

If you place the edit cursor at a parenthesis (()), bracket ([]), or brace ({}) the editor will highlight the selected enclosure as well as the opening/closing matching enclosure character. If there are multiple enclosure characters right next to each other, then the enclosure following the edit cursor will be selected. If the enclosure character does not highlight, then this means that there is not a matching opening/closing enclosure.
2.4.5 Go to Line Number
You can go to a specific line number in the file by pressing the Ctrl+G keys and then typing in the line number.

2.4.6 Opening a File in a Separate Window
You can open a file in the current window by selecting the File->Open File... menu from the task bar or by pressing the Ctrl+O keys. You can open the active file in a separate VSC window by pressing the Ctrl+K keys and then pressing the O key. The file will be opened in the a new window and remain open in the active window. You can also open a new VSC window by selecting the File->New Window menu or by pressing the Ctrl+Shift+N keys.

2.4.7 Shortcut Keys
You can display the assigned Shortcut Keys by pressing the F1 key and then typing in key to display all commands referencing the key string. Select the Preferences: Open Keyboard Shortcuts menu. You can also press the Ctrl+K Ctrl+S keys in sequence to display the Shortcut Keys window.
Modifications and/or additions to the Shortcut Key assignments can be made by selecting the `keybindings.json` link at the top of the page. This will open a split window display that displays the default Shortcut Keys in the left window and the user defined Shortcut Keys in the right window. Use the same procedure as modifying a setting to modify a Shortcut Key, by copying the binding definition from the left window into the right window and making the desired changes. Be sure to save the `keybindings.json` file after making your changes.

The format of the keystrokes that represent a single Shortcut is defined in the following table.

<table>
<thead>
<tr>
<th>Shortcut</th>
<th>Sample</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>key</td>
<td>F1</td>
<td>Press the single key.</td>
</tr>
<tr>
<td>key+key</td>
<td>Ctrl+Shift+Enter</td>
<td><em>key</em> is the name of the key to press. The + character means that the keys must be pressed at the same time. The + key is not pressed.</td>
</tr>
<tr>
<td>key key</td>
<td>Ctrl+K Ctrl+S</td>
<td>The keys should be pressed in sequence, one after the other. Each key can be a combination of multiple keys that are pressed at the same time as explained above. Unless <em>Shift</em> is part of the key sequence, then lower case letters are being specified.</td>
</tr>
</tbody>
</table>
2.4.8 Running Commands

The commands accessible by shortcut keys or the menus can be found and run from the command popup dialog and are accessed in the editor by pressing the F1 key. Once the command popup is displayed you can search for commands by typing in text in the search line. The commands that match the search will be displayed along with the Shortcut Keys that are assigned to the commands. Select on the command to run it.

![Running a Command]

2.5 Running/Debugging the Post

The *Autodesk Fusion 360 Post Processor Utility* extension allows you to run the post processor that you are editing directly from the editor and to debug the post by matching the output lines in the NC file with the code line that generated the output. You can run the post against the provided intermediate files generated from the Benchmark Parts or you can create your own intermediate file to run the post against.

2.5.1 Autodesk Post Processor Commands

There are built-in commands that pertain to running the post processor. These commands are accessed by pressing the F1 key and typing HSM in the search field.

![Displaying the Autodesk Post Processor Commands]

The following table describes the available commands.
<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Post Utility</td>
<td>Displays a menu where you can post process the selected intermediate (CNC) file against the open post processor, select a new CNC file, or display the Autodesk Post Help window. You can also use the shortcut Ctrl+Alt+G to run the post processor.</td>
</tr>
<tr>
<td>Change post executable</td>
<td>Sets the location of the post processor engine executable.</td>
</tr>
<tr>
<td>Show debugged code</td>
<td>Displays the entry functions that are called and the line numbers that generated the block in the output NC file. This is the same output that is displayed when you call the setWriteStack(true) and setWriteInvocations(true) functions.</td>
</tr>
<tr>
<td>Delete CNC file</td>
<td>This command cannot be run from the Commands menu. Right clicking on a CNC file in the CNC Selection list and selecting Delete CNC File will delete the file and remove it from the list.</td>
</tr>
<tr>
<td>Disable auto line selection</td>
<td>Disables the feature of automatically displaying the line in the post processor that generated the selected line in the NC output file.</td>
</tr>
<tr>
<td>Download CNC exporting post processor</td>
<td>Downloads the Exporting Post Processor used for generating your own CNC files for testing.</td>
</tr>
<tr>
<td>Post help</td>
<td>Displays the online Autodesk CAM Post Processor Documentation web page.</td>
</tr>
</tbody>
</table>

### 2.5.2 The Post Processor Properties

You can display the properties associated with the open post processor by opening the Explorer flyout and expanding the Post Properties list. Clicking on a property will prompt you to change the property. The 🔄 symbol will be displayed next to the property if it has been changed from the default value.

If you add a new property to the post or for some reason the properties don’t display, you can press the yellow refresh symbol in the Post Properties header to refresh the displayed properties.
2.5.3 Running the Post Processor

To run the post processor that is open in the editor you can use the Ctrl+Alt+G shortcut or run the Post Utility from the Command window as described in the previous section. First you will need to select the intermediate CNC file to run the post against. You select the CNC file by opening the Explorer flyout and expanding the CNC Selector list until you find the desired CNC file.

You can also select the CNC file from the Post Utility menu.

Select the required command

Change CNC file
Post process
Help

Select the CNC File or Post Processor Using the Post Utility Command
If running a post processor for the first time in the editor it is possible that the location of the post engine executable (post.exe) is not known. In this case you will see the following message displayed.

![Message](image)

You can press the *Browse*... button to search for *post.exe*. The executable will be in one of the following locations depending on the version of HSM being run.

<table>
<thead>
<tr>
<th>HSM Version</th>
<th>Post Executable Location</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fusion</td>
<td>C:\User\username\AppData\Local\Autodesk\webdeploy\production(id)\Applications\CAM360 \username is your user name that you logged in as. (id) is a unique and long name that changes depending on the version of Fusion that you have installed. You will usually select the folder with the latest date.</td>
</tr>
<tr>
<td>Inventor</td>
<td>C:\Program Files\Autodesk\Inventor CAM yyyy yyyy is the version number (year) of Inventor.</td>
</tr>
<tr>
<td>HSMWorks</td>
<td>C:\Program Files\HSMWorks</td>
</tr>
</tbody>
</table>

Post Executable Locations

Once you have posted against the CNC file, the output NC file or Log file will be displayed in the right panel of the split screen. When the *HSMPostUtility: Enable Auto Line Selection* setting is true, then clicking twice on a line in the output NC file will highlight the line in the post processor that generated the output. The second click must be on a different character on the same output line to highlight the line. Then, by clicking on a different character in the same line you will be walked through the stack of functions that were called in the generation of the output.
2.5.4 Creating Your Own CNC Intermediate Files

The Autodesk Post Processor extension comes with built-in CNC intermediate files that are generated using the HSM Benchmark Parts. These can be used for testing most aspects of the post processor, but there are times when you will need to test specific scenarios. For these cases you can create your own CNC file to use as input.

First you will need to download the export cnc file to vs code.cps post processor. You can do this by running the Download CNC exporting post processor command.

![Download the CNC Exporting Post Processor]

A file browser will come up that allows you to select the folder where you want to download the post. Follow the directions in the Downloading and Installing a Post Processor section for installing a post processor on your system.

Once the post processor is installed you will want to post process the operations you want to use for testing. The CNC exporting post processor is run just like any other Autodesk post processor, except it will not generate NC code, but will rather create a copy of the CNC file from the Autodesk CAM system in the Custom location of the CNC Selector folder. Most posts use a number for the output file name, it is recommended that you give the CNC file a unique name that describes the operations that were used to generate it.

![Create a Custom CNC Intermediate File]

Once you click the yellow refresh button you should see the CNC file in the Custom branch of the CNC Selector list and can use it when post processing from the VSC editor. If you decide that you no longer
need a custom CNC intermediate file you can delete it by right clicking on the CNC file and select *Delete CNC File*.

### 3 JavaScript Overview

#### 3.1 Overview

Autodesk post processors are written using the JavaScript language. It resembles the C, C++, and Java programming languages, is interpreted rather than being a compiled language, and is object-orientated. JavaScript as it is used for developing post processors is fairly simple to learn and understand, but still retains its complex nature for more advanced programmers.

This chapter covers the basics of the JavaScript language and conventions used by Autodesk post processors. There are many web sites that document the JavaScript language. The ELOQUENT JAVASCRIPT site has a nicely laid out format. If you prefer a hard copy JavaScript guide, then the *JavaScript the Definitive Guide*, Author: David Flanagan, Publisher: O’Reilly is recommended. Whichever manual you use, you will want to focus on the core syntax of JavaScript and ignore the browser and client-side aspects of the language.

The Autodesk post processor documentation is provided as the *post.chm* file with HSMWorks and Inventor CAM or you can visit the Autodesk CAM Post Processor Documentation web site. You will find that the *post.chm* version of the documentation is easier to view, since it has a working Index.

#### 3.2 JavaScript Syntax

JavaScript is a case sensitive language, meaning that all functions, variables, and any other identifiers must always be typed exactly the same with regards to lower and uppercase letters.

```javascript
currentCoolant = 7;
currentCoolant = 8;
currentcoolant = 9;
```

**Case Sensitive Definition of 3 Different Variables**
JavaScript ignores spaces and new lines between variables, operators, names, and delimiting characters. Variable and function names cannot have spaces in them, as this would create separate entities. Commands can be continued onto multiple lines and are terminated with a semicolon (;) to mark the end of the logical command. If you are defining a string literal within quotes, then the literal should be defined on a single line and not on multiple lines. If a text string is too long for a single line, then it should be concatenated using an operation.

```javascript
message = "The 3 inch bore needs to be probed prior to starting " + 
"the next operation."
```

### Breaking Up a Text String onto Multiple Lines

There are two methods of defining comments in JavaScript. You can either enclose comments between the /* and */ characters, which will treat all text between these delimiters as a comment, or place the // characters prior to the comment text.

The /* comment */ format is typically used as the descriptive header of a function or to block out multiple lines of code. Any characters on the line that follow the // characters are treated as a comment, so you can have a single comment line or add a comment to the end of a JavaScript statement.

```javascript
/**
 * Output a comment.
 */
function writeComment(text) {
  writeln(formatComment(text)); // write out comment line
}
```

### Comment Lines

Using indentation for function contents, if blocks, loops and continuation lines is recommended as this makes it easier to visualize the code. Tab characters, though supported by JavaScript, are discouraged from being used. It is preferred to use virtual tab stops of two spaces for indenting code in post processor code. Most editors, including the Autodesk Post Processor Editor can be setup to automatically convert tab characters to spaces that will align each indent at two spaces. Please refer to the Post Processor Editor chapter for an explanation on how to setup the Autodesk recommended editor.

```javascript
function test (input) {
```
// indent 2 spaces inside of function
if (input == 1) {
    writeBlock( // indent 2 more spaces in if block or loop
        gAbsIncModal.format(90), // indent 2 more spaces for continuation lines
        gMotionModal.format(0)
    );
}

Indent Code 2 Spaces Inside Function, If Block, Loop, and Continuation Line

3.3 Variables

Variables are simply names associated with a value. The value can be a number, string, boolean, array, or object. Variables in JavaScript are untyped, meaning that they are defined by the value that they have assigned to them and the value type can change throughout the program. For example, you can assign a number to a variable and later in the program you can assign the same variable a string value. The `var` keyword is used to define a variable.

If a variable is not assigned a value, then it will be assigned the special value of `undefined`.

```
var a;  // define variable 'a', it will have the value of undefined
var b = 1; // assign a value of 1 to the variable 'b'
var c = "text"; // assign a text string to the variable 'c'
c = 2.5; // 'c' now contains a number instead of string
```

Variable Definitions

While you can include multiple variable declarations on the same `var` line, this is against the standard used for post processors and is not recommended. You can also implicitly create a variable simply by assigning a value to the variable name without using the `var` keyword, but is also not recommended. When declaring a new variable, be sure to not use the same name as a JavaScript or Post Kernel keyword, for example do not name it `var`, `for`, `cycle`, `currentSection`, etc. Refer to the appropriate documentation for a list of keywords/variables allocated in JavaScript or the Post Kernel.

JavaScript supports both global variables and local variables. A global variable is defined outside the scope of a function, for example at the top of the file prior to defining any functions. Global variables are accessible to all functions within the program and will have the same value from function to function. Local variables are only accessible from within the function that they are defined. You can use the same name for local variables in multiple functions and they will each have their own unique value in the separate functions. Unlike the C and C++ languages, local variables defined within an if block or loop are accessible to the entire function and are not local to the block that they are defined in.

3.3.1 Numbers

Besides containing a standard numeric value, a variable assigned to a number creates a `Number` object. For this discussion, we will consider an object a variable with associated functions. These functions are specific to numbers and are listed in the following table.
### Number Object Functions

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>toExponential(digits)</td>
<td>Format a number using exponential notation</td>
<td>String representation of number</td>
</tr>
<tr>
<td>toFixed(digits)</td>
<td>Format a number with a fixed number of digits</td>
<td>String representation of number</td>
</tr>
<tr>
<td>toLocaleString()</td>
<td>Format a number according to locale conventions</td>
<td>String representation of number</td>
</tr>
<tr>
<td>toPrecision(digits)</td>
<td>Format a number using either a fixed number of digits or using exponential notation depending on value of number</td>
<td>String representation of number</td>
</tr>
<tr>
<td>toString()</td>
<td>Format a number</td>
<td>String representation of number</td>
</tr>
</tbody>
</table>

### Sample Number Output

```javascript
var a = 12.12345;
b = a.toExponential(2);  // b = "1.21e+1"
b = a.toFixed(3);         // b = "12.123"
b = a.toString();         // b = "12.12345"
```

The JavaScript built-in Math object contains functions and constants that apply to numbers. The following table lists the Math functions and constants that are most likely to be used in a post processor. All Math functions return a value.

<table>
<thead>
<tr>
<th>Function</th>
<th>Return value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Math.abs(x)</td>
<td>Absolute value of x</td>
</tr>
<tr>
<td>Math.acos(x)</td>
<td>Arc cosine of x in radians</td>
</tr>
<tr>
<td>Math.asin(x)</td>
<td>Arc sine of x in radians</td>
</tr>
<tr>
<td>Math.atan(x)</td>
<td>Arc tangent of x in radians</td>
</tr>
<tr>
<td>Math.atan2(y, x)</td>
<td>Counterclockwise angle between the positive X-axis and the point x,y in radians</td>
</tr>
<tr>
<td>Math.ceil(x)</td>
<td>Rounds up x to the next integer</td>
</tr>
<tr>
<td>Math.cos(x)</td>
<td>Cosine of x</td>
</tr>
<tr>
<td>Math.floor(x)</td>
<td>Rounds down x to the next integer</td>
</tr>
<tr>
<td>Math.max(args)</td>
<td>The maximum value of the input arguments</td>
</tr>
<tr>
<td>Math.min(args)</td>
<td>The minimum value of the input arguments</td>
</tr>
<tr>
<td>Math.PI</td>
<td>The value of PI, approximately 3.14159</td>
</tr>
<tr>
<td>Math.pow(x, y)</td>
<td>x raised to the power of y</td>
</tr>
<tr>
<td>Math.round(x)</td>
<td>Rounds x to the nearest integer</td>
</tr>
<tr>
<td>Math.sin(x)</td>
<td>Sine of x</td>
</tr>
<tr>
<td>Math.sqrt(x)</td>
<td>Square root of x</td>
</tr>
<tr>
<td>Math.tan(x)</td>
<td>Tangent of x</td>
</tr>
<tr>
<td>Math.NaN</td>
<td>The value corresponding to the not-a-number property</td>
</tr>
</tbody>
</table>

### Math Object

```javascript
a = Math.sqrt(4); // a = 2
a = Math.round(4.59); // a = 5
```
### Sample Math Object Output

The Math trigonometric functions all work in radians. As a matter of fact, most functions that pass angles in the post processor work in radians. There are kernel supplied functions that are available for converting between radians and degrees. $toDeg(x)$ returns the degree equivalent of the radian value $x$ and conversely the $toRad(x)$ function returns the radian equivalent of the degree value $x$.

#### 3.3.2 Strings

Variables assigned a text string will create a `String` object, which contain a full complement of functions that can be used to manipulate the string. These functions are specific to strings and are listed in the following table. The table details the basic usage of these functions as you would use them in a post processor. Some of the functions accept a `RegExp` object which is not covered in this manual, please refer to dedicated JavaScript manual for a description of this object.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>charAt(n)</td>
<td>Returns a single character at position n</td>
<td>The $n$th character</td>
</tr>
<tr>
<td>indexOf(substring, start)</td>
<td>Finds the <code>substring</code> within the string. $start$ is optional and specifies the starting location within the string to start the search at.</td>
<td>The location of the first occurrence of <code>substring</code> within the string.</td>
</tr>
<tr>
<td>lastIndexOf(substring, start)</td>
<td>Finds the last occurrence of <code>substring</code> within the string. $start$ is optional and specifies the starting location within the string to start the search at.</td>
<td>The location of the last occurrence of <code>substring</code> within the string.</td>
</tr>
<tr>
<td>length</td>
<td>Returns the length of the string. $length$ is not a function, but rather a property of a string and does not use () in its syntax.</td>
<td>The length of the string</td>
</tr>
<tr>
<td>localeCompare(target)</td>
<td>Compares the string with <code>target</code> string.</td>
<td>A negative number if <code>string</code> is less than <code>target</code>, 0 if the strings are identical, and a positive number if <code>string</code> is greater than <code>target</code></td>
</tr>
<tr>
<td>replace(pattern, replacement)</td>
<td>Replaces the <code>pattern</code> text within the string with the <code>replacement</code> text.</td>
<td>The updated string.</td>
</tr>
<tr>
<td>slice(start, end)</td>
<td>Creates a substring from the string consisting of the <code>start</code> character up to, but not including the <code>end</code> character of the string.</td>
<td>A substring containing the text from <code>string</code> starting at <code>start</code> and ending at <code>end</code>. A negative value for <code>start</code> or <code>end</code> specifies a position from the end of the <code>string</code>; -1 is the last character, -2 is the second to last character, etc.</td>
</tr>
<tr>
<td>split(delimiter, limit)</td>
<td>Splits a string at each occurrence of the <code>delimiter</code> string.</td>
<td>An array of strings created by splitting <code>string</code> into substrings at the delimiter. A maximum of <code>limit</code> substrings will be created.</td>
</tr>
<tr>
<td>toLocaleLowerCase()</td>
<td>Converts the string to all lowercase letters in a locale-specific method.</td>
<td>Lowercase string.</td>
</tr>
<tr>
<td>Function</td>
<td>Description</td>
<td>Returns</td>
</tr>
<tr>
<td>--------------------------</td>
<td>-----------------------------------------------------------------------------</td>
<td>---------------------</td>
</tr>
<tr>
<td>toLocaleUpperCase()</td>
<td>Converts the string to all uppercase letters in a locale-specific method.</td>
<td>Upper case string.</td>
</tr>
<tr>
<td>toLowerCase()</td>
<td>Converts the string to all lowercase letters.</td>
<td>Lower case string.</td>
</tr>
<tr>
<td>toUpperCase()</td>
<td>Converts the string to all uppercase letters.</td>
<td>Upper case string.</td>
</tr>
</tbody>
</table>

**String Object Functions**

```javascript
var a = "First, Second, Third";
b = a.charAt(3);                          // b = "s"
b = a.indexOf("Second");           // b = 7
b = a.length;                                // b = 20
b = a.localeCompare("ABC");            // b = 5;
b = a.replace(/,/g, ";           // b = "First- Second- Third"
b = a.slice(0, -7);                        // b = "First, Second"
b = a.toLowerCase() ;                // b = "first, second, third"
b = a.toUpperCase();                 // b = "FIRST, SECOND, THIRD"
```

**Sample String Output**

### 3.3.3 Booleans

Booleans are the simplest of the variable types. They contain a value of either true or false, which are JavaScript keywords.

```javascript
var a = true; // 'a' is defined as a boolean
if (a) {
    // processes the code in this if block since 'a' is 'true'
}
```

**Sample Boolean Assignment**

### 3.3.4 Arrays

An array is a composite data type that stores values in consecutive order. Each value stored in the array is considered an element of the array and the position within an array is called an index. Each element of an array can be any variable type and each element can have a different variable type than the other elements in the array.

An array, like numbers and strings, are considered an object with functions associated with it. You can define an array using two different methods, as an empty array using a new Array object, or by creating an array literal with defined values for the array. You can specify the initial size of the array when defining an Array object. The initial size of an array defined with values is the number of values contained in the initialization.

```javascript
var a = new Array(); // creates a blank array, all values are assigned undefined
```
var a = new Array(10);  // creates a blank array with 10 elements
var a = [true, "a", 3.17];  // creates an array with the first 3 elements assigned
var a = [{x:1, y:2}, {x:3, y:4}, {x:5, y:6}];  // creates an array of 3 xy objects

Array Definitions

You can access an array element by using the [ ] brackets. The name of the array will appear to the left of the brackets and the index to the element within the array inside of the brackets. The index can be a simple number or an equation.

var a = [1, 2, "text", false];
b = a[0];       // b = 1
a[5] = "next";  // a = [1, 2, "text", false, "next"]
b = a[2+a[0]];  // b = false;

Accessing Elements Within an Array

The Array object has the following functions associated with it.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>concat(values)</td>
<td>Appends the values to an array.</td>
<td>Original array with concatenated elements</td>
</tr>
<tr>
<td>join(sepator)</td>
<td>Combines all elements of an array into a string. <code>separator</code> is optional and specifies the string used to separate the elements of the array. The default is a comma.</td>
<td>String containing array elements.</td>
</tr>
<tr>
<td>length</td>
<td>Returns the allocated size of the array. <code>length</code> is not a function, but rather a property of an array and does not use () in its syntax.</td>
<td>The size of the array.</td>
</tr>
<tr>
<td>pop()</td>
<td>Pops the last element from the array and decreases the size of the array by 1.</td>
<td>The value of the last element of the array.</td>
</tr>
<tr>
<td>push(values)</td>
<td>Pushes the <code>values</code> onto the array and increases the size of the array by the number of <code>values</code>.</td>
<td>Updated size of array.</td>
</tr>
<tr>
<td>reverse()</td>
<td>Reverses the order of the elements of the array.</td>
<td>Returns nothing, but rather modifies the original array.</td>
</tr>
<tr>
<td>shift(values)</td>
<td>Removes the first element from the array and decreases the size of the array by 1.</td>
<td>The value of the first element of the array.</td>
</tr>
<tr>
<td>slice(start, end)</td>
<td>Creates a new array consisting of the <code>start</code> element up to, but not including the <code>end</code> element of the array.</td>
<td>An array containing the elements from <code>array</code> starting at <code>start</code> and ending at <code>end-1</code>. A negative value for <code>start</code> or <code>end</code> specifies a position from the end of the <code>array</code>; -1 is the last element, -2 is the second to last element, etc.</td>
</tr>
<tr>
<td>sort(function)</td>
<td>Sorts the elements of the array. The original array will be modified. The sort method uses an alphabetical order of elements converted to strings by default. You can specify a function</td>
<td>The sorted array.</td>
</tr>
</tbody>
</table>
Function | Description | Returns
--- | --- | ---
toLocaleString() | Format an array according to locale conventions | String representation of array
toString | Format an array | String representation of array
unshift() | Adds the values to the beginning of an array and increases the size of the array by the number of values. | Updated size of array.

Array Object Functions

```javascript
var a = [1, 2, 3, 4, 5, 6, 7, 8];
b = a.concat(9, 10, 11); // b = [1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11]
b = a.join(" "); // b = "1, 2, 3, 4, 5, 6, 7, 8"
b = a.length; // b = 8
a.push(9, 10, 11) // a = [1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11]
b = a.pop(); // a = [1, 2, 3, 4, 5, 6, 7, 8, 9, 10], b = 10
a.reverse(); // a = [10, 9, 8, 7, 6, 5, 4, 3, 2, 1]
b = a.unshift(12, 11); // a = [12, 11, 10, 9, 8, 7, 6, 5, 4, 3, 2, 1], b = 12
b = a.shift(); // a = [11, 10, 9, 8, 7, 6, 5, 4, 3, 2, 1], b = 12
b = a.slice(4, 7); // b = [7, 6, 5]
a.sort(function(a, b) {
    return a-b;
});
b = a.toString() // b = "1,2,3,4,5,6,7,8,9,10,11"
```

Sample Array Output

3.3.5 Objects

An Object is similar to an array in that it stores multiple values within a single variable. The difference is that objects use a name for each sub-entity rather than relying on an index pointer into an array. The properties table in a post processor is an object. You can define an object using two different methods, explicitly using the Object keyword, or implicitly by creating an object literal with defined names and values for the object. Each named entity within an object can be any type of variable, number, string, array, boolean, and another object. Objects can also be stored in an array.

Objects can be expanded to include additional named elements at any time and are not limited to the named elements when they are created.

```javascript
var a = new Object(); // creates a blank object, without named elements
var a = {x:1, y:2, z:3}; // creates an object for storing coordinates
a.feed = 10.0; // adds the 'feed' element to the 'a' Object
var a = [{x:1, y:2}, {x:3, y:4}, {x:5, y:6}]; // creates an array of 3 xy objects
```
3.3.6 The Vector Object

The Vector object is built into the post processor and is used to store and work with vectors. The vector components are stored in the x, y, z elements of the Vector object. Certain post processor variables are stored as vectors and some functions require vectors as input. A Vector object is created in the same manner as any other object. Vector objects are typically used to store and work on vectors, spatial points, and rotary angles.

```javascript
var a = new Vector(); // creates a blank Vector object
var a = new Vector(1, 0, 0); // creates an X-axis vector {x:1, y:0, z:0}
a.x = -1; // assigns -1 to the x element of the vector
setWorkPlane(new Vector(0, 0, 0)); // defines a null vector inline
```

The following tables describe the attributes and functions contained in the Vector object. Since an attribute is simply a value contained in the Vector object, it does not have an argument.

<table>
<thead>
<tr>
<th>Attribute</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>abs</td>
<td>Contains the absolute coordinates of the vector</td>
</tr>
<tr>
<td>length</td>
<td>Contains the length of the vector</td>
</tr>
<tr>
<td>length2</td>
<td></td>
</tr>
<tr>
<td>negated</td>
<td>Contains the negated vector</td>
</tr>
<tr>
<td>normalized</td>
<td>Contains the normalized/unit vector</td>
</tr>
<tr>
<td>x</td>
<td>Contains the X-component</td>
</tr>
<tr>
<td>y</td>
<td>Contains the Y component</td>
</tr>
<tr>
<td>z</td>
<td>Contains the Z component</td>
</tr>
</tbody>
</table>

**Sample Vector Definitions**

You can directly modify an attribute of a vector, but if you do then the remaining attributes will not be updated. For example, if you directly store a value in the x attribute, vec.x = .707, the length attribute of the vector will not be updated. You should use the vec.setX(.707) method instead.

If the Returns column in the following table has *Implicit*, then there is no return value, rather the Vector object associated with the function is modified implicitly. For this reason, if you are going to nest a Vector function within an expression, do not use the Implicit function, but rather the equivalent function that returns a vector.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>divide(value)</td>
<td>Divides each component of the object vector by the value</td>
<td>Implicit</td>
</tr>
<tr>
<td>getCoordinate(coordinate)</td>
<td>Returns the value of the vector component (0=x, 1=y, 2=z)</td>
<td>Component of vector</td>
</tr>
<tr>
<td>getMaximum()</td>
<td>Determines the largest component value in the vector</td>
<td>Maximum component value</td>
</tr>
<tr>
<td>getMinimum()</td>
<td>Determines the minimum component value in the vector</td>
<td>Minimum component value</td>
</tr>
<tr>
<td>getNegated()</td>
<td>Calculates the negated vector</td>
<td>Vector at 180 degrees to the object vector (vector * -1)</td>
</tr>
</tbody>
</table>

**Vector Attributes**
### Function Details

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>getNormalized()</code></td>
<td>Calculates the normalized/unit vector</td>
<td>Normalized or unit vector</td>
</tr>
<tr>
<td><code>getX()</code></td>
<td>Returns the X-coordinate of the vector</td>
<td>X-coordinate</td>
</tr>
<tr>
<td><code>getXYAngle()</code></td>
<td>Calculates the angle of the vector in the XY-plane</td>
<td>Angle of vector in XY-plane</td>
</tr>
<tr>
<td><code>getY()</code></td>
<td>Returns the Y-coordinate of the vector</td>
<td>Y-coordinate</td>
</tr>
<tr>
<td><code>getZ()</code></td>
<td>Returns the Z-coordinate of the vector</td>
<td>Z-coordinate</td>
</tr>
<tr>
<td><code>getZAngle()</code></td>
<td>Calculates the Z-angle of the vector relative to the XY-plane</td>
<td>Z-angle of vector relative to the XY-plane</td>
</tr>
<tr>
<td><code>isZero()</code></td>
<td>Determines if the vector is a null vector (0,0,0)</td>
<td>True if it is a null vector</td>
</tr>
<tr>
<td><code>multiply(value)</code></td>
<td>Multiplies each component of the vector by the value</td>
<td>Implicit</td>
</tr>
<tr>
<td><code>negate()</code></td>
<td>Multiplies each component of the vector by -1. Creates a vector at 180 degrees to the object vector</td>
<td>Implicit</td>
</tr>
<tr>
<td><code>setCoordinate(coordinate, value)</code></td>
<td>Sets the value of the vector component (0=x, 1=y, 2=z)</td>
<td>Implicit</td>
</tr>
<tr>
<td><code>setX()</code></td>
<td>Sets the X-coordinate of the vector</td>
<td>Implicit</td>
</tr>
<tr>
<td><code>setY()</code></td>
<td>Sets the Y-coordinate of the vector</td>
<td>Implicit</td>
</tr>
<tr>
<td><code>setZ()</code></td>
<td>Sets the Z-coordinate of the vector</td>
<td>Implicit</td>
</tr>
<tr>
<td><code>toDeg()</code></td>
<td>Converts radians to degrees</td>
<td>Angles in degrees</td>
</tr>
<tr>
<td><code>toRad()</code></td>
<td>Converts degrees to radians</td>
<td>Angles in radians</td>
</tr>
<tr>
<td><code>toString()</code></td>
<td>Formats the vector as a string, e.g. &quot;(1, 2, 3)&quot;</td>
<td>String representation of vector</td>
</tr>
</tbody>
</table>

### Vector Object Functions

Static functions do not require an associated Vector object.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>Vector.cross(left, right)</code></td>
<td>Calculates the cross product of two vectors</td>
<td>Vector perpendicular to the two vectors</td>
</tr>
<tr>
<td><code>Vector.diff(left, right)</code></td>
<td>Calculates the difference between two vectors</td>
<td>Left vector minus right vector</td>
</tr>
<tr>
<td><code>Vector.dot(left, right)</code></td>
<td>Calculates the dot product of the two vectors</td>
<td>Cosine of angle between the two vectors</td>
</tr>
<tr>
<td><code>Vector.getAbsolute()</code></td>
<td>Converts the vector components to absolute values</td>
<td>Vector with absolute coordinates</td>
</tr>
<tr>
<td><code>Vector.getAngle()</code></td>
<td>Calculates the angle between two vectors</td>
<td>Angle between the two vectors in radians</td>
</tr>
<tr>
<td><code>Vector.getDistance(left, right)</code></td>
<td>Calculates the distance between two vectors. Typically used when the vectors store XYZ spatial coordinates rather than vectors.</td>
<td>Distance between two points</td>
</tr>
<tr>
<td><code>Vector.getDistance2(left, right)</code></td>
<td>Calculates the square of the distance between two vectors.</td>
<td>Squared distance between two points.</td>
</tr>
<tr>
<td><code>Vector.lerp(left, right, u)</code></td>
<td>Calculates a point at a percentage of the distance between the two coordinates. ‘u’ specifies the percentage of the distance to create the point at.</td>
<td>Point at a percentage of the line between two points</td>
</tr>
</tbody>
</table>
### Function

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>Vector.product(vector, value)</td>
<td>Multiplies each component of the vector by the value</td>
<td>Vector * value</td>
</tr>
<tr>
<td>Vector.sum(left, right)</td>
<td>Adds the two vectors</td>
<td>Left vector plus right vector</td>
</tr>
</tbody>
</table>

**Static Vector Functions**

```plaintext
b = a.length(); // b = length of Vector a
c = Vector.getAngle(a, b) // c = angle in radians between vectors a and b
var a = new Vector(1, 2, 1.5);
d = a.getMaximum(); // d = 2
b = Vector.getDistance(point1, point2).normalized; // b = directional vector from point1 to point2
b = Vector.dot(vector1, vector2); // b = cosine of angle between vector1 & vector2
b = a.negated; // b = vector at 180 degrees to Vector a
```

**Sample Vector Expressions**

### 3.3.7 The Matrix Object

The *Matrix* object is built-in to the post processor and is used to store and work with matrices. Matrices are normally used when working with multi-axis machines, for 3+2 operations and for adjusting the coordinates for table rotations. Matrices in the post processor contain only the rotations for each axis and do not contain translation values.

Certain post processor variables are stored as matrices, such as the *workPlane* variable, and some functions require matrices as input. A *Matrix* object has functions that can be used when creating the matrix and are not dependent on working with an existing matrix.

<table>
<thead>
<tr>
<th>Assignment Function</th>
<th>Definition</th>
</tr>
</thead>
<tbody>
<tr>
<td>Matrix()</td>
<td>Identity matrix (1,0,0, 0,1,0, 0,0,1)</td>
</tr>
<tr>
<td>Matrix(i1, j1, k1, i2, j2, k2, i3, j3, k3)</td>
<td>Canonical matrix</td>
</tr>
<tr>
<td>Matrix(scale)</td>
<td>Scale matrix</td>
</tr>
<tr>
<td>Matrix(right, up, forward)</td>
<td>Matrix using 3 vectors</td>
</tr>
<tr>
<td>Matrix(vector, angle)</td>
<td>Rotation matrix around the vector</td>
</tr>
</tbody>
</table>

**Matrix Assignment Functions**

```plaintext
var a = new Matrix(); // creates an identity matrix
var a = new Vector(-1, 0, 0, -1,0, 0,0, 1); // creates a matrix rotated 180 degrees in the XY-plane
var a = new Matrix(.5); // creates a half scale matrix
var a = new Matrix(new Vector(1, 0, 0), 30); // creates an X-rotation matrix of 30 degrees
```

**Sample Matrix Definitions**

The following tables describe the attributes and functions contained in the *Matrix* object. Since an attribute is simply a value contained in the Matrix object, it does not have an argument.
### Attribute Description

<table>
<thead>
<tr>
<th>Attribute</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>forward</td>
<td>Contains the forward vector</td>
</tr>
<tr>
<td>n1</td>
<td>Contains the length of the row vectors of this matrix</td>
</tr>
<tr>
<td>n2</td>
<td>Contains the square root of this matrix vector lengths</td>
</tr>
<tr>
<td>Negated</td>
<td>Contains the negated matrix</td>
</tr>
<tr>
<td>right</td>
<td>Contains the right vector</td>
</tr>
<tr>
<td>transposed</td>
<td>Contains the inverse matrix</td>
</tr>
<tr>
<td>up</td>
<td>Contains the up vector</td>
</tr>
</tbody>
</table>

#### Matrix Attributes

You can directly modify an attribute of a matrix, but if you do then the remaining attributes will not be updated. For example, if you directly store a vector in the forward attribute, the other attributes will not be updated to reflect this modification. You should use the `matrix.setForward(vector)` method instead.

If the Returns column in the following table has *Implicit*, then there is no return value, rather the `Matrix` object associated with the function is modified implicitly. For this reason, if you are going to nest a `Matrix` function within an expression, do not use the Implicit function, but rather the equivalent function that returns a matrix.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>add(matrix)</td>
<td>Adds the specified matrix to this matrix</td>
<td>Implicit</td>
</tr>
<tr>
<td>getColumn(column)</td>
<td>Retrieves the matrix column as a vector</td>
<td>Vector containing the specified column of this matrix</td>
</tr>
<tr>
<td>getElement(row, column)</td>
<td>Retrieves the matrix element as a value</td>
<td>Value of this matrix element</td>
</tr>
<tr>
<td>getEuler2(convention)</td>
<td>Calculates the angles for the specified Euler convention</td>
<td>Vector containing Euler angles of this matrix. Refer to the Work Plane section of the manual for a description of Euler conventions.</td>
</tr>
<tr>
<td>getForward()</td>
<td>Returns the forward vector. This will be 0,0,1 in an identity matrix</td>
<td>Forward vector of this matrix</td>
</tr>
<tr>
<td>getN1()</td>
<td>Returns the length of the row vectors of this matrix</td>
<td>Returns right_vector + up_vector + forward_vector of matrix</td>
</tr>
<tr>
<td>getN2()</td>
<td>Returns the square root of this matrix vector lengths</td>
<td>Math.sqrt(n1)</td>
</tr>
<tr>
<td>getNegated()</td>
<td>Calculates the negated matrix</td>
<td>Matrix * -1.</td>
</tr>
<tr>
<td>getRight()</td>
<td>Returns the right vector. This will be 1,0,0 in an identity matrix</td>
<td>Right vector of matrix</td>
</tr>
<tr>
<td>getRow(row)</td>
<td>Retrieves the matrix row as a vector</td>
<td>Vector containing the specified row of this matrix</td>
</tr>
<tr>
<td>getTiltAndTilt(first, second)</td>
<td>Calculates the X &amp; Y rotations around the fixed frame to match the forward direction. 'first' and 'second' can be 0 or 1 and must be different.</td>
<td>Calculated forward direction of this matrix</td>
</tr>
<tr>
<td>getTransposed()</td>
<td>Returns the transposed (inverse) of the matrix</td>
<td>Inversed matrix</td>
</tr>
<tr>
<td>getTurnAndTilt(first, second)</td>
<td>Calculates the X, Y, Z rotations around the fixed frame to match the</td>
<td>Calculated forward direction</td>
</tr>
</tbody>
</table>
# Matrix Functions

Static functions do not require an associated `Matrix` object.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>Matrix.diff(left, right)</td>
<td>Calculates the difference between two matrices</td>
<td>Left matrix minus right matrix</td>
</tr>
<tr>
<td>Matrix.getAxisRotation(vector, angle)</td>
<td>Calculates a rotation matrix</td>
<td>Rotation matrix of 'angle' radians around the axis 'vector'</td>
</tr>
<tr>
<td>Matrix.getXRotation(angle)</td>
<td>Calculates a rotation matrix around the X-axis</td>
<td>Rotation matrix of 'angle' radians around the X-axis</td>
</tr>
<tr>
<td>Matrix.getXYZRotation(abc)</td>
<td>Calculates the rotation matrix for the given angles</td>
<td>Rotation matrix that satisfies the specified XYZ rotations</td>
</tr>
<tr>
<td>Matrix.getYRotation(angle)</td>
<td>Calculates a rotation matrix around the Y-axis</td>
<td>Rotation matrix of 'angle' radians around the Y-axis</td>
</tr>
<tr>
<td>Matrix.getZRotation(angle)</td>
<td>Calculates a rotation matrix around the Z-axis</td>
<td>Rotation matrix of 'angle' radians around the Z-axis</td>
</tr>
<tr>
<td>Matrix.sum(left, right)</td>
<td>Adds the two matrices</td>
<td>Left matrix plus right matrix</td>
</tr>
</tbody>
</table>

**Static Matrix Functions**

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
<th>Returns</th>
</tr>
</thead>
<tbody>
<tr>
<td>Function</td>
<td>Description</td>
<td>Returns</td>
</tr>
<tr>
<td>getUp()</td>
<td>Returns the up vector. This will be 0.1.0 in an identity matrix</td>
<td>Right vector of matrix</td>
</tr>
<tr>
<td>isIdentity()</td>
<td>Determines if the matrix is an identity matrix (1,0,0, 0,1,0, 0,0,1).</td>
<td>True if it is an identity matrix</td>
</tr>
<tr>
<td>isZero()</td>
<td>Determines if the matrix is a null matrix (0,0,0, 0,0,0, 0,0,0)</td>
<td>True if it is a null matrix</td>
</tr>
<tr>
<td>multiply(value)</td>
<td>Multiplies each component of the matrix by the value</td>
<td>Result of matrix times specified value</td>
</tr>
<tr>
<td>multiply(matrix)</td>
<td>Multiplies the matrix by the specified matrix</td>
<td>Results of matrix times specified matrix</td>
</tr>
<tr>
<td>multiply(vector)</td>
<td>Multiplies the specified vector by the matrix</td>
<td>Vector multiplied by the matrix</td>
</tr>
<tr>
<td>negate()</td>
<td>Calculates the negated matrix</td>
<td>Implicit</td>
</tr>
<tr>
<td>normalize()</td>
<td>Calculates the negated matrix</td>
<td>Implicit</td>
</tr>
<tr>
<td>setColumn(column, vector)</td>
<td>Sets the matrix column as a vector</td>
<td>Implicit</td>
</tr>
<tr>
<td>setElement(row, column, vector)</td>
<td>Sets the matrix element</td>
<td>Implicit</td>
</tr>
<tr>
<td>setForward(vector)</td>
<td>Sets the forward vector</td>
<td>Implicit</td>
</tr>
<tr>
<td>setRight(vector)</td>
<td>Sets the right vector</td>
<td>Implicit</td>
</tr>
<tr>
<td>setRow(row, vector)</td>
<td>Sets the matrix row as a vector</td>
<td>Implicit</td>
</tr>
<tr>
<td>setUp(vector)</td>
<td>Sets the up vector</td>
<td>Implicit</td>
</tr>
<tr>
<td>subtract(matrix)</td>
<td>Subtracts the specified matrix from this matrix</td>
<td>Implicit</td>
</tr>
<tr>
<td>toString()</td>
<td>Formats the matrix as a string, e.g. &quot;[[1, 0, 0], [0, 1, 0], [0, 0, 1]]&quot;</td>
<td>String representation of matrix</td>
</tr>
<tr>
<td>transpose()</td>
<td>Creates the transposed/inverse of this matrix</td>
<td>Implicit</td>
</tr>
</tbody>
</table>
### 3.4 Expressions

Variables can be assigned a simple value or text string, or can be more complex in nature containing a list of variables or literals and operators that perform operations on the values contained in the expression. The following table lists the common operators supported by JavaScript and provides samples using the operators. The operator precedence is also listed (column P), where the operators with a higher precedence number are performed prior to the operators of a lower precedence number. Operators with the same precedence number will calculate in the order that they appear in the expression.

Unary operators only require a single operand instead of two. For example, \( y = x++ \) will increment the variable \( x \) after it is assigned to the variable \( y \).

<table>
<thead>
<tr>
<th>P</th>
<th>Operator</th>
<th>Operands</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>13</td>
<td>()</td>
<td>Expression</td>
<td>Overrides the assigned precedence of operators</td>
</tr>
<tr>
<td>12</td>
<td>++</td>
<td>Integer</td>
<td>Unary increment</td>
</tr>
<tr>
<td></td>
<td>--</td>
<td>Integer</td>
<td>Unary decrement</td>
</tr>
<tr>
<td></td>
<td>~</td>
<td>Integer</td>
<td>Unary bitwise complement</td>
</tr>
<tr>
<td></td>
<td>!</td>
<td>Boolean</td>
<td>Unary logical complement (not)</td>
</tr>
<tr>
<td>11</td>
<td>*</td>
<td>Number</td>
<td>Multiplication</td>
</tr>
<tr>
<td></td>
<td>/</td>
<td>Number</td>
<td>Division</td>
</tr>
<tr>
<td></td>
<td>%</td>
<td>Number</td>
<td>Remainder</td>
</tr>
<tr>
<td>10</td>
<td>+</td>
<td>Number, String</td>
<td>Addition</td>
</tr>
<tr>
<td></td>
<td>-</td>
<td>Number</td>
<td>Subtraction</td>
</tr>
<tr>
<td>9</td>
<td>&lt;&lt;=</td>
<td>Integer</td>
<td>Bitwise shift left</td>
</tr>
<tr>
<td></td>
<td>&gt;&gt;=</td>
<td>Integer</td>
<td>Bitwise shift right</td>
</tr>
<tr>
<td>8</td>
<td>&lt;</td>
<td>Number, String</td>
<td>Less than</td>
</tr>
<tr>
<td></td>
<td>&lt;=</td>
<td>Number, String</td>
<td>Less than or equal to</td>
</tr>
<tr>
<td></td>
<td>&gt;</td>
<td>Number, String</td>
<td>Greater than</td>
</tr>
<tr>
<td></td>
<td>&gt;=</td>
<td>Number, String</td>
<td>Greater than or equal to</td>
</tr>
<tr>
<td>7</td>
<td>==</td>
<td>Any</td>
<td>Equal to</td>
</tr>
<tr>
<td></td>
<td>!=</td>
<td>Any</td>
<td>Not equal to</td>
</tr>
<tr>
<td></td>
<td>===</td>
<td>Any</td>
<td>Equal to and same variable type</td>
</tr>
<tr>
<td></td>
<td>!==</td>
<td>Any</td>
<td>Not equal to and same variable type</td>
</tr>
<tr>
<td>6</td>
<td>&amp;</td>
<td>Integer</td>
<td>Bitwise AND</td>
</tr>
<tr>
<td>5</td>
<td>^</td>
<td>Integer</td>
<td>Bitwise XOR</td>
</tr>
<tr>
<td>4</td>
<td></td>
<td></td>
<td>Integer</td>
</tr>
</tbody>
</table>
### Expression Operators

<table>
<thead>
<tr>
<th>P</th>
<th>Operator</th>
<th>Operands</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td><code>&amp;&amp;</code></td>
<td>Boolean</td>
<td>Logical AND</td>
</tr>
<tr>
<td>2</td>
<td>`</td>
<td></td>
<td>`</td>
</tr>
<tr>
<td>1</td>
<td><code>=</code></td>
<td>Any</td>
<td>Assignment</td>
</tr>
<tr>
<td></td>
<td><code>+=</code></td>
<td>Number, String</td>
<td>Assignment with addition</td>
</tr>
<tr>
<td></td>
<td><code>-=</code></td>
<td>Number</td>
<td>Assignment with subtraction</td>
</tr>
<tr>
<td></td>
<td><code>*=</code></td>
<td>Number</td>
<td>Assignment with multiplication</td>
</tr>
<tr>
<td></td>
<td><code>/=</code></td>
<td>Number</td>
<td>Assignment with division</td>
</tr>
</tbody>
</table>

### Sample Expressions

#### Expression Operators

<table>
<thead>
<tr>
<th>x</th>
<th>y</th>
<th>Expression</th>
<th>Result</th>
<th>Expression</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td>5</td>
<td><code>z = x + y * 3</code></td>
<td>18</td>
<td><code>z = (x + y) * 3</code></td>
<td>24</td>
</tr>
<tr>
<td></td>
<td></td>
<td><code>z = ++x</code></td>
<td><code>z = 4, x = 4</code></td>
<td><code>z = x++</code></td>
<td><code>z = 3, x = 4</code></td>
</tr>
<tr>
<td></td>
<td></td>
<td><code>x += y</code></td>
<td>8</td>
<td><code>x *= y</code></td>
<td>15</td>
</tr>
<tr>
<td></td>
<td></td>
<td><code>z = y / x</code></td>
<td>1.667</td>
<td><code>z = y % x</code></td>
<td>2.0</td>
</tr>
<tr>
<td>&quot;Start&quot;</td>
<td>&quot;End&quot;</td>
<td><code>z = x + y</code></td>
<td>&quot;Start-End&quot;</td>
<td><code>x += y</code></td>
<td>&quot;Start-End&quot;</td>
</tr>
<tr>
<td>2</td>
<td>3</td>
<td><code>z = x &amp; y</code></td>
<td>2</td>
<td>`z = x</td>
<td>y`</td>
</tr>
<tr>
<td>1</td>
<td>&quot;1&quot;</td>
<td><code>z = x == y</code></td>
<td>true</td>
<td><code>x === y</code></td>
<td>false</td>
</tr>
<tr>
<td>true</td>
<td>false</td>
<td><code>z = x</code></td>
<td>true</td>
<td><code>z = !y</code></td>
<td>true</td>
</tr>
<tr>
<td></td>
<td></td>
<td>`z = x</td>
<td></td>
<td>y`</td>
<td>true</td>
</tr>
</tbody>
</table>

### 3.5 Conditional Statements

Conditional statements are commands or functions that will test the results of an expression and then process statements based on the outcome of the conditional. Conditionals typically check Boolean type expressions, but can also be used to test if a value is `undefined` or a string is blank.

This section describes the conditional statements and functions used when developing a post processor. Some of the conditionals are supported by JavaScript and others are inherent in the post processor kernel.

#### 3.5.1 The if Statement

The `if` statement is the most common method for testing a conditional and executing statements based on the outcome of the test. It can contain a single body of statements to execute when the expression is true, a second body of statements to execute when the expression is false, or it can contain multiple conditionals that are checked in order using the `else if` construct.

As with all commands that affect a body of code, `if` statements can be nested inside of other `if` bodies and loops.

The syntax of `if` statements should follow the Autodesk standard of always including the `{ }` brackets around each body of code, specifying the opening bracket (`{`) on the conditional line, and the closing
bracket (}) at the start of the line following the body of code for each section as shown in the following examples.

```javascript
if (conditional1) {
    // execute code if conditional1 is true
}

if (conditional1) {
    // execute code if conditional1 is true
} else {
    // execute code if conditional1 is false
}

if (conditional1) {
    // execute code if conditional1 is true
} else if (conditional2) {
    // execute code if conditional1 is false and conditional2 is true
} else {
    // execute code if all conditionals are false
}
```

**If Statement Syntax**

```javascript
if (hasParameter("operation-comment")) {
    comment = getParameter("operation-comment");
}

if (isProbeOperation()) {
    var workOffset = probeOutputWorkOffset ? probeOutputWorkOffset : currentWorkOffset;
    if (workOffset > 99) {
        error(localize("Work offset is out of range."));
        return;
    } else if (workOffset > 6) {
        probeWorkOffsetCode = probe100Format.format(workOffset - 6 + 100);
    } else {
        probeWorkOffsetCode = workOffset + "."; // G54->G59
    }
}
```

**Sample If Statements**

### 3.5.2 The switch Statement

The *switch* statement is similar to an *if* statement in that it causes a branch in the flow of a program's execution based on the outcome of a conditional. *switch* statements are typically used when checking the value of a single variable, whereas *if* conditionals can test complex expressions.
The syntax of `switch` bodies will contain a single switch statement with a variable whose value determines the code to be executed. `case` statements will be included in the `switch` body, with each one containing the value that causes its body of code to be executed. The end of each `case` body of code must have a `break` statement so that the next `case` body of code is not executed. A `default` statement can be defined that contains code that will be executed if the `switch` variable does not match any of the `case` values.

`case` statements should follow the Autodesk standard of always including specifying the opening bracket `{` on the `switch` line, and the closing bracket `}` at the start of the line at the end of the body of code for each section. The `case` statements will be aligned with the `switch` statement and all code within each `case` body will be indented.

```javascript
switch (variable) {
    case value1:
        // execute if variable = value1
        break;
    case value2:
        // execute if variable = value2
    case value3:
        // execute if variable = value3
    default:
        // execute if variable does not equal value1, value2, or value3
        break;
}
```

**Switch Block Syntax**

```javascript
switch (coolant) {
    case COOLANT_FLOOD:
        m = 8;
        break;
    case COOLANT_THROUGH_TOOL:
        m = 88;
        break;
    case COOLANT_AIR:
        m = 51;
        break;
    default:
        onUnsupportedCoolant(coolant);
}
```

**Sample Switch Blocks**
3.5.3 The Conditional Operator (?)

The ? conditional operator tests an expression and returns different values based on whether the expression is true or false. It is a compact version of a simple if block and is used in an assignment type statement or as part of an expression.

```
var a = conditional ? true_value : false_value;
```

In the above syntax, `a` will be assigned `true_value` if the conditional is true, or `false_value` if it is false.

```
homeGcode = properties.useG30 ? 30 : 28;
// could be expanded into this if block
if (properties.useG30) {
    homeGcode = 30;
} else {
    homeGcode = 28;
}
```

Sample ? Conditional Operator

3.5.4 The typeof Operator

The typeof operator is not a conditional operator per the general terminology, but it is always used as a part of a conditional to determine if a function or variable exists. When used in an expression it will return a string that describes the variable type of the operand. This is the only way to test if a function exists prior to calling the function or if a variable exists before referencing it. If you try to reference a non-existent variable or function without testing to see if it exists first, the post processor will terminate with an error.

The typeof operator is followed by a single operand name, i.e. "typeof variable". It can return the following string values.

<table>
<thead>
<tr>
<th>Operand Type</th>
<th>Return Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>number</td>
<td>&quot;number&quot;</td>
</tr>
<tr>
<td>string</td>
<td>&quot;string&quot;</td>
</tr>
<tr>
<td>boolean</td>
<td>&quot;boolean&quot;</td>
</tr>
<tr>
<td>object, array, null</td>
<td>&quot;object&quot;</td>
</tr>
<tr>
<td>function</td>
<td>&quot;function&quot;</td>
</tr>
<tr>
<td>undefined</td>
<td>&quot;undefined&quot;</td>
</tr>
</tbody>
</table>

```
if ((typeof getHeaderVersion == "function") && getHeaderVersion()) {
    writeComment(localize("post version") + ": " + getHeaderVersion());
}
```

Sample typeof Usage
3.5.5 The conditional Function

The *conditional* function will test an expression and if it is true will return the specified value. If the expression is false, then a blank string is returned. The *conditional* function is mainly used for determining if a specific code should be output in a block.

```
conditional(expression, true_value)
```

**conditional Syntax**

```java
writeBlock(
    gRetractModal.format(98), gAbsIncModal.format(90), gCycleModal.format(82),
    getCommonCycle(x, y, z, cycle.retract),
    conditional(P > 0, "P" + milliFormat.format(P)), //optional
    feedOutput.format(F)
);
```

**conditional Usage**

Since *conditional* is a function, any function calls contained in the arguments will be processed even if the expression equates to false. This means that if a modal is used to format a value, the value will be formatted prior to evaluating the expression and the modal’s current value will be set using this value, even if the value is not output.

```
writeBlock(conditional(isRapid, gMotionModal.format(0)), x, y, z);
```

Sets the gMotionModal Modal Value to 0 Even when isRapid is false and G00 is not Output

3.5.6 try / catch

The *try/catch* block is an exception handling mechanism. This allows the post processor to control the outcome of an exception. Depending on the exception that is encountered, the JavaScript code could continue processing or terminate with an error. The *try/catch* block is used to override the normal processing of exceptions in JavaScript.

```
try {
    // code that may generate an exception
} catch (e) { // e is a local variable that contains the exception object or value that was thrown
    // code to perform if an exception is encountered
}
```

**try/catch Syntax**

```
try {
    programId = getInt(programName);
} catch(e) {
    error(localize("Program name must be a number."));
    return;
}
```

**try/catch Usage**
3.5.7 The validate Function

The validate function tests an expression and raises an exception if the expression is false. The post processor will typically output an error if an exception is raised, so in essence, the validate function determines if an expression is true or false and outputs an error using the provided message if it is false.

```
validate(expression, error_message)
```

**validate Syntax**

```
validate(retracted, "Cannot cancel length compensation if the machine is not fully retracted.");
```

**Sample validate Code**

In the above sample, an error will be generated if retracted is set to false.

3.5.8 Comparing Real Values

Real values are stored as binary numbers and are not truncated as you see them in an output file, so there are times when the numbers are not equal even if they show as the same value in the output file. For this reason, it is recommended that you either use a tolerance or truncate them when comparing their values. The format.getResultingValue function can be used to truncate a number to a fixed number of decimal places.

```
var a = 3.141592654;
var b = 3.141593174;

// simple comparison
if (a == b) { // false

// comparison using a tolerance
var toler = .0001;
if (Math.abs(a - b) <= toler) { // true

// comparison using truncated values
var spatialFormat = createFormat({decimals:4});
if ((spatialFormat.getResultingValue(a) - spatialFormat.getResultingValue(b)) == 0) { // true
```

**Comparing Real Values**

3.6 Looping Statements

Loops perform repetitive actions. There are various styles of looping statements; for, for/in, while, and do/while. You should choose the looping statement that lends itself to the style of loop you are coding.
The syntax of looping statements should follow the Autodesk standard of always including the {} brackets around each body of code, specifying the opening bracket () on the looping statement, and the closing bracket () at the start of the line following the body of code for the loop. Loops can be nested within other bodies of code, like conditionals or other loops.

### 3.6.1 The for Loop

The for loop is the most common of the looping statements. It includes a counter and an expression on when to end the loop, so it will loop through the body of the loop a fixed number of times, unless interrupted by the break command. The counter variable is initialized before the loop starts and is tested when the expression is evaluated before each iteration of the loop. The counter variable is incremented at the end of the loop, just before the expression is evaluated again. Multiple counters can be initialized and incremented in a for loop by separating the counters with a comma (,).

```javascript
for(initialize_counter; test expression ; increment_counter) {
    // body of loop
}
```

#### for Loop Syntax

```javascript
for (var i = 0; i < getNumberOfSections(); ++i) { // loop for the number of sections in intermediate file
    if (getSection(i).workOffset > 0) {
        error(localize("Using multiple work offsets is not possible if the initial work offset is 0.")));
        return;
    }
}

for (i = 0, j = ary.length - 1 ; i < ary.length / 2; ++i, --j) { // reverse the order of an array
    var tl = ary[i];
    ary[i] = ary[j];
    ary[j] = tl;
}
```

#### Sample for Loops

### 3.6.2 The for/in Loop

The for/in loop allows you to traverse the properties of an object. It is not commonly used in post processors (except for the dump.cps post processor), but can be useful for debugging the property names and values in an object.

```javascript
for(variable in object) {
    // body of loop
}
```

#### for/in Loop Syntax
for(var element in properties) { // write out the property table
    writeln("properties." + element + " = " + properties[element]);
}

Sample for/in Loop

3.6.3 The while Loop
The while loop evaluates an expression and will execute the body of the loop when the expression is true and will end the loop when the expression is false. Since the expression is tested at the top of the loop, the body of code in the loop will not be executed when the expression is initially set to false.

while (expression) {
    // body of loop
}

while Loop Syntax

while (c > 2*Math.PI) {
    c = 2 * Math.PI;
}

Sample while Loop

3.6.4 The do/while Loop
The do/while loop is pretty much the same as the while loop, but the expression is tested at the end of the loop rather than at the start of the loop. This means that the loop will be executed at least once, even if the expression is initially set to false.

do {
    // body of loop
} while (expression)

do/while Loop Syntax

var i = 0;
var found = false;
do {
    if (mtype[i++] == "Start") {
        found = true;
    }
} while (!found && i < mtype.length);

Sample do/while Loop
3.6.5 The break Statement

The `break` statement is used to interrupt a loop or switch statement prematurely. When the `break` statement is encountered during a loop or switch body, then the innermost loop/switch will be ended and control will move to the first statement outside of the loop/switch.

*break* is pretty much mandatory with switch statements. For loops, *break* can be used to get out of the loop when an error is encountered, or when a defined pattern is found within an array.

```javascript
for (i = 0; i < mtype.length; ++i) {
    if (mtype[i] == "Start") {
        break; // exits the loop
    }
}
```

Sample Usage of break Command

3.6.6 The continue Statement

The `continue` statement is used to bypass the remainder of the loop body and restarts the loop at the next iteration.

```javascript
for (i = 0; i < mtype.length; ++i) {
    if (mtype[i] < 0) {
        continue; // skips this iteration of the loop and continues with the next iteration
    }
    ...
}
```

Sample Usage of break Command

3.7 Functions

Functions in JavaScript behave in the same manner as functions in other high-level programming languages. In a post processor all code, except for the global settings at the top of the file, is contained in functions, either entry functions (`onOpen`, `onSection`, etc.) or helper functions (`writeBlock`, `setWorkPlane`, etc.). The code in a function will not be processed until that function is called from within another routine (for the sake of clarity the calling function will be referred to as a 'routine' in this section). Here are the main reasons for placing code in a separate function rather than programming it in the upper level routine that calls the function.

1. The same code is executed in different areas of the code, either from the same function or in multiple functions. Placing the common code in its own function eliminates duplicate code from the file, making it easier to understand and maintain.

2. To logically separate logic and make it easier to understand. Separating code into its own function can keep the calling routine from becoming too large and harder to follow, even if the function is only called one time.
3.7.1 The function Statement

A function consists of the function statement, a list of arguments, the body of the function (JavaScript code), and optional return statement(s).

```javascript
function name([arg1 [,arg2 [,..., argn]]]) {
    ...
    code
    ...
}
```

**function Statement Syntax**

The argument list is optional and contains identifiers that are passed into the function by the calling routine. The arguments passed to the function are considered read-only as far as the calling routine is concerned, meaning that any changes to these variables will be kept local to the called function and not propagated to the calling routine. You use the `return` statement to return value(s) to the calling routine.

```javascript
function writeComment(text) {
    writeln(formatComment(text)); // text is accepted as an argument and passed to formatComment
}
```

**Sample function Definition**

Arguments accepted by a function can either be named identifiers as shown in the previous example, or you can use the `arguments` array to reference the function arguments. The `arguments` array is built-in to JavaScript and is treated as any other `Array` object, meaning that it has the length property and access to the `Array` attributes and functions.

```javascript
transferType = parseChoice(properties.transferType,"PHASE","SPEED","STOP");
...
function parseChoice() {
    for (var i = 1; i < arguments.length; ++i) {
        if (String(arguments[0]).toUpperCase() == String(arguments[i]).toUpperCase()) {
            return i - 1;
        }
    }
    return -1;
}
```

**Sample Usage of arguments Array**

3.7.2 Calling a function

A function call is treated the same as any other expression. It can be standalone, assign a value, and be placed anywhere within an expression. The value returned by the called function is treated as any other variable. You simply type the name of the function with its arguments.

```javascript
setWorkPlane(abc); // function does not return a value
```
3.7.3 The return Statement

As you can see in the previous sections, a function can be treated the same as any other expression and all expressions have values. The return statement is used to provide a value back to the calling routine. You will recall that a function does not have to return a value, in this case you do not have to place a return statement in the function, the function will automatically return when the end of the function body is reached. You can place a return statement anywhere within the function, the function will be ended whenever a return statement is reached.

```
return [expression]
```

The return value can be any valid variable type; a number, string, object, or array. If you want to return multiple values from a function, then you must return either an object or an array. You can also propagate the JavaScript this object which will be automatically returned to the calling routine when the end of the function is reached or when processing a return statement without an expression. If the this object is used, then the function will be used to create a new object and you will need to define the function call as if you were creating any other type of object as shown in the following example.

```
function writeComment(text) {
    writeln(formatComment(text));
} // implicit return

function parseChoice() {
    for (var i = 1; i < arguments.length; ++i) {
        if (String(arguments[0]).toUpperCase() == String(arguments[i]).toUpperCase()) {
            return i - 1; // return the matching choice
        }
    }
    return -1; // return choice not found
}

function FeedContext(id, description, feed) {
    this.id = id;
    this.description = description;
    this.feed = feed;
} // return this object {id, description, feed}

var feedContext = new FeedContext(id, "Cutting", feedCutting); // create new FeedContext object
```
4 Entry Functions

The post processor Entry functions are the interface between the kernel and the post processor. An Entry function will be called for each record in the intermediate file. Which Entry function is called is determined by the intermediate file record type. All Entry functions have the ‘on’ prefix, so it is recommended that you do not use this prefix with any functions that you add to the post processor.

Here is a list of the supported Entry functions and when they are called. The following sections in this Chapter provide more detailed documentation for the most common of the Entry functions.

<table>
<thead>
<tr>
<th>Entry Function</th>
<th>Invoked When ...</th>
</tr>
</thead>
<tbody>
<tr>
<td>onCircular(clockwise, cx, cy, cz, x, y, z, feed)</td>
<td>Circular move</td>
</tr>
<tr>
<td>onClose()</td>
<td>End of post processing</td>
</tr>
<tr>
<td>onCommand(value)</td>
<td>Manual NC command not handled in its own function</td>
</tr>
<tr>
<td>onComment(string)</td>
<td>Comment Manual NC command</td>
</tr>
<tr>
<td>onCycle()</td>
<td>Start of a cycle</td>
</tr>
<tr>
<td>onCycleEnd()</td>
<td>End of a cycle</td>
</tr>
<tr>
<td>onCyclePoint(x, y, z)</td>
<td>Each cycle point</td>
</tr>
<tr>
<td>onDwell(value)</td>
<td>Dwell Manual NC command</td>
</tr>
<tr>
<td>onLinear(x, y, z, feed)</td>
<td>3-axis cutting move</td>
</tr>
<tr>
<td>onLinear5D(x, y, z, a, b, c, feed)</td>
<td>5-axis cutting move</td>
</tr>
<tr>
<td>onMachine()</td>
<td>Machine configuration changes</td>
</tr>
<tr>
<td>onManualNC()</td>
<td>Manual NC commands</td>
</tr>
<tr>
<td>onMovement(value)</td>
<td>Movement type changes</td>
</tr>
<tr>
<td>onOpen()</td>
<td>Post processor initialization</td>
</tr>
<tr>
<td>onOrientateSpindle(value)</td>
<td>Spindle orientation is requested</td>
</tr>
<tr>
<td>onParameter(string, value)</td>
<td>Each parameter setting</td>
</tr>
<tr>
<td>onPassThrough(string)</td>
<td>Pass through Manual NC command</td>
</tr>
<tr>
<td>onPower(boolean)</td>
<td>Power mode for water/plasma/laser changes</td>
</tr>
<tr>
<td>onRadiusCompensation()</td>
<td>Radius compensation mode changes</td>
</tr>
<tr>
<td>onRapid(x, y, z)</td>
<td>3-axis Rapid move</td>
</tr>
<tr>
<td>onRapid5D(x, y, z, a, b, c)</td>
<td>5-axis Rapid move</td>
</tr>
<tr>
<td>onRewindMachine(a, b, c)</td>
<td>Rotary axes limits are exceeded</td>
</tr>
<tr>
<td>onSection()</td>
<td>Start of an operation</td>
</tr>
<tr>
<td>onSectionEnd()</td>
<td>End of an operation</td>
</tr>
<tr>
<td>onSectionEndSpecialCycle()</td>
<td>End of a special cycle operation</td>
</tr>
<tr>
<td>onSectionSpecialCycle()</td>
<td>Start of a special cycle operation (Stock Transfer)</td>
</tr>
<tr>
<td>onSpindleSpeed(value)</td>
<td>Spindle speed changes</td>
</tr>
</tbody>
</table>
### 4.1 Global Section

The global section is not an Entry function, but rather is called when the post processor is first initialized. It defines settings used by the post processor kernel, the property table displayed with the post processor dialog inside of HSM, definitions for formatting output codes, and global variables used by the post processor.

While the global section is typically located at the top of the post processor, any variables defined outside of a function are in the global section and accessible by all functions, even the functions defined before the variable. You may notice global variables being defined in the middle of the post processor code just before a function. This allows for a group of functions to be easily cut-and-pasted from one post to another post, including the required global variables.

#### 4.1.1 Kernel Settings

Some of the variables defined in the global section are actually defined in and used by the post engine. These variables are usually at the very top of the file and are easily discerned, since they are not preceded by `var`. The following table provides a description of the kernel settings that you will find in most post processors.

<table>
<thead>
<tr>
<th>Setting</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>allowedCircularPlanes</td>
<td>Defines the allowed circular planes. This setting is described in the <code>onCircular</code> section.</td>
</tr>
<tr>
<td>allowHelicalMoves</td>
<td>Specifies whether helical moves are allowed. This setting is described in the <code>onCircular</code> section.</td>
</tr>
<tr>
<td>allowSpiralMoves</td>
<td>Specifies whether spiral moves are allowed. This setting is described in the <code>onCircular</code> section.</td>
</tr>
<tr>
<td>capabilities</td>
<td>Defines the capabilities of the post processor. The capabilities can be <code>CAPABILITY_MILLING</code>, <code>CAPABILITY_TURNING</code>, <code>CAPABILITY_JET</code>, <code>CAPABILITY_SETUP_SHEET</code>, and <code>CAPABILITY_INTERMEDIATE</code>. Multiple capabilities can be enabled by using the logical OR operator.</td>
</tr>
<tr>
<td></td>
<td>`capabilities = CAPABILITY_MILLING</td>
</tr>
<tr>
<td>certificationLevel</td>
<td>Certification level of the post configuration used to determine if the post processor is certified to run against the post engine. This value rarely changes.</td>
</tr>
<tr>
<td>description</td>
<td>Short description of post processor. This will be displayed along with the post processor name in the <em>Post Process</em> dialog in HSM when selecting a post processor to run.</td>
</tr>
<tr>
<td>extension</td>
<td>The output NC file extension.</td>
</tr>
<tr>
<td>Setting</td>
<td>Description</td>
</tr>
<tr>
<td>-----------------</td>
<td>-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>highFeedMapping</td>
<td>Specifies the high feed mapping mode for rapid moves. Valid modes are HIGH_FEED_NO_MAPPING, HIGH_FEED_MAP_MULTI, HIGH_FEED_MAP_XY_Z, and HIGH_FEED_MAP_ANY. This setting can be changed dynamically in the Property table when running the post processor.</td>
</tr>
<tr>
<td>highFeedrate</td>
<td>Specifies the feedrate to use when mapping rapid moves to linear moves.</td>
</tr>
<tr>
<td>legal</td>
<td>Legal notice of company that authored the post processor</td>
</tr>
<tr>
<td>mapToWCS</td>
<td>Specifies whether the work plane is mapped to the model origin and work plane. When disabled the post is responsible for handling mapping from the model origin to the setup origin. This variable must be defined using the following syntax and can only be defined in the global section. Any deviation from this format, including adding extra spaces, will cause this command to be ignored.</td>
</tr>
<tr>
<td></td>
<td>mapToWCS = true; mapToWCS = false;</td>
</tr>
<tr>
<td>mapWorkOrigin</td>
<td>Specifies whether the coordinates are mapped to the work plane origin. When disabled the post is responsible for handling the work plane origin. This variable must be defined using the following syntax and can only be defined in the global section. Any deviation from this format, including adding extra spaces, will cause this command to be ignored.</td>
</tr>
<tr>
<td></td>
<td>mapWorkOrigin = true; mapWorkOrigin = false;</td>
</tr>
<tr>
<td>maximumCircularRadius</td>
<td>Specifies the maximum radius of circular moves that can be output as circular interpolation and can be changed dynamically in the Property table when running the post processor. This setting is described in the onCircular section.</td>
</tr>
<tr>
<td>maximumCircularSweep</td>
<td>Specifies the maximum circular sweep of circular moves that can be output as circular interpolation. This setting is described in the onCircular section.</td>
</tr>
<tr>
<td>minimumChordLength</td>
<td>Specifies the minimum delta movement allowed for circular interpolation and can be changed dynamically in the Property table when running the post processor. This setting is described in the onCircular section.</td>
</tr>
<tr>
<td>minimumCircularRadius</td>
<td>Specifies the minimum radius of circular moves that can be output as circular interpolation and can be changed dynamically in the Property table when running the post processor. This setting is described in the onCircular section.</td>
</tr>
<tr>
<td>minimumCircularSweep</td>
<td>Specifies the minimum circular sweep of circular moves that can be output as circular interpolation. This setting is described in the onCircular section.</td>
</tr>
<tr>
<td>minimumRevision</td>
<td>The minimum revision of the post kernel that is supported by the post processor. This value will remain the same unless the post processor takes advantage of functionality added to a later version of the post engine that is not available in earlier versions.</td>
</tr>
</tbody>
</table>
### Setting | Description
--- | ---
programNameIsInteger | Specifies whether the program name must be an integer (true) or can be a text string (false).
tolerance | Specifies the tolerance used to linearize circular moves that are expanded into a series of linear moves. This setting is described in the onCircular section.
unit | Contains the output units of the post processor. This is usually the same as the input units, either MM or IN, but can be changed in the onOpen function of the post processor by setting it to the desired units.
vendor | Name of the machine tool manufacturer.
vendorUrl | URL of the machine tool manufacturer's web site.

### Post Kernel Settings

```c
description = "RS-274D";
vendor = "Autodesk";
vendorUrl = "http://www.autodesk.com";
legal = "Copyright (C) 2012-2017 by Autodesk, Inc.";
certificationLevel = 2;
minimumRevision = 24000;
longDescription = "Generic post for the RS-274D format. Most CNCs will use a format very similar to RS-274D. When making a post for a new CNC control this post will often serve as the basis."

extension = "nc";
setCodePage("ascii");
capabilities = CAPABILITY_MILLING;
tolerance = spatial(0.002, MM);
minimumChordLength = spatial(0.01, MM);
minimumCircularRadius = spatial(0.01, MM);
maximumCircularRadius = spatial(1000, MM);
minimumCircularSweep = toRad(0.01);
maximumCircularSweep = toRad(180);
allowHelicalMoves = true;
allowedCircularPlanes = undefined; // allow any circular motion
```

### 4.1.2 Property Table

Stock post processors are designed to run the machine without any modifications, but may not create the output exactly as you would like to see it. The Property Table contains settings that can be changed at runtime so that the stock post can remain generic in nature, but still be easily customized by various users. The settings in the Property Table will typically be used to control small variations in the output created by the post processor, with major changes handled by settings in the Fixed Settings section.
When you Post Process from HSM you will be presented with a dialog that allows you to select the post processor to execute, the output file path, and other settings. The Property Table will also be displayed in the dialog allowing you to override settings within the post processor each time it is run.

The Property Table is defined in the post processor so you have full control over the information displayed in it, with the exception of the *Built-in* properties, which are displayed with every post processor and define the post kernel variables described previously. The *properties* object defined in the post processor defines the property names as they are used in the post processor along with the default values assigned to each property.

```javascript
// user-defined properties
properties = {
    writeMachine: true, // write machine
    writeTools: true, // writes the tools
    preloadTool: true, // preloads next tool on tool change if any
    showSequenceNumbers: true, // show sequence numbers
    sequenceNumberStart: 10, // first sequence number
    sequenceNumberIncrement: 5, // increment for sequence numbers
    optionalStop: true, // optional stop
    separateWordsWithSpace: true // specifies that the words should be separated with a white space
    rotaryTableAxis: "none" // none, X, Y, Z, -X, -Y, -Z
};
```

The default values for the variables can be a number, boolean, or a text string.

The *propertyDefinitions* object gives you control on how you want the properties displayed to the user in the Property Table. There should be a matching entry in the *propertyDefinitions* object for every entry
in the properties object. If there is not a matching entry, then the variable name from the properties object will be displayed and this property will not have tool tip text associated with it.

```javascript
// user-defined property definitions
propertyDefinitions = {
    writeMachine: {title: "Write machine",
                  description: "Output the machine settings in the header of the code.",
                  group: 0, type: "boolean"},
    writeTools: {title: "Write tool list", description: "Output a tool list in the header of the code.",
                 group: 0, type: "boolean"},
    preloadTool: {title: "Preload tool",
                  description: "Preloads the next tool at a tool change (if any).",
                  type: "boolean"},
    showSequenceNumbers: {title: "Use sequence numbers",
                          description: "Use sequence numbers for each block of outputted code.",
                          group: 1, type: "boolean"},
    sequenceNumberStart: {title: "Start sequence number", description: "Sequence number start value",
                          group: 1, type: "integer"},
    sequenceNumberIncrement: {title: "Sequence number increment",
                              description: "The amount by which the sequence number is incremented by in each block.",
                              group: 1, type: "integer"},
    optionalStop: {title: "Optional stop",
                   description: "Outputs optional stop code during when necessary in the code.",
                   type: "boolean"},
    separateWordsWithSpace: {title: "Separate words with space",
                             description: "Adds spaces between words if 'yes' is selected.",
                             type: "boolean"},
    rotaryTableAxis: {
        title: "Rotary table axis",
        description: "Selects the rotary table axis orientation.",
        type: "enum",
        values: {
            {title: "No rotary", id: "none"},
            {title: "Along +X", id: "x"},
            {title: "Along +Y", id: "y"},
            {title: "Along +Z", id: "z"},
            {title: "Along -X", id: "-x"},
            {title: "Along -Y", id: "-y"},
            {title: "Along -Z", id: "-z"}
        }
    }
};
```

The following table describes the supported variable properties in the propertyDefinitions object. It is important that the format of the propertyDefinitions object follows the above example, where the name of the variable is first, followed by a colon (:), and the properties enclosed in braces ({}). The values property is an array and its properties must be enclosed in brackets ([{}]).
<table>
<thead>
<tr>
<th><strong>Property</strong></th>
<th><strong>Description</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>title</td>
<td>Description of the variable displayed in the User Interface within the Property column.</td>
</tr>
<tr>
<td>description</td>
<td>A description of the variable displayed as the tool tip when the mouse is positioned over this variable.</td>
</tr>
<tr>
<td>group</td>
<td>The group number that this variable belongs to. All variables with the same group number will be displayed together in the User Interface. (This property is not supported as of this writing)</td>
</tr>
<tr>
<td>type</td>
<td>Defines the input type. The input types are described in the following table.</td>
</tr>
<tr>
<td>values</td>
<td>Contains a list (array) of choices for the <em>enum</em> or <em>integer</em> input type. It is not valid with any other input type.</td>
</tr>
</tbody>
</table>

**Property Table User Interface Definition**

<table>
<thead>
<tr>
<th><strong>Input Type</strong></th>
<th><strong>Description</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>&quot;integer&quot;</td>
<td>Integer value</td>
</tr>
<tr>
<td>&quot;number&quot;</td>
<td>Real value</td>
</tr>
<tr>
<td>&quot;spatial&quot;</td>
<td>Real value</td>
</tr>
<tr>
<td>&quot;angle&quot;</td>
<td>Angular value in degrees</td>
</tr>
<tr>
<td>&quot;boolean&quot;</td>
<td>true or false</td>
</tr>
<tr>
<td>&quot;string&quot;</td>
<td>Text string</td>
</tr>
<tr>
<td>&quot;enum&quot;</td>
<td>The <em>enum</em> input type defines this variable as having fixed choices associated with it. These choices are defined individually in the <em>values</em> property array. An <em>enum</em> input type should be defined using string values.</td>
</tr>
</tbody>
</table>

**Property Table Input Types**

<table>
<thead>
<tr>
<th><strong>Values Property</strong></th>
<th><strong>Description</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>title</td>
<td>The text of the choice item displayed in the User Interface for this variable.</td>
</tr>
<tr>
<td>id</td>
<td>The value that will be returned in the variable when the post processor is called. All references to this property, e.g. <em>properties.rotaryTableAxis</em>, in the post processor should expect only one of these <em>id</em> values as its value. The <em>id</em> must be a text string when associated with an <em>enum</em> input type or an integer value when associated with an <em>integer</em>.</td>
</tr>
</tbody>
</table>

**Enum Choices Properties**

**Entry Functions 4-65**
4.1.3 Format Definitions

The format definitions area of the global section is used to define the formatting of codes output to the NC file. It consists of the format definitions (createFormat) as well as definitions that determine when the codes will be output or suppressed (createModal, createVariable, createReferenceVariable, createIncrementalVariable).

The createFormat command defines how codes are formatted before being output to the NC file. It can be used to create a complete format for an output code, including the letter prefix, or to create a primary format that is referenced with the output definitions. It has the following syntax.

\[
\text{createFormat}({\text{specifier}:value, \text{specifier}:value, \ldots});
\]

createFormat Syntax

The specifiers must be enclosed in braces ({})) and contain the specifier name followed by a colon (:) and then by a value. Multiple specifiers are separated by commas.

<table>
<thead>
<tr>
<th>Specifier</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>prefix</td>
<td>Defines the prefix of the output value as a text string. The prefix should only be defined if this is a standalone format and is not used for multiple output definitions.</td>
</tr>
<tr>
<td>suffix</td>
<td>Defines the suffix of the output value as a text string. The suffix should only be defined if this is a standalone format and is not used for multiple output definitions.</td>
</tr>
<tr>
<td>decimals</td>
<td>Defines the number digits to the right of the decimal point to output. The default is 6.</td>
</tr>
<tr>
<td>forceDecimal</td>
<td>When set to \textit{true} the decimal point will always be included with the formatted number. \textit{false} will remove the decimal point for integer values.</td>
</tr>
<tr>
<td>forceSign</td>
<td>When set to \textit{true} will force the output of a plus (+) sign on positive numbers. The default is \textit{false}.</td>
</tr>
<tr>
<td>width</td>
<td>Specifies the minimum width of the output string. If the formatted value's width is less than the \textit{width} value, then the start of the number will either be</td>
</tr>
</tbody>
</table>
Specifier | Value
--- | ---
 | filled with spaces or zeros depending on the value of `zeropad`. If the format is used to output a code to the NC file be sure to set `zeropad` to `true`, otherwise the prefix and value could be separated by spaces. The width of the output string includes the decimal point when it is included in the number, but not the sign of the number. The default is 0.
zeropad | When set to `true` will fill the beginning of the output string with zeros to match the specified width. If `width` is not specified or the output string is longer than `width`, then no zeros will be added. The default is `false`.
trim | When set to `true` the trailing zeros will be trimmed from the right of the decimal point. The default is `true`.
trimLeadZero | When set to `true` will trim the lead zero from a floating-point number if the number is fractional, e.g. 0.123 instead of 0.123. The default is `false`.
scale | Defines a scale factor to multiply the value by prior to formatting it for output. `scale` can be a number or a number designator, such as `DEG`. The default is 1.
offset | Defines a number to add to the value prior to formatting it for output. The default is 0.
separator | Defines the character to use as the decimal point. The default is `.`.
inherit | Inherits all properties from an existing `format`.

### createFormat Properties

Once a `format` is created, it can be used to create a formatted text string of a value that matches the properties in the defined `format`. The following table describes the functions defined in the `format` object.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>areDifferent(a, b)</td>
<td>Returns <code>true</code> if the input values are different after being formatted.</td>
</tr>
<tr>
<td>format(value)</td>
<td>Returns the formatted text string representation of the number.</td>
</tr>
<tr>
<td>getError(value)</td>
<td>Returns the inverse of the remaining portion of the value that is not formatted for the number. For example, if the formatted value of 4.5005 is &quot;4.500&quot;, then the value returned from <code>getError</code> will be -0.0005.</td>
</tr>
<tr>
<td>getMinimumValue()</td>
<td>Returns the minimum value that can be formatted using this <code>format</code>, for example, 1 for <code>decimals:0</code>, .1 for <code>decimals:1</code>, etc.</td>
</tr>
<tr>
<td>getResultingValue(value)</td>
<td>Returns the real value that the formatted output text string represents.</td>
</tr>
<tr>
<td>isSignificant(value)</td>
<td>Returns true if the value will be non-zero when formatted.</td>
</tr>
</tbody>
</table>

### format Functions

```javascript
var xFormat = createFormat({decimals:3, trim: false, forceSign: true});
xFormat.format(4.5); // returns "+4.500"
xFormat.areDifferent(9.123, 9.1234); // returns false, both numbers are 9.123
xFormat.getMinimumValue(); // returns 0.001
xFormat.isSignificant(.0005); // returns true (rounded to .001)
xFormat.isSignificant(.00049); // returns false
```
4.1.4 Output Variable Definitions

The format object is used to format values, but has no connection to the output of the variable, except for formatting a text string that could be output. It does not know what the last output variable is, which is important when you do not want to output a code if the value has not changed from its previous output value.

The createVariable, createModal, createReferenceVariable, and createIncrementalVariable functions create output objects that are used to control the output of a code. The createVariable and createModal objects are used to output codes/registers only when they change from the previous output value, the createReferenceVariable is used to output values when they are different from a specified reference value, and the createIncrementalVariable is used for the output of incremental values, i.e. the output value will be an incremental value based on the previous value and the input value.

The createVariable and createModal objects can be used interchangeably since they both output only the values that have changed. In a post processor you will see that the createModal object is used for the output of G-code or M-code modal groups, where multiple codes can be output in a single block and will only be output when the code changes value from the previous code in this group. The createVariable object is used for all other code/register output such as the axes registers, spindle speed, feedrates, etc. The only difference in these objects the functions that belong to them, for example you can disable the output of a Variable, but not of a Modal.

You can use the createFormat object for codes/registers that should be output whenever they are encountered in the post, just be sure to add the prefix to the definition.

```
createVariable({specifier:value, specifier:value, ...}, format);
createModal({specifier:value, specifier:value, ...}, format);
createReferenceVariable({specifier:value, specifier:value, ...}, format);
createIncrementalVariable({specifier:value, specifier:value, ...}, format);
```
The specifiers must be enclosed in braces ({})) and contain the specifier name followed by a colon (:) and then by a value. Multiple specifiers are separated by commas. A format object is provided as the second parameter. Some of the specifiers are common to all three objects and some to a particular object, as listed in the following table.

<table>
<thead>
<tr>
<th>Specifier</th>
<th>Object</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>prefix</td>
<td>(all)</td>
<td>Text string that overrides the prefix defined in format.</td>
</tr>
<tr>
<td>force</td>
<td>(all)</td>
<td>When set to true forces the formatting of the value even if it does not change from the previous value. The default is false.</td>
</tr>
<tr>
<td>onchange</td>
<td>createVariable</td>
<td>Defines the method to be invoked when the formatting of the value results in output.</td>
</tr>
<tr>
<td></td>
<td>createModal</td>
<td></td>
</tr>
<tr>
<td>suffix</td>
<td>createModal</td>
<td>Text string that overrides the suffix defined in format.</td>
</tr>
<tr>
<td>first</td>
<td>createIncrementalVariable</td>
<td>Defines the initial value of an incremental variable. You will also have to call the .format(first) function after creating the IncrementalVariable to properly store the initial value.</td>
</tr>
</tbody>
</table>

Output Variable Properties

The `onchange` property typically defines a function that is called whenever the formatting of the variable results in an output text string, such as when the value changes or is forced out. The following example will force out the gMotionModal code whenever the plane code is changed.

```javascript
var gPlaneModal = createModal({
  onchange: function () {gMotionModal.reset();}
}, gFormat);
```

### onChange Usage

Once an output variable is created, it can be used to create a formatted text string for output. The following table describes the functions assigned to the output variable objects. The functions are properties of the defined `variable` object.

<table>
<thead>
<tr>
<th>Function</th>
<th>Object</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>disable()</td>
<td>Variable</td>
<td>Disables this variable from being output. Will cause the return value from the format function to always be a blank string (&quot;&quot;&quot;).</td>
</tr>
<tr>
<td></td>
<td>ReferenceVariable</td>
<td></td>
</tr>
<tr>
<td></td>
<td>IncrementalVariable</td>
<td></td>
</tr>
<tr>
<td>enable()</td>
<td>Variable</td>
<td>Enables this variable for output. This is the default condition when the variable is created.</td>
</tr>
<tr>
<td></td>
<td>Reference Variable</td>
<td></td>
</tr>
<tr>
<td></td>
<td>IncrementalVariable</td>
<td></td>
</tr>
<tr>
<td>format(value [,ref])</td>
<td>(all)</td>
<td>Returns the formatted text string representation of the number. Can return a blank string if the value is the same as the stored value in the Variable and Modal objects, the same as the reference value in the ReferenceVariable object, or generates</td>
</tr>
<tr>
<td>Function</td>
<td>Object</td>
<td>Description</td>
</tr>
<tr>
<td>---------------</td>
<td>-------------------------</td>
<td>---------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>getCurrent()</td>
<td>Variable</td>
<td>Returns the value currently stored in this variable.</td>
</tr>
<tr>
<td>isEnabled()</td>
<td>Variable</td>
<td>Returns true if this variable is enabled for output.</td>
</tr>
<tr>
<td>reset()</td>
<td>Variable</td>
<td>Forcés the output of the formatted text string on the next call to format, overriding the rules for not outputting a value.</td>
</tr>
<tr>
<td>setPrefix()</td>
<td>(all)</td>
<td>Overrides the prefix of the variable.</td>
</tr>
<tr>
<td>setSuffix()</td>
<td>Modal</td>
<td>Overrides the suffix of the variable.</td>
</tr>
</tbody>
</table>

**Variable Functions**

```javascript
var xyzFormat = createFormat({decimals:3, forceDecimal:true});
var xOutput = createVariable({prefix:"X"}, xyzFormat);
xOutput.format(4.5); // returns "X4.5"
xOutput.format(4.5); // returns "" (4.5 is currently stored in the xOutput variable)
xOutput.reset();    // force xOutput on next formatting
xOutput.format(4.5); // returns "X4.5"
xOutput.disable();   // disable xOutput formatting
xOutput.format(1.2); // returns "" since it is disabled

var gFormat = createFormat({prefix:"G", decimals:0, width:2, zeropad:true});
var gMotionModal = createModal({force:true}, gFormat);
gMotionModal.format(0); // returns G00
gMotionModal.format(0); // returns G00 (force is set to 'true')
gMotionModal.format.setPrefix("G1=");
gMotionModal.format.setSuffix("*");
gMotionModal.format(1); // returns "G1=01*"

var iOutput = createReferenceVariable({prefix:"I", forceDecimal}, xyzFormat);
iOutput.format(.001, 0); // returns "I0.001"
iOutput.format(.0001, 0); // returns ""

var zOutput = createIncrementalVariable({prefix:"Z", first:.5}, xyzFormat);
zOutput.format(.5); // after creating the IncrementalVariable you must call the format function
// with the same value as 'first' to properly set the initial value
zOutput.format(1.2); // returns "Z0.7"
```
4.1.5 Fixed Settings

The fixed settings area of the global section defines settings in the post processor that enable features that may change from machine to machine, but are not common enough to place in the Property Table. These settings are usually not modified by the post processor, but can be modified to enable features on your machine that are disabled in a stock post processor or vice versa.

```javascript
// fixed settings
var firstFeedParameter = 500;
var useMultiAxisFeatures = false;
var forceMultiAxisIndexing = false; // force multi-axis indexing for 3D programs
var maximumLineLength = 80; // the maximum number of characters allowed in a line
var minimumCyclePoints = 5; // min number of points in cycle operation to consider for subprogram
var WARNING_WORK_OFFSET = 0;
var ANGLE_PROBE_NOT_SUPPORTED = 0;
var ANGLE_PROBE_USE_ROTATION = 1;
var ANGLE_PROBE_USE_CAXIS = 2;
```

4.1.6 Collected State

The collected state area of the global section contains global variables that will be changed during the execution of the post processor and are either referenced in multiple functions or need to maintain their values between calls to the same function.

```javascript
// collected state
var sequenceNumber;
var currentWorkOffset;
```

4.2 onOpen

```javascript
function onOpen() {
```

The `onOpen` function is called at start of each CAM operation and can be used to define settings used in the post processor and output the startup blocks.

1. Define settings based on properties
2. Define the multi-axis machine configuration
3. Output program name and header
4. Perform checks for duplicate tool numbers and work offsets
5. Output initial startup codes

### 4.2.1 Define Settings Based on Post Properties

The fixed settings section at the top of the post processor contain settings that are fixed and will not be changed during the processing of the intermediate file. Settings and variables that are dependant on the properties defined in the Property Table are defined in the `onOpen` function, since this is the function called when the post processor first starts.

Some of the variables that may be defined here are the maximum circular sweep, starting sequence number, formats, properties that can be changed using a Manual NC command, etc.

```javascript
if (properties.useRadius) {
    maximumCircularSweep = toRad(90); // avoid potential center calculation errors for CNC
}

// define sequence number output
if (properties.sequenceNumberOperation) {
    properties.showSequenceNumbers = false;
}
sequenceNumber = properties.sequenceNumberStart;

// separate codes with a space in output block
if (!properties.separateWordsWithSpace) {
    setWordSeparator('');
}

// Manual NC command can change the transfer type
transferType = parseToggle(properties.transferType, "PHASE", "SPEED");
```

### Defining Dynamic Variables in the `onOpen` Function

The majority of machines on the market today accept input in both inches and millimeters. It is possible that your machine must be programmed in only one unit. If this is the case, then you can define the `unit` variable in the `onOpen` function to force the output of all relevant information in inches or millimeters.

```javascript
unit = MM; // set output units to millimeters, use IN for inches
```

### 4.2.2 Define the Multi-Axis Configuration

The `onOpen` function contains calls to the functions that will optionally create a hardcode machine configuration and activate the machine configuration, whether it be hardcoded or defined in the CAM.
Entry Functions

system. Following is an example of this code. For a complete description of defining a multi-axis configuration please see the *Multi-Axis Post Processors* chapter.

```javascript
// define and enable machine configuration
gottenMachineConfiguration = (typeof machineConfiguration.isReceived == "function")
    ? machineConfiguration.isReceived() :
        ((machineConfiguration.getDescription() != ")") ||
        machineConfiguration.isMultiAxisConfiguration());
if (typeof defineMachine == "function") {
    defineMachine(); // hardcoded machine configuration
} activateMachine(); // enable the machine optimizations and settings
```

**4.2.3 Output Program Name and Header**

The program name and program comment are defined in the Post Process tab of the CAM setup in HSM. The *programNameIsInteger* variable defined at the top of the program determines if the program name needs to be a number or can be a text string.

writeLn("%"); // output start of NC file
if (programName) {
    var programId;
    try {
        programId = getAsInt(programName);
    } catch(e) {
        error(localize("Program name must be a number."));
        return;
    }
    if (!((programId >= 1) && (programId <= 99999))) {
        error(localize("Program number is out of range.");
```
return;
}
writeln("O" + oFormat.format(programId) +
conditional(programComment, " " + formatComment(programComment.substr(0,
maximumLineLength - 2 - ("O" + oFormat.format(programId)).length - 1)))
);
lastSubprogram = programId;
} else {
  error(localize("Program name has not been specified."));
  return;
}

Output the Program Name as an Integer and Program Comment

Some machines don't use a program number and accept the program name as a comment.

writeln("%"); // output start of NC file
if (programName) {
  writeComment(programName);
} if (programComment) {
  writeComment(programComment);
}

Output the Program Name as a Comment

The program header can consist of the output filename, version numbers, the run date and time, the
description of the machine, and the list of tools used in the program.

// Output current run information
if (hasParameter("generated-by") && getParameter("generated-by")) {
  writeComment("      " + localize("CAM") + ": " + getParameter("generated-by"));
} if (hasParameter("document-path") && getParameter("document-path")) {
  writeComment("      " + localize("Document") + ": " + getParameter("document-path"));
} var eos = longDescription.indexOf(".");
writeComment(localize(" Post Processor: ") + ((eos == -1) ?
  longDescription : longDescription.substr(0, eos + 1)));
if (typeof getHeaderVersion == "function") && getHeaderVersion() {
  writeComment("   " + localize("Post version") + ": " + getHeaderVersion());
} if (typeof getHeaderDate == "function") && getHeaderDate() {
  writeComment("   " + localize("Post modified") + ": " + getHeaderDate());
} var d = new Date(); // output current date and time
writeComment("           " + localize("Date") + ": "+ d.toLocaleDateString() + " " +
// dump machine configuration
var vendor = machineConfiguration.getVendor();
var model = machineConfiguration.getModel();
var description = machineConfiguration.getDescription();

if (properties.writeMachine && (vendor || model || description)) {
    writeComment(localize("Machine"));
    if (vendor) {
        writeComment("  " + localize("vendor") + ": " + vendor);
    }
    if (model) {
        writeComment("  " + localize("model") + ": " + model);
    }
    if (description) {
        writeComment("  " + localize("description") + ": " + description);
    }
}

Output Machine Information

In the above code sample, the machine information is retrieved from the machineConfiguration, but a machine configuration file is not always available to the post processor, so it is possible to hard code the machine description.

machineConfiguration.setVendor("Doosan");
machineConfiguration.setModel("Lynx");
machineConfiguration.setDescription(description);

Defining the Machine Information

// dump tool information
if (properties.writeTools) {
    var zRanges = {};
    if (is3D()) {
        var numberOfSections = getNumberOfSections();
        for (var i = 0; i < numberOfSections; ++i) {
            var section = getSection(i);
            var zRange = section.getGlobalZRange();
            var tool = section.getTool();
            if (zRanges[tool.number]) {
                zRanges[tool.number].expandToRange(zRange);
            } else {
                zRanges[tool.number] = zRange;
            }
        }
    }
}
var tools = getToolTable();
if (tools.getNumberOfTools() > 0) {
    for (var i = 0; i < tools.getNumberOfTools(); ++i) {
        var tool = tools.getTool(i);
        var comment = "T" + toolFormat.format(tool.number) + " " +
                        "D=" + xyzFormat.format(tool.diameter) + " " +
                        localize("CR") + "=" + xyzFormat.format(tool.cornerRadius);
        if ((tool.taperAngle > 0) && (tool.taperAngle < Math.PI)) {
            comment += " " + localize("TAPER") + "+" + taperFormat.format(tool.taperAngle) +
                       localize("deg");
        }
        if (zRanges[tool.number]) {
            comment += " " + localize("ZMIN") + "=" +
                       xyzFormat.format(zRanges[tool.number].getMinimum());
        }
        comment += " " + getToolTypeName(tool.type);
        writeComment(comment);
    }
}

4.2.4 Performing General Checks

Basic checks for using duplicate tool numbers, undefined work offsets, and other requirements can be done in the onOpen function since all operations can be accessed at any time during post processing.

if (false) {
    // set to true to check for duplicate tool numbers w/different cutter geometry
    // check for duplicate tool number
    for (var i = 0; i < getNumberOfSections(); ++i) {
        var sectioni = getSection(i);
        var toolsi = sectioni.getTool();
        for (var j = i + 1; j < getNumberOfSections(); ++j) {
            var sectionj = getSection(j);
            var toolsj = sectionj.getTool();
            if (toolsi.number === toolsj.number) {
                if (xyzFormat.areDifferent(toolsi.diameter, toolsj.diameter) ||
                    xyzFormat.areDifferent(toolsi.cornerRadius, toolsj.cornerRadius) ||
                    abcFormat.areDifferent(toolsi.taperAngle, toolsj.taperAngle) ||
                    (toolsi.numberOfFlutes != toolsj.numberOfFlutes)) {
                    error(
                        subst(
                            localize("Using the same tool number for different cutter geometry for operation '%1' and
'\%2'."),

"%1", tooli.number); 
                    subst(
                        localize("Using the same tool number for different cutter geometry for operation '%1' and
'\%2'."),

"%2", toolsj.number);
                }
            }
        }
    }
}
4.2.5 Output Initial Startup Codes

Codes that set the machine to its default condition are usually output at the beginning of the NC file. These codes could include the units setting, absolute mode, the feedrate mode, etc.

```plaintext
// output default codes
writeBlock(gAbsIncModal.format(90), gFeedModeModal.format(94), gPlaneModal.format(17),
gFormat.format(49), gFormat.format(40), gFormat.format(80));

// output units code
switch (unit) {
  case IN:
    writeBlock(gUnitModal.format(20));
    break;
  case MM:
    writeBlock(gUnitModal.format(21));
    break;
}
```

Check for Duplicate Tool Numbers using Different Cutter Geometry

// don't allow WCS 0 unless it is the only WCS used in the program
if ((getNumberOfSections() > 0) && (getSection(0).workOffset == 0)) {
  for (var i = 0; i < getNumberOfSections(); ++i) {
    if (getSection(i).workOffset > 0) {
      error(localize("Using multiple work offsets is not possible if the initial work offset is 0."));
      return;
    }
  }
}

Check for Work Offset 0 when Multiple Work Offsets are Used in Program
4.3 **onSection**

```javascript
function onSection() {

The `onSection` function is called at start of each CAM operation and controls the output of the following blocks.

1. End of previous section
2. Operation comments and notes
3. Tool change
4. Work plane
5. Initial position

The first part of `onSection` determines if there is a change in the tool being used and if the Work Coordinate System offset or Work Plane is different from the previous section. These settings determine the output required between operations.

```javascript
var insertToolCall = isFirstSection() ||
  currentSection.getForceToolChange && currentSection.getForceToolChange() ||
  (tool.number != getPreviousSection().getTool().number);

var retracted = false; // specifies that the tool has been retracted to the safe plane
var newWorkOffset = isFirstSection() ||
  !isSameDirection(getPreviousSection().getGlobalFinalToolAxis(),
  currentSection.getGlobalInitialToolAxis());
```

Tool Change, Work Coordinate System Offset, and Work Plane Settings
4.3.1 Ending the Previous Operation

You would expect that the NC blocks output at the end of an operation to be output in the onSectionEnd function, but in most posts, this is handled in onSection and for the final operation, in the onClose function. This code will typically stop the spindle, turn off the coolant, and retract the tool.

```c
if (insertToolCall || newWorkOffset || newWorkPlane) {

    // stop spindle before retract during tool change
    if (insertToolCall && !isFirstSection()) {
        onCommand(COMMAND_STOP_SPINDLE);
    }

    // retract to safe plane
    retracted = true;
    writeRetract(Z);
}
...
...
    onCommand(COMMAND_COOLANT_OFF);

    if (!isFirstSection() && properties.optionalStop) {
        onCommand(COMMAND_OPTIONAL_STOP);
    }

Ending the Previous Operation

The code to retract the tool can vary from post to post, depending on the controller model and the machine configuration. It can output an absolute move to the machine home position, for example using G53, or move to a clearance plane relevant to the current work offset, for example G00 Z5.0.

The onSectionEnd section has an example of ending the operation when not done in the onSection function.

4.3.2 Operation Comments and Notes

The operation comment is output in the onSection function and optionally notes that the user attached to the operation.
if (hasParameter("operation-comment")) {
    var comment = getParameter("operation-comment");
    if (comment) {
        writeComment(comment);
    }
}

The output of the operation notes is normally handled by the post processor property \textit{showNotes}.
// user-defined properties
properties = {
    ...
    showNotes: false, // specifies that operation notes should be output
    ...
}

Define the showNotes Property

if (properties.showNotes && hasParameter("notes")) {
    var notes = getParameter("notes");
    if (notes) {
        var lines = String(notes).split("\n");
        var r1 = new RegExp("^[\s]+", "g");
        var r2 = new RegExp("[\s]+$", "g");
        for (line in lines) {
            var comment = lines[line].replace(r1, "").replace(r2, "");
            if (comment) {
                writeComment(comment);
            }
        }
    }
}

Output Operation Notes

4.3.3 Tool Change

Tool change blocks are output whenever a new tool is loaded in the spindle or the tool change is forced, either by a Manual NC Force tool change command or internally, for example when a safe start is forced at each operation. The tool change blocks usually contain the following information.

1. Tool number and tool change code
2. Tool comment
3. Comment containing lower Z-limit for tool (optional)
4. Selection of next tool
5. Spindle speed and direction
6. Coolant codes
The Length Offset value is usually output with the Initial Position as described further in this chapter. The Diameter Offset value is output with a motion block in onLinear. All other tool parameters are output in the tool change code.

```java
if (insertToolCall) {
    ...
    if (tool.number > numberOfToolSlots) {
        warning(localize("Tool number exceeds maximum value.");
    }
    writeBlock("T" + toolFormat.format(tool.number), mFormat.format(6));
    if (tool.comment) {
        writeComment(tool.comment);
    }
    ...
}
```

Output Tool Change and Tool Comment

You will have to change the setting of `showToolZMin` to `true` if you want the lower Z-limit comment output at a tool change.

```javascript
var showToolZMin = false; // set to true to enable output of lower Z-limit
if (showToolZMin) {
    if (is3D()) {
        var numberOfSections = getNumberOfSections();
        var zRange = currentSection.getGlobalZRange();
        var number = tool.number;
        for (var i = currentSection.getId() + 1; i < numberOfSections; ++i) {
            var section = getSection(i);
            if (section.getTool().number != number) {
                ...
            }
        }
    }
}
```
The selection of the next tool is optional and is controlled by the post processor property `preloadTool`.

```javascript
// user-defined properties
properties = {
  ...
  preloadTool: true, // preloads next tool on tool change if any
  ...
}
```

**Define the preloadTool Property**

The first tool will be loaded on the last operation of the program.

```javascript
if (properties.preloadTool) {
  var nextTool = getNextTool(tool.number);
  if (nextTool) {
    writeBlock("T" + toolFormat.format(nextTool.number));
  } else {
    // preload first tool
    var section = getSection(0);
    var firstToolNumber = section.getTool().number;
    if (tool.number != firstToolNumber) {
      writeBlock("T" + toolFormat.format(firstToolNumber));
    }
  }
}
```

**Preload the Next Tool**

The spindle codes will be output with a tool change and if the spindle speed changes.

```javascript
if (insertToolCall ||
  isFirstSection() ||
  (rpmFormat.areDifferent(tool.spindleRPM, sOutput.getCurrent())) ||
  (tool.clockwise != getPreviousSection().getTool().clockwise)) {
  if (tool.spindleRPM < 1) {
    error(localize("Spindle speed out of range.");
    return;
  }
```
if (tool.spindleRPM > 99999) {
    warning(localize("Spindle speed exceeds maximum value."));
}
writeBlock(
    sOutput.format(tool.spindleRPM), mFormat.format(tool.clockwise ? 3 : 4)
);
}

Output Spindle Codes

You will find different methods of outputting the coolant codes in the various posts. The latest method uses a table to define the coolant on and off codes. The table is defined just after the properties table at the top of the post processor. You can define a single code for each coolant mode or multiple codes using an array. When adding or changing the coolant codes supported by your machine, this is the only area of the code that needs to be changed.

```javascript
var singleLineCoolant = false; // specifies to output multiple coolant codes in one line rather than in separate lines
// samples:
// {id: COOLANT_THROUGH_TOOL, on: 88, off: 89}
// {id: COOLANT_THROUGH_TOOL, on: [8, 88], off: [9, 89]}
var coolants = [
    {id: COOLANT_FLOOD, on: 8},
    {id: COOLANT_MIST},
    {id: COOLANT_THROUGH_TOOL, on: 88, off: 89},
    {id: COOLANT_AIR},
    {id: COOLANT_AIR_THROUGH_TOOL},
    {id: COOLANT_SUCTION},
    {id: COOLANT_FLOOD_MIST},
    {id: COOLANT_FLOOD_THROUGH_TOOL, on: [8, 88], off: [9, 89]},
    {id: COOLANT_OFF, off: 9}
];
```

Coolant Definition Table

The coolant code is output using the following code in `onSection`.

```javascript
// set coolant after we have positioned at Z
setCoolant(tool.coolant);
```

Output of Coolant Codes

The `setCoolant` function will output each coolant code in separate blocks. It does this by calling the `getCoolantCodes` function to obtain the coolant code(s) and using `writeBlock` to output each individual coolant code. Both of these functions are generic in nature and should not have to be modified.

It may be that you want to output the coolant codes(s) in a block with other codes, such as the initial position or the spindle speed. In this case you can call `getCoolantCodes` directly in the `onSection`
function and add the output of the coolant codes to the appropriate block. The following example will output the coolant codes with the initial position of the operation.

```javascript
var coolantCodes = getCoolantCodes(tool.coolant);
var initialPosition = getFramePosition(currentSection.getInitialPosition());
writeBlock(
  gAbsIncModal.format(90),
  gMotionModal.format(0),
  xOutput.format(initialPosition.x),
  yOutput.format(initialPosition.y),
  coolantCodes,
);
```

getCoolantCodes Function Supports Multiple Codes for Single Coolant Mode

### 4.3.4 Work Coordinate System Offsets

The active Work Coordinate System (WCS) offset is defined in the CAM setup dialog. It defaults to 0 and if you are only using a single WCS, this should be fine as the post processor will convert it to 1. If you are using multiple WCS, then you will need to explicitly define the WCS or the post processor will fail when a default of 0 is used for one setup and a positive number is used for another setup. You can override the WCS defined in the setup in either a folder or pattern.

WCS codes are output when a new tool is used for the operation or when the WCS offset number used is changed. WCS offsets are typically controlled using the G54 to G59 codes and possibly an extended syntax for handling work offsets past 6.

```javascript
// wcs
```
if (insertToolCall) { // force work offset when changing tool
    currentWorkOffset = undefined;
}
var workOffset = currentSection.workOffset;
if (workOffset == 0) { // change work offset of 0 to 1
    warningOnce(localize("Work offset has not been specified. Using G54 as WCS."),
    WARNING_WORK_OFFSET);
    workOffset = 1;
}
if (workOffset > 0) {
    if (workOffset > 6) { // handle work offsets greater than 6
        var code = workOffset - 6;
        if (code > 3) {
            error(localize("Work offset out of range."));
            return;
        }
        if (workOffset != currentWorkOffset) {
            forceWorkPlane();
            writeBlock(gFormat.format(59) + "." + code); // G59.n
            currentWorkOffset = workOffset;
        }
    } else { // handle work offsets 1-6
        if (workOffset != currentWorkOffset) {
            forceWorkPlane();
            writeBlock(gFormat.format(53 + workOffset)); // G54->G59
            currentWorkOffset = workOffset;
        }
    }
}

Output the Work Coordinate System Offset Number

4.3.5 Work Plane – 3+2 Operations
3+2 operations are supported by defining a tool orientation for the operation. This tool orientation is referenced as the Work Plane in the post processor. The tool orientation is defined in the Geometry tab of the operation.
The output for a Work Plane will either be the rotary axes positions or the definition of the Work Plane itself as Euler angles. For machine controls that support both formats the useMultiAxisFeatures variable determines the Work Plane method to use. This variable, along with other variables that control 3+2 operations, is defined with the machine configuration settings and functions towards the top of the post processor.

```javascript
// Start of machine configuration logic
...
var useMultiAxisFeatures = false; // enable to use control enabled tilted plane
var useABCPrepositioning = false; // enable to preposition rotary axes prior to tilted plane output
var forceMultiAxisIndexing = false; // force multi-axis indexing for 3D programs
var eulerConvention = EULER_ZXZ_R; // euler angle convention for 3+2 operations
```

Definition of Variables for Tilted Plane Support
The **eulerConvention** setting is passed to the `getEuler2` function and is used to calculate the Euler angles for the Work Plane. It specifies the order of the primary axis rotations that the machine control requires and can be one of the values in the following table.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Parameter</th>
<th>Parameter</th>
<th>Parameter</th>
</tr>
</thead>
<tbody>
<tr>
<td>EULER_XYZ_R</td>
<td>EULER_XY_R</td>
<td>EULER_XZX_R</td>
<td>EULER_XZY_R</td>
</tr>
<tr>
<td>EULER_YXY_R</td>
<td>EULER_YX_R</td>
<td>EULER_YZX_R</td>
<td>EULER_YZY_R</td>
</tr>
<tr>
<td>EULER_ZXY_R</td>
<td>EULER_ZX_R</td>
<td>EULER_ZYX_R</td>
<td>EULER_ZYZ_R</td>
</tr>
<tr>
<td>EULER_XYZ_S</td>
<td>EULER_XY_S</td>
<td>EULER_XZX_S</td>
<td>EULER_XZY_S</td>
</tr>
<tr>
<td>EULER_YXY_S</td>
<td>EULER_YZ_S</td>
<td>EULER_YXZ_S</td>
<td>EULER_YZY_S</td>
</tr>
<tr>
<td>EULER_ZXY_S</td>
<td>EULER_XZ_S</td>
<td>EULER_ZYX_S</td>
<td>EULER_ZYZ_S</td>
</tr>
</tbody>
</table>

**Euler Angle Order**

Check the Programming Manual for your machine to determine if Euler angles are supported and the order of rotations. The _R (rotated) variants of the Euler angles will use the modified orientation after each rotation for each axis. The _S (static) variants will use the original coordinate system for all rotations and is sometimes referred to as pitch, row, yaw.

The `useMultiAxisFeatures` and `useABCPrepositioning` variables can be controlled from the post processor properties, simply adding a property with the same name. The `activateMachine` function automatically checks for this property and will use it if it is defined.

```javascript
properties = {
  ...
  useMultiAxisFeatures: {
    title: "Use G68.2",
    description: "Enable to output G68.2 blocks for 3+2 operations, disable to output rotary angles.",
    type: "boolean",
    value: true,
    scope:['"machine", "post"],
    group:"multiaxis"},
```

**Variables that Control the Output of 3+2 Operations**

- **useMultiAxisFeatures**: Enable to use the tilted plane feature of the control. Disable to output the rotary axis positions for 3+2 operations.
- **useABCPrepositioning**: Enable to position the rotary axes prior to the output of the tilted plane. Disable to only output the tilted plane. This variable is only used when `useMultiAxisFeatures` is set to `true`.
- **forceMultiAxisIndexing**: Forces the output of the rotary axes/tilted plane when the program is purely 3-axis. Disabling this variable will not output the rotary axis positions if the entire program is 3-axis.
- **eulerConvention**: Defines the order of the Euler angle calculations that is required by the machine for tilted plane output.
The logic that controls the Work Plane calculation is usually found in the `defineWorkPlane` function but can also be defined as inline code within the `onSection` function. The preferred method is using the `defineWorkPlane` function, which controls the calculation and output of the rotary angles for multi-axis and 3+2 operations. `defineWorkPlane` will be called from `onSection`.

```javascript
// position rotary axes for multi-axis and 3+2 operations
var abc = defineWorkPlane(_section, true);

// Calling the defineWorkPlane Function
```

The `defineWorkPlane` function is defined as follows and returns the initial rotary positions for multi-axis and 3+2 operations.

```javascript
defineWorkPlane(_section, _setWorkPlane)
```

### Arguments

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>_section</code></td>
<td>The operation (section) used to calculate the rotary angles.</td>
</tr>
<tr>
<td><code>_setWorkPlane</code></td>
<td><code>true</code> = output the rotary angle positions and adjust the output coordinates for the 3+2 rotation. <code>false</code> = don’t output the rotary angle positions. The rotary angles will still be calculated and the output coordinates will be adjusted for the 3+2 rotation.</td>
</tr>
</tbody>
</table>

The `defineWorkPlane` Function

The logic that controls the Work Plane calculation is typically located in the `defineWorkPlane` section, but can be in the `onSection` function for legacy post processors.

```javascript
// use Euler angles for Work Plane
if (useMultiAxisFeatures) {
    var abc = _section.workPlane.getEuler2(eulerConvention);
    cancelTransformation();

// use rotary angles for Work Plane
} else {
    abc = getWorkPlaneMachineABC(_section.workPlane, true);
}

// output the work plane
if (_setWorkPlane) {
```

Entry Functions 4-89
setWorkPlane(abc);
}

### Work Plane Calculations

The function `getWorkPlaneMachineABC` is used to calculate the rotary axes positions that satisfy the Work Plane. It will return the calculated angles of either the rotary axis or tilted plane positions.

#### `getWorkPlaneMachineABC(workPlane, rotate)`

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>workPlane</td>
<td>The work plane matrix used to calculate the rotary-angles/tilted-plane. This variable is typically <code>section.workPlane</code>.</td>
</tr>
<tr>
<td>rotate</td>
<td>Enable to adjust the output coordinates for the work plane orientation. Disable to just calculate the</td>
</tr>
</tbody>
</table>

### The `getWorkPlaneMachineABC` Function

This function is standard from post to post, but there are a couple of areas that are controlled by user defined settings.

The first step is whether you require the rotary axes positions to be output closest to the angles used for the previous Work Plane. This setting is `false` by default, but you can set it to `true` to enable it. You can also define a starting position for the rotary axes so that if the first operation is a 3+2 operation, then it will choose the closest angles to your starting angles.

```javascript
var closestABC = true; // choose closest machine angles
var currentMachineABC = new Vector(0, 0, 0); // set initial angles

function getWorkPlaneMachineABC(workPlane, _rotate) {
    // Select the Closest Machine Angles when Defining the Work Plane Orientation
    The 3+2 operation coordinates may need to be adjusted for the rotary axes. This is done by calling `section.optimize3DPositionsByMachine` with the rotary axes and optimization type. Most posts will use the Tool Control Point (TCP) setting for each axis by using the OPTIMIZE_AXIS setting.

    if (!currentSection.isOptimizedForMachine()) {
        machineConfiguration.setToolLength(addToolLength ? currentSection.getTool().getBodyLength() : 0); // define the tool length for head adjustments
        currentSection.optimize3DPositionsByMachine(machineConfiguration, abc, OPTIMIZE_AXIS);
    }

    // Adjust the Coordinates for the Rotary Axes
    It is important to know that the XYZ coordinates provided to the post processor for 3+2 are in the work plane coordinate system, meaning they are in the XY-plane defined by the work plane. This is fine for machines that support multi-axis features such as G68.2, CYCLE800, etc., but could be incorrect for machines that do not support these features.

    // Calculations
    // The workplane is used to calculate the rotary axes positions that satisfy the
    // angles used for the work plane. This setting is defined set
    // of angles.
    // The first step is whether you require the rotary axes positions to be output closest to the angles used for
    // the previous Work Plane. This setting is `false` by default, but you can set it to `true` to enable it. You can
    // also define a starting position for the rotary axes so that if the first operation is a 3+2 operation, then it
    // will choose the closest angles to your starting angles.
    // function getWorkPlaneMachineABC(workPlane, rotate) {
    //     // Select the Closest Machine Angles when Defining the Work Plane Orientation
    //     The 3+2 operation coordinates may need to be adjusted for the rotary axes. This is done by calling
    //     `section.optimize3DPositionsByMachine` with the rotary axes and optimization type. Most posts will use
    //     the Tool Control Point (TCP) setting for each axis by using the OPTIMIZE_AXIS setting.
    //     if (!currentSection.isOptimizedForMachine()) {
    //         machineConfiguration.setToolLength(addToolLength ? currentSection.getTool().getBodyLength() : 0); // define the tool length for head adjustments
    //         currentSection.optimize3DPositionsByMachine(machineConfiguration, abc, OPTIMIZE_AXIS);
    //     }
    //     // Adjust the Coordinates for the Rotary Axes
    //     It is important to know that the XYZ coordinates provided to the post processor for 3+2 are in the work
    //     plane coordinate system, meaning they are in the XY-plane defined by the work plane. This is fine for
    //     machines that support multi-axis features such as G68.2, CYCLE800, etc., but could be incorrect for
    //     machines that do not support these features.
    // }
```
The `section.optimize3DPositionsByMachine` function is used to calculate the proper coordinates aligned with the defined machine configuration for the specified operation.

```plaintext
section.optimize3DPositionsByMachine(machineConfiguration, abc, optimizeType);
```

Adjust the Coordinates for the Machine Configuration for 3+2 Machining

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>machineConfiguration</td>
<td>The active machine configuration.</td>
</tr>
<tr>
<td>abc</td>
<td>The current rotary axis positions passed as a Vector.</td>
</tr>
<tr>
<td>optimizeType</td>
<td>Optimization type as described in the following table.</td>
</tr>
</tbody>
</table>

**Optimize3DPositionsByMachine Arguments**

<table>
<thead>
<tr>
<th>optimizeType</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>OPTIMIZE_NONE</td>
<td>The coordinates will be the tool tip position (TCP).</td>
</tr>
<tr>
<td>OPTIMIZE_BOTH</td>
<td>The coordinates will be adjusted for the table and head rotations.</td>
</tr>
<tr>
<td>OPTIMIZE_TABLES</td>
<td>The coordinates will be adjusted for the rotary tables.</td>
</tr>
<tr>
<td>OPTIMIZE_HEADS</td>
<td>The coordinates will be adjusted for the rotary heads.</td>
</tr>
<tr>
<td>OPTIMIZE_AXIS</td>
<td>The coordinates will be adjusted based on the TCP setting for each axis as defined in the <code>createAxis</code> command.</td>
</tr>
</tbody>
</table>

**Optimization Types for 3+2 Operations**

If TCP positions are output in a 3+2 operation you will have to ensure that the TCP has been enabled for this operation (G43.4, TRAORI, etc.).

In situations where the tool can become perpendicular to the rotary table it is not possible to control the rotary table position using the Work Plane. You will notice in this case that the table does not move to satisfy the Work Plane rotation, but rather the output points are rotated to satisfy the Work Plane.
You can override this logic and have the rotary table move instead by adding the following code to the TCP setting for 3+2 machining.

```javascript
var tcp = false;
cancelTransformation();
if (tcp) {
    setRotation(W); // TCP mode
} else {
    var O = machineConfiguration.getOrientation(abc);
    var R = machineConfiguration.getRemainingOrientation(abc, W);

    // rotate table if possible to satisfy Work Plane rotation
    var rotate = true;
    var axis = machineConfiguration.GetAxisV();
    if (axis isEnabled() && axis.isTable()) {
        var ix = axis.getCoordinate();
        var rotAxis = axis.getAxis();
        if (isSameDirection(machineConfiguration.getDirection(abc), rotAxis) ||
            isSameDirection(machineConfiguration.getDirection(abc), Vector.product(rotAxis, -1))) {
            var direction = isSameDirection(machineConfiguration.getDirection(abc), rotAxis) ? 1 : -1;
            abc.setCoordinate(ix, Math.atan2(R.right.y, R.right.x) * direction);
            rotate = false;
        }
    }
    if (rotate) {
        setRotation(R);
    }
}
```

**Rotate Table when Tool is Perpendicular to Table**

The logic that controls the Work Plane calculation is typically located in the `defineWorkPlane` section, but can be in the `onSection` function for legacy post processors.

```javascript
var abc = new Vector(0, 0, 0);
// use 5-axis indexing for multi-axis mode
if (!is3D() || machineConfiguration.isMultiAxisConfiguration()) {
    //
    if (currentSection.isMultiAxis()) {
        forceWorkPlane();
        cancelTransformation();
    } else {
        // use Euler angles for Work Plane
        if (useMultiAxisFeatures) {
            var eulerXYZ = currentSection.workPlane.getEuler2(EULER_ZXZ_R);
            abc = new Vector(eulerXYZ.x, eulerXYZ.y, eulerXYZ.z);
            cancelTransformation();
        }
    }
}
```
Work Plane Calculations

You should be aware that the X-axis direction of the Work Plane does affect the Euler angle calculation. The typical method of defining the Work Plane is to keep the X-axis orientation pointing in the positive direction as you look down the Z-axis, but on some table/table style machines this will cause the machining to be on the back side of the table, so in this case you will want the X-axis pointing in the negative direction.

The `setWorkPlane` function does the actual output of the Work Plane and can vary from post processor to post processor, depending on the requirements of the machine control. It will output the calculated Euler angles or rotary axes positions, and in some cases, both. In the following code, G68.2 is used to define the Work Plane using Euler angles.

```javascript
function setWorkPlane(abc) {
  if (is3D() && !machineConfiguration.isMultiAxisConfiguration()) {
    return;
  }

  // the Work Plane does not change, do not output it
  if (!((currentWorkPlaneABC == undefined) ||
    abcFormat.areDifferent(abc.x, currentWorkPlaneABC.x) ||
    abcFormat.areDifferent(abc.y, currentWorkPlaneABC.y) ||
    abcFormat.areDifferent(abc.z, currentWorkPlaneABC.z))) {
    return; // no change
  }

  // unlock rotary axes
  onCommand(COMMAND_UNLOCK_MULTI_AXIS);

  // retract the tool
  if (!retracted) {
```
writeRetract(Z);

// output using Euler angles
if (useMultiAxisFeatures) {
cancelWorkPlane();

// preposition the rotary axes
if (machineConfiguration.isMultiAxisConfiguration()) {
  var machineABC = abc.isNonZero() ? getWorkPlaneMachineABC(currentSection.workPlane, false) : abc;
  if (useABCPrepositioning || abc.isZero()) {
    positionABC(machineABC, true);
  }
  setCurrentABC(machineABC); // required for machine simulation
}
if (abc.isNonZero()) {
  gRotationModal.reset();
  writeBlock(gRotationModal.format(68.2), "X" + xyzFormat.format(0), "Y" + xyzFormat.format(0), "Z" + xyzFormat.format(0), "I" + abcFormat.format(abc.x), "J" + abcFormat.format(abc.y), "K" + abcFormat.format(abc.z)); // set frame
  writeBlock(gFormat.format(53.1)); // turn machine
}

// output rotary axis positions
} else {
  positionABC(abc, true);
}

// lock rotary axes
onCommand(COMMAND_LOCK_MULTI_AXIS);

currentWorkPlaneABC = abc;

Output Work Plane in setWorkPlane Function

4.3.6 Initial Position
The initial position of the operation is available to the onSection function and is output here. Tool length compensation on the control is enabled with the initial position when the tool is changed or if it has been disabled between operations.

// force all axes to be output at start of operation
forceAny();

// get the initial tool position and retract in Z if necessary
var initialPosition = getFramePosition(currentSection.getInitialPosition());
if (!retracted) {
    if (getCurrentPosition().z < initialPosition.z) {
        writeBlock(gMotionModal.format(0), zOutput.format(initialPosition.z));
    }
}

// output tool length offset on tool change or if tool has been retracted
if (insertToolCall || retracted) {
    var lengthOffset = tool.lengthOffset;
    if (lengthOffset > numberOfToolSlots) {
        error(localize("Length offset out of range."));
        return;
    }
    gMotionModal.reset();
    writeBlock(gPlaneModal.format(17));
    // output XY and then Z with 3-axis or table configuration
    if (!machineConfiguration.isHeadConfiguration()) {
        writeBlock(
            gAbsIncModal.format(90),
            gMotionModal.format(0), xOutput.format(initialPosition.x), yOutput.format(initialPosition.y)
        );
        writeBlock(gMotionModal.format(0), gFormat.format(43), zOutput.format(initialPosition.z), hFormat.format(lengthOffset));
    } else {
        writeBlock(
            gAbsIncModal.format(90),
            gMotionModal.format(0),
            gFormat.format(43), xOutput.format(initialPosition.x),
            yOutput.format(initialPosition.y),
            zOutput.format(initialPosition.z), hFormat.format(lengthOffset)
        );
    }
    // do not activate tool length compensation if already activated
} else {
    writeBlock(
        gAbsIncModal.format(90),
        gMotionModal.format(0),
        xOutput.format(initialPosition.x),
        yOutput.format(initialPosition.y)
    );
}

Output Current Position and Tool Length Compensation
4.4 onSectionEnd

function onSectionEnd() {

The onSectionEnd function can be used to define the end of an operation, but in most post processors this is handled in the onSection function. The reason for this is that different output will be generated depending on if there is a tool change, WCS change, or Work Plane change and this logic is handled in the onSection function (see the insertToolCall variable), though it could be handled in the onSectionEnd function if desired by referencing the getNextSection and isLastSection functions.

```javascript
var insertToolCall = isLastSection() ||
    getNextSection().getForceToolChange && getNextSection().getForceToolChange() ||
    (getNextSection().getTool().number != tool.number);

var retracted = false; // specifies that the tool has been retracted to the safe plane
var newWorkOffset = isLastSection() ||
    (currentSection.workOffset != getNextSection().workOffset); // work offset changes
var newWorkPlane = isLastSection() ||
    !isSameDirection(currentSection.getGlobalFinalToolAxis(),
    getNextSection().getGlobalInitialToolAxis());

if (insertToolCall || newWorkOffset || newWorkPlane) {
    // stop spindle before retract during tool change
    if (insertToolCall) {
        onCommand(COMMAND_STOP_SPINDLE);
    }
    // retract to safe plane
    retracted = true;
    writeBlock(gFormat.format(28), gAbsIncModal.format(91), "Z" + xyzFormat.format(0)); // retract
    writeBlock(gAbsIncModal.format(90));
    zOutput.reset();
    if (insertToolCall) {
        onCommand(COMMAND_COOLANT_OFF);
        if (properties.optionalStop) {
            onCommand(COMMAND_OPTIONAL_STOP);
        }
    }
}
```

Ending the Operation in onSectionEnd

You will need to remove the similar code from the onSection function and probably the onClose function, which will duplicate the session ending code if left intact.
One reason for ending the operation in the `onSectionEnd` function is if a Manual NC command is used between operations. The Manual NC command will be processed prior to the `onSection` function and if the previous operation is terminated in `onSection`, then the Manual NC command will be acted upon prior to ending the previous operation.

The `onSectionEnd` function is pretty basic in most posts and will reset codes that may have been changed in the operation and possibly some variables that are operation specific.

```plaintext
function onSectionEnd() {
    writeBlock(gPlaneModal.format(17));
    forceAny();
}
```

**Basic onSectionEnd Function**

### 4.5 onClose

```plaintext
function onClose() {

    // end previous operation
    writeln("\n");
    optionalSection = false;

    onCommand(COMMAND_COOLANT_OFF);

    writeRetract(Z); // retract
    disableLengthCompensation(true);
    setSmoothing(false);
    zOutput.reset();
    setWorkPlane(new Vector(0, 0, 0)); // reset working plane
    writeRetract(X, Y); // return to home

    // output end-of-program codes
    onImpliedCommand(COMMAND_END);
    onImpliedCommand(COMMAND_STOP_SPINDLE);
    writeBlock(mFormat.format(30)); // stop program, spindle stop, coolant off
    writeln("%");
}
```

**Basic onClose Function**

### 4.6 onTerminate

```plaintext
function onTerminate() {
}
```

**Entry Functions 4-97**
The `onTerminate` function is called at the end of post processing, after `onClose`. It is called after all output to the NC file is finished and the NC file is closed. It may be used to rename the output file(s) after processing has finished, to automatically create a setup sheet, or to run another program against the output NC file.

```javascript
function onTerminate() {
    var outputPath = getOutputPath();
    var programFilename = FileSystem.getFilename(outputPath);
    var programSize = FileSystem.getFileSize(outputPath);
    var postPath = findFile("setup-sheet-excel-2007.cps");
    var intermediatePath = getIntermediatePath();
    var a = "--property unit " + ((unit == IN) ? "0" : "1"); // use 0 for inch and 1 for mm
    if (programName) {
        a += "--property programName \\" + programName + \\"
    }
    if (programComment) {
        a += "--property programComment \\" + programComment + \\"
    }
    a += "--property programFilename \\" + programFilename + \\"
    a += "--property programSize \\" + programSize + \\"
    a += "--noeditor --log temp.log " + postPath + "\" \" + intermediatePath + "\" \" + FileSystem.replaceExtension(outputPath, "xlsx") + "\" \"
    execute(getPostProcessorPath(), a, false, "")
    executeNoWait("excel", "\" \" + FileSystem.replaceExtension(outputPath, "xlsx") + "\"", false, ")
}
```

### Create and Display Setup Sheet from `onTerminate`

#### 4.7 `onCommand`

```javascript
function onCommand(command) {

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>command</td>
<td>Command to process.</td>
</tr>
</tbody>
</table>

The `onCommand` function can be called by a Manual NC command, directly from HSM, or from the post processor.

<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>COMMAND_ACTIVATE_SPEED_FEED_SYNCHRONIZATION</td>
<td>Activate threading mode</td>
</tr>
<tr>
<td>COMMAND_ALARM</td>
<td>Alarm</td>
</tr>
<tr>
<td>COMMAND_ALERT</td>
<td>Alert</td>
</tr>
<tr>
<td>COMMAND_BREAK_CONTROL</td>
<td>Tool break control</td>
</tr>
<tr>
<td>COMMAND_CALIBRATE</td>
<td>Run calibration cycle</td>
</tr>
<tr>
<td>COMMAND_CHANGE_PALLET</td>
<td>Change pallet</td>
</tr>
<tr>
<td>COMMAND_CLEAN</td>
<td>Run cleaning cycle</td>
</tr>
</tbody>
</table>
```
<table>
<thead>
<tr>
<th>Command</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>COMMAND_CLOSE_DOOR</td>
<td>Close primary door</td>
</tr>
<tr>
<td>COMMAND_COOLANT_OFF</td>
<td>Coolant off (M09)</td>
</tr>
<tr>
<td>COMMAND_COOLANT_ON</td>
<td>Coolant on (M08)</td>
</tr>
<tr>
<td>COMMAND_DEACTIVATE_SPEED_FEED_SYNCHRONIZATION</td>
<td>Deactivate threading mode</td>
</tr>
<tr>
<td>COMMAND_END</td>
<td>Program end (M02)</td>
</tr>
<tr>
<td>COMMAND_EXACT_STOP</td>
<td>Exact stop</td>
</tr>
<tr>
<td>COMMAND_LOAD_TOOL</td>
<td>Tool change (M06)</td>
</tr>
<tr>
<td>COMMAND_LOCK_MULTI_AXIS</td>
<td>Locks the rotary axes</td>
</tr>
<tr>
<td>COMMAND_MAIN_CHUCK_CLOSE</td>
<td>Close main chuck</td>
</tr>
<tr>
<td>COMMAND_MAIN_CHUCK_OPEN</td>
<td>Open main chuck</td>
</tr>
<tr>
<td>COMMAND_OPEN_DOOR</td>
<td>Open primary door</td>
</tr>
<tr>
<td>COMMAND_OPTIONAL_STOP</td>
<td>Optional program stop (M01)</td>
</tr>
<tr>
<td>COMMAND_ORIENTATE_SPINDLE</td>
<td>Orientate spindle (M19)</td>
</tr>
<tr>
<td>COMMAND_POWER_OFF</td>
<td>Power off</td>
</tr>
<tr>
<td>COMMAND_POWER_ON</td>
<td>Power on</td>
</tr>
<tr>
<td>COMMAND_SECONDARY_CHUCK_CLOSE</td>
<td>Close secondary chuck</td>
</tr>
<tr>
<td>COMMAND_SECONDARY_CHUCK_OPEN</td>
<td>Open secondary chuck</td>
</tr>
<tr>
<td>COMMAND_SECONDARY_SPINDLE_SYNCHRONIZATION_ACTIVATE</td>
<td>Activate spindle synchronization</td>
</tr>
<tr>
<td>COMMAND_SECONDARY_SPINDLE_SYNCHRONIZATION_DEACTIVATE</td>
<td>Deactivate spindle synchronization</td>
</tr>
<tr>
<td>COMMAND_SPINDLE_CLOCKWISE</td>
<td>Clockwise spindle direction (M03)</td>
</tr>
<tr>
<td>COMMAND_SPINDLE_COUNTERCLOCKWISE</td>
<td>Counter-clockwise spindle direction (M04)</td>
</tr>
<tr>
<td>COMMAND_START_CHIP_TRANSPORT</td>
<td>Start chip conveyor</td>
</tr>
<tr>
<td>COMMAND_START_SPINDLE</td>
<td>Start spindle in previous direction</td>
</tr>
<tr>
<td>COMMAND_STOP</td>
<td>Program stop (M00)</td>
</tr>
<tr>
<td>COMMAND_STOP_CHIP_TRANSPORT</td>
<td>Stop chip conveyor</td>
</tr>
<tr>
<td>COMMAND_STOP_SPINDLE</td>
<td>Stop spindle (M05)</td>
</tr>
<tr>
<td>COMMAND_TOOL_MEASURE</td>
<td>Measure tool</td>
</tr>
<tr>
<td>COMMAND_UNLOCK_MULTI_AXIS</td>
<td>Unlocks the rotary axes</td>
</tr>
<tr>
<td>COMMAND_VERIFY</td>
<td>Verify path/tool/machine integrity</td>
</tr>
</tbody>
</table>

Valid Commands

The Manual NC commands that call `onCommand` are described in the *Manual NC Commands* chapter. Internal calls to `onCommand` are usually generated when expanding a cycle. The post processor itself will call `onCommand` directly to perform simple functions, such as outputting a program stop, cancelling coolant, opening the main door, turning on the chip conveyor, etc.

```c
// stop spindle and cancel coolant before retract during tool change
if (insertToolCall && !isFirstSection()) {
    onCommand(COMMAND_COOLANT_OFF);
    onCommand(COMMAND_STOP_SPINDLE);
}
```

Calling `onCommand` Directly from Post Processor
The `onImpliedCommand` function changes the state of certain settings in the post engine without calling `onCommand` and outputting the associated codes with the command. The state of certain parameters is important when the post processor engine expands cycles.

```javascript
onImpliedCommand(COMMAND_END);
onImpliedCommand(COMMAND_STOP_SPINDLE);
onImpliedCommand(COMMAND_COOLANT_OFF);
writeBlock(mFormat.format(30)); // stop program, spindle stop, coolant off
```

Using `onImpliedCommand`

### 4.8 `onComment`

```javascript
function onComment(message) {
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>message</td>
<td>Text of comment to output.</td>
</tr>
</tbody>
</table>

The `onComment` function is called when the Manual NC command `Comment` is issued. It will format and output the text of the comment to the NC file.

There are two other functions that are used to format and output comments, `formatComment` and `writeComment`. These comment functions are standard in nature and do not typically have to be modified, though the `permittedCommentChars` variable, defined at the top of the post, is used to define the characters that are allowed in a comment and may have to be changed to match the control. The `formatComment` function will remove any characters in the comment that are not specified in this variable. Lowercase letters will be converted to uppercase by the `formatComment` function. If you want to support lowercase letters, then they would have to be added to the `permittedCommentChars` variable and the `formatComment` function would need to have the conversion to uppercase removed.

```javascript
var permittedCommentChars = "ABCDEFGHIJKLMNOPQRSTUVWXYZ0123456789,.=_-";
```

**Defining the Permitted Characters for Comments**

```javascript
/** Format a comment */
function formatComment(text) {
```

---

**Entry Functions 4-100**

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return "(" + filterText(String(text).toUpperCase(), permittedCommentChars).replace(/\{|\}/g, "") + ");

/** Output a comment */
function writeComment(text) {
    writeln(formatComment(text));
}

/** Process the Manual NC Comment command */
function onComment(message) {
    var comments = String(message).split(";"); // allow multiple lines of comments per command
    for (comment in comments) {
        writeComment(comments[comment]);
    }
}

The Comment Functions

### 4.9 onDwell

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>seconds</td>
<td>Dwell time in seconds.</td>
</tr>
</tbody>
</table>

The `onDwell` function can be called by a Manual NC command, directly from HSM, or from the post processor. The Manual NC command that calls `onDwell` is described in the Manual NC Commands chapter. Internal calls to `onDwell` are usually generated when expanding a cycle. The post processor itself will call `onDwell` directly to output a dwell block.

```javascript
function onDwell(seconds) {
    if (seconds > 99999.999) {
        warning(localize("Dwelling time is out of range."));
    }
    milliseconds = clamp(1, seconds * 1000, 99999999);
    writeBlock(gFeedModeModal.format(94), gFormat.format(4), "P" +
               milliFormat.format(milliseconds));
}
```

Output the Dwell Time in Milliseconds

```javascript
onCommand(COMMAND_COOLANT_ON);
onDwell(1.0); // dwell 1 second after turning coolant on
```

Calling onDwell Directly from Post Processor
Almost all parameters used for creating a machining operation in HSM are passed to the post processor. Common parameters are available using built in post processor variables (currentSection, tool, cycle, etc.) as well as being made available as parameters. Other parameters are passed to the `onParameter` function.

```javascript
74: onParameter('operation:context', 'operation')
75: onParameter('operation:strategy', 'drill')
76: onParameter('operation:operation_description', 'Drill')
77: onParameter('operation:tool_type', 'tap right hand')
78: onParameter('operation:undercut', 0)
79: onParameter('operation:tool_isTurning', 0)
80: onParameter('operation:tool_isMill', 0)
81: onParameter('operation:tool_isDrill', 1)
82: onParameter('operation:tool_taperedType', 'tapered_bull_nose')
83: onParameter('operation:tool_unit', 'inches')
84: onParameter('operation:tool_number', 4)
85: onParameter('operation:tool_diameterOffset', 4)
86: onParameter('operation:tool_lengthOffset', 4)
```

Sample Parameters Passed to the `onParameter` Function from Dump Post Processor

The name of the parameter along with its value is passed to the `onParameter` function. Some Manual NC commands will call the `onParameter` function, these are described in the Manual NC Commands chapter. You can see how to run and analyze the output from the `dump.cps` post processor in the Debugging chapter.

```javascript
function onParameter(name, value) {
    if (name == "probe-output-work-offset") {
        probeOutputWorkOffset = (value > 0) ? value : 1;
    }
}
```

Sample `onParameter` Function

### 4.10.1 `getParameter` Function

```javascript
value = getParameter(name)
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>name</td>
<td>Parameter name.</td>
</tr>
</tbody>
</table>
You can retrieve operation parameters at any place in the post processor by calling the `getParameter` function. Operation parameters are defined as parameters that are redefined for each machining operation. There is a chance that a parameter does not exist in all flavors of HSM, so it is recommended that the presence of the parameter is first verified by calling the `hasParameter` function.

```javascript
if (hasParameter("operation-comment")) {
  var comment = getParameter("operation-comment");
  if (comment) {
    writeComment(comment);
  }
}
```

**Verify a Parameter Exists Using the hasParameter Function**

When scanning through the operations in the intermediate file it is possible to access the parameters for that operation by using the section variant of the `hasParameter` and `getParameter` functions.

```javascript
// write out all operation comments
writeln("List of Operations:");
for (var i = 0; i < getNumberOfSections(); ++i) {
  var section = getSection(i);
  if (section.hasParameter("operation-comment")) {
    var comment = section.getParameter("operation-comment");
    if (comment) {
      writeln("  " + comment);
    }
  }
}
writeln("\n");
```

**Using Section Variant of getParameter**

### 4.10.2 `getGlobalParameter` Function

```javascript
value = getGlobalParameter(name)
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>name</td>
<td>Parameter name.</td>
</tr>
</tbody>
</table>

Some parameters are defined at the start of the intermediate file prior to the first operation. These parameters are considered global and are accessed using the `hasGlobalParameter` and `getGlobalParameter` functions. The same rules that apply to the operation parameters apply to global parameters.

-1: onOpen()
0: onParameter('product-id', 'fusion360')
1: onParameter('generated-by', 'Fusion 360 CAM 2.0.3803')
Sample Global Variables

When processing multiple setups at the same time some of the global parameters will change from one setup to the next. The `getGlobalParameter` function though will always reference the parameters of the first setup, so if you want to access the parameters of the active setup then you will need to use the `onParameter` function rather than the `getGlobalParameter` function.

```javascript
function onParameter(name, value) {
  if (name == "job-description") {
    setupName = value;
  }
}
```

Using onParameter to Store the Active Setup Name

4.11 onPassThrough

Function onPassThrough (value)

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>value</td>
<td>Text to be output to the NC file.</td>
</tr>
</tbody>
</table>

The `onPassThrough` function is called by the Pass through Manual NC command and is used to pass a text string directly to the NC file without any processing by the post processor. This function is described in the Manual NC Commands chapter.
4.12 onSpindleSpeed

function onSpindleSpeed(speed) {
  writeBlock(sOutput.format(spindleSpeed));
}

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>spindleSpeed</td>
<td>The new spindle speed in RPM.</td>
</tr>
</tbody>
</table>

The onSpindleSpeed function is used to output changes in the spindle speed during an operation, typically from the post processor engine when expanding a cycle.

Sample onSpindleSpeed Function

4.13 onOrientateSpindle

function onOrientateSpindle(angle) {

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>angle</td>
<td>Spindle orientation angle in radians.</td>
</tr>
</tbody>
</table>

The onOrientateSpindle function is not typically called. When a cycle that orientates the spindle is expanded the onCommand(COMMAND_ORIENTATE_SPINDLE) function is called.

4.14 onRadiusCompensation

function onRadiusCompensation() {

The onRadiusCompensation function is called when the radius (cutter) compensation mode changes. It will typically set the pending compensation mode, which will be handled in the motion functions (onRapid, onLinear, onCircular, etc.). Radius compensation, when enabled in an operation, will be enabled on the move approaching the part and disabled after moving off the part.

The state of radius compensation is stored in the global radiusCompensation variable and is not passed to the onRadiusCompensation function. Radius compensation is defined when creating the machining operation in HSM (1). The Sideways Compensation (2) setting determines the side of the part that the tool will be on when cutting. It is based on the forward direction of the tool during the cutting operation.
## Enabling/Disabling Radius Compensation

<table>
<thead>
<tr>
<th>Compensation Type</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>In computer</td>
<td>The tool is offset from the part based on the tool diameter. The center line of the offset tool is sent to the post processor and the radius compensation mode is OFF (G40).</td>
</tr>
<tr>
<td>In control</td>
<td>The tool is not offset from the part. The centerline of the tool as if it is on the part is sent to the post processor and the radius compensation mode is determined by the Sideways Compensation setting (G41/G42). The control will perform the entire offsetting of the tool.</td>
</tr>
<tr>
<td>Wear</td>
<td>The tool is offset from the part based on the tool diameter. The center line of the offset tool is sent to the post processor and the radius compensation mode is determined by the Sideways Compensation setting (G41/G42). The control will compensate for tool wear.</td>
</tr>
<tr>
<td>Inverse wear</td>
<td>Same as Wear, but the opposite compensation direction will be used (G42/G41).</td>
</tr>
<tr>
<td>Off</td>
<td>The tool is not offset from the part. The centerline of the tool as if it is on the part is sent to the post processor and the radius compensation mode will be disabled (G40).</td>
</tr>
</tbody>
</table>

### Radius Compensation Modes

```javascript
var pendingRadiusCompensation = -1;

function onRadiusCompensation() {
  pendingRadiusCompensation = radiusCompensation;
}
```

### Sample onRadiusCompensation Function

### 4.15 onMovement

```javascript
function onMovement(movement) {
  // Function implementation
}
```
Arguments | Description
---|---
movement | Movement type for the following motion(s).

`onMovement` is called whenever the movement type changes. It is used to tell the post when there is a positioning, entry, exit, or cutting type move. There is also a `movement` global variable that contains the movement setting. This variable can be referenced directly in other functions, such as `onLinear`, to access the movement type without defining the `onMovement` function.

The supported movement types are listed in the following table.

<table>
<thead>
<tr>
<th>Movement Type</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>MOVEMENT_CUTTING</td>
<td>Standard cutting motion.</td>
</tr>
<tr>
<td>MOVEMENT_EXTENDED</td>
<td>Extended movement type. Not common.</td>
</tr>
<tr>
<td>MOVEMENT_FINISH_CUTTING</td>
<td>Finish cutting motion.</td>
</tr>
<tr>
<td>MOVEMENT_HIGH_FEED</td>
<td>Movement at high feedrate. Not typically used. Rapid moves output using a linear move at the high feedrate will use the MOVEMENT_RAPID type.</td>
</tr>
<tr>
<td>MOVEMENT_LEAD_IN</td>
<td>Lead-in motion.</td>
</tr>
<tr>
<td>MOVEMENT_LEAD_OUT</td>
<td>Lead-out motion.</td>
</tr>
<tr>
<td>MOVEMENT_LINK_DIRECT</td>
<td>Direction (non-cutting) linking move.</td>
</tr>
<tr>
<td>MOVEMENT_LINK_TRANSITION</td>
<td>Transition (cutting) linking move.</td>
</tr>
<tr>
<td>MOVEMENT_PLUNGE</td>
<td>Plunging move.</td>
</tr>
<tr>
<td>MOVEMENT_PREDRILL</td>
<td>Predrilling motion.</td>
</tr>
<tr>
<td>MOVEMENT_RAMP</td>
<td>Ramping entry motion.</td>
</tr>
<tr>
<td>MOVEMENT_RAMP_HELIX</td>
<td>Helical ramping motion.</td>
</tr>
<tr>
<td>MOVEMENT_RAMP_PROFILE</td>
<td>Profile ramping motion.</td>
</tr>
<tr>
<td>MOVEMENT_RAMP_ZIG_ZAG</td>
<td>Zig-Zag ramping motion.</td>
</tr>
<tr>
<td>MOVEMENT_RAPID</td>
<td>Rapid movement.</td>
</tr>
<tr>
<td>MOVEMENT_REduced</td>
<td>Reduced cutting motion.</td>
</tr>
</tbody>
</table>

Movement types are used in defining parametric feedrates in some milling posts and for removing all non-cutting moves for waterjet/plasma/laser machines that require only the cutting profile.

### 4.16 onRapid

```cpp
function onRapid(_x, _y, _z) {

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>_x, _y, _z</td>
<td>The tool position.</td>
</tr>
</tbody>
</table>
```

The `onRapid` function handles rapid positioning moves (G00) while in 3-axis mode. The tool position is passed as the `_x, _y, _z` arguments. The format of the `onRapid` function is pretty basic, it will handle a change in radius compensation, may determine if the rapid moves should be output at a high feedrate.
(due to the machine making dogleg moves while in rapid mode), and output the rapid move to the NC file.

If the **High feedrate mapping** property is set to **Always use high feed**, then the `onLinear` function will be called with the high feedrate passed in as the feedrate and the `onRapid` function will not be called.

---

**Table:**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>(Built-in) Allow helical moves</td>
<td>Yes</td>
</tr>
<tr>
<td><strong>(Built-in) High feedrate mapping</strong></td>
<td><strong>Always use high feed</strong></td>
</tr>
<tr>
<td>(Built-in) High feedrate</td>
<td></td>
</tr>
<tr>
<td>(Built-in) Maximum circular radius</td>
<td></td>
</tr>
<tr>
<td>(Built-in) Minimum chord length</td>
<td></td>
</tr>
<tr>
<td>(Built-in) Minimum circular radius</td>
<td></td>
</tr>
<tr>
<td>(Built-in) Tolerance</td>
<td>0.001</td>
</tr>
</tbody>
</table>

---

```
function onRapid(_x, _y, _z) {
  // format tool position for output
  var x = xOutput.format(_x);
  var y = yOutput.format(_y);
  var z = zOutput.format(_z);

  // ignore if tool does not move
  if (x || y || z) {
    if (pendingRadiusCompensation >= 0) { // handle radius compensation
      error(localize("Radius compensation mode cannot be changed at rapid traversal."));
      return;
    }

    // output move at high feedrate if movement in more than one axis
    if (!properties.useG0 && (((x ? 1 : 0) + (y ? 1 : 0) + (z ? 1 : 0)) > 1)) {
      writeBlock(gFeedModeModal.format(94), gMotionModal.format(1), x, y, z,
                 getFeed(highFeedrate));
    }
  } else {
    writeBlock(gMotionModal.format(0), x, y, z);
    forceFeed();
  }
}
```

---

**Sample onRapid Function**
4.17 onExpandedRapid

**onExpandedRapid(x, y, z);**

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>x, y, z</td>
<td>The tool position.</td>
</tr>
</tbody>
</table>

It is possible that the post processor will need to generate rapid positioning moves during the processing of the intermediate file. An example would be creating your own expanded drilling cycle. Instead of calling `onRapid` with the post generated moves, it is recommended that `onExpandedRapid` be called instead. This will ensure that the post engine is notified of the move and the current position is set. `onExpandedRapid` will then call `onRapid` with the provided arguments.

The `onExpandedRapid` function is not considered an entry function, since it will never be called directly by the post processor engine.

4.18 onLinear

```javascript
function onLinear(_x, _y, _z, feed) {
    // force move when radius compensation changes
    if (pendingRadiusCompensation >= 0) {
        xOutput.reset();
        yOutput.reset();
    }

    // format tool position for output
    var x = xOutput.format(_x);
    var y = yOutput.format(_y);
    var z = zOutput.format(_z);
    var f = getFeed(feed);

    if (x || y || z) {
        // handle radius compensation changes
    }
}
```

The `onLinear` function handles linear moves (G01) at a feedrate while in 3-axis mode. The tool position is passed as the `_x, _y, _z` arguments. The format of the `onLinear` function is pretty basic, it will handle a change in radius compensation and outputs the linear move to the NC file.
if (pendingRadiusCompensation >= 0) {
    pendingRadiusCompensation = -1;
    var d = tool.diameterOffset;
    if (d > 200) {
        warning(localize("The diameter offset exceeds the maximum value.");
    }
    writeBlock(gPlaneModal.format(17));
    switch (radiusCompensation) {
    case RADIUS_COMPENSATION_LEFT:
        dOutput.reset();
        writeBlock(gFeedModeModal.format(94), gMotionModal.format(1), gFormat.format(41), x, y, z,
                    dOutput.format(d), f);
        break;
    case RADIUS_COMPENSATION_RIGHT:
        dOutput.reset();
        writeBlock(gFeedModeModal.format(94), gMotionModal.format(1), gFormat.format(42), x, y, z,
                    dOutput.format(d), f);
        break;
    default:
        writeBlock(gFeedModeModal.format(94), gMotionModal.format(1), gFormat.format(40), x, y, z,
        f);
        // output non-compensation change move at feedrate
        } else {
            writeBlock(gFeedModeModal.format(94), gMotionModal.format(1), x, y, z, f);
        }
    // no movement, but feedrate changes
    } else if (f) {
    if (getNextRecord().isMotion()) {
        // try not to output feed without motion
        forceFeed(); // force feed on next line
    } else {
        writeBlock(gFeedModeModal.format(94), gMotionModal.format(1), f);
    }
}

Sample onLinear Function

4.19 onExpandedLinear

onExpandedLinear(x, y, z, feed);

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>_x, _y, _z</td>
<td>The tool position.</td>
</tr>
<tr>
<td>feed</td>
<td>The feedrate.</td>
</tr>
</tbody>
</table>
It is possible that the post processor will need to generate cutting moves during the processing of the intermediate file. An example would be creating your own expanded drilling cycle. Instead of calling \textit{onLinear} with the post generated moves, it is recommended that \textit{onExpandedLinear} be called instead. This will ensure that the post engine is notified of the move and the current position is set. \textit{onExpandedLinear} will then call \textit{onLinear} with the provided arguments.

The \textit{onExpandedLinear} function is not considered an entry function, since it will never be called directly by the post processor engine.

### 4.20 onRapid5D

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>_x, _y, _z</td>
<td>The tool position.</td>
</tr>
<tr>
<td>_a, _b, _c</td>
<td>The rotary angles if a machine configuration has been defined, otherwise the tool axis vector is passed.</td>
</tr>
</tbody>
</table>

The \textit{onRapid5D} function handles rapid positioning moves (G00) in multi-axis operations. The tool position is passed as the \_x, \_y, \_z arguments and the rotary angles as the \_a, \_b, \_c arguments. If a machine configuration has not been defined, then \_a, \_b, \_c contains the tool axis vector. The \textit{onRapid5D} function will be called for all rapid moves in a multi-axis operation, even if the move is only a 3-axis linear move without rotary movement.

Like the \textit{onRapid} function, the \textit{onRapid5D} function handles a change in radius compensation, may determine if the rapid moves should be output at a high feedrate (due to the machine making dogleg moves while in rapid mode), and outputs the rapid move to the NC file.
var y = yOutput.format(_y);
var z = zOutput.format(_z);
var a = aOutput.format(_a);
var b = bOutput.format(_b);
var c = cOutput.format(_c);
writeBlock(gMotionModal.format(0), x, y, z, a, b, c);

// Machine Configuration has not been defined, output tool axis with move
} else {
    forceXYZ();
    var x = xOutput.format(_x);
    var y = yOutput.format(_y);
    var z = zOutput.format(_z);
    var i = ijkFormat.format(_a);
    var j = ijkFormat.format(_b);
    var k = ijkFormat.format(_c);
    writeBlock(gMotionModal.format(0), x, y, z, "I" + i, "J" + j, "K" + k);
}
forceFeed();
}

Sample onRapid5D Function

Please refer to the Multi-Axis Post Processors chapter for a detailed explanation on supporting a multi-axis machine.

### 4.21 onLinear5D

```javascript
function onLinear5D(_x, _y, _z, _a, _b, _c, feed) {

    // enable this code if machine does not accept IJK tool axis vector input
    if (false) {
        if (!currentSection.isOptimizedForMachine()) {

```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>_x, _y, _z</td>
<td>The tool position.</td>
</tr>
<tr>
<td>_a, _b, _c</td>
<td>The rotary angles if a machine configuration has been defined, otherwise the tool axis vector is passed.</td>
</tr>
<tr>
<td>feed</td>
<td>The feedrate.</td>
</tr>
</tbody>
</table>

The `onLinear5D` function handles cutting moves (G01) in multi-axis operations. The tool position is passed as the _x, _y, _z arguments and the rotary angles as the _a, _b, _c arguments. If a machine configuration has not been defined, then _a, _b, _c contains the tool axis vector. The `onLinear5D` function will be called for all cutting moves in a multi-axis operation, even if the move is only a 3-axis linear move without rotary movement.

Like the `onLinear` function, the `onLinear5D` function handles a change in radius compensation, and outputs the cutting move to the NC file.

```javascript
function onLinear5D(_x, _y, _z, _a, _b, _c, feed) {
    // enable this code if machine does not accept IJK tool axis vector input
    if (false) {
        if (!currentSection.isOptimizedForMachine()) {

```
error(localize("This post configuration has not been customized for 5-axis toolpath."))); return;
}

// handle radius compensation changes
if (pendingRadiusCompensation >= 0) {
  error(localize("Radius compensation cannot be activated/deactivated for 5-axis move.")); return;
}

// Machine Configuration has been defined, output rotary angles with move
if (currentSection.isOptimizedForMachine()) {
  var x = xOutput.format(_x);
  var y = yOutput.format(_y);
  var z = zOutput.format(_z);
  var a = aOutput.format(_a);
  var b = bOutput.format(_b);
  var c = cOutput.format(_c);

  // calculate multi-axis feedrate
  var f = {frn:0, fmode:0};
  if (a || b || c) {
    f = getMultiaxisFeed(_x, _y, _z, _a, _b, _c, feed);
  } else {
    f.frn = getFeed(feed);
    f.fmode = 94;
  }

  // ignore if tool does not move
  if (x || y || z || a || b || c) {
    writeBlock(gMotionModal.format(1), x, y, z, a, b, c, f);
  } else if (f) {
    if (getNextRecord().isMotion()) { // try not to output feed without motion
      forceFeed(); // force feed on next line
    } else {
      writeBlock(gMotionModal.format(1), f);
    }
  }
}

// Machine Configuration has not been defined, output tool axis with move
} else {
  forceXYZ();
  var x = xOutput.format(_x);
  var y = yOutput.format(_y);
  var z = zOutput.format(_z);
```
var i = ijkFormat.format(_a);
var j = ijkFormat.format(_b);
var k = ijkFormat.format(_c);
var f = getFeed(feed);

// ignore if tool does not move
if (x || y || z || i || j || k) {
    writeBlock(gMotionModal.format(1), x, y, z, "I" + i, "J" + j, "K" + k, f);
} else if (f) {
    if (getNextRecord().isMotion()) { // try not to output feed without motion
        forceFeed(); // force feed on next line
    } else {
        writeBlock(gMotionModal.format(1), f);
    }
}
```

Sample onLinear5D Function

Please refer to the *Multi-Axis Post Processors* chapter for a detailed explanation on supporting a multi-axis machine.

### 4.22 onCircular

```javascript
function onCircular(clockwise, cx, cy, cz, x, y, z, feed) {
```

<table>
<thead>
<tr>
<th>Argument</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>clockwise</td>
<td>Set to <code>true</code> if the circular direction is in the clockwise direction, <code>false</code> if counter-clockwise.</td>
</tr>
<tr>
<td>cx, cy, cz</td>
<td>Center coordinates of circle.</td>
</tr>
<tr>
<td>x, y, z</td>
<td>Final point on circle</td>
</tr>
<tr>
<td>feed</td>
<td>The feedrate.</td>
</tr>
</tbody>
</table>

The `onCircular` function is called whenever there is circular, helical, or spiral motion. The circular move can be in any of the 3 standard planes, XY-plane, YZ-plane, or ZX-plane, it is up to the `onCircular` function to determine which types of circular are valid for the machine and to correctly format the output.

The structure of the `onCircular` function in most posts uses the following layout.

1. Test for radius compensation. Most controls do not allow radius compensation to be started on a circular move.
2. Full circle output.
3. Center point (IJK) output.
4. Radius output.
Each of the different styles of output will individually handle the output of circular interpolation in each of the planes and possibly 3-D circular interpolation if it is supported.

```javascript
if (pendingRadiusCompensation >= 0) { // Disallow radius compensation
    error(localize("Radius compensation cannot be activated/deactivated for a circular move."));
    return;
}

if (isFullCircle()) { // Full 360 degree circles
    if (properties.useRadius || isHelical()) { // radius mode does not support full arcs
        linearize(tolerance);
        return;
    }
}

else if (!properties.useRadius) { // Incremental center point output
    switch (getCircularPlane()) {
        case PLANE_XY:
        break;
        case PLANE_ZX:
        break;
        case PLANE_YZ:
        break;
    }
    // circular record is not in major plane
    linearize(tolerance);
}
```

---

**Standard onCircular Structure**

```javascript
switch (getCircularPlane()) {
    case PLANE_XY:
        writeBlock(gPlaneModal.format(17), gMotionModal.format(clockwise ? 2 : 3),
                    xOutput.format(x), yOutput.format(y), zOutput.format(z),
                    iOutput.format(cx - start.x, 0), jOutput.format(cy - start.y, 0), getFeed(feed));
        break;
    case PLANE_ZX:
        writeBlock(gPlaneModal.format(18), gMotionModal.format(clockwise ? 2 : 3),
                    xOutput.format(x), yOutput.format(y), zOutput.format(z),
                    iOutput.format(cx - start.x, 0), kOutput.format(cz - start.z, 0), getFeed(feed));
        break;
    case PLANE_YZ:
        writeBlock(gPlaneModal.format(19), gMotionModal.format(clockwise ? 2 : 3),
                    xOutput.format(x), yOutput.format(y), zOutput.format(z),
                    jOutput.format(cy - start.y, 0), kOutput.format(cz - start.z, 0), getFeed(feed));
        break;
    default: // circular record is not in major plane
        linearize(tolerance);
}
```
4.22.1 Circular Interpolation Settings

There are settings that affect how circular interpolation is handled in the post engine, basically telling the post engine when to call `onCircular` or when to linearize the points by calling `onLinear` multiple times instead. The following table describes the circular interpolation settings.

<table>
<thead>
<tr>
<th>Setting</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>allowedCircularPlanes</td>
<td>Defines the standard planes that circular interpolation is allowed in, PLANE_XY, PLANE_YZ, PLANE_ZX. It can be set to <code>undefined</code> to allow circular interpolation in all three planes, 0 to disable circular interpolation, or a bit mask of PLANE_XY, PLANE_YZ, and/or PLANE_ZX to allow only certain planes.</td>
</tr>
<tr>
<td>allowHelicalMoves</td>
<td>Helical interpolation is allowed when this variable is set to <code>true</code>. Helical moves are linearized if set to <code>false</code>.</td>
</tr>
<tr>
<td>allowSpiralMoves</td>
<td>Spiral interpolation is defined as circular moves that have a different starting radius than ending radius and can be enabled by setting this variable to <code>true</code>. Spiral moves are linearized if set to <code>false</code>.</td>
</tr>
<tr>
<td>maximumCircularRadius</td>
<td>Specifies the maximum radius of circular moves that can be output as circular interpolation and can be changed dynamically in the Property table when running the post processor. Any circular records whose radius exceeds this value will be linearized. This variable must be set in millimeters (MM).</td>
</tr>
<tr>
<td></td>
<td><code>maximumCircularRadius = spatial(1000, MM); // 39.37 inch</code></td>
</tr>
<tr>
<td>maximumCircularSweep</td>
<td>Specifies the maximum angular sweep of circular moves that can be output as circular interpolation and is specified in radians. Any circular records whose delta angle exceeds this value will be linearized.</td>
</tr>
<tr>
<td>minimumChordLength</td>
<td>Specifies the minimum delta movement allowed for circular interpolation and can be changed dynamically in the Property table when running the post processor. Any circular records whose delta linear movement is less than this value will be linearized. This variable must be set in millimeters (MM).</td>
</tr>
<tr>
<td>minimumCircularRadius</td>
<td>Specifies the minimum radius of circular moves that can be output as circular interpolation and can be changed dynamically in the Property table when running the post processor. Any circular records whose radius is less than this value will be linearized. This variable must be set in millimeters (MM).</td>
</tr>
<tr>
<td>minimumCircularSweep</td>
<td>Specifies the minimum angular sweep of circular moves that can be output as circular interpolation and is specified in radians. Any circular records whose delta angle is less than this value will be linearized.</td>
</tr>
</tbody>
</table>
| tolerance              | Specifies the tolerance used to linearize circular moves that are expanded into a series of linear moves. Circular interpolation records can be linearized due to the conditions of the circular interpolation settings not
### Circular Interpolation Settings

<table>
<thead>
<tr>
<th>Setting</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>allowedCircularPlanes = undefined;</td>
<td>// allow all circular planes</td>
</tr>
<tr>
<td>allowedCircularPlanes = 0;</td>
<td>// disable all circular planes</td>
</tr>
<tr>
<td>allowedCircularPlanes = (1 &lt;&lt; PLANE_XY)</td>
<td></td>
</tr>
<tr>
<td>tolerance = spatial(0.002, MM);</td>
<td>// linearization tolerance of .00008 IN</td>
</tr>
<tr>
<td>minimumChordLength = spatial(0.01, MM);</td>
<td>// minimum linear movement of .0004 IN</td>
</tr>
<tr>
<td>maximumCircularRadius = spatial(1000, MM);</td>
<td>// minimum circular radius of .0004 IN</td>
</tr>
<tr>
<td>minimumCircularSweep = toRad(0.01);</td>
<td>// minimum angular movement of .01 degrees</td>
</tr>
<tr>
<td>maximumCircularSweep = toRad(180);</td>
<td>// circular interpolation up to 180 degrees</td>
</tr>
<tr>
<td>allowHelicalMoves = true;</td>
<td>// enable helical interpolation</td>
</tr>
<tr>
<td>allowSpiralMoves = false;</td>
<td>// disallow spiral interpolation</td>
</tr>
</tbody>
</table>

Example Circular Interpolation Settings

### 4.22.2 Circular Interpolation Common Functions

There are built-in functions that are utilized by the onCircular function. These functions return values used in the onCircular function, determine if the circular record should be linearized, and control the flow of the onCircular function logic.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>getCircularCenter()</td>
<td>Returns the center point of the circle as a Vector.</td>
</tr>
<tr>
<td>getCircularChordLength()</td>
<td>Returns the delta linear movement of the circular interpolation record.</td>
</tr>
<tr>
<td>getCircularNormal()</td>
<td>Returns the normal of the circular plane as a Vector. The normal is flipped if the circular movement is in the clockwise direction. This follows the right-hand plane convention.</td>
</tr>
<tr>
<td>getCircularPlane()</td>
<td>Returns the plane of the circular interpolation record, PLANE_XY, PLANE_ZX, or PLANE_YZ. If the return value is -1, then the circular plane is not a major plane, but is in 3-D space.</td>
</tr>
<tr>
<td>getCircularRadius()</td>
<td>Returns the end radius of the circular motion.</td>
</tr>
<tr>
<td>getCircularStartRadius()</td>
<td>Returns the start radius of the circular motion. This will be different than the end radius for spiral moves.</td>
</tr>
<tr>
<td>getCircularSweep()</td>
<td>Returns the angular sweep of the circular interpolation record in radians.</td>
</tr>
<tr>
<td>getCurrentPosition()</td>
<td>Returns the starting point of the circular move as a Vector.</td>
</tr>
<tr>
<td>getHelicalDistance()</td>
<td>Returns the distance the third axis will move during helical interpolation. Returns 0 for a 2-D circular interpolation record.</td>
</tr>
<tr>
<td>getHelicalOffset()</td>
<td>Returns the distance along the third axis as a Vector. This function is used when helical interpolation is supported outside one of the three standard circular planes.</td>
</tr>
</tbody>
</table>
### Function Description

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>getHelicalPitch()</td>
<td>Returns the distance that the third axis travels for a full 360-degree sweep, i.e. the pitch value of the thread.</td>
</tr>
<tr>
<td>getPositionU(u)</td>
<td>Returns the point on the circle at u percent along the arc as a Vector.</td>
</tr>
<tr>
<td>isFullCircle()</td>
<td>Returns true if the angular sweep of the circular motion is 360 degrees.</td>
</tr>
<tr>
<td>isHelical()</td>
<td>Returns true if the circular interpolation record contains helical movement. The variable allowHelicalMoves must be set to true for helical records to be passed to the onCircular function.</td>
</tr>
<tr>
<td>isSpiral()</td>
<td>Returns true if the circular interpolation record contains spiral movement (the start and end radii are different). The variable allowSpiralMoves must be set to true for spiral records to be passed to the onCircular function.</td>
</tr>
<tr>
<td>linearize(tolerance)</td>
<td>Linearizes the circular motion by outputting a series of linear moves.</td>
</tr>
</tbody>
</table>

#### 4.22.3 Helical Interpolation

Helical interpolation is defined as circular interpolation with movement along the third linear axis. The third linear axis is defined as the axis that is not part of the circular plane, for example, the Z-axis is the third linear axis for circular interpolation in the XY-plane. The variable allowHelicalMoves must be set to true for the post processor to support helical interpolation.

Helical interpolation is typically output using the same format as circular interpolation with the addition of the third axis and optionally a pitch value (incremental distance per 360 degrees) for the third axis. Most stock post processors are already setup to output the third axis with circular interpolation (it won’t be output for a 2-D circular move).

```plaintext
case PLANE_XY:
    writeBlock(gPlaneModal.format(17), gMotionModal.format(clockwise ? 2 : 3),
              xOutput.format(x), yOutput.format(y), zOutput.format(z),
              iOutput.format(cx-start.x, 0), jOutput.format(cy-start.y, 0), kOutput.format(getHelicalPitch()),
              feedOutput.format(feed));
    break;
```

#### 4.22.4 Spiral Interpolation

Spiral interpolation is defined as circular interpolation that has a different radius at start of the circular move than the radius at the end of the move. The variable allowSpiralMoves must be set to true for the post processor to support helical interpolation.

Spiral interpolation when supported on a control is typically specified with a G-code different than the standard G02/G03 circular interpolation G-codes. Most stock post processors do not support spiral interpolation.
if (isSpiral()) {
    var startRadius = getCircularStartRadius();
    var endRadius = getCircularRadius();
    var dr = Math.abs(endRadius - startRadius);
    if (dr > maximumCircularRadiiDifference) { // maximum limit
        if (isHelical()) { // not supported
            linearize(tolerance);
            return;
        }
    }

    switch (getCircularPlane()) {
    case PLANE_XY:
        writeBlock(gPlaneModal.format(17), gMotionModal.format(clockwise ? 2.1 : 3.1),
                   xOutput.format(x), yOutput.format(y), zOutput.format(z),
                   iOutput.format(cx - start.x, 0), jOutput.format(cy - start.y, 0), getFeed(feed));
        break;
    case PLANE_ZX:
        writeBlock(gPlaneModal.format(18), gMotionModal.format(clockwise ? 2.1 : 3.1),
                   xOutput.format(x), yOutput.format(y), zOutput.format(z),
                   iOutput.format(cx - start.x, 0), kOutput.format(cz - start.z, 0), getFeed(feed));
        break;
    case PLANE_YZ:
        writeBlock(gPlaneModal.format(19), gMotionModal.format(clockwise ? 2.1 : 3.1),
                   xOutput.format(x), yOutput.format(y), zOutput.format(z),
                   jOutput.format(cy - start.y, 0), kOutput.format(cz - start.z, 0), getFeed(feed));
        break;
    default:
        linearize(tolerance);
        return;
    }
}

**Spiral Interpolation Output**

### 4.22.5 3-D Circular Interpolation

3-D circular interpolation is defined as circular interpolation that is not on a standard circular plane (XY, ZX, YZ).

3-D circular interpolation when supported on a control is typically specified with a G-code different than the standard G02/G03 circular interpolation G-codes and must contain either the mid-point of the circular move and/or the normal vector of the circle. Most stock post processors do not support 3-D circular interpolation.
if (properties.allow3DArcs) {  // a post property is used to enable support of 3-D circular
// make sure maximumCircularSweep is well below 360deg
var ip = getPositionU(0.5);  // calculate mid-point of circle
writeBlock(gMotionModal.format(clockwise ? 2.4 : 3.4),  // 3-D circular direction G-codes
          xOutput.format(ip.x), yOutput.format(ip.y), zOutput.format(ip.z),  // output mid-point of circle
          getFeed(feed));
writeBlock(xOutput.format(x), yOutput.format(y), zOutput.format(z));  // output end-point
} else {
    linearize(tolerance);
}

### 3-D Circular Interpolation Output

#### 4.23 onCycle

```javascript
function onCycle() {
    // The onCycle function is called once at the beginning of an operation that contains a canned cycle and
    // can contain code to prepare the machine for the cycle. Mill post processors will typically set the
    // machining plane here.
    writeBlock(gPlaneModal.format(17));
}
```

**Sample onCycle Function**

Mill/Turn post processors will usually handle the stock transfer sequence in the onCycle function. Logic
for the Mill/Turn post processors will be discussed in a dedicated chapter.

#### 4.24 onCyclePoint

```javascript
function onCyclePoint(x, y, z) {
    // Canned cycle output is handled in the onCyclePoint function, which includes positioning to the
    // clearance plane, formatting of the cycle block, calculating the cycle parameters, discerning if the canned
    // cycle is supported on the machine or should be expanded, and probing cycles which will not be
    // discussed in this chapter.
    // The location of the hole bottom for the cycle is passed in as the x, y, z arguments to the onCyclePoint
    // function. All other parameters are available in the cycle object or through cycle specific function calls.
    // The flow of outputting canned cycles usually follows the following logic.

    // 1. First hole location in cycle
        // a. Position to clearance plane
```

**Entry Functions 4-120**
b. Canned cycle is supported on machine
   i. Calculate common cycle parameters
   ii. Format and output canned cycle

c. Canned cycle is not supported on machine
   i. Expand cycle into linear moves

2. 2<sup>nd</sup> through n<sup>th</sup> holes
   a. Cycle is not expanded
      i. Output hole location
   b. Cycle is expanded
      i. Expand cycle at new location

The actual output of the cycle blocks is handled in a switch block, with a separate case for each of the supported cycles.

```java
switch (cycleType) {
    case "drilling":
        writeBlock(
            gRetractModal.format(98), gAbsIncModal.format(90), gCycleModal.format(81),
            getCommonCycle(x, y, z, cycle.retract),
            feedOutput.format(F)
        );
        break;

    case "deep-drilling":
        if (P > 0) { // the machine does not support a dwell code, so expand the cycle
            expandCyclePoint(x, y, z);
        } else {
            writeBlock(
                gRetractModal.format(98), gAbsIncModal.format(90), gCycleModal.format(83),
                getCommonCycle(x, y, z, cycle.retract),
                "Q" + xyzFormat.format(cycle.incrementalDepth),
                feedOutput.format(F)
            );
        }
        break;
}
```

Sample Cycle Formatting Code

If a cycle is not supported and needs to be expanded by the post engine, then you can either remove the entire case block for this cycle and it will be handled in the default block, or you can specifically expand the cycle. The second method is handy when the canned cycle does not support all of the parameters available in HSM, for example if a dwell is not supported for a deep drilling cycle on the machine, but you want to be able to use a dwell.

Expanding a Cycle When a Feature is not Support on the Machine

The 2<sup>nd</sup> through the n<sup>th</sup> locations in a cycle operation are typically output using simple XY moves without any of the cycle definition codes. Expanded cycles still need to be expanded at these locations.
4.24.1 Drilling Cycle Types

The following table contains the drilling (hole making cycles). The cycle type is stored in the `cycleType` variable as a text string. The standard G-code used for the cycle is included in the description, where expanded defines the cycle as usually not being supported on the machine and expanded instead.

<table>
<thead>
<tr>
<th>cycleType</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>drilling</td>
<td>Feed in to depth and rapid out (G81)</td>
</tr>
<tr>
<td>counter-boring</td>
<td>Feed in to depth, dwell, and rapid out (G82)</td>
</tr>
<tr>
<td>chip-breaking</td>
<td>Multiple pecks with periodic partial retract to clear chips (G73)</td>
</tr>
<tr>
<td>deep-drilling</td>
<td>Peck drilling with full retraction at end of each peck (G83)</td>
</tr>
<tr>
<td>break-through-drilling</td>
<td>Allows for reduced speed and feed before breaking through hole (expanded)</td>
</tr>
<tr>
<td>gun-drilling</td>
<td>Guided deep drilling allows for a change in spindle speed for positioning (expanded)</td>
</tr>
<tr>
<td>tapping</td>
<td>Feed in to depth, reverse spindle, optional dwell, and feed out. Automatically determines left or right tapping depending on the tool selected. (G74/G84)</td>
</tr>
<tr>
<td>left-tapping</td>
<td>Left-handed tapping (G74)</td>
</tr>
<tr>
<td>right-tapping</td>
<td>Right-handed tapping (G84)</td>
</tr>
<tr>
<td>tapping-with-chip-breaking</td>
<td>Tapping with multiple pecks. Automatically determines left or right tapping depending on the tool selected. (expanded)</td>
</tr>
<tr>
<td>reaming</td>
<td>Feed in to depth and feed out (G85)</td>
</tr>
<tr>
<td>boring</td>
<td>Feed in to depth, dwell, and feed out (G86)</td>
</tr>
<tr>
<td>stop-boring</td>
<td>Feed to depth, stop the spindle, and feed out (G87)</td>
</tr>
<tr>
<td>fine-boring</td>
<td>Feed to depth, orientate the spindle, shift from wall, and rapid out (G76)</td>
</tr>
</tbody>
</table>
### Types of Drilling Cycles

Any of these cycles can be expanded if the machine control does not support the specific cycle. There are some caveats, where the post (and machine) must support certain capabilities for the expanded cycle to run correctly on the machine. The following table lists the commands that must be defined in the `onCommand` function to support the expansion of these cycles. It is expected that the machine will support these features if they are enabled in the post processor.

<table>
<thead>
<tr>
<th>cycleType</th>
<th>Supported onCommand Command</th>
</tr>
</thead>
<tbody>
<tr>
<td>tapping</td>
<td>COMMAND_SPINDLE_CLOCKWISE</td>
</tr>
<tr>
<td>left-tapping</td>
<td>COMMAND_SPINDLE_COUNTERCLOCKWISE</td>
</tr>
<tr>
<td>right-tapping</td>
<td>COMMAND_ACTIVATE_SPEED_FEED_SYNCHRONIZATION</td>
</tr>
<tr>
<td>tapping-with-chip-breaking</td>
<td>COMMAND_DEACTIVATE_SPEED_FEED_SYNCHRONIZATION</td>
</tr>
<tr>
<td>stop-boring</td>
<td>COMMAND_STOP_SPINDLE</td>
</tr>
<tr>
<td>fine-boring</td>
<td>COMMAND_START_SPINDLE</td>
</tr>
<tr>
<td>back-boring</td>
<td>COMMAND_STOP_SPINDLE</td>
</tr>
<tr>
<td></td>
<td>COMMAND_START_SPINDLE</td>
</tr>
<tr>
<td></td>
<td>COMMAND_ORIENTATE_SPINDLE</td>
</tr>
</tbody>
</table>

### Required Command Support for Expanded Cycles

Certain cycles will use the following parameters when they are expanded.

<table>
<thead>
<tr>
<th>machineParameters.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>chipBreakingDistance</td>
<td>The distance to retract to break the chips during a <code>chip-breaking</code> cycle.</td>
</tr>
<tr>
<td>drillingSafeDistance</td>
<td>Specifies the safety distance above the stock when repositioning into the hole for the <code>chip-breaking</code> and <code>deep-drilling</code> cycles.</td>
</tr>
<tr>
<td>spindleOrientation</td>
<td>The spindle orientation angle after orientating the spindle.</td>
</tr>
<tr>
<td>spindleSpeedDwell</td>
<td>Dwell in seconds after the spindle speed changes during a cycle.</td>
</tr>
</tbody>
</table>

### Parameters for Expanded Cycles

You define the expanded cycle parameters using the following syntaxes.

```javascript
machineParameters.chipBreakingDistance = toPreciseUnit(0.1, MM);
machineParameters.drillingSafeDistance = toPreciseUnit(2, MM);
machineParameters.spindleOrientation = 0;
machineParameters.spindleSpeedDwell = 1.5;
```

### Defining Expanded Cycles Parameters
## 4.24.2 Cycle parameters

The parameters defined in the cycle operation are passed to the cycle functions using the `cycle` object. The following variables are available and are referenced as `cycle.parameter`.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>accumulatedDepth</td>
<td>The depth of the combined cuts before the tool will be fully retracted during a <em>chip-breaking</em> cycle.</td>
</tr>
<tr>
<td>backBoreDistance</td>
<td>The cutting distance of a <em>back-boring</em> cycle.</td>
</tr>
<tr>
<td>bottom</td>
<td>The bottom of the hole.</td>
</tr>
<tr>
<td>breakThroughDistance</td>
<td>The distance above the hole bottom to switch to the break-through feedrate and spindle speed during a <em>break-through-drilling</em> cycle.</td>
</tr>
<tr>
<td>breakThroughFeedRate</td>
<td>The feedrate used when breaking through the hole during a <em>break-through-drilling</em> cycle.</td>
</tr>
<tr>
<td>breakThroughSpindleSpeed</td>
<td>The spindle speed used when breaking through the hole during a <em>break-through-drilling</em> cycle.</td>
</tr>
<tr>
<td>chipBreakDistance</td>
<td>The distance to retract the tool to break the chip during a <em>chip-breaking</em> cycle.</td>
</tr>
<tr>
<td>clearance</td>
<td>Clearance plane where to tool will retract the tool to after drilling a hole and position to the next hole.</td>
</tr>
<tr>
<td>compensation</td>
<td>Radius compensation in effect for <em>circular-pocket-milling</em> and <em>thread-milling</em> cycles. This value can be control, wear, and inverseWear.</td>
</tr>
<tr>
<td>compensationShiftOrientation</td>
<td>Same as shiftOrientation.</td>
</tr>
<tr>
<td>depth</td>
<td>The depth of the hole.</td>
</tr>
<tr>
<td>diameter</td>
<td>The diameter of the hole for <em>circular-pocket-milling</em> and <em>thread-milling</em> cycles.</td>
</tr>
<tr>
<td>direction</td>
<td>Either <em>climb</em> or <em>conventional</em> milling for <em>circular-pocket-milling</em> and <em>thread-milling</em> cycles.</td>
</tr>
<tr>
<td>dwell</td>
<td>The dwell time in seconds.</td>
</tr>
<tr>
<td>dwellDepth</td>
<td>The distance above the cut depth at which to dwell, used for <em>gun-drilling</em> cycles.</td>
</tr>
<tr>
<td>feedrate</td>
<td>The primary cutting feedrate.</td>
</tr>
<tr>
<td>incrementalDepth</td>
<td>The incremental pecking depth of the first cut.</td>
</tr>
<tr>
<td>incrementalDepthReduction</td>
<td>The incremental pecking depth reduction per cut for pecking cycles.</td>
</tr>
<tr>
<td>minimumIncrementalDepth</td>
<td>The minimum pecking depth of cut for pecking cycles.</td>
</tr>
<tr>
<td>numberOfSteps</td>
<td>The number of horizontal passes for the <em>thread-milling</em> cycle.</td>
</tr>
<tr>
<td>plungeFeedrate</td>
<td>The cutting feedrate. The same as <code>feedrate</code>.</td>
</tr>
<tr>
<td>plungesPerRetract</td>
<td>The number of cuts before the tool will be fully retracted during a <em>chip-breaking</em> cycle.</td>
</tr>
<tr>
<td>positioningFeedrate</td>
<td>The feedrate used to position the tool during a <em>gun-drilling</em> cycle.</td>
</tr>
<tr>
<td>positioningSpindleSpeed</td>
<td>The spindle speed used when positioning the tool during a <em>gun-drilling</em> cycle.</td>
</tr>
<tr>
<td>repeatPass</td>
<td>Set to true if the final pass should be repeated for <em>circular-pocket-milling</em> and <em>thread-milling</em> cycles.</td>
</tr>
<tr>
<td>retract</td>
<td>The plane where the tool will position to prior to starting the cycle (feeding into the hole).</td>
</tr>
</tbody>
</table>
Entry Functions

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>retractFeedrate</td>
<td>The tool retraction feedrate, used when feeding out of the hole.</td>
</tr>
<tr>
<td>shift</td>
<td>The distance to shift the tool away from the wall during a fine-boring and back-boring cycle.</td>
</tr>
<tr>
<td>shiftDirection</td>
<td>The direction in radians to shift the tool away from the wall during a fine-boring and back-boring cycle. The shift direction will be PI radians (180 degrees) from the wall plus this amount.</td>
</tr>
<tr>
<td>shiftOrientation</td>
<td>The spindle orientation of the tool in radians when shifting the tool away from the wall during a fine-boring or back-boring cycle.</td>
</tr>
<tr>
<td>stepover</td>
<td>The horizontal stepover distance for circular-pocket-milling and thread-milling cycles.</td>
</tr>
<tr>
<td>stock</td>
<td>The top of the hole.</td>
</tr>
<tr>
<td>stopSpindle</td>
<td>When set to 1, the spindle will be stopped during positioning/retracting in a gun-drilling cycle.</td>
</tr>
<tr>
<td>threading</td>
<td>Either right or left-handed threading for thread-milling cycles.</td>
</tr>
</tbody>
</table>

**Cycle Parameters**

### 4.24.3 The Cycle Planes/Heights

The drilling cycles use different heights during the execution of the cycle. These heights are specified in the Heights tab for the Drilling operation. One thing you should keep in mind is that the names given to these heights do not match the cycle parameter names in the post processor. The following table gives the relationship between the HSM height names and the equivalent cycle parameter names.

<table>
<thead>
<tr>
<th>Operation Heights Tab</th>
<th>Cycle Parameter</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clearance Height</td>
<td>(none)</td>
<td>The plane to position to the first point of the cycle and to retract the tool to after the final point of the cycle.</td>
</tr>
<tr>
<td>Retract Height</td>
<td>cycle.clearance</td>
<td>The tool rapids to this plane from the clearance height and will position between the holes at this height.</td>
</tr>
<tr>
<td>Feed Height</td>
<td>cycle.retract</td>
<td>The tool will feed from this plane into the hole.</td>
</tr>
<tr>
<td>Top Height</td>
<td>cycle.stock</td>
<td>The top of the hole.</td>
</tr>
<tr>
<td>Bottom Height</td>
<td>cycle.bottom</td>
<td>The bottom of the hole. This height is the plane where the tool will drill to and will be different from the actual bottom of the hole if the Drill tip through bottom box is checked.</td>
</tr>
</tbody>
</table>

**Correlation Between Cycle Operation Heights and Cycle Parameters**
HSM assumes that the tool will always be retracted to the Retract Height (*cycle.clearance*) between holes, you will notice this in the simulation of the cycle in HSM. This is typically handled in the machine control with a G98 (Retract to clearance plane) code. Of course this code can be different from machine control to machine control and there are controls that will always retract to the Feed Height (*cycle.retract*) at the end of a drilling operation. In this case it is up to the post processor to retract the tool to the Retract Height.

You can cancel the cycle at the end of the `onCyclePoint` function and output a tool retract block to take the tool back up to the Retract Height. When this method is used it is also mandatory that the full cycle be output for every hole in the operation and not just the first cycle point. Some machines support a retract plane to be specified with the cancel cycle code, i.e. G80 Rxxx.

```javascript
function onCyclePoint(x, y, z) {
  // if (isFirstCyclePoint()) {
    if (true) { // output a full cycle block for every hole in the operation
      repositionToCycleClearance(cycle, x, y, z);
      ...
      ...
      default:
      expandCyclePoint(x, y, z);
    }
  } else {
    if (cycleExpanded) {
      // retract tool (add at the end of the cycleType switch code)
      gMotionModal.format.reset();
      writeBlock(gCycleModal.format(80), gMotionModal.format(0), zOutput.format(cycle.clearance));
    } else {
      if (cycleExpanded) {
      ...
      ...
      }
    }
  }
}
```

**Retracting the Tool to the Retract Plane when Unsupported by Machine Control**

### 4.24.4 Common Cycle Functions

There are functions that are commonly used in the `onCyclePoint` function. The following table lists these functions.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>isFirstCyclePoint()</td>
<td>Returns <em>true</em> if this is the first point in the cycle operation. It is usually called to determine whether to output a full cycle block or just the cycle location.</td>
</tr>
<tr>
<td>isLastCyclePoint()</td>
<td>Returns <em>true</em> if this is the last point in the cycle operation. This function is typically used for a lathe threading operation since HSM sends a single pass to the <code>onCyclePoint</code> function and the full depth of the thread is required to output a single threading block. <code>onCycleEnd</code> is used to terminate a drilling cycle, so this function is not typically used in drilling cycles.</td>
</tr>
<tr>
<td>isProbingCycle()</td>
<td>Returns <em>true</em> if this is a probing cycle.</td>
</tr>
<tr>
<td>repositionToCycleClearance()</td>
<td>Moves the tool to the Retract Height plane (<em>cycle.clearance</em>). This function is typically called prior to outputting a full cycle block.</td>
</tr>
</tbody>
</table>
## Common Cycle Functions

These functions are built into the post engine, except the \texttt{getCommonCycle} function, which is contained in the post processor. It takes the cycle location (x, y, z) and the retract plane/distance (r) as arguments. Some machines require that the retract value be programmed as a distance from the current location rather than as an absolute position. There are two ways to accomplish this. You can pass in the distance as the retract value.

### Pass Retract Distance to Standard getCommonCycle Function

Or you can pass the clearance plane in to the \texttt{getCommonCycle} function and have it calculate the distance. This method is typically used in post processors that support subprograms that require a retract plane while in absolute mode and a distance when in incremental mode.
Pass Retract and Clearance Heights to getCommonCycle Function

### 4.24.5 Pitch Output with Tapping Cycles

Tapping cycles can be sometimes be output with a standard FPM feedrate, sometimes with a thread pitch, and sometimes using the FPR feedrate mode. There are different variables and formats involved depending on the format used. When using pitch or FPR feedrates you will need to create a format for this style of feedrate. The format is defined at the top of the post processor with the rest of the format definitions. Refer to the Format Definitions and Output Variable Definitions sections.

```javascript
var feedFormat = createFormat({decimals:(unit == MM ? 0 : 1), forceDecimal:true});
var pitchFormat = createFormat({decimals:(unit == MM ? 3 : 4), forceDecimal:true});
... var feedOutput = createVariable({prefix:"F"}, feedFormat);
var pitchOutput = createVariable({prefix:"F", force:true}, pitchFormat);
```

Create the Pitch Output Format

In the tapping sections of the `onCyclePoint` function you will need to assign the correct pitch value to the output. The tapping pitch is stored in the `tool.threadPitch` variable.

```javascript
case "tapping":
  writeBlock(
    gRetractModal.format(98), gCycleModal.format((84),
    getCommonCycle(x, y, z, cycle.retract),
    (conditional(P > 0, "P" + milliFormat.format(P)),
    pitchOutput.format(tool.threadPitch))
  );
  forceFeed(); // force the feedrate to be output after a tapping cycle with pitch output
break;
```

Output the Thread Pitch on a Tapping Cycle

If the tapping cycle requires that the machine be placed in FPR mode, then you can also calculate the pitch value by dividing the feedrate by the spindle speed. You will also need to output the FPR code (G95) with the tapping cycle and reset it at the end of the tapping operation, usually in the `onCycleEnd` function.

```javascript
var F = cycle.feedrate / spindleSpeed;
writeBlock(
  gRetractModal.format(98), gFeedModeModal.format(95), gCycleModal.format((84),
  getCommonCycle(x, y, z, cycle.retract),
...)
);
4.25 onCycleEnd

function onCycleEnd() {

The onCycleEnd function is called after all points in the cycle operation have been processed. The cycle is cancelled in this function and the feedrate mode (FPM) is reset if it is a tapping operation that uses FPR feedrates.

function onCycleEnd() {
  if (!cycleExpanded) {
    writeBlock(gCycleModal.format(80));
    // writeBlock(gFeedModeModal.format(94)), gCycleModal.format(80)); // reset FPM mode
    zOutput.reset();
  }
}

onCycleEnd Function

4.26 onRewindMachine

function onRewindMachine(_a, _b, _c) {

<table>
<thead>
<tr>
<th>Argument</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>_a, _b, _c</td>
<td>Rotary axes rewind positions.</td>
</tr>
</tbody>
</table>

The onRewindMachine function is used to reposition the rotary axes when a machine limit is reached. It is described in detail in the Rewinding of the Rotary Axis when Limits are Reached section of this manual.

4.27 Common Functions

There are functions that are common in most of the generic posts. Some of these functions are used in conjunction with other post processor functions and are described in the appropriate section of this manual, for example the formatComment function is described with the onComment function. This section describes the common functions that are generic in nature and used throughout the post processor.
4.27.1 writeln

\[
\text{writeln(text);}
\]

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>text</td>
<td>Text to output to the NC file</td>
</tr>
</tbody>
</table>

The `writeln` function is built into the post engine and is not defined in the post processor. It is used to output text to the NC file without formatting it. Text can be a quoted text string or a text expression. `writeln` is typically used for outputting text strings that don't require formatting, or debug messages.

```plaintext
writeln("%"); // outputs '%
writeln("Vector = " + new Vector(x, y, z)); // outputs the x, y, z variables in vector format
writeln(""); // outputs a blank line
writeln(formatComment("Load tool " + tool.number + " in spindle");
    // outputs 'Load tool n in spindle' as a comment
```

Sample writeln Calls

4.27.2 writeBlock

```plaintext
function writeBlock(arguments) {
    var text = formatWords(arguments);
    if (!text) {
        return;
    }
    if (properties.showSequenceNumbers) {
        // add sequence numbers to output blocks
        if (optionalSection) {
            if (text) {
                writeWords("/", "N" + sequenceNumber, text);
            }
        } else {
            writeWords2("N" + sequenceNumber, text);
        }
    }
}
```

The `writeBlock` function writes a block of codes to the output NC file. It will add a sequence number to the block, if sequence numbers are enabled and add an optional skip character if this is an optional operation. A list of formatted codes and/or text strings are passed to the `writeBlock` function. The code list is separated by commas, so that each code is passed as an individual argument, which allows for the codes to be separated by the word separator defined by the `setWordSeparator` function.
sequenceNumber += properties.sequenceNumberIncrement;
} else {
    // no sequence numbers
    if (optionalSection) {
        writeWords2("/", text);
    } else {
        writeWords(text);
    }
}

Sample writeBlock Function

writeBlock(gAbsIncModal.format(90), xFormat.format(x), yFormat.format(y));
writeBlock("G28", "X" + xFormat.format(0), "Y" + yFormat.format(0));  // outputs 'G28 X0 Y0'
writeBlock("G28" + "X" + xFormat.format(0) + "Y" + yFormat.format(0));  // outputs 'G28 X0Y0'

Sample writeBlock Calls

The writeBlock function does not usually have to be modified.

4.27.3 toPreciseUnit

toPreciseUnit(value, units);

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>value</td>
<td>The input value.</td>
</tr>
<tr>
<td>units</td>
<td>The units that the value is given in, either MM or IN.</td>
</tr>
</tbody>
</table>

The toPreciseUnit function allows you to specify a value in a given units and that value will be returned in the active units of the input intermediate CNC file. When developing a post processor, it is highly recommended that any unit based hard coded numbers use the toPreciseUnit function when defining the number.

yAxisMinimum = toPreciseUnit(gotYAxis ? -50.8 : 0, MM); // minimum range for the Y-axis
yAxisMaximum = toPreciseUnit(gotYAxis ? 50.8 : 0, MM); // maximum range for the Y-axis
xAxisMinimum = toPreciseUnit(0, MM); // maximum range for the X-axis (radius mode)

Defining Values using toPreciseUnit

4.27.4 force---
The force functions are used to force the output of the specified axes and/or feedrate the next time they are supposed to be output, even if it has the same value as the previous value.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>forceXYZ</td>
<td>Forces the output of the linear axes (X, Y, Z) on the next motion block.</td>
</tr>
<tr>
<td>forceABC</td>
<td>Forces the output of the rotary axes (A, B, C) on the next motion block.</td>
</tr>
<tr>
<td>Function</td>
<td>Description</td>
</tr>
<tr>
<td>-------------</td>
<td>-----------------------------------------------------------------------------</td>
</tr>
<tr>
<td>forceFeed</td>
<td>Forces the output of the feedrate on the next motion block.</td>
</tr>
<tr>
<td>forceAny</td>
<td>Forces all axes and the feedrate on the next motion block.</td>
</tr>
</tbody>
</table>

### Force Functions

```javascript
/** Force output of X, Y, and Z on next output. */
function forceXYZ() {
    xOutput.reset();
yOutput.reset();
zOutput.reset();
}

/** Force output of A, B, and C on next output. */
function forceABC() {
    aOutput.reset();
bOutput.reset();
cOutput.reset();
}

/** Force output of F on next output. */
function forceFeed() {
    currentFeedId = undefined;
    feedOutput.reset();
}

/** Force output of X, Y, Z, A, B, C, and F on next output. */
function forceAny() {
    forceXYZ();
    forceABC();
    forceFeed();
}
```

### Sample Force Functions

#### 4.27.5 writeRetract

```javascript
function writeRetract(arguments) {
    // Function implementation...
}
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>arguments</td>
<td>X, Y, and/or Z. Separated by commas when multiple axes are specified.</td>
</tr>
</tbody>
</table>

The `writeRetract` function is used to retract the Z-axis to its clearance plane and move the X and Y axes to their home positions.

The `writeRetract` function can be called with one or more axes to move to their home position. The axes are specified using their standard names of X, Y, Z, and are separated by commas if multiple axes are specified in the call to `writeRetract`. 
The writeRetract function is not generic in nature and may have to be changed to match your machine's requirements. For example, some machines use a G28 to move an axis to its home position, some will use a G53 with the home position, and some use a standard G00 block.

```javascript
/** Output block to do safe retract and/or move to home position. */
function writeRetract() {
    // initialize routine
    var _xyzMoved = new Array(false, false, false);
    var _useG28 = properties.useG28; // can be either true or false

    // check syntax of call
    if (arguments.length == 0) {
        error(localize("No axis specified for writeRetract()."));
        return;
    }
    for (var i = 0; i < arguments.length; ++i) {
        if ((arguments[i] < 0) || (arguments[i] > 2)) {
            error(localize("Bad axis specified for writeRetract()."));
            return;
        }
        if (_xyzMoved[arguments[i]]) {
            error(localize("Cannot retract the same axis twice in one line"));
            return;
        }
        _xyzMoved[arguments[i]] = true;
    }

    // special conditions
    if (_useG28 && _xyzMoved[2] && (_xyzMoved[0] || _xyzMoved[1])) { // XY don't use G28
        error(localize("You cannot move home in XY & Z in the same block."));
        return;
    }
    if (_xyzMoved[0] || _xyzMoved[1]) {
        _useG28 = false;
    }

    // define home positions
    var _xHome;
    var _yHome;
    var _zHome;
    if (!_useG28) {
        writeRetract(Z); // move the Z-axis to its home position
        writeRetract(X, Y); // move the X and Y axes to their home positions
    }
}
```

Sample writeRetract Calls
```javascript
_xHome = 0;
_yHome = 0;
_zHome = 0;
} else {
    if (properties.homePositionCenter &&
        hasParameter("part-upper-x") && hasParameter("part-lower-x")) {
        _xHome = (getParameter("part-upper-x") + getParameter("part-lower-x")) / 2;
    } else {
        _xHome = machineConfiguration.hasHomePositionX() ?
            machineConfiguration.getHomePositionX() : 0;
    }
    _yHome = machineConfiguration.hasHomePositionY() ?
        machineConfiguration.getHomePositionY() : 0;
    _zHome = machineConfiguration.getRetractPlane();
}

// format home positions
var words = [];
for (var i = 0; i < arguments.length; ++i) {
    // define the axes to move
    switch (arguments[i]) {
    case X:
        // special conditions
        if (properties.homePositionCenter) {
            writeBlock(gMotionModal.format(0), xOutput.format(_xHome));
            _xyzMoved[0] = false;
            break;
        }
        words.push("X" + xyzFormat.format(_xHome));
        break;
    case Y:
        words.push("Y" + xyzFormat.format(_yHome));
        break;
    case Z:
        words.push("Z" + xyzFormat.format(_zHome));
        retracted = true;
        break;
    }
}

// output move to home
if (words.length > 0) {
    if (_useG28) {
        gAbsIncModal.reset();
        writeBlock(gFormat.format(28), gAbsIncModal.format(91), words);
        writeBlock(gAbsIncModal.format(90));
    }
}```

} else { // use G53 to move to home position
    gMotionModal.reset();
    writeBlock(gAbsIncModal.format(90), gFormat.format(53), gMotionModal.format(0), words);
}

// force any axes that move to home on next block
if (_xyzMoved[0]) {
    xOutput.reset();
}
if (_xyzMoved[1]) {
    yOutput.reset();
}
if (_xyzMoved[2]) {
    zOutput.reset();
}
}

Sample writeRetract Function

5 Manual NC Commands

Manual NC commands are used to control the behavior of individual operations when there is not a
setting in the operation form for controlling a specific feature of a control. You can use Manual NC
commands to display a message, insert codes into the output NC file, perform an optional stop, define a
setting, etc. The Manual NC menu is accessed from different areas of the ribbon menu depending on the
product you are running.

Selecting a Manual NC Command in the HSM Products (Fusion 360, Inventor, HSMWorks)

Once you select the Manual NC menu you will see a form displayed that is used to select the type of
Manual NC command that you want to pass to the post processor and optionally the parameter that will
be passed with the command.
If you use a Manual NC command in your part, then it is necessary that the post processor is equipped to handle this command. Some of the commands are supported by the stock post processors, such as Stop, Optional stop, and Dwell, while support would have to be added to the post processor to support other Manual NC commands. If you use a Manual NC command that is not supported by the post, then it will either generate an error or be ignored. The general rule is it will generate an error if the onCommand function is called and will be ignored when another function is called.

5.1 onManualNC and expandManualNC

```javascript
function onManualNC(command, value) {
    expandManualNC(command, value)
}
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>command</td>
<td>The Manual NC command that invoked the function.</td>
</tr>
<tr>
<td>value</td>
<td>The value entered with the command.</td>
</tr>
</tbody>
</table>

The onManualNC function is defined in the post processor and is used to process Manual NC commands. It accepts the command and the value that is assigned to the command. If the onManualNC function is not defined in the post processor, then a separate function will be called as listed in the table below.

The expandManualNC command can also be used to process the Manual NC command using the separate functions listed in the table. It is typically used as the default condition in the onManualNC function to process commands where you do not care if they are entered as a Manual NC command or from an internal call in the post processor.

The following table describes the Manual NC commands along with the function that will be called when the command is processed when the onManualNC function does not exist or expandManualNC is called.

<table>
<thead>
<tr>
<th>Manual NC Command</th>
<th>Description</th>
<th>Command</th>
<th>Value</th>
<th>Function Called</th>
</tr>
</thead>
<tbody>
<tr>
<td>Comment</td>
<td>Operator message</td>
<td>COMMAND_COMMENT</td>
<td>message</td>
<td>onComment</td>
</tr>
<tr>
<td>Stop</td>
<td>Machine stop</td>
<td>COMMAND_STOP</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Manual NC Command</td>
<td>Description</td>
<td>Command</td>
<td>Value</td>
<td>Function Called</td>
</tr>
<tr>
<td>-------------------</td>
<td>-------------</td>
<td>---------</td>
<td>-------</td>
<td>-----------------</td>
</tr>
<tr>
<td>Optional Stop</td>
<td>Optional stop</td>
<td>COMMAND_OPTIONAL_STOP</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Dwell</td>
<td>Dwell</td>
<td>COMMAND_DWELL</td>
<td>Dwell time in seconds</td>
<td>onDwell</td>
</tr>
<tr>
<td>Tool break control</td>
<td>Check for tool breakage</td>
<td>COMMAND_BREAK_CONTROL</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Measure tool</td>
<td>Automatically measure tool length</td>
<td>COMMAND_TOOL_MEASURE</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Start chip transport</td>
<td>Start chip conveyor</td>
<td>COMMAND_START_CHIP_TRANSPORT</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Stop chip transport</td>
<td>Stop chip conveyor</td>
<td>COMMAND_STOP_CHIP_TRANSPORT</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Open door</td>
<td>Open main door</td>
<td>COMMAND_OPEN_DOOR</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Close door</td>
<td>Close main door</td>
<td>COMMAND_CLOSE_DOOR</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Calibrate</td>
<td>Calibration of machine</td>
<td>COMMAND_CALIBRATE</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Verify</td>
<td>Verify integrity of machine</td>
<td>COMMAND_VERIFY</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Clean</td>
<td>Request a cleaning cycle</td>
<td>COMMAND_CLEAN</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Action</td>
<td>User defined action</td>
<td>COMMAND_ACTION</td>
<td>text</td>
<td>onParameter</td>
</tr>
<tr>
<td>Print message</td>
<td>Print a message from the machine</td>
<td>COMMAND_PRINT_MESSAGE</td>
<td>message</td>
<td>onParameter</td>
</tr>
<tr>
<td>Display message</td>
<td>Display operator message</td>
<td>COMMAND_DISPLAY_MESSAGE</td>
<td>message</td>
<td>onParameter</td>
</tr>
<tr>
<td>Alarm</td>
<td>Create an alarm on the machine</td>
<td>COMMAND_ALARM</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Alert</td>
<td>Request an alert event on the machine</td>
<td>COMMAND_ALERT</td>
<td></td>
<td>onCommand</td>
</tr>
<tr>
<td>Pass through</td>
<td>Output literal text to NC file</td>
<td>COMMAND_PASS_THROUGH</td>
<td>text</td>
<td>onPassThrough</td>
</tr>
<tr>
<td>Force tool change</td>
<td>Force a tool change</td>
<td>section.getForceToolChange()</td>
<td>(none)</td>
<td></td>
</tr>
<tr>
<td>Call program</td>
<td>Call a subprogram</td>
<td>COMMAND_CALL_PROGRAM</td>
<td>text</td>
<td>onParameter</td>
</tr>
</tbody>
</table>

**5.1.1 Sample onManualNC Function**

The `onManualNC` function is a recent addition to the post processor and will not be found in most generic post processors. You do not have to define it to process Manual NC commands, and if it is
defined, do not need to process all Manual NC commands in this function. It could be used to process only the commands where you need to know if they were generated from a CAM Manual NC command instead of a direct call from within the post processor.

For example, the following `onManualNC` function definition could be used to process comments entered using the CAM Manual NC command differently than comments generated from the post processor. It simply appends the text ‘MSG,’ prior to the comment for a Manual NC Display comment command. All other Manual NC commands are processed normally.

```javascript
function onManualNC(command, value) {
  switch (command) {
    case COMMAND_DISPLAY_MESSAGE:
      writeComment("MSG, " + value);
      break;
    default:
      expandManualNC(command, value); // normal processing of Manual NC command
      }
}
```

### Handling of Display Message Command in onManualNC

#### 5.1.2 Delay Processing of Manual NC Commands

Manual NC commands are processed at the placement in the operation tree where they are entered, which means that they will be processed prior to the call to `onSection`. Since `onSection` typically terminates the previous operation prior to starting the new operation, this might not be the desirable location to process the Manual NC command.

The following code examples show how Manual NC commands can be buffered and output at any point during the operation. You can simply copy the `onManualNC` and `executeManualNC` functions into your post processor and add the appropriate call(s) to `executeManualNC` where you want to process the Manual NC commands.

```javascript
/**
 * Buffer Manual NC commands for processing later
 */
var manualNC = [];
function onManualNC(command, value) {
  manualNC.push({command:command, value:value});
}

/**
 * Processes the Manual NC commands
 * Pass the desired command to process or leave argument list blank to process all buffered commands
 */
function executeManualNC(command) {
  // process buffered Manual NC commands
}
```
for (var i = 0; i < manualNC.length; ++i) {
    if (!command || (command == manualNC[i].command)) {
        switch(manualNC[i].command) {
            case COMMAND_DISPLAY_MESSAGE:
                writeComment("MSG, " + manualNC[i].value);
                break;
            default:
                expandManualNC(manualNC[i].command, manualNC[i].value);
        }
    }
}
for (var i = manualNC.length -1; i >= 0; --i) {
    if (!command || (command == manualNC[i].command)) {
        manualNC.splice(i, 1);
    }
}

Manual NC Commands Support Functions

The calls to process the Manual NC commands can be placed anywhere in the post processor. In the following code example, the COMMAND_DISPLAY_MESSAGE command is processed just before the tool change block is output and the rest of the Manual NC commands after the tool change block.

```java
executeManualNC(COMMAND_DISPLAY_MESSAGE); // display Manual NC message
writeBlock("T" + toolFormat.format(tool.number), mFormat.format(6));
if (tool.comment) {
    writeComment(tool.comment);
}
executeManualNC(); // process remaining Manual NC commands
```

Processing of Manual NC Commands in the Desired Location

The following sections give a description of the functions that are called by the Manual NC commands outside of the onManualNC function and samples on how they are handled in the functions. The onComment and onDwell functions are described in the Entry Functions chapter, since they are simple functions and behave in the same manner no matter how they are called.

5.2 onCommand

function onCommand(command) {

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>command</td>
<td>Command to process.</td>
</tr>
</tbody>
</table>

All Manual NC commands that do not require an associated parameter are passed to the onCommand function and as you see from the Manual NC Commands table, this entails the majority of the
commands. The onCommand function also handles other commands that are not generated by a Manual NC command and these are described in the onCommand section in the Entry Functions chapter.

```javascript
// define commands that output a single M-code
var mapCommand = {
  COMMAND_STOP:0,
  COMMAND_OPTIONAL_STOP:1,
  COMMAND_START_CHIP_TRANSPORT:31,
  COMMAND_STOP_CHIP_TRANSPORT:33
  ...
};

function onCommand(command) {
  switch (command) {
    ...
    case COMMAND_BREAK_CONTROL: // handle the 'Tool break' command
      if (!toolChecked) { // avoid duplicate COMMAND_BREAK_CONTROL
        onCommand(COMMAND_STOP_SPINDLE);
        onCommand(COMMAND_COOLANT_OFF);
        writeBlock(
          gFormat.format(65),
          "P" + 9853,
          "T" + toolFormat.format(tool.number),
          "B" + xyzFormat.format(0),
          "H" + xyzFormat.format(properties.toolBreakageTolerance)
        );
        toolChecked = true;
      }
      return;
    case COMMAND_TOOL_MEASURE: // ignore tool measurements
      return;
    }
  }

  // handle commands that output a single M-code
  var stringId = getCommandStringId(command);
  var mcode = mapCommand[stringId];
  if (mcode !== undefined) {
    writeBlock(mFormat.format(mcode));
  } else { 
    onUnsupportedCommand(command);
  }

  return;
}
```

Handling Manual NC Commands in the onCommand Function
5.3 onParameter

function onParameter(name, value) {

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>name</td>
<td>Parameter name.</td>
</tr>
<tr>
<td>value</td>
<td>Value stored in the parameter.</td>
</tr>
</tbody>
</table>

The `onParameter` function is not only called for all parameters defined in the intermediate file (see the many calls to `onParameter` in the dump.cps post processor output) it also handles the `Action`, `Call program`, `Display message`, and `Print message` Manual NC commands. It is passed both the name of the parameter being defined and the text string associated with that parameter.

<table>
<thead>
<tr>
<th>Manual NC Command</th>
<th>Name</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Action</td>
<td>action</td>
<td>text</td>
</tr>
<tr>
<td>Call program</td>
<td>call-subprogram</td>
<td>text</td>
</tr>
<tr>
<td>Display message</td>
<td>display</td>
<td>text</td>
</tr>
<tr>
<td>Print message</td>
<td>Print</td>
<td>text</td>
</tr>
</tbody>
</table>

### Manual NC Commands Handled in onParameter

This section will describe how the `Action` command can be used, since this is the most commonly used of these commands.

The `Action` command is typically used to define post processor settings, similar to the post properties defined at the top of the post processor, except that the settings defined using this command typically only apply to a single operation. Since the HSM operations are executed in the order that they are defined in the CAM tree, the Manual NC command will always be processed prior to the operation that they precede. You can also use the `Action` command to define a setting so that the command can be executed within another section of the post, by referencing this setting. You can even define settings that are typically set in the post properties into your program, so you are not reliant on making sure that the property is set for a specific program. In this case the `Action` command would set the value of the post property based on the input value associated with the command.

It is the `onParameter` function’s responsibility to parse the text string passed as part of the `Action` command. The text string could be a value, list of values, command and value, etc. The following table lists the `Action` commands that are supported by the sample post processor code used in this section. These `Action` commands set variables that will be used elsewhere in the program.

<table>
<thead>
<tr>
<th>Action Command</th>
<th>Values</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>Smoothing</td>
<td>Off, Low, Medium, High</td>
<td>Sets the smoothing type</td>
</tr>
<tr>
<td>Tolerance</td>
<td>.001-.999</td>
<td>Smoothing tolerance</td>
</tr>
<tr>
<td>fastToolChange</td>
<td>Yes, No</td>
<td>Overrides the <code>fastToolChange</code> post property</td>
</tr>
</tbody>
</table>

### Sample Action Type Manual NC Commands

In this example, the format for entering the `Action` Manual NC command is to specify the command followed by the ‘:’ separator which in turn is followed by the value, in the `Action` text field.
var smoothingType = 0;
var smoothingTolerance = .001;
function onParameter(name, value) {
    var invalid = false;
    switch (name) {
    case "action":
        var sText1 = String(value).toUpperCase();
        var sText2 = new Array();
        sText2 = sText1.split(":");
        if (sText2.length != 2) {
            error(localize("Invalid action command: ") + value);
            return;
        }
        switch (sText2[0]) {
        case "SMOOTHING":
            smoothingType = parseChoice(sText2[1], "OFF", "LOW", "MEDIUM", "HIGH");
            if (smoothingType == undefined) {
                error(localize("Smoothing type must be Off, Low, Medium, or High"));
                return;
            }
            break;
        case "TOLERANCE":
            smoothingTolerance = parseFloat(sText2[1]);
            if (isNaN(smoothingTolerance) || (smoothingTolerance < .001) || (smoothingTolerance > .999)) {
                error(localize("Smoothing tolerance must be a value between .001 and .999"));
                return;
            }
            break;
        case "FASTTOOLCHANGE":
            var fast = parseChoice(sText2[1], "YES", "NO");
            if (fast == undefined) {
                error(localize("fastToolChange must be Yes or No"));
                return;
            }
            break;
        default:
            invalid = true;
            break;
        }
    return谎
}
Handling the Action Manual NC Command

To make it easier to use custom Action Manual NC commands you can use the Template capabilities of HSM. First you will create the Manual NC command that you will turn into a template using the example in the Action Command Format picture shown above. Once the Manual NC command is created you will want to give it a meaningful name by renaming it in the Operation Tree.

Now you will create a template from this Manual NC command by right clicking on the Manual NC command and selecting Store As Template. You will want to give the template the same name as you did in the rename operation.
Creating the Manual NC Command Template

The template is now ready to be used in other operations and parts. You do this by right clicking a Setup or a Folder in the Operations Tree, position the mouse over the *Create From Template* menu and select the template you created.

Using the Manual NC Command Template You Created

### 5.4 `onPassThrough`

Function `onPassThrough (value)`

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>value</td>
<td>Text to be output to the NC file.</td>
</tr>
</tbody>
</table>

The *Pass through* Manual NC command is used to pass a text string directly to the NC file without any processing by the post processor. It is similar to editing the NC file and adding a line of text by hand. The text string could be standard codes (G, M, etc.) or a simple message. Since the post has no control or knowledge of the codes being output, it is recommended that you use the *Pass through* command sparingly and only with codes that cannot be output using another method.

The `onPassThrough` function handles the *Pass through* Manual NC command and is passed the text entered with the command. The following sample code will accept a text string with comma delimiters that will separate the text into individual lines.

```javascript
function onPassThrough(text) {
    var commands = String(text).split(",");
    for (text in commands) {
        writeBlock(commands[text]);
    }
}
```

Output Lines of Codes/Text Separated by Commands Using the *Pass through* Manual NC Command
Like the Action Manual NC command, you can setup a Template to use with the Pass through command if you find yourself needing to output the same codes in multiple instances.

6 Debugging

6.1 Overview
The first thing to note when debugging is that there is not an interactive debugger associated with the Autodesk CAM post processors. This means that all debugging information must be output using settings within the post and with explicit writes. This section describes different methods you can use when debugging your post.

You can also use the HSM Post Processor Editor to aid in debugging your program as described in the Running/Debugging the Post section of this manual.

6.2 The dump.cps Post Processor
The dump.cps post processor will process an intermediate CNC file and output a file that contains all of the information passed from HSM to the post processor. The output file has a file extension of .dmp. The contents of the dump file will show the settings of all parameter values and will list the entry functions called along the arguments passed to the function and any settings that apply to that function. The dump.cps output can be of tremendous value when developing and debugging a post processor.

```
342: onParameter('dwell', 0)
344: onParameter('incrementalDepth', 0.03937007874015748)
346: onParameter('incrementalDepthReduction', 0.003937007932681737)
348: onParameter('minimumIncrementalDepth', 0.01968503937007874)
350: onParameter('accumulatedDepth', 5)
352: onParameter('chipBreakDistance', 0.004023600105694899)
354: onMovement(MOVEMENT_CUTTING /*cutting*/)
354: onCycle()
   cycleType='chip-breaking'
   cycle.clearance=123456
   cycle.retract=0.19685039370078738
   cycle.stock=0
   cycle.depth=0.810440544068344
   cycle.feedrate=15.748000257597194
   cycle.retractFeedrate=39.370100366787646
   cycle.plungeFeedrate=15.748000257597194
   cycle.dwell=0
   cycle.incrementalDepth=0.03937007874015748
   cycle.incrementalDepthReduction=0.003937007932681737
   cycle.minimumIncrementalDepth=0.01968503937007874
   cycle.accumulatedDepth=5
   cycle.chipBreakDistance=0.004023600105694899
```
6.3 Debugging using Post Processor Settings

There are variables available to the developer that control the output of debugging information. This section contains a description of these variables.

6.3.1 debugMode

```c
debugMode = true;
```

Setting the `debugMode` variable to true enables the output of debug information from the `debug` command and is typically defined at the start of the post processor.

6.3.2 setWriteInvocations

```c
setWriteInvocations (value);
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>value</td>
<td><code>true</code> outputs debug information for the entry functions.</td>
</tr>
</tbody>
</table>

Enabling the `setWriteInvocations` setting will create debug output in the NC file similar to what is output using the `dump` post processor. The debug information contains the entry functions (`onParameter`, `onSection`, etc.) called during post processing and the parameters that they are called with. This information will be output prior to actually calling the entry function and is labeled using the `!DEBUG:` text.

```c
!DEBUG: onRapid(-0.433735, 1.44892, 0.23622)
N190 Z0.2362
!DEBUG: onLinear(-0.433735, 1.44892, 0.0787402, 39.3701)
N195 G1 Z0.0787 F39.37
!DEBUG: onLinear(-0.433735, 1.44892, -0.5, 19.685)
N200 Z-0.5 F19.68
```

setWriteInvocations Output

6.3.3 setWriteStack

```c
setWriteStack (value);
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>value</td>
<td><code>true</code> outputs the call stack that outputs the line to the NC file.</td>
</tr>
</tbody>
</table>

Sample dump.cps Output
Enabling the `setWriteStack` setting displays the call stack whenever text is output to the NC file. The call stack will consist of the `!DEBUG:` label, the call level, the name of the post processor, and the line number of the function call (the function name is not included in the output).

```
!DEBUG: 1 rs274.cps:108
!DEBUG: 2 rs274.cps:919
!DEBUG: 3 rs274.cps:357
N125 M5
```

**setWriteStack Output**

```
...  
108: writeWords2("N" + sequenceNumber, arguments);  
...  
357: onCommand(COMMAND_STOP_SPINDLE);  
...  
919: writeBlock(mFormat.format(mcode));
```

**Post Processor Contents**

### 6.4 Functions used with Debugging

Functions that can be used to output debug information to the log and NC files include `debug`, `writeln`, and `log`. Additionally, the `writeComment` function present in almost all post processors can be used.

The text provided to the debug functions can contain operations and follow the same rules as defining a string variable in JavaScript. You can also specify vectors or matrixes and these will be properly formatted for output. For example,

```javascript
var x = 3;
devbug("The value of x is " + x);
```

For floating point values you may want to create a format that limits the number of digits to right of the decimal point, as some numbers can be quite long when output.

```javascript
var numberFormat = createFormat({decimals:4});
var x = 3;
devbug("The value of x is " + numberFormat.format(x));
```

When writing output debug information to the log and/or NC files it is recommended that you precede the debug text with a fixed string, such as "DEBUG – ", so that it is easily discernable from other output.

### 6.4.1 debug

```javascript
devbug (text);
```
### Arguments

<table>
<thead>
<tr>
<th>Argument</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>text</td>
<td>Outputs text to the log file when debugMode is set to true.</td>
</tr>
</tbody>
</table>

The `debug` function outputs the provided text message to the log file only when the `debugMode` variable is set to true. The text is output exactly as provided, without any designation that the output was generated by the `debug` function.

#### 6.4.2 log

```plaintext
log(text);
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>text</td>
<td>Outputs text to the log file.</td>
</tr>
</tbody>
</table>

The `log` function outputs the text to the log file. It is similar to the `debug` function, but does not rely on the `debugMode` setting.

#### 6.4.3 writeln

```plaintext
writeln(text);
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>text</td>
<td>Outputs text to the NC file.</td>
</tr>
</tbody>
</table>

The `writeln` function outputs the text to the NC file. It is used extensively in post processors to output valid data to the NC file and not just debug text.

#### 6.4.4 writeComment

```plaintext
writeComment(text);
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>text</td>
<td>Outputs text to the NC file as a comment.</td>
</tr>
</tbody>
</table>

The `writeComment` function is defined in the post processor and is used to output comments to the output NC file. It is described in the onComment section of this manual.

#### 6.4.5 writeDebug

```plaintext
writeDebug(text);
```

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>text</td>
<td>Outputs text to the NC and log files.</td>
</tr>
</tbody>
</table>
The `writeDebug` function is not typically present in the generic post processors. You can create one to handle the output of debug information to both the log file and NC file so that if the post processor either fails or runs successfully you would still see the debug output.

```javascript
function writeDebug(text) {
    if (true) { // can use the global setting 'debugMode' instead
        writeln("DEBUG - " + text); // can use 'writeComment' instead
        log("DEBUG - " + text); // can use 'debug' instead
    }
}
```

**Sample writeDebug Function**

7 Multi-Axis Post Processors

7.1 Adding Basic Multi-Axis Capabilities

Adding multi-axis capabilities to a post processor can be rather straight forward or difficult depending on the situation. This chapter will cover the basics and the more complex aspects of multi-axis support, such as adjusting points for a head, inverse time feedrates, etc.

The generic RS-274D Sample Multi-axis Post Processor is available to use as a sample for implementing multi-axis support in any post processor. It supports CAM defined and hardcoded Machine Configurations. You can use this post processor for testing rotary axes configurations and for copying functionality into your custom post processor.

Please note that support for 3+2 operations is not handled here, except for the setup of the machine. Refer to the Work Plane section in the `onSection` chapter for a description on how to handle 3+2 operations.

7.1.1 Create the Rotary Axes Formats

The output formats for the rotary axes must first be defined. In existing multi-axis posts and posts that contain the skeleton structure of multi-axis support these codes should already be defined. You should add (or verify that they already exist) the following definitions at the top of the post processor in the same area that all other formats are defined.

```javascript
var abcFormat = createFormat({decimals:3, forceDecimal:true, scale:DEG});
...
var aOutput = createVariable({prefix:"A"}, abcFormat);
var bOutput = createVariable({prefix:"B"}, abcFormat);
var cOutput = createVariable({prefix:"C"}, abcFormat);
```

**Define the Rotary Axes Formats**

The `scale:DEG` parameter specifies that the rotary axes angles will be output in degrees. If you require the output to be in radians, then omit the `scale` setting.
7.1.2 The Machine Configuration Settings and Functions

The machine configuration and the associated settings are above the `onOpen` function and define and activate the machine configuration in the post processor. If your post processor does not have this code, or it uses the older method of defining a machine configuration in `onOpen`, then you should copy this code from the RS-274D Sample Multi-axis post processor into your post. All lines between and including the following lines should be copied.

```javascript
// Start of machine configuration logic
...
// End of machine configuration logic
```

Copy this Code to your Custom Post Processor

You will also need to add the following code to the top of the `onOpen` function to call the machine configuration functions.

```javascript
function onOpen() {
    // define and enable machine configuration
    receivedMachineConfiguration = (typeof machineConfiguration.isReceived == "function") ?
        machineConfiguration.isReceived() :
        ((machineConfiguration.getDescription() != "") ||
        machineConfiguration.isMultiAxisConfiguration());
    if (typeof defineMachine == "function") {
        defineMachine(); // hardcoded machine configuration
    }
    activateMachine(); // enable the machine optimizations and settings
}
```

Copy this Code to the Top of the onOpen Function

The variables at the top of the machine configuration code control certain aspects of multi-axis logic within the post processor.

```javascript
var compensateToolLength = false; // add the tool length to the pivot distance for nonTCP rotary heads
var virtualTooltip = false; // translate the pivot point to the virtual tool tip for nonTCP rotary heads
```

<table>
<thead>
<tr>
<th>Variable</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>compensateToolLength</td>
<td>This variable is only used for rotary head configurations that do not support TCP. When it is enabled, the body length of the tool (length below holder) will be added to the pivot distance. Rotary head configurations are discussed in detail in the Adjusting the Points for Offset Rotary Axes section.</td>
</tr>
<tr>
<td>virtualTooltip</td>
<td>This variable is only used for rotary head configurations that do not support TCP. When it is enabled the virtual tooltip will be output. If it is disabled the pivot point will be output. Rotary head configurations are discussed in detail in the Adjusting the Points for Offset Rotary Axes section.</td>
</tr>
</tbody>
</table>

Multi-axis Control Variables
7.1.3 Creating a Hardcoded Multi-Axis Machine Configuration

You can use a Machine Configuration in the CAM system to define the rotary axes kinematics of the machine or it can be hardcoded in the post processor. This section describes how you would hardcode the machine configuration inside of the post processor script.

The hardcoded machine configuration can be found in the `defineMachine` function. The basic code for defining the multi-axis machine configuration will look similar to the following example.

```javascript
function defineMachine() {
    // if (!receivedMachineConfiguration) { // CAM provided machine configuration takes precedence
    if (true) { // hardcoded machine configuration takes precedence
        // define machine kinematics
        var aAxis = createAxis({coordinate:X, table:true, axis:[1, 0, 0], offset:[0, 0, 0], range:[-120, 30],
                               cyclic:false, preference:-1, tcp:false});
        var cAxis = createAxis({coordinate:Z, table:true, axis:[0, 0, 1], offset:[0, 0, 0], cyclic:true,
                               tcp:false});
        machineConfiguration = new MachineConfiguration(aAxis, cAxis);
        setMachineConfiguration(machineConfiguration); // inform post kernel of hardcoded configuration
        if (receivedMachineConfiguration) {
            warning(localize("The provided CAM machine configuration is overwritten by the postprocessor.");)
            receivedMachineConfiguration = false; // CAM provided machine configuration is overwritten
        }
    }
    /* home positions */
    // machineConfiguration.setHomePositionX(toPreciseUnit(0, IN));
    // machineConfiguration.setHomePositionY(toPreciseUnit(0, IN));
    // machineConfiguration.setRetractPlane(toPreciseUnit(0, IN));
}
```

Define Hardcoded Machine Configuration

The rotary axes can be customized to match the machine configuration using the parameters in the `createAxis` command.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>table</td>
<td>Set to <code>true</code> when the rotary axis is a table, or <code>false</code> if it is a head. The default if not specified is <code>true</code>.</td>
</tr>
<tr>
<td>axis</td>
<td>Specifies the rotational axis of the rotary axis in the format of a vector, i.e. ([0, 0, 1]). This vector does not have to be orthogonal to a major plane, for example it could be ([0, .7071, .7071]). The direction of the rotary axes are based on the righthand rule for tables and the lefthand rule for heads. You can change direction of the axis by supplying a vector pointing in the opposite direction, i.e. ([0, 0, -1]). This parameter is required.</td>
</tr>
<tr>
<td>offset</td>
<td>Defines the rotational position of the axis in the format of a coordinate, i.e. ([0, 0, 0]). For machines that support TCP the <code>offset</code> parameter can be omitted. The offset values for tables are based on the part origin defined in the Setup. The offset value for the...</td>
</tr>
</tbody>
</table>
Parameter | Description
--- | ---
rider or primary rotary head is based on the distance from the tool stop (or spindle face) position to the pivot point of the rotary head. The offset value for the carrier rotary head (when the machine has a head/head configuration) is based on the pivot point of the rider axis to the pivot point of the carrier axis. The default is [0, 0, 0].
coordinate | Defines the coordinate of the axis, either X, Y, or Z. You will notice a number used in most of the generic posts, in this case 0=X, 1=Y, and 2=Z. Either specification is acceptable input. This parameter is required.
cyclic | Defines whether the axis is cyclic (continuous) in nature, in that the output will always be within the range specified by the range parameter. Cyclic axes will never cause the onRewindFunction to be called, since they are continuous in nature and do not have limits. The range applies specifically to output values for this axis. The default is false.
tcp | Defines whether the control supports Tool Center Point programming for this axis. Each axis can have its own setting. The default is true.
range | Defines the upper and lower limits of the rotary axis using the format [lower, upper]. If the rotary axis is cyclic, then the range sets the limits of the output values for this axis, if it is not cyclic the range is the actual physical limits of the machine.
preference | Specifies the preferred angle direction at the beginning of an operation. -1 = choose the negative angle, 0 = no preference, and 1 = choose the positive angle. The default is 0.
reset | Defines the starting position of the axis for a new operation and when the rotary axes need to be rewound and reconfigured due to exceeding the limits. 0 = remember the position from previous section, 1 = reset to 0 at start of operation, 2 = reset to 0 at automatic rewind, 3 = reset to 0 at start of operation and at automatic rewind. This parameter is implemented since R42225 of the post engine.
resolution | Specifies the resolution in degrees of the rotational actuator. Typically, this will be set to the number of digits to the right of the decimal as specified in the createFormat call for the rotary axes. The default is 0.

**createAxis Parameters**

The order in which the axes are defined in the new MachineConfiguration call is important and must use the following order:

<table>
<thead>
<tr>
<th>Order</th>
<th>Rotary Axis</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Rotary head rider</td>
</tr>
<tr>
<td>2</td>
<td>Rotary head carrier</td>
</tr>
<tr>
<td>3</td>
<td>Rotary table carrier</td>
</tr>
<tr>
<td>4</td>
<td>Rotary table rider</td>
</tr>
</tbody>
</table>

```
// 4 axis setup, A rotates around X, direction is positive
var aAxis = createAxis({coordinate:X, table:true, axis:[1, 0, 0], cyclic:true, tcp:false, preference:1});
machineConfiguration = new MachineConfiguration(aAxis);
```

```
// 4 axis setup, A rotates around X, direction is negative
var aAxis = createAxis({coordinate:X, table:true, axis:[-1, 0, 0], cyclic:true, tcp:false, preference:1});
```
machineConfiguration = new MachineConfiguration(aAxis);
setMachineConfiguration(machineConfiguration);

// 5 axis setup, B rotates around Y, C rotates around Z, directions both positive
var bAxis = createAxis({coordinate:Y, table:true, axis:[0, 1, 0], range:[-120,120],
tcp:true, preference:1});
var cAxis = createAxis({coordinate:Z, table:true, axis:[0, 0, 1], cyclic:true, tcp:true});
machineConfiguration = new MachineConfiguration(bAxis, cAxis);
setMachineConfiguration(machineConfiguration);

// Same table/table setup, without TCP, top and center of C-axis is defined as the origin
var bAxis = createAxis({coordinate:Y, table:true, axis:[0, 1, 0], offset:0, 0, -12.5,
range:[-120,120], tcp:false, preference:1});
var cAxis = createAxis({coordinate:Z, table:true, axis:[0, 0, 1], cyclic:true, tcp:false});
machineConfiguration = new MachineConfiguration(bAxis, cAxis);
setMachineConfiguration(machineConfiguration);

// 5-axis head/head setup without TCP
var aAxis = createAxis({coordinate:X, table:false, axis:[-1, 0, 0], offset:[0, 0, 8.75],
range:[-120,120], tcp:false, preference:-1});
var cAxis = createAxis({coordinate:Z, table:false, axis:[0, 0, 1], cyclic:false, range:[-180, 180],
tcp:false});
machineConfiguration = new MachineConfiguration(aAxis, cAxis);
setMachineConfiguration(machineConfiguration);

Sample Rotary Configurations

7.1.4 Calculating the Rotary Angles

Once a Machine Configuration is defined the rotary axes angles need to be calculated and the tool end point needs to be adjusted for the rotary axes if TCP is not supported. This holds true for CAM and hardcoded Machine Configurations. This is handled in the activateMachine function and should not have to be modified. It is described here for reference purposes only.

The optimizeMachineAngles2 function calculates the rotary axes angles and adjusts the XYZ coordinates for the rotary axes if TCP is not supported. The following values are passed to the optimizeMachineAngles2 function.

<table>
<thead>
<tr>
<th>Value</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>OPTIMIZE_NONE</td>
<td>Don't adjust the coordinates for the rotary axes. Used for TCP mode.</td>
</tr>
<tr>
<td>OPTIMIZE_BOTH</td>
<td>Adjust the coordinates for the rotary axes. For rotary heads that do not support TCP it is possible that the tool length has to be added to the tool end point coordinates. This scenario is discussed further in the Adjusting the Points for Rotary Heads section of this chapter.</td>
</tr>
<tr>
<td>OPTIMIZE_TABLES</td>
<td>Adjust the coordinates for rotary tables. No adjustment will be made for heads.</td>
</tr>
</tbody>
</table>
### Settings for Adjusting the Input Coordinates for the Rotary Axes

Rotary head adjustments that require that the tool length be added to the offset distance of the axis cannot be adjusted using the `optimizeMachineAngles2` function, since the tool length will vary from tool to tool. Instead, the Section function `optimizeMachineAnglesByMachine` is called for each section. This is also true for post processors that may change the Machine Configuration during the processing of the operations. Following is the generic code used in the `activateMachine` function that is used to calculate the rotary axes angles and adjust the tool end point coordinates.

```java
// calculate the ABC angles and adjust the points for multi-axis operations
// tables and rotary heads with TCP support can be optimized with a single call
var addToolLength = true;
if (!machineConfiguration.isHeadConfiguration() || !addToolLength) {
    optimizeMachineAngles2(OPTIMIZE_AXIS);
}
else {
    for (var i = 0; i < getNumberOfSections(); ++i) {
        var section = getSection(i);
        if (section.isMultiAxis()) {
            machineConfiguration.setToolLength(section.getTool().getBodyLength()); // define the tool length for head adjustments
            section.optimizeMachineAnglesByMachine(machineConfiguration, OPTIMIZE_AXIS);
        }
    }
}
```

### Rotary Axes Calculations and Coordinate Transformation

If the call to calculate the rotary axes and adjust the input coordinates is not made then the tool end point and tool axis vector will be passed to the `onRapid5D` and `onLinear5D` multi-axis functions.

### 7.1.5 Output Initial Rotary Position

A function should be defined that outputs the rotary axis position in a block by themselves. In legacy posts this code is contained inline can be found in multiple places within the post.

```c
/** Positions the rotary axes in rapid mode */
```
function positionABC(abc, force) {
    if (force) {
        forceABC();
        gMotionModal.reset();
    }
    var a = aOutput.format(abc.x);
    var b = bOutput.format(abc.y);
    var c = cOutput.format(abc.z);
    if (a || b || c) {
        if (!retracted) {
            writeRetract(Z);
        }
        writeBlock(gMotionModal.format(0), a, b, c);
        currentMachineABC = abc;
        setCurrentABC(abc);
    }
}

Output Initial Rotary Axes Positions

The initial rotary axes positions must be calculated prior calling the positionABC function. The function getInitialToolAxisABC() is used to obtain the initial rotary axes positions for multi-axis operations.

if (currentSection.isMultiAxis()) {
    var abc = section.getInitialToolAxisABC();
    positionABC(abc, true);
}

Calculate Initial Rotary Angles for a Multi-axis Operation

7.1.6 Create the onRapid5D and onLinear5D Functions

Now that you have the machine defined you will need to verify that the onRapid5D and onLinear5D functions are present. These are the functions that will process the tool path generated by multi-axis operations. If your post already has these functions defined, then great you should be (almost) ready to go, if not then add the following functions to your post.

function onRapid5D(_x, _y, _z, _a, _b, _c) {
    if (!currentSection.isOptimizedForMachine()) {
        error(localize("This post configuration has not been customized for 5-axis simultaneous toolpath.");
        return;
    }
    if (pendingRadiusCompensation >= 0) {
        error(localize("Radius compensation mode cannot be changed at rapid traversal.");
        return;
    }
    var x = xOutput.format(_x);
function onLinear5D(_x, _y, _z, _a, _b, _c, feed, feedMode) {
    if (!currentSection.isOptimizedForMachine()) {
        error(localize("This post configuration has not been customized for 5-axis simultaneous toolpath.")));
        return;
    }
    if (pendingRadiusCompensation >= 0) {
        error(localize("Radius compensation cannot be activated/deactivated for 5-axis move.")));
        return;
    }
    var x = xOutput.format(_x);
    var y = yOutput.format(_y);
    var z = zOutput.format(_z);
    var a = aOutput.format(_a);
    var b = bOutput.format(_b);
    var c = cOutput.format(_c);
    var f = feedOutput.format(_feed);
    // get feedrate number
    var fMode = feedMode == FEED_INVERSE_TIME ? 93 : 94;
    var f = feedMode == FEED_INVERSE_TIME ? inverseTimeOutput.format(feed) : feedOutput.format(feed);
    if (x || y || z || a || b || c) {
        writeBlock(gMotionModal.format(1), x, y, z, a, b, c, f);
    } else if (f) {
        if (getNextRecord().isMotion()) { // try not to output feed without motion
            feedOutput.reset(); // force feed on next line
        } else {
            writeBlock(gfFeedModeModal.format(fMode), MotionModal.format(1, f));
        }
    }
}
Both of these functions as presented are basic in nature and the requirements for your machine may require some modification.

### 7.1.7 Multi-Axis Common Functions

There are functions that are useful when developing a post processor for a multi-axis machine. These functions are used to determine if the rotary axes are configured, the beginning and ending tool axis or rotary axes positions for an operation, and control the flow of the multi-axis logic.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>machineConfiguration.isMultiAxisConfiguration()</code></td>
<td>Returns <code>true</code> if a machine configuration containing rotary axes has been defined. It is still possible to create output for some multi-axis machines if the rotary axes have not been defined, by outputting the tool axis vector instead of the rotary axes positions or by using Euler angles for 3+2 operations.</td>
</tr>
<tr>
<td><code>machineConfiguration.getABC(matrix)</code></td>
<td>Returns the rotary axes angles for the provided matrix. This matrix is usually the Work Plane matrix (<code>currentSection.workPlane</code>).</td>
</tr>
<tr>
<td><code>machineConfiguration.remapToABC(abc, current)</code></td>
<td>Returns the closest rotary axes angles to the <code>current</code> axes positions as a Vector. <code>abc</code> is the rotary angles to be remapped.</td>
</tr>
<tr>
<td><code>machineConfiguration.remapABC(abc)</code></td>
<td>Returns the rotary axes angles within the valid range for each angle as a Vector.</td>
</tr>
<tr>
<td><code>machineConfiguration.getPreferredABC(abc)</code></td>
<td>Returns the preferred rotary axes angles given the input <code>abc</code> angles as a Vector. The preferred angles will be in the valid range for each angle.</td>
</tr>
<tr>
<td><code>machineConfiguration.isABCSupported(abc)</code></td>
<td>Returns <code>true</code> if the abc angles are within the valid ranges for the defined rotary axes. Returns <code>false</code> if any of the angles are outside of their defined range.</td>
</tr>
<tr>
<td><code>section.isOptimizedForMachine()</code></td>
<td>Returns <code>true</code> if the rotary axes angles have been calculated for the section.</td>
</tr>
<tr>
<td><code>section.isMultiAxis()</code></td>
<td>Returns <code>true</code> if the operation specified by <code>section</code> is a multi-axis operation.</td>
</tr>
<tr>
<td><code>section.getGlobalInitialToolAxis()</code></td>
<td>Returns the initial tool axis for the provided section as a Vector. Usually used at the start of an operation using the <code>currentSection</code> variable.</td>
</tr>
<tr>
<td><code>section.getInitialToolAxisABC()</code></td>
<td>Returns the initial rotary axes angles for the provided section as a Vector. Usually used at the start of an operation using the <code>currentSection</code> variable. An error will be generated if a machine configuration containing rotary axes has not been defined.</td>
</tr>
<tr>
<td><code>section.getGlobalFinalToolAxis()</code></td>
<td>Returns the final tool axis for the provided section as a Vector. Usually used at the start of an operation using <code>getPreviousSection()</code>.</td>
</tr>
<tr>
<td><code>section.getFinalToolAxisABC()</code></td>
<td>Returns the final rotary axes angles for the provided section as a Vector. Usually used at the start of an operation using <code>getPreviousSection()</code> using the <code>currentSection</code> variable. An error will be generated if a machine configuration containing rotary axes has not been defined.</td>
</tr>
<tr>
<td>Function</td>
<td>Description</td>
</tr>
<tr>
<td>----------------------------------</td>
<td>-------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>section.getOptimizedTCPMode()</td>
<td>Returns the mode used to adjust the output coordinates for the rotary axes for this section. The different modes are listed in the Calculating the Rotary Axes section in this chapter.</td>
</tr>
<tr>
<td>getCurrentDirection()</td>
<td>Returns the current rotary axes angles as a Vector in a multi-axis operation. It will return the Work Plane forward vector when in a 3-axis or 3+2 operation.</td>
</tr>
<tr>
<td>is3D()</td>
<td>Returns true if the entire program is a 3-axis operation with no multi-axis operations. Returns false if even one operation is a 3+2 or multi-axis operation.</td>
</tr>
<tr>
<td>setCurrentABC(abc)</td>
<td>Sets the current ABC position in the post engine. This function should be called whenever the rotary angles are calculated and output within the post processor.</td>
</tr>
</tbody>
</table>

### 7.2 Output of Continuous Rotary Axis on a Rotary Scale

There are two different styles that are commonly used for rotary axes output, using a linear scale or a rotary scale. A linear scale is the more standard case in today’s machines and will move on a progressive scale similar to a linear axis output. For example, a value of 720 degrees will move the axis two revolutions from 0 degrees. A linear scale is almost always used with a non-continuous axes and can be used with a continuous rotary axis.

A rotary scale on the other had typically outputs the rotary angle positions between 0 and 360 degrees, usually with the sign ± specifying the direction. If a sign is not required and the control will always take the shortest route, then it is pretty straight forward to output the rotary axis on a rotary scale, simply define it as a cyclic axis with a range of 0 to 360 degrees.

```javascript
var aAxis = createAxis({coordinate:0, table:true, axis:[1, 0, 0], cyclic:true, range:[0, 360]});
```

Create Rotary Axis Using a Rotary Scale. Machine will Take the Shortest Route

For controls that require a sign to designate the direction the rotary axis will move, you will need to define the rotary axis on a linear scale. Yes, it sounds counterintuitive, but the output variable will handle converting the linear scale value to a signed rotary scale value.

```javascript
var aAxis = createAxis({coordinate:0, table:true, axis:[1, 0, 0], cyclic:true});
```

Create Rotary Axis Using a Linear Scale when Output Using a Rotary Scale

The following functions will need to be added to your post, which define an alternate output variable to use to calculate the angle on a rotary scale.

```javascript
// Start of rotary scale output
function createRotaryVariable(specifiers, format) {

// your code here

```
return new RotaryVariable(specifiers, format);
}

function RotaryVariable(specifiers, format) {
  if (!(this instanceof RotaryVariable)) {
    throw new Error(localize("RotaryVariable constructor called as a function."));
  }
  this.variable = createVariable(specifiers, format);
  this.format2 = format;
  this.current = 0;
}

RotaryVariable.prototype.format = function (value) {
  // calculate angle between 0-360 degrees
  var angle = value % (Math.PI * 2);
  angle = angle < 0 ? angle + (Math.PI * 2) : angle;

  // calculate the correct direction (sign) for the output angles
  var delta = this.format2.getResultingValue(value - this.current);
  if (delta == 0) {
    angle = this.variable.getCurrent();
  } else if (delta < 0) {
    if (this.format2.getResultingValue(angle) == 0) {
      angle = Math.PI * 2;
    }
    angle *= -1;
  }
  this.current = value;
  return this.variable.format(angle);
};

RotaryVariable.prototype.reset = function () {
  return this.variable.reset();
};

RotaryVariable.prototype.disable = function () {
  return this.variable.disable();
};

RotaryVariable.prototype.enable = function () {
  return this.variable.enable();
};

// End of rotary scale output

Define the Rotary Scale Functions
Now you will need to use the `createRotaryVariable` function when creating the output variable instead of the `createVariable` function that is normally used.

```plaintext
// aOutput = createVariable({prefix:"A"}, abcFormat);
aOutput = createRotaryVariable({prefix:"A"}, abcFormat);
```

Create the Output Variable using a Rotary Scale

There are no more modifications needed.

### 7.3 Adjusting the Points for Offset Rotary Axes

The post processor kernel has support for offset tables and heads when TCP is not supported on the machine. The offsets from the part origin to the rotary center(s) must be defined when the axis is created. This is done using the `offset` parameter in `createAxis`.

```plaintext
var aAxis = createAxis({coordinate:X, table:false, axis:[-1, 0, 0], offset:[0, 0, 8.75], range:[-120,120], tcp:false, preference:-1});
```

Create an Offset Rotary Head

It is important to know how the offsets are applied to each style of rotary axis. For rotary heads remember the head rider axis is defined first and then the head carrier axis. When the carrier and rider heads share a common pivot point, then only the offset for the rider axis needs to be defined. This offset is defined from the tool stop position to the pivot point. When the pivot points are different, the carrier axis offset is defined as the offset from the rider pivot point. Most machines will use a common pivot point for both rotary axes.

<table>
<thead>
<tr>
<th>Rotary Axis</th>
<th>Rotary Axis</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rotary head rider</td>
<td>Distance from tool stop to pivot point</td>
</tr>
<tr>
<td>Rotary head carrier</td>
<td>Distance from Head Rider pivot point to Head Carrier pivot point</td>
</tr>
<tr>
<td>Rotary table carrier</td>
<td>Distance from part origin to center of table</td>
</tr>
<tr>
<td>Rotary table rider</td>
<td>Distance from part origin to center of table</td>
</tr>
</tbody>
</table>

Non-TCP Rotary Axis Offsets
When defining an offset rotary table, defining the offset is all that is needed before the rotary angles and transformed coordinates are calculated.

For offset heads on machines that do not support TCP there are a couple of more function calls that may be needed.

It is possible that the tool length needs to be added to the offset of the head rider axis defined in the `createAxis` function. On small hobbyist machines it could be that the tool will always be the same length and can then be defined as part of the offset. On machines that use different tool lengths you will need to inform the post engine of the tool length to be added to the pivot distance prior to calculating the offset coordinates for the section. This is done by calling the `machineConfiguration.setToolLength` function with the length of the tool from the tool end point to the tool stop position used to define the offset for the head.
Tool Length Definition

The output of the offset head coordinates can either be at the pivot point of the axis or the tool end point when the rotary axes are at 0 degrees (the tool is vertical). You would normally setup the machine with the tool tip at Z0. In this case the output coordinates will be at the virtual tool tip, meaning that the coordinates will be where the tool tip position would be when the rotary axes are at 0 degrees, even when the axes are tilted.

The `machineConfiguration.setVirtualTooltip` function is used to define whether the output coordinates are at the pivot point or at the virtual tool tip. In either case it is important that the proper offset distance and tool length are provided in order for the correct XYZ coordinates to be calculated. The `activateMachine` handles the calculation of offset tables and heads based on the definition of each rotary axes and the following settings.

```csharp
// Start of machine configuration logic
var compensateToolLength = false; // add the tool length to the pivot distance for nonTCP heads
var virtualTooltip = false; // translate the pivot point to the virtual tool tip for nonTCP heads
```

Defining the Tool Length and Virtual Tool Tip Setting for Rotary Heads
7.4 Calculation of the Multi-Axis Tool Position

It is possible to manually calculate the machine linear position based on the tool end point position or the tool end point position based on the machine linear position based on the rotary axis positions. The `machineConfiguration.getOptimizedPosition` function performs both conversions.

```
machineConfiguration.getOptimizedPosition(current, abc, tcpType, optimizeType, force)
```

### Adjust a Coordinate for the Rotary Axis Positions

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Variable Type</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>current</td>
<td>Vector</td>
<td>Either the tool tip or machine XYZ position based on <code>tcpType</code>.</td>
</tr>
<tr>
<td>abc</td>
<td>Vector</td>
<td>The rotary axis positions.</td>
</tr>
<tr>
<td>tcpType</td>
<td>Value</td>
<td>Type of conversion.</td>
</tr>
<tr>
<td>optimizeType</td>
<td>Value</td>
<td>Type of optimization.</td>
</tr>
<tr>
<td>force</td>
<td>Boolean</td>
<td>Set to true to adjust the values even if TCP is in effect. Valid for TCP_XYZ_OPTIMIZED and TCP_TOOL_OPTIMIZED.</td>
</tr>
</tbody>
</table>

### getOptimizedPosition Parameters

```
value = machineConfiguration.getOptimizedPosition(current, abc, tcpType, optimizeType, force)
```

#### tcpType Values

<table>
<thead>
<tr>
<th>Value</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>TCP_XYZ</td>
<td>Converts the tool tip to the machine XYZ position.</td>
</tr>
<tr>
<td>TCP_TOOL</td>
<td>Converts the machine XYZ position to the tool tip position.</td>
</tr>
<tr>
<td>TCP_XYZ_OPTIMIZED</td>
<td>Converts the tool tip to the machine XYZ position only when the input coordinates are adjusted for the rotary axes (non-TCP).</td>
</tr>
<tr>
<td>TCP_TOOL_OPTIMIZED</td>
<td>Converts the machine XYZ position to the tool tip position only when the input coordinates are adjusted for the rotary axes (non-TCP).</td>
</tr>
</tbody>
</table>

#### optimizeType Values

<table>
<thead>
<tr>
<th>Value</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>OPTIMIZE_BOTH</td>
<td>Adjust the coordinates for both tables and heads.</td>
</tr>
<tr>
<td>OPTIMIZE_TABLES</td>
<td>Adjust the coordinates for rotary tables only.</td>
</tr>
<tr>
<td>OPTIMIZE_HEADS</td>
<td>Adjust the coordinates for rotary heads only.</td>
</tr>
</tbody>
</table>

```java
// calculate the machine XYZ position from the tool tip position
var xyz = machineConfiguration.getOptimizedPosition(toolTip, abc, TCP_XYZ, OPTIMIZE_BOTH, false);

function onRapid5D(_x, _y, _z, _a, _b, _c) {
```

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var tooltip = machineConfiguration.getOptimizedPosition(
    new Vector(_x, _y, _z),
    new Vector(_a, _b, _c),
    TCP_TOOL_OPTIMIZED, OPTIMIZE_HEAD,
    false);

Sample Coordinate Conversions

7.5 Handling the Singularity Issue in the Post Processor

The post processor kernel handles the problem when the tool axis direction approaches the singularity of the machine. The singularity is defined as the tool axis orientation that is perpendicular to a rotary axis, either a table or head. When the tool direction approaches the singularity, you may notice that the rotary axis can start to swing violently even if there is only a small deviation in the tool axis. If you can imagine a machine with an A-axis trunnion carrying a C-axis table and the tool axis is 0, sin(.001), cos(.001). This causes the output rotary positions to be A.001 C0. Now if the rotary axis changes to 0, sin(.001), cos(.001), a change of less than .002 degrees you will notice that the rotary positions to be A.001 C90. You can see where a very small directional change in the tool axis (<.002) will cause a 90-degree change in the C-axis.

The singularity logic in the kernel will massage the tool axis direction to keep the tool within tolerance and minimize the rotary axis movement in these cases. A safeguard that linearizes the moves around the singularity has also been implemented. This linearization will add tool locations as necessary to keep the tool endpoint within tolerance of the part.
There are settings in the post processor that manage how the singularity issue is handled. These settings are defined using the following command.

```
machineConfiguration.setSingularity(adjust, method, cone, angle, tolerance, linearizationTolerance)
```

<table>
<thead>
<tr>
<th>Variable</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>adjust</td>
<td>Set to <code>true</code> to enable singularity optimization within the post processor. Singularity optimization includes the ability to adjust the tool axis to minimize singularity issues (large rotary axis movement when the tool axis approaches perpendicularity to a rotary axis) and the linearization of the moves around the singularity to keep the tool endpoint within tolerance. The default is <code>true</code>.</td>
</tr>
<tr>
<td>method</td>
<td>When set to <code>SINGULARITY_LINEARIZE_OFF</code> it disables the linearization of the moves to keep the tool endpoint within tolerance of the programmed tool path around the singularity. <code>SINGULARITY_LINEARIZE_ROTARY</code> will linearize the moves around the singularity. Additional points are added to keep the tool within the specified tolerance and is optimized for revolved movement as if the tool were moving around a cylinder or other revolved feature. <code>SINGULARITY_LINEARIZE_LINEAR</code> will also add additional points to keep the tool endpoint moving in a straight line. The default is <code>SINGULARITY_LINEARIZE_ROTARY</code>.</td>
</tr>
<tr>
<td>cone</td>
<td>Specifies the angular distance that the tool axis vector must be within in reference to the singularity point before the singularity logic is activated. This is usually a small value (less than 5 degrees), since the further away the tool...</td>
</tr>
<tr>
<td>Variable</td>
<td>Description</td>
</tr>
<tr>
<td>-------------------</td>
<td>---------------------------------------------------------------------------------------------------------------------------------------------</td>
</tr>
<tr>
<td>variable</td>
<td>axis is from the singularity, the less noticeable the fluctuations in the rotary axes will be and the less benefit this feature will provide. This parameter is specified in radians and the default value is .052 (3 degrees).</td>
</tr>
<tr>
<td>angle</td>
<td>The minimum angular delta movement that the rotary axes must move prior to considering adjusting the tool axis vector for singularity optimization. This limit is used to keep from adjusting the tool axis vector when the rotary axes do not fluctuate greatly. This is typically set to a value of 10 degrees or more. This parameter is in radians and the default value is .175 (10 degrees).</td>
</tr>
<tr>
<td>tolerance</td>
<td>The tolerance value used to keep the tool within tolerance when the tool axis is adjusted to minimize rotary axis movement around the singularity. The default value is .04mm (.0015in).</td>
</tr>
<tr>
<td>linearizationTolerance</td>
<td>The tolerance value to use when additional points are added to keep the tool endpoint within tolerance of the programmed move when the tool axis is near the singularity. The default value is .04mm (.0015in).</td>
</tr>
</tbody>
</table>

The default settings are valid for most tool paths, but this command allows for some tweaking in special cases where you want to fine tune the output.

### 7.6 Rewinding of the Rotary Axes when Limits are Reached

The post processor kernel will select the starting angles of the rotary axes based on the best possible solution to avoid rewind situations when one of the rotary axes crosses its limits. This is accomplished by scanning the entire operation to see if a rewind of the rotary axes is required due to limit violations and if so adjusting the starting angles of the rotary axes to see if the rewind can be avoided. If a solution to avoid the rewind cannot be found, then the solution that produces the most rotary movement prior to requiring a rewind will be used.

The best possible solution for the rotary axes is always selected at the start of an operation and when a rewind is required due to a rotary axis crossing the limits, the tool will always stop on the exact limit of the machine, eliminating scenarios where a valid solution for the rewinding of the rotary axes could not always be found.

When a rewind is required there is a group of functions that can be added to the custom post processor to handle the actual rewinding of the affected rotary axis. This code can be easily copied into your custom post processor and modified to suit your needs with just a little bit of effort.

One setting that is very important when defining a rotary axis is the cyclic parameter in the call to createAxis. cyclic is considered synonymous with continuous, meaning that this axis has no limits and will not be considered when determining if the rotary axes have to be repositioned to stay within limits. The range specifier used in conjunction with a cyclic axis defines the output limits of a rotary axis, for example specifying a range of [0,360] will cause all output angles for this axis to be output between 0 and 360 degrees. The range for a non-cyclic axis defines the actual physical limits of that axis on the machine and are used to determine when a rewind is required. Please note that the physical limits of the machine may be a numeric limit of the control instead of a physical limit, such as 9999.9999.
Another important setting is the reset parameter, which allows you to define the starting angle at the start of an operation and after a rewind of the axes has occurred. By default, the post engine will use the ending angle of the previous multi-axis operation. Some controls allow for the rotary axis encoder to be reset so that the stored angle is reset to be within the 0-360 degrees without unwinding the axis. In this case you will want to issue the proper codes to reset the axis encoder, for example G28 C0, and specify reset:3 when you create the axis.

Now on to how you can implement the automatic rewind capabilities in your post. The bulk of the feature is handled by the post processor kernel, but there are some variables and functions that are required in your post.

```javascript
var performRewinds = true; // enables the rewind/reconfigure logic
var stockExpansion = new Vector(toPreciseUnit(0.1, IN), toPreciseUnit(0.1, IN), toPreciseUnit(0.1, IN)); // expand stock XYZ values
var safeRetractDistance = (unit == IN) ? 1 : 25; // additional distance to retract out of stock
var safeRetractFeed = (unit == IN) ? 20 : 500; // retract feed rate
var safePlungeFeed = (unit == IN) ? 10 : 250; // plunge feed rate
```

<table>
<thead>
<tr>
<th>Variable</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>performRewinds</td>
<td>When set to false an error will be generated when a rewind of a rotary axis is required. Setting it to true will enable the rewind logic.</td>
</tr>
<tr>
<td>safeRetractDistance</td>
<td>Defines the distance to be added to the retract position when the tool is positioned past the stock material to safely remove it from the stock. If it is set to 0, then the tool will retract to the outer stock plus the stock expansion.</td>
</tr>
<tr>
<td>safeRetractFeed</td>
<td>Specifies the feedrate to retract the tool prior to rewinding the rotary axis.</td>
</tr>
<tr>
<td>safePlungeFeed</td>
<td>Specifies the feedrate to plunge the tool back into the part after rewinding the rotary axis.</td>
</tr>
<tr>
<td>stockExpansion</td>
<td>The tool will retract past the defined stock by default. You can expand the defined stock on all sides by defining the stockAllowance vector, which contains the expansion value for X, Y, and Z.</td>
</tr>
</tbody>
</table>

The enabling of the rewind logic is handled in the activateMachine function.

<table>
<thead>
<tr>
<th>Function</th>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>onRewindMachineEntry</td>
<td>(none)</td>
<td>This function is called at the start of the automatic rewind process and allows the user to override the default rewind logic. Returning true from this function will disable the rewind logic in the post engine, while false will continue with the rewind/reconfigure process.</td>
</tr>
<tr>
<td>onMoveToSafeRetractPosition</td>
<td>(none)</td>
<td>Moves the tool to a safe retract position after retracting the tool from the part.</td>
</tr>
</tbody>
</table>
onRotateAxes | x, y, z, a, b, c | Repositions the rotary axes to their new location as provided by a,b,c after the tool has been moved to its safe position.

onReturnFromSafeRetractPosition | x, y, z | Repositions the linear axes to the position of the tool when it was retracted from the part.

Automatic Rewind Entry Functions

The onRewindMachineEntry function is used to either override or supplement the standard rewind logic. It will simply return false when the standard rewind logic of retracting the tool, repositioning the rotary axes, and repositioning the tool is desired. Code can be added to this function for controls that just require the encoder to be reset or to output the new rotary axis position when the control will automatically track the tool with the rotary axis movement. The following example resets the C-axis encoder when it is currently at a multiple of 360 degrees and the B-axis does not change.

```javascript
/** Allow user to override the onRewind logic. */
function onRewindMachineEntry(_a, _b, _c) {
    // reset the rotary encoder if supported to avoid large rewind
    if (false) {
        // disabled by default
        if ((abcFormat.getResultingValue(_c) == 0) && !abcFormat.areDifferent(getCurrentDirection().y, _b)) {
            writeBlock(gAbsIncModal.format(91), gFormat.format(28), "C" + abcFormat.format(0));
            writeBlock(gAbsIncModal.format(90));
            return true;
        }
    }
    return false;
}
```

Sample Code to Reset Encoder Instead of Rewinding C-axis

Returning a value of true designates that the onRewindMachineEntry function performed all necessary actions to reposition the rotary axes and the retract/reposition/plunge sequence will not be performed. Returning false will process the retract/reposition/plunge sequence normally.

The onMoveToSafeRetractPosition function controls the move to a safe position after the tool is retracted from the part and before the rotary axes are repositioned. It will typically move to the home position in Z and optionally in X and Y using a G28 or G53 style block. You should find similar code to retract the tool when positioning the rotary axes for a 3+2 operation and in the onClose function, which positions the tool at the end of the program. You should use the same logic found in these areas for the onMoveToSafeRetractPosition function.

```javascript
/** Retract to safe position before indexing rotaries. */
function onMoveToSafeRetractPosition() {
    writeRetract(Z); // retract to home position
    // cancel TCP so that tool doesn't follow rotaries
}
```
if (lengthCompensationActive) {
    writeBlock(gFormat.format(49), formatComment("TCPC OFF"));
}

if (false) { // enable to move to safe position in X & Y
    writeRetract(X, Y);
}

Move to a Safe Position Prior to Repositioning Rotary Axes

The `onRotateAxes` function is used to position the rotary axes to their new position as calculated by the post engine. \(_a, \_b, \_c\) define the new rotary axis position. \(_x, \_y, \_z\) should be ignored and not used.

```cpp
/** Rotate axes to new position above reentry position */
function onRotateAxes(_x, _y, _z, _a, _b, _c) {
    // position rotary axes
    xOutput.disable();
    yOutput.disable();
    zOutput.disable();
    invokeOnRapid5D(_x, _y, _z, _a, _b, _c);
    xOutput.enable();
    yOutput.enable();
    zOutput.enable();
}
```

Position the Rotary Axes

The `onReturnFromSafeRetractPosition` function controls the move back to the position of the tool at the original retract location past the stock. This function is called after the rotary axes are repositioned.

```cpp
/** Return from safe position after indexing rotaries. */
function onReturnFromSafeRetractPosition(_x, _y, _z) {
    // reinstate TCP
    if (lengthCompensationActive) {
        writeBlock(gFormat.format(43.4), hFormat.format(tool.lengthOffset), formatComment("TCPC ON"));
    }

    // position in XY
    forceXYZ();
    xOutput.reset();
    yOutput.reset();
    zOutput.disable();
    invokeOnRapid(_x, _y, _z);

    // position in Z
    zOutput.enable();
    invokeOnRapid(_x, _y, _z);
}
7.7 Multi-Axis Feedrates

During multi-axis contouring moves, the machine control will typically expect the feedrate numbers to be either in Inverse Time or some form of Degrees Per Minute. Inverse Time feedrates are simply the inverse of the time that the move takes, i.e. \( \frac{1}{\text{movetime}} \). If your control supports both Inverse Time and Degrees Per Minute feedrates, it is recommended that you use Inverse Time as this is the most accurate. Please note that if your machine supports TCP (Tool Control Point) programming, then it probably supports direct Feed Per Minute (FPM) feedrates during multi-axis contouring moves and does not require either Inverse Time or DPM feedrates.

Multi-axis feedrate calculations are handled by the post engine and will work with all machine configurations; table/table, head/head, and head/table. One capability of the multi-axis feedrate calculation is that it considers the actual tool tip movement in reference to the rotary axes movement and not just the straight-line movement along the programmed tool tip, creating more accurate multi-axis feedrates. In the following picture the move along the arc caused by the movement of the rotary axis (green arc) is used in the calculation instead of the straight-line move generated by HSM (blue line).

![Actual Tool Path on Machine is Used in Feedrate Calculations](image)

Multi-axis feedrate support is handled in the `setFeedRateMode` function defined in the machine configuration logic included with the *Start of machine configuration* logic code at the top of the post.
/**
   Define the multi-axis feedrate mode
*/
function setFeedrateMode(reset) { // setting reset to 'true' will reset to the default multi-axis feedrate mode
   // don't need to set multi-axis feedrates for TCP machines
   if (!tcpIsSupported && !reset) || !machineConfiguration.isMultiAxisConfiguration()) {
      return;
   }

   machineConfiguration.setMultiAxisFeedrate(
      tcpIsSupported ? FEED_FPM : FEED_INVERSE_TIME, // can be FEED_DPM
      INVERSE_MINUTES, // can be INVERSE_SECONDS or DPM_COMBINATION for DPM feeds
      unit == MM ? 1.0 : 0.1 // ratio of rotary accuracy to linear accuracy for DPM calculations
   );
}

<table>
<thead>
<tr>
<th>Variable</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>feedMode</td>
<td>FEED_INVERSE_TIME (inverse time), FEED_DPM (degrees per minute), or FEED_FPM (programmed feedrate).</td>
</tr>
<tr>
<td>maximumFeedrate</td>
<td>Defines the maximum value that can be output for both inverse time and degrees per minute feedrates.</td>
</tr>
<tr>
<td>feedType</td>
<td>Multi-axis feedrate options. For inverse time feedrates, the options are INVERSE_MINUTES or INVERSE_SECONDS, defining the units of time to use in inverse time feedrate calculations. For DPM feedrates, then the options are DPM_STANDARD for straight degrees per minute calculations or DPM_COMBINATION which uses a combination of degrees per minute and linear feed per minute (this is the most typical for machines that want a form of DPM feedrates).</td>
</tr>
<tr>
<td>outputTolerance</td>
<td>The tolerance for deciding whether to output a feedrate value or not. If the feedrate value is within this tolerance of the previous feedrate value, then it will be set to the previous value. This is used to minimize the output of multi-axis feedrate numbers.</td>
</tr>
<tr>
<td>bpwRatio</td>
<td>Defines the pulse weight ratio for the rotary axes when DPM feedrates are output as a combination of linear and rotary movements. The pulse weight is a scale factor based on the rotary axes accuracy compared to the linear axes accuracy. For example, it should be set to .1 when the linear axes are output on .0001 increments and the rotary axes on .001 increments.</td>
</tr>
</tbody>
</table>

setMultiAxisFeedrate Parameters

If Inverse Time feedrates are supported you will need to create the inverseTimeOutput variable at the top of the post processor code and if the accuracy of the Inverse Time feedrates is different than the standard FPM feedrate you will also need to create a new format to associate with it. The gFeedModeModal modal variable will also need to be defined for support of G93/G94 output if it does not already exist.
Now there are other areas of the post processor that need to be changed to support these feedrate modes. First, the `onLinear5D` function must have support added to receive and output the feedrate mode and to output the feedrate value using the correct format.

```javascript
function onLinear5D(_x, _y, _z, _a, _b, _c, feed, feedMode) {
  if (!currentSection.isOptimizedForMachine()) {
    error(localize("This post configuration has not been customized for 5-axis simultaneous toolpath.");)
    return;
  }
  // at least one axis is required
  if (pendingRadiusCompensation >= 0) {
    error(localize("Radius compensation cannot be activated/deactivated for 5-axis move.");)
    return;
  }
  var x = xOutput.format(_x);
  var y = yOutput.format(_y);
  var z = zOutput.format(_z);
  var a = aOutput.format(_a);
  var b = bOutput.format(_b);
  var c = cOutput.format(_c);

  // get feedrate number
  var fMode = feedMode == FEED_INVERSE_TIME ? 93 : 94;
  var f = feedMode == FEED_INVERSE_TIME ? inverseTimeOutput.format(feed) : feedOutput.format(feed);

  if (x || y || z || a || b || c) {
    writeBlock(gFeedModeModal.format(fMode), gMotionModal.format(1), x, y, z, a, b, c, f);
  } else if (f) {
    if (getNextRecord().isMotion()) { // try not to output feed without motion
      feedOutput.reset(); // force feed on next line
    } else {
      writeBlock(gFeedModeModal.format(fMode), gMotionModal.format(1), f);
    }
  }
}
```
**onLinear5D Required Changes**

You will need to reset the feedrate mode to FPM either at the end of the multi-axis operation or on a standard 3-axis move. It is much easier to do this at the end of the section, otherwise you would have to modify all instances that output feedrates, such as in `onLinear, onCircular, onCycle`, etc.

```javascript
function onSectionEnd() {
    ...
    if (currentSection.isMultiAxis()) {
        writeBlock(gFeedModeModal.format(94)); // inverse time feed off
    }
}
```

**Reset FPM Mode in onSectionEnd**

```javascript
writeBlock(gFeedModeModal.format(94), gMotionModal.format(1), gFormat.format(40), x, y, z, f);
```

**Optionally Reset FPM Mode in All Output Blocks with Feedrates**

It is possible that your machine control does not support standard inverse time or DPM feedrates. If this is the case you will need to write your own function to handle multi-axis feedrates. The `getMultiAxisMoveLength` function will assist in the movement length calculations required for calculating multi-axis feedrates. It takes the current position for the linear and rotary axes and will calculate the tool tip, linear axes, and rotary axes lengths of the move from the previous location.

```javascript
var length = machineConfiguration.getMultiAxisLength(x, y, z, a, b, c);
```

**Calculate the Length of the Multi-Axis Move**

`getMultiAxisMoveLength` will return `MoveLength` object, which can then be accessed using the following functions to obtain the different move lengths.

<table>
<thead>
<tr>
<th>Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td><code>getRadialToolTipMoveLength</code></td>
<td>Calculated tool endpoint movement along the actual tool path.</td>
</tr>
<tr>
<td><code>getLinearMoveLength</code></td>
<td>Combined linear delta movement.</td>
</tr>
<tr>
<td><code>getRadialMoveLength</code></td>
<td>Combined rotary delta movement.</td>
</tr>
</tbody>
</table>

**MoveLength Functions**

```javascript
var moveLength = getMultiAxisMoveLength(x, y, z, a, b, c);
var toolTipLength = moveLength.getRadialToolTipMoveLength();
var xyzLength = moveLength.getLinearMoveLength();
var abcLength = moveLength.getRadialMoveLength();
```

**Retrieve the Calculated Move Lengths for the Tool Tip, Linear Axes, and Rotary Axes**

8 Adding Support for Probing

Fusion and HSM have support for multiple styles of probing operations, including WCS Probing, Geometry Probing, and Surface Inspection. While the probing capabilities are supported by many of the library post processors, they are not supported by all of them and custom post processors may not have
these capabilities. This chapter discusses the required changes to a post processor to support the probing operations.

8.1 WCS Probing

WCS Probing is defined as probing operations that are used to probe the part for the purpose of defining a Work Coordinate System. While all Autodesk CAM products support WCS Probing, you will find these operations in a different area of the interface for each of the products.

You can check the post processor you are working with to see if it supports WCS Probing. The easiest method is to try to run a probing operation against the post, the post will fail if probing is not supported. You may see an error message complaining about the spindle speed being out of range (probe operations do not turn on the spindle) or a message that states that the probing cycle must be handled in the post processor.

Error: Spindle speed out of range.
Error at line: 735
Error in operation: ‘WCS Probe1’
Failed while processing onSection() for record 261.

Error: The probe cycle 'probing-xy-outer-corner' is machine specific and must always be handled in the post configuration.
Error in operation: ‘WCS Probe1’
Failed while processing onCycle() for record 280.

If you receive either of these messages, then probing is not supported in your post processor and you will need to add it.
8.1.1 Probing Operations

There is a sample model available for testing the probing logic in a post processor. In Fusion it is contained in the CAM Samples/Post Processor folder. This model contains a part designed for testing probing cycles using the available WCS Probing operations.

One thing you will notice when creating a probing operation is that interface is intelligent enough to only give you the probing operation types that apply to the type of geometry selected. For example, if you select a planar face perpendicular to the X-axis, then the only operations available to you are the X surface and Angle along X-axis operations.
The WCS Probing operations are considered a canned cycle in the post processor and therefore are output in the `onCyclePoint` function, with the probe type being stored in the `cycleType` variable. The following table lists the available probing operations. You should note that probing cycles cannot be expanded and must be handled in the post processor, either by performing the cycle or by giving an error.

<table>
<thead>
<tr>
<th><code>cycleType</code></th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>probing-X</td>
<td>Probes a wall perpendicular to the X-axis.</td>
</tr>
<tr>
<td>probing-Y</td>
<td>Probes a wall perpendicular to the Y-axis.</td>
</tr>
<tr>
<td>probing-Z</td>
<td>Probes a wall perpendicular to the Z-axis.</td>
</tr>
<tr>
<td>probing-x-wall</td>
<td>Probes a wall thickness in the X-axis.</td>
</tr>
<tr>
<td>probing-y-wall</td>
<td>Probes a wall thickness in the Y-axis.</td>
</tr>
<tr>
<td>probing-x-channel</td>
<td>Probes the open distance between two walls in the X-axis</td>
</tr>
<tr>
<td>probing-y-channel</td>
<td>Probes the open distance between two walls in the Y-axis</td>
</tr>
<tr>
<td>probing-x-channel-with-island</td>
<td>Probes the open distance between two walls with an island between the walls in the X-axis</td>
</tr>
<tr>
<td>probing-y-channel-with-island</td>
<td>Probes the open distance between two walls with an island between the walls in the Y-axis</td>
</tr>
<tr>
<td>probing-xy-circular-boss</td>
<td>Probes the outer wall of a circular boss</td>
</tr>
<tr>
<td>probing-xy-circular-hole</td>
<td>Probes the inner wall of a circular hole</td>
</tr>
<tr>
<td>probing-xy-circular-hole-with-island</td>
<td>Probes the inner wall of a circular hole with an island in the hole</td>
</tr>
<tr>
<td>probing-xy-rectangular-boss</td>
<td>Probes the outer walls of a rectangular protrusion</td>
</tr>
<tr>
<td>probing-xy-rectangular-hole</td>
<td>Probes the inner walls of a rectangular hole</td>
</tr>
<tr>
<td>probing-xy-rectangular-hole-with-island</td>
<td>Probes the inner walls of a rectangular hole with an island in the hole</td>
</tr>
<tr>
<td>probing-xy-inner-corner</td>
<td>Probes an inner corner. Modifies the origin and rotation of the part.</td>
</tr>
<tr>
<td>probing-xy-outer-corner</td>
<td>Probes an outer corner. Modifies the origin and rotation of the part.</td>
</tr>
<tr>
<td>probing-x-plane-angle</td>
<td>Probes a wall at an angle to the X-axis. Modifies the rotation of the part.</td>
</tr>
<tr>
<td>probing-y-plane-angle</td>
<td>Probes a wall at an angle to the Y-axis. Modifies the rotation of the part.</td>
</tr>
</tbody>
</table>

The parameters defined in the WCS Probing operation are passed to the cycle functions using the `cycle` object. The following variables are available and are referenced as ‘`cycle.parameter`’.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>approach1</td>
<td>The distance from the contact point at which the probe starts to approach the part.</td>
</tr>
<tr>
<td>approach2</td>
<td>The distance from the contact point at which the probe starts to approach the second face of a multi-face operation.</td>
</tr>
</tbody>
</table>
### Parameter Description

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>depth</td>
<td>The position along the probe axis to touch the part.</td>
</tr>
<tr>
<td>probeClearance</td>
<td>The height the probe rapids to on its way to the start of the probing and</td>
</tr>
<tr>
<td></td>
<td>the position it returns to after the probing operation is finished.</td>
</tr>
<tr>
<td>probeOvertravel</td>
<td>The maximum distance the probe can move beyond the expected contact point</td>
</tr>
<tr>
<td></td>
<td>and still record a measurement.</td>
</tr>
<tr>
<td>probeSpacing</td>
<td>The probe spacing between points on the selected face for Angle style</td>
</tr>
<tr>
<td></td>
<td>probing.</td>
</tr>
<tr>
<td>retract</td>
<td>The height to retract the probe to at the programmed feedrate.</td>
</tr>
<tr>
<td>width1</td>
<td>The width of the boss or hole being probed.</td>
</tr>
<tr>
<td>width2</td>
<td>The width of the secondary walls (Y-axis) of a rectangular boss or hole</td>
</tr>
<tr>
<td></td>
<td>being probed.</td>
</tr>
</tbody>
</table>

#### Probing Parameters

---

### 8.1.2 Adding the Core Probing Logic

Adding WCS Probing support requires the main logic to output the probing cycle, supporting functions, and some logic added to the main sections of the post processor. You should first open a post processor that contains support for probing before starting to add probing to your post processor, since the logic and most of the code will remain the same. Most of the generic post processors use Renishaw style probing Macros (Fanuc, Haas, etc.), but there are also controls that support probing without the use of these Macros, such as the Datron, Heidenhain, and Siemens controls. Be sure to start with closest match to the machine you are creating a post processor for. The examples used in this chapter use the code for the Renishaw style probing Macros.

The following functions support angular probing and may have to be modified to match the requirements of your control. The code shown is for a Fanuc style control. They should be added prior to the `onCyclePoint` function.

```javascript
/**
 * Determine if angular probing is supported.
 */
function getAngularProbingMode() {
  if (machineConfiguration.isMultiAxisConfiguration()) {
    if (machineConfiguration.isMachineCoordinate(2)) {
      return ANGLE_PROBE_USE_CAXIS;
    } else {
      return ANGLE_PROBE_USE_ROTATION;
    }
  } else {
    return ANGLE_PROBE_NOT_SUPPORTED;
  }
}
```

---

**Adding Support for Probing 8-177**
Output rotation offset based on angular probing cycle.

```javascript
function setProbingAngle() {
  if ((g68RotationMode == 1) || (g68RotationMode == 2)) { // Rotate coordinate system for Angle Probing
    if (!properties.useG54x4) {
      gRotationModal.reset();
      gAbsIncModal.reset();
      writeBlock(
        gRotationModal.format(68), gAbsIncModal.format(90),
        (g68RotationMode == 1) ? "X0" : "X[135]",
        (g68RotationMode == 1) ? "Y0" : "Y[136]",
        "Z0", "I0.0", "J0.0", "K1.0", "R[139]"
      );
      g68RotationMode = 3;
    } else if (angularProbingMode != ANGLE_PROBE_NOT_SUPPORTED) {
      writeBlock("#26010=#135");
      writeBlock("#26011=#136");
      writeBlock("#26012=#137");
      writeBlock("#26015=#139");
      writeBlock(gFormat.format(54.4), "P1");
      g68RotationMode = 0;
    } else {
      error(localize("Angular probing is not supported for this machine configuration."));
      return;
    }
  }
}
```

### Probing Parameters

The core logic for probing is in the `onCycle` function. The first part of the code to copy into your post is at the top of the `onCyclePoint` function and defines the WCS code to adjust for the probing operation.

```javascript
var probeWorkOffsetCode;
if (isProbeOperation()) {
  if (!useMultiAxisFeatures && !isSameDirection(currentSection.workPlane.forward, new Vector(0, 0, 1)) && (!cycle.probeMode || (cycle.probeMode == 0))) {
    error(localize("Updating WCS / work offset using probing is only supported by the CNC in the WCS frame.
    
    return;
  }
}
var workOffset = probeOutputWorkOffset ? probeOutputWorkOffset : currentWorkOffset;
if (workOffset > 99) {
    error(localize("Work offset is out of range.
    
    return;`
The highlighted code is controller specific and may have to be modified to match your control. It will be similar to the WCS logic in the `onSection` function.

The code that outputs the probing calls is usually located after the drilling cycle logic in the main switch block. Copy all code that contains the case statements for probing operations.

```java
switch (cycleType) {
    case "drilling":
        …
    case "probing-x": // copy from this line to before the “default” case
        …
    default:
    // 2nd through nth cycle point
    } else {
        if (isProbeOperation()) {
            // do nothing
            } else if (cycleExpanded) {
        // 2nd through nth cycle point
        } else {
            if (workOffset > 6) {
                probeWorkOffsetCode = probe100Format.format(workOffset - 6 + 100);
            } else {
                probeWorkOffsetCode = workOffset + "."; // G54->G59
            }
        }
```

Add the following code to the `onCycleEnd` function to end the probing operation.

```java
function onCycleEnd() {
    if (isProbeOperation()) {
        writeBlock(probeCode.code.format(probeCode.value), "P" + 9810, zOutput.format(cycle.clearance)); // protected retract move
        writeBlock(probeCode.code.format(probeCode.value), "P" + 9833); // spin the probe off
        setProbingAngle(); // define rotation of part
        // we can move in rapid from retract optionally
    } else { 
        …
    }
```
8.1.3 Adding the Supporting Probing Logic

There are various locations that contain support logic for probing operations in the post processor. Some of this code may already be in your post processor. If the post uses a special format for the output of the Probe WCS code, then you will need to add this format at the top of the post.

```javascript
var probe100Format = createFormat({decimals:3, zeropad:true, width:3, forceDecimal:true});
```

May be Required for Formatting the Probe WCS Code

Add the following definitions to the *fixed settings* section at the top of the post processor.

```javascript
var ANGLE_PROBE_NOT_SUPPORTED = 0;
var ANGLE_PROBE_USE_ROTATION = 1;
var ANGLE_PROBE_USE_CAXIS = 2;
```

Add to Fixed Settings Section

Add the following variables to the *collected state* section at the top of the post processor.

```javascript
var g68RotationMode = 0;
var angularProbingMode;
```

Add to Collected State Section

The following function and variable definition should be added prior to the *onParameter* function. The *onParameter* function should also have the shown conditional added if it is not there.

```javascript
function isProbeOperation() {
    return hasParameter("operation-strategy") && (getParameter("operation-strategy") == "probe");
}

var probeOutputWorkOffset = 1;

function onParameter(name, value) {
    if (name == "probe-output-work-offset") {
        probeOutputWorkOffset = (value > 0) ? value : 1;
    }
}
```

Add Prior to and to onParameter Function

The following code needs to be added to the *onSection* function.

```javascript
if (!isProbeOperation() &&
    (insertToolCall ||
    forceSpindleSpeed ||
    isFirstSection() ||
    rpmFormat.areDifferent(spindleSpeed, sOutput.getCurrent())) ||
    (tool.clockwise != getPreviousSection().getTool().clockwise)) {
    forceSpindleSpeed = false;
}
```
Don’t Output Spindle Speed with a Probe Tool

```javascript
if (isProbeOperation()) {
    if (g68RotationMode != 0) {
        error(localize("You cannot probe while G68 Rotation is in effect."));
        return;
    }
    angularProbingMode = getAngularProbingMode();
    writeBlock(probeCode.code.format(probeCode.value), "P" + 9832); // spin the probe on
}
```

Add at the end of the onSection Function

Coolant should be disabled during probing operations, so make sure that the following conditional is in the `getCoolantCodes` function.

```javascript
function getCoolantCodes(coolant) {
    var multipleCoolantBlocks = new Array(); // create a formatted array to be passed into the outputted line
    if (!coolants) {
        error(localize("Coolants have not been defined."));
    }
    if (isProbeOperation()) { // avoid coolant output for probing
        coolant = COOLANT_OFF;
    }
}
```

Disable Coolant for Probing Operations

8.2 Geometry Probing

Geometry Probing behaves similarly to WCS Probing. It is used to measure geometric features on the part during machining. The measured geometric features are checked against specified tolerances for size and position. Based on the result, you can update the tool wear, or instruct the machine to stop machining if the feature is out of tolerance. Geometry Probing is initiated using the `Probe Geometry` operation listed in the PROBING menu.
Like in WCS Probing, the parameters defined in the Geometry Probing operation are passed to the cycle functions using the *cycle* object. These are in addition to the parameters defined for WCS Probing, which are also available in Geometry Probing. The following variables are available and are referenced as ‘cycle.parameter’.

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>angleAskewAction</td>
<td>Set to “stop-message” when Askew Action is enabled.</td>
</tr>
<tr>
<td>incrementComponent</td>
<td>Increments the output component number when printing the results.</td>
</tr>
<tr>
<td>outOfPositionAction</td>
<td>Set to “stop-message” when Out of Position Action is enabled.</td>
</tr>
<tr>
<td>printResults</td>
<td>Measurements will be printed to a file on the controller when enabled.</td>
</tr>
<tr>
<td>toleranceAngle</td>
<td>Used to determine if angular measurement is within tolerance.</td>
</tr>
<tr>
<td>tolerancePosition</td>
<td>Used to determine if the positional measurement is within tolerance.</td>
</tr>
<tr>
<td>toleranceSize</td>
<td>Used to determine if the size of the feature (hole, boss) is within tolerance.</td>
</tr>
<tr>
<td>toolDiameterOffset</td>
<td>Defines the tool diameter offset register used to machine the feature.</td>
</tr>
<tr>
<td>toolLengthOffset</td>
<td>Defines the tool length offset register used to machine the feature.</td>
</tr>
<tr>
<td>toolWearErrorCorrection</td>
<td>The percentage of the deviation to update the tool wear by.</td>
</tr>
<tr>
<td>toolWearUpdateThreshold</td>
<td>The minimum deviation that will trigger a tool wear update.</td>
</tr>
<tr>
<td>updateToolWear</td>
<td>Enabled when tool wear compensation should be activated on the controller.</td>
</tr>
<tr>
<td>wrongSizeAction</td>
<td>Set to “stop-message” when Wrong Size Action is enabled.</td>
</tr>
</tbody>
</table>

To add Geometry Probing to your post you will first need to implement WCS Probing. After this there are only minor changes required to support Geometry Probing. First make sure that the *isProbeOperation* looks like the following.

```javascript
function isProbeOperation() {
  return hasParameter("operation-strategy") && ((getParameter("operation-strategy") == "probe" ||
        getParameter("operation-strategy") == "probe_geometry");
}
```

*isProbeOperation Function with Geometry Probing Support*

In the *onCyclePoint* function you will need to modify the probing cycles so that they call the *getProbingArguments* function, which formats the parameter output for both WCS and Geometry Probing.

```javascript
case "probing-x":
```

*Adding Support for Probing  8-182*
forceXYZ();
// move slowly always from clearance not retract
writeBlock(gFormat.format(65), "P" + 9810, zOutput.format(z - cycle.depth), getFeed(F)); //
protected positioning move
writeBlock(
    gFormat.format(65), "P" + 9811,
    "X" + xyzFormat.format(x + approach(cycle.approach1) * (cycle.probeClearance +
    tool.diameter/2)),
    "Q" + xyzFormat.format(cycle.probeOvertravel),
    getProbingArguments(cycle, probeWorkOffsetCode) // "S" + probeWorkOffsetCode
);
break;

Add Call to getProbingArguments to All Probing Operations

Now you will need to add the getProbingArguments function prior to the onCycleEnd function.

function getProbingArguments(cycle, probeWorkOffsetCode) {
    var probeWCS = hasParameter("operation-strategy") && (getParameter("operation-strategy") ==
    "probe");
    return [
        (cycle.angleAskewAction == "stop-message" ? "B" + xyzFormat.format(cycle.toleranceAngle ?
        cycle.toleranceAngle : 0) : undefined),
        ((cycle.updateToolWear && cycle.toolWearErrorCorrection < 100) ? "F" +
        xyzFormat.format(cycle.toolWearErrorCorrection ? cycle.toolWearErrorCorrection / 100 : 100) :
        undefined),
        (cycle.wrongSizeAction == "stop-message" ? "H" + xyzFormat.format(cycle.toleranceSize ?
        cycle.toleranceSize : 0) : undefined),
        (cycle.outOfPositionAction == "stop-message" ? "M" + xyzFormat.format(cycle.tolerancePosition ?
        cycle.tolerancePosition : 0) : undefined),
        ((cycle.updateToolWear && cycleType == "probing-z") ? "T" +
        xyzFormat.format(cycle.toolLengthOffset) : undefined),
        ((cycle.updateToolWear && cycleType !== "probing-z") ? "T" +
        xyzFormat.format(cycle.toolDiameterOffset) : undefined),
        (cycle.updateToolWear ? "V" + xyzFormat.format(cycle.toolWearUpdateThreshold ?
        cycle.toolWearUpdateThreshold : 0) : undefined),
        (cycle.printResults ? "W" + xyzFormat.format(1 + cycle.incrementComponent) : undefined), // 1
        for advance feature, 2 for reset feature count and advance component number. first reported result in a
        program should use W2.
        conditional(probeWorkOffsetCode && probeWCS, "S" + probeWorkOffsetCode)
    ];
}

getProbingArguments Function Formats Probing Parameters for Output.
8.3 Inspect Surface

The Inspect Surface operation creates a probing strategy that specifies contact points across the surfaces of the model to be measured by a probe while the part is still on the machine tool. The results can then be imported and compared against the model to identify if the manufactured part is in or out of tolerance.

Inspection streamlines the manufacturing process by letting you identify problem areas and decide on any rework needed earlier in the process. It also helps to reduce the need to move parts between the machine tool and a measuring device.

Surface Inspection is initiated using the Inspect Surface operation listed in the PROBING menu.

If you wish to use the Inspect Surface operations, you will need a post processor that will allow you to output and run these inspection paths on your machine. You can either use one of the generic Inspection post processors available on the Post Library for Autodesk Fusion 360, or modify your current milling post which is already set up for your machine to add in the inspection functionality.

The Inspection post processors will have the inspection or inspect surface suffix appended to the name of the post processor. These are the only post processors that support Inspect Surface operations. You will need to use one of these generic posts as a source for adding the inspection code to your post processor.

8.3.1 Inspect Surface Operations

Inspect Surface operations differ from the other probing operations, in that you will select points on the face of the part to inspect instead of individual features of the part.
The Surface Inspect operations are considered a cycle in the post processor and therefore call the onCyclePoint function, though they are expanded in the inspectionCycleInspect function. The standard cycleType variable to define the cycle type is not set for Surface Inspect operations, but rather the isInspectionOperation function is used to determine if it is a Surface Inspection cycle. This is further explained in the Adding the Supporting Surface Inspect Logic section. Unlike other cycles that pass a single point to the onCyclePoint function, the Surface Inspect cycle will contain the following 3 points per cycle location, with each location generating a separate and subsequent call to onCyclePoint.

<table>
<thead>
<tr>
<th>Location</th>
<th>How to determine</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>First</td>
<td>isFirstCyclePoint()</td>
<td>Safe move to approach inspection location</td>
</tr>
<tr>
<td>Second</td>
<td>(default)</td>
<td>Inspection move</td>
</tr>
<tr>
<td>Third</td>
<td>isLastCyclePoint()</td>
<td>Retract move</td>
</tr>
</tbody>
</table>

Three Points per Inspection Location

The parameters defined in the Inspect Surface operation are passed to the cycle functions using either the cycle object or through section parameters (getParameter). These parameters are not described here, since they are handled in the core Surface Inspect functions that are copied from an existing inspection post processor.

8.3.2 Adding the Core Inspect Surface Logic

Adding Surface Inspect support requires the main logic to be copied directly from a post processor that already supports inspection, and logic added to the main sections of the post processor. You should first open a post processor that contains support for inspection before starting to add Inspect Surface support to your post processor, since the logic and most of the code will remain the same. As of this writing, the following post processors have support for inspection, notice that all of them are named with the inspect surface or inspection suffix.
### Post Processors that Support Surface Inspect Operations

<table>
<thead>
<tr>
<th>Post Library Name</th>
<th>Filename</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fanuc Inspection</td>
<td>fanuc inspection.cps</td>
</tr>
<tr>
<td>HAAS (pre-NGC) Inspect Surface</td>
<td>haas inspect surface.cps</td>
</tr>
<tr>
<td>HAAS – Next Generation Control Inspect Surface</td>
<td>haas next generation inspect surface.cps</td>
</tr>
<tr>
<td>Heidenhain Inspection</td>
<td>heidenhain inspection.cps</td>
</tr>
<tr>
<td>Siemens SINUMERIK 840D Inspection</td>
<td>siemens 840D inspection.cps</td>
</tr>
</tbody>
</table>

You can also search the online Post Library for Autodesk Fusion 360 to see if any other post processors have been added with inspection capabilities.

The main code for Inspect Surface logic is located at the end of the post processor. You will need to copy from the definition of description located after the `onClose` or `onTerminate` function to the end of the file and add this code to the end of your post processor.

```csharp
description = "HAAS - Next Generation Control Inspect Surface";
minimumRevision = 42251;
longDescription = "Generic post for the HAAS Next Generation control with inspect surface capabilities.";
```

The main code for Inspect Surface logic is located at the end of the post processor. You will need to copy from the definition of description located after the `onClose` or `onTerminate` function to the end of the file and add this code to the end of your post processor.

```csharp
description = "HAAS - Next Generation Control Inspect Surface";
minimumRevision = 42251;
longDescription = "Generic post for the HAAS Next Generation control with inspect surface capabilities.";
```

### 8.3.3 Adding the Supporting Inspect Surface Logic

There are a number of locations that contain support logic for Inspect Surface operations in the post processor. You can refer to any of the generic post processors that support Inspect Surface operations for an example on where this code is implemented.

Add the following code at the end of the `onOpen` function.
// Probing Surface Inspection
if (typeof inspectionWriteVariables == "function") {
    inspectionWriteVariables();
}

Add to the End of the onOpen Function

For multi-axis machines it is important that an actual machine configuration is defined and is not reliant on 3+2 plane codes and/or IJK output. Please refer to the Multi-Axis Post Processors section for a description on implementing multi-axis support to your post processor.

If your post processor does not have the isInspectionOperation function defined, then add it after the isProbeOperation function.

function isInspectionOperation(section) {
    return section.hasParameter("operation-strategy") && (section.getParameter("operation-strategy") == "inspectSurface");
}

Add isInspectionOperation

The following code needs to be added to the onSection function.

if (!isInspectionOperation(currentSection) && !isProbeOperation() &&
    (insertToolCall ||
    forceSpindleSpeed ||
    isFirstSection() ||
    (rpmFormat.areDifferent(spindleSpeed, sOutput.getCurrent())) ||
    (tool.clockwise != getPreviousSection().getTool().clockwise)) {
    forceSpindleSpeed = false;
    Don’t Output Spindle Speed with a Probe Tool
}

At the end of the onSection function, but before any subprograms are defined, add the following code.

if (isInspectionOperation(currentSection) && (typeof inspectionProcessSectionStart == "function")) {
    inspectionProcessSectionStart();
}

Initialize the Surface Inspect Operation

At the top of the onCyclePoint function add in the following code.

if (isInspectionOperation(currentSection) && (typeof inspectionCycleInspect == "function")) {
    inspectionCycleInspect(cycle, x, y, z);
    return;
}

Call the Controlling Surface Inspect Function

At the start of the onSectionEnd function add the following code.
### 9 Additive Capabilities and Post Processors

So far in this guide we’ve discussed post processors as they pertain to subtractive machining, but Fusion 360 also supports Additive FFF (fused filament fabrication) printers. This chapter discusses the basics of selecting a machine capable of additive manufacturing, generating an additive tool path, creating output, and the details of an additive post processor.

#### 9.1 Getting Started

This section will give an overview of creating an Additive tool path but will not go into great detail on all of the features of the Additive capabilities of Fusion, just enough to get you started on post processing.

You will of course need a model that you want to print to start with. For the examples in this manual we will use the Fusion Keychain model provided as a CAM sample with your installation of Fusion 360. This model contains subtractive manufacturing operations which can be combined with Additive manufacturing operations, as long as your machine supports both capabilities.
You will see the ADDITIVE tab on the MANUFACTURE ribbon. Selecting this tab will display the Additive menus.

### 9.1.1 Finding a Machine

The first step in creating an Additive tool path is to define the machine that you will be using. Unlike Subtractive operations where the Machine Configuration is optional, it is required for Additive operations. Pressing the Machine Library icon in the Additive menus will display the Fusion Machine Library dialog. Select the Samples menu and check the Additive box to list the available Additive machines. We will be using the Prusa I3 MK2 machine. You should drag this machine into your Local library for convenience.
Finding an Additive Machine and Storing in Your Local Library

Once you find your machine you will need to select the post processor that corresponds to this machine. You can do this by right clicking on the Prusa I3 MK2 machine and choosing Select a post...

Assigning a Post Processor to the Additive Machine

The Fusion Post Library dialog will then be displayed. Select the Samples library and check the Additive box to display only the post processors supporting the Additive capabilities. You will want to select the Prusa I3 MK2 machine. You can drag this post to your Local library.
9.1.2 Creating an Additive Setup

In the Fusion Keychain model you will notice that there is already a subtractive setup defined. For machines that support both additive and subtractive machining you can define both types of operations as long as they are in separate setups. The subtractive operations for these machines are exactly the same as they would be for a purely subtractive (milling) machine. For this sample we will be ignoring the subtractive setup and working with the additive only.

To create an Additive setup, press the Setup menu, change the Operation Type to Additive, and select the configuration for your machine by pressing the Select... button under Machine.
Defining an Additive Setup

Now you will need to associate a post processor with the Machine Configuration. Do this by pressing the Edit… button under the Machine prompt. The Machine Configuration will display, change the Post location to Personal – local, and select the prusa.cps post processor from the Post Processor drop down menu.

Associating a Post Processor to a Machine Configuration

You can select and/or edit the Print Settings directly from the Setup dialog when creating the Additive Setup. The Print Settings are specific to the creation of the Additive toolpaths, with settings to modify the bed temperature, nozzle temperature, layer thickness, infill style, etc. You can also create your own default print settings by giving them a new name.
Defining the Print Settings

The Print Settings can be edited outside of the Setup dialog by right clicking on the Print Settings icon under the Additive Setup.

Editing the Print Settings

After creating the Setup you should see a representation of the machine base and envelope with the part located on it. Feel free to rename the new setup to Additive so you know that this is an additive operation. If you were going to do both additive and subtractive operations in the same model, then you will want to move the Additive setup above the Subtractive setup.
If the part is not in the location on the machine where you want it, you can easily reposition it using the POSITION menus.

9.1.3 Creating and Simulating an Additive Operation
An Additive operation is automatically created when an Additive setup is created. You can see this operation by expanding the Additive setup in the Browser. There can only be one Additive operation per setup. You will need to generate the Additive Toolpath manually by selecting Generate from the ACTIONS menus or by pressing Ctrl+G. This may take a while depending on the complexity of the model.
To simulate the Additive toolpath press the *Simulate* button in the ACTIONS menus. Additive toolpaths simulate in the same manner as Subtractive toolpaths, but it is recommended that you place the cursor over the green slide bar at the bottom of the window, hold down the left mouse button, and move the mouse to the left and right to visualize the Additive process.
9.2 Creating a New Machine Configuration

When adding a new Additive post processor you will need to create a corresponding Machine Configuration. You do this by copying an existing Machine Configuration into your Local library by opening up the Fusion Machine Library dialog, selecting the Machine Configuration you want to copy, and then pasting it into your Local folder.

Once you create a copy of the Machine Configuration in your Local folder you will need to edit it and describe your machine. Be sure to give it a unique name and description and go through all sections to properly define the machine.
After creating your Machine Configuration you will need to copy a seed post into a local folder, for example `prusa.cps`, and give it a meaningful name. You can then assign this post processor to your machine. You can also select the default output folder for your G-code files when posting.

You are now ready to edit your post processor.
### 9.3 Additive Variables

There are variables that are specific to Additive machines. These variables are either globally defined or are accessed through function calls. The following table lists the variables available for Additive machines.

<table>
<thead>
<tr>
<th>Variable</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>bedCenter</td>
<td>Post processor defined object that stores the center coordinates of the bed.</td>
</tr>
<tr>
<td>bedTemp</td>
<td>Temperature of bed.</td>
</tr>
<tr>
<td>Extruder</td>
<td>An unnamed object that contains the extruder definition. This object is obtained by calling the <code>getExtruder</code> function.</td>
</tr>
<tr>
<td>extruderOffsets</td>
<td>Post processor defined array that defines the offsets from the reference (first) extruder for each extruder.</td>
</tr>
<tr>
<td>layerCount</td>
<td>Number of printed layers for entire printing operation.</td>
</tr>
<tr>
<td>machineConfiguration</td>
<td>The Machine Configuration definition.</td>
</tr>
<tr>
<td>numberOfExtruders</td>
<td>Number of extruders used.</td>
</tr>
<tr>
<td>partCount</td>
<td>Number of bodies created during printing.</td>
</tr>
<tr>
<td>printerLimits</td>
<td>Post processor defined variable that stores the limits of the machine.</td>
</tr>
<tr>
<td>printTime</td>
<td>The amount of time the print should take.</td>
</tr>
</tbody>
</table>

**Global Additive Variables**

The post processor defined variables are defined in the `getPrinterGeometry` function from the `machineConfiguration` settings and are typically in all Additive post processors.

### 9.3.1 The `machineConfiguration` Object

The `machineConfiguration` object is standard between all machine types, milling, turning, additive, etc. `machineConfiguration` settings are always referenced using a function. The variables returned from the functions are described in the following table.

<table>
<thead>
<tr>
<th>MachineConfiguration Function</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>hasCenterPosition()</td>
<td>Returns <code>true</code> if the center position of the printer table is defined.</td>
</tr>
<tr>
<td>getCenterPositionX(id)</td>
<td>The center of the printer table in X.</td>
</tr>
<tr>
<td>getCenterPositionY(id)</td>
<td>The center of the printer table in Y.</td>
</tr>
<tr>
<td>getCenterPositionZ(id)</td>
<td>The center of the printer table in Z.</td>
</tr>
<tr>
<td>getExtruderOffsetX(id)</td>
<td>The offset in X from the reference extruder.</td>
</tr>
<tr>
<td>getExtruderOffsetY(id)</td>
<td>The offset in Y from the reference extruder.</td>
</tr>
<tr>
<td>getExtruderOffsetZ(id)</td>
<td>The offset in Z from the reference extruder.</td>
</tr>
<tr>
<td>hasParkPosition()</td>
<td>Returns <code>true</code> if the home position of the machine is defined.</td>
</tr>
<tr>
<td>getParkPositionX(id)</td>
<td>The home position of the machine in X.</td>
</tr>
<tr>
<td>getParkPositionY(id)</td>
<td>The home position of the machine in Y.</td>
</tr>
<tr>
<td>getParkPositionZ(id)</td>
<td>The home position of the machine in Z.</td>
</tr>
<tr>
<td>getModel()</td>
<td>The model type of the printer.</td>
</tr>
<tr>
<td>getNumberExtruders()</td>
<td>Number of defined extruders.</td>
</tr>
</tbody>
</table>

* `machineConfiguration Functions used for Additive*
When there is a `has---` function defined for the corresponding `get---` function you should first call the `has---` function prior to calling the `get---` function to avoid possible errors.

```java
if (machineConfiguration.hasCenterPosition()) {
    printerLimits.x.min = 0 - machineConfiguration.getCenterPositionX();
    printerLimits.y.min = 0 - machineConfiguration.getCenterPositionY();
    printerLimits.z.min = 0 + machineConfiguration.getCenterPositionZ();
}
```

**Call hasCenterPosition Prior to Calling getCenterPosition**

### 9.3.2 The Extruder Object

There is not really a named Extruder object, meaning you cannot use the `new Extruder` syntax to create an object as you would a Vector, but there is the `getExtruder` function that will return an unnamed object that has extruder specific variables. Each extruder can be referenced by passing the extruder number to the `getExtruder` function.

```javascript
var totalLength = getExtruder(1).extrusionLength;
```

**Get the Total Length of Material Used for Extruder 1**

The following table defines the variables accessible using the `getExtruder` function

<table>
<thead>
<tr>
<th>Extruder Variable</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>extrusionLength</td>
<td>Total length of material used for this extruder during printing.</td>
</tr>
<tr>
<td>filamentDiameter</td>
<td>The diameter of the filament material.</td>
</tr>
<tr>
<td>materialName</td>
<td>The name of the material used for the extruder.</td>
</tr>
<tr>
<td>nozzleDiameter</td>
<td>The diameter of the extruder nozzle.</td>
</tr>
<tr>
<td>temperature</td>
<td>The temperature setting for the extruder.</td>
</tr>
</tbody>
</table>

**Extruder Variables**

### 9.4 Additive Entry Functions

Additive post processors use most of the common Entry functions for Subtractive posts, with some specialized Entry functions for Additive post processors only. Remember that Entry functions are called from the post processor kernel based on the record type in the intermediate file, so this means that there is a difference between Subtractive and Additive intermediate files.

The following table defines the unique or modified Entry Functions for Additive post processors. You can reference the table in the subtractive Entry Functions section for a description of the common entry functions.

<table>
<thead>
<tr>
<th>Entry Function</th>
<th>Invoked When …</th>
</tr>
</thead>
<tbody>
<tr>
<td>onBedTemp(temp, wait)</td>
<td>Bed temperature change.</td>
</tr>
<tr>
<td>onClose()</td>
<td>End of post processing.</td>
</tr>
<tr>
<td>Entry Function</td>
<td>Invoked When …</td>
</tr>
<tr>
<td>-----------------------------</td>
<td>-----------------------------------------------------</td>
</tr>
<tr>
<td>onExtruderChange(id)</td>
<td>Change of extruders.</td>
</tr>
<tr>
<td>onExtruderTemp(temp, wait, id)</td>
<td>Extruder temperature change.</td>
</tr>
<tr>
<td>onExtrusionReset(length)</td>
<td>Resets the length of the extrusion material used.</td>
</tr>
<tr>
<td>onFanSpeed(speed, id)</td>
<td>Change of fan speed.</td>
</tr>
<tr>
<td>onLayer(layer)</td>
<td>Change of layer level.</td>
</tr>
<tr>
<td>onOpen()</td>
<td>Post processor initialization.</td>
</tr>
<tr>
<td>onLinearExtrude(x, y, z, f, e)</td>
<td>Additive pass.</td>
</tr>
<tr>
<td>onParameter(string, value)</td>
<td>Each parameter setting.</td>
</tr>
<tr>
<td>onRapid(x, y, z)</td>
<td>Positioning Rapid move.</td>
</tr>
<tr>
<td>onSection()</td>
<td>Start of an operation.</td>
</tr>
</tbody>
</table>

### Additive Entry Functions

Many of the entry functions will get their arguments and settings from either the Machine Configuration or Print Settings. These dialogs can be accessed by pressing the right mouse button when over the Additive setup and selecting *Edit*.

![Editing the Setup](image)

This will display the Setup dialog, where you can select to edit either the Machine Configuration (described in the previous section) or Print Settings. You can also display the Print Settings dialog by pressing the *Print Settings* button in the *Additive* menus.
9.4.1 Global Section

The global section for an Additive post is consistent with the standard global section for Subtractive posts, it contains the description of the post processor and machine, its capabilities, kernel settings, property table, and global variables. The capabilities of the post must be set to CAPABILITY_ADDITIVE.

```cpp
capabilities = CAPABILITY_ADDITIVE;
// capabilities = CAPABILITY_ADDITIVE | CAPABILITY_MILLING; // additive & subtractive
```

Setting the Post Processor Capabilities to Additive

The common global variables found in an Additive post are listed below. These variables are defined in the `getPrinterGeometry` function using settings from the Machine Configuration.

```javascript
// needed for range checking, will be effectively passed from Fusion
var printerLimits = {
    x: {min: 0, max: 250.0}, // Defines the x bed size
    y: {min: 0, max: 210.0}, // Defines the y bed size
    z: {min: 0, max: 210.0} // Defines the z bed size
};

// For information only
var bedCenter = {
```

Editing the Print Settings
Global Settings

9.4.2 onOpen

function onOpen()

The `onOpen` function is called at the start of post processing and is used to define settings and output startup blocks.

1. Define settings
2. Output machine and program description
3. Output initial startup codes

The machine definition settings are defined in the `getPrinterGeometry` function, which is called at the start of the `onOpen` function.

getPrinterGeometry();

Define Machine Geometry

Following is an example of code that outputs the program and machine information to the output file.

if (programName) {
    writeComment(programName);
} else {
    writeComment(programComment);
}

writeComment("Printer Name: "+ machineConfiguration.getVendor()+" "+
               machineConfiguration.getModel());
writeComment("Print time: "+ xyzFormat.format(printTime)+"s");
writeComment("Material used: "+ dimensionFormat.format(getExtruder(1).extrusionLength));
writeComment("Material name: "+ getExtruder(1).materialName);
writeComment("Filament diameter: "+ dimensionFormat.format(getExtruder(1).filamentDiameter));
writeComment("Nozzle diameter: "+ dimensionFormat.format(getExtruder(1).nozzleDiameter));
writeComment("Extruder offset x: "+ dimensionFormat.format(extruderOffsets[0][0]));
writeComment("Extruder offset y: "+ dimensionFormat.format(extruderOffsets[0][1]));
writeComment("Extruder offset z: "+ dimensionFormat.format(extruderOffsets[0][2]));
writeComment("Max temp: "+ integerFormat.format(getExtruder(1).temperature));

var extruderOffsets = [[0, 0, 0], [0, 0, 0]];
var activeExtruder = 0;  //Track the active extruder.
Some machines require that startup codes be output at the start of the program to initialize the machine. This could include homing the axes, initialization codes, etc.

```java
// initialize the machine
writeBlock("G28 W ; home all without mesh bed level");
writeBlock("G80 ; mesh bed leveling");
```

### Output the Initial Startup Codes

#### 9.4.3 onSection

```javascript
function onSection() {

The **onSection** function is called at the start of each Additive operation, checks that the operation is within the limits of the machine, and outputs the codes required at the start of an operation.

```javascript
// verify that the toolpath is within the build volume of the machine
var range = currentSection.getBoundingBox();
axes = ["x", "y", "z"];
formats = [xFormat, yFormat, zFormat];
for (var element in axes) {
    var min = formats[element].getResultingValue(range.lower[axes[element]]);
    var max = formats[element].getResultingValue(range.upper[axes[element]]);
    if (printerLimits[axes[element]].max < max || printerLimits[axes[element]].min > min) {
        error(localize("A toolpath is outside of the build volume.")));;
    }
}
```

### Check the Toolpath with the Limits of the Machine

```java
// output start of operation codes
writeBlock(gFormat.format(92), eOutput.format(0));
// set unit
writeBlock(gFormat.format(unit == MM ? 21 : 20));
writeBlock(gAbsIncModal.format(90)); // absolute spatial co-ordinates
writeBlock(mFormat.format(82)); // absolute extrusion co-ordinates
```

### Output Start of Additive Operation Codes

#### 9.4.4 onClose

```javascript
function onClose() {

The **onClose** function is called at the end of the last operation. It is used to output the end-of-program codes.

```
function onClose() {
    // output end-of-program codes
    writeComment("Disable stepper on all axis except z");
    writeBlock(mFormat.format(84) + " X Y E");
    writeComment("END OF GCODE");
}

Sample onClose Function

9.4.5 onBedTemp

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>temp</td>
<td>The bed temperature in Celsius.</td>
</tr>
<tr>
<td>wait</td>
<td>Set to true when the machine should wait for the bed to warm up.</td>
</tr>
</tbody>
</table>

The `onBedTemp` function is called multiple times during a toolpath. At the start of the operation `onBedTemp` is called with `wait` set to `false` to start heating the bed. It is called a second time prior to the start of the toolpath with `wait` set to `true` so that the machine waits for it to reach the targeted temperature. It will also be called at the end of the program to turn off the heating of the bed.

The maximum bed temperature is defined in the `Limits` tab when defining the Machine Configuration in Fusion.

function onBedTemp(temp, wait) {
    if (wait) {
        writeBlock(mFormat.format(190), sOutput.format(temp));
    } else {
        writeBlock(mFormat.format(140), sOutput.format(temp));
    }
}

Sample onBedTemp Function

9.4.6 onExtruderChange

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>id</td>
<td>Extruder number to activate. The first extruder is 0.</td>
</tr>
</tbody>
</table>

The `onExtruder` function handles a switch from one extruder to another similar to a tool change in a subtractive machine. The number of extruders is defined in the `Information` tab when defining the Machine Configuration in Fusion.
function onExtruderChange(id) {
    if (id < numberOfExtruders) {
        writeBlock(tFormat.format(id));
        activeExtruder = id;
        xOutput.reset();
        yOutput.reset();
        zOutput.reset();
    } else {
        error(localize("This printer doesn't support the extruder ") + integerFormat.format(id) + " !");
    }
}

Sample onExtruderChange Function

9.4.7 onExtrusionReset

function onExtrusionReset(length) {

Arguments  Description
length      Length of the additive material used for the active extruder.

The onExtrusionReset function will be called to reset the length of the used additive material when the active extruder changes. At the beginning of the program it will be called with a value of 0 and when switching between one extruder and another it will pass the length of additive material used for the newly activated extruder.

function onExtrusionReset(length) {
    eOutput.reset();
    writeBlock(gFormat.format(92), eOutput.format(length));
}

Sample onExtrusionReset Function

9.4.8 onLayer

function onLayer(layer) {

Arguments  Description
layer      Current layer being printed.

The onLayer function is called for every printed layer and passes in the active layer. It can be used to output a comment prior to the toolpath for each layer and/or to increment a counter on the machine control to show the printing progress.

function onLayer(num) {
    writeComment("Layer : " + integerFormat.format(num) + " of " +
                 integerFormat.format(layerCount));
}

Sample onLayer Function
Additive Capabilities and Post Processors

### 9.4.9 onExtruderTemp

```javascript
function onExtruderTemp(temp, wait, id) {
    Arguments | Description
    --- | ---
    temp | The extruder temperature in Celsius.
    wait | Set to true when the machine should wait for the extruder to warm up.
    id | Extruder number to set the temperature for. The first extruder is 0.
```

The `onExtruderTemp` function is called multiple times during a toolpath. At the start of the operation `onExtruderTemp` is called with `wait` set to false to start heating the extruder. It is called a second time prior to the start of the toolpath with `wait` set to true so that the machine waits for it to reach the targeted temperature. It will also be called at the end of the program to turn off the heating of the extruder.

The desired extruder temperature is defined in the Extruder tab of the Print Settings dialog. The maximum extruder temperature is set in the Extruder Configuration tab when defining the Machine Configuration in Fusion.

```javascript
function onExtruderTemp(temp, wait, id) {
    if (id < numberOfExtruders) {
        if (wait) {
            writeBlock(mFormat.format(109), sOutput.format(temp), tFormat.format(id));
        } else {
            writeBlock(mFormat.format(104), sOutput.format(temp), tFormat.format(id));
        }
    } else {
        error(localize("This printer doesn't support the extruder ") + integerFormat.format(id) + "!");
    }
}
```

**Sample onExtruderTemp Function**

### 9.4.10 onFanSpeed

```javascript
function onFanSpeed(speed, id) {
    Arguments | Description
    --- | ---
    speed | The fan speed as a percentage of the default speed in the range of 0-255.
    id | Extruder number to set the fan speed for, typically the active extruder.
```

The `onFanSpeed` function is used to turn on and off the fan used for cooling the extruded material. The fan is controlled starting at the layer after the number of disabled layers defined in the Cooling tab of the Print Settings dialog.

```javascript
function onFanSpeed(speed, id) {
```

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if (speed == 0) {
    writeBlock(mFormat.format(107));
} else {
    writeBlock(mFormat.format(106), sOutput.format(speed));
}
}

Sample onFanSpeed Function

9.4.11 onParameter

function onParameter(name, value) {

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>name</td>
<td>Parameter name.</td>
</tr>
<tr>
<td>value</td>
<td>Value stored in the parameter.</td>
</tr>
</tbody>
</table>

The onParameter function behaves the same as it does in a Subtractive post processor, but there is one parameter that is specific to Additive machines. This is the feedRate parameter that defines the travel speed that the machine will move when positioning without extruding material and for extruder changes.

function onParameter(name, value) {
    switch (name) {
        // feedrate is set before rapid moves and extruder change
        case "feedRate":
            if (unit == IN) {
                value /= 25.4;
            }
            setFeedRate(value);
            break;
    }
}

Sample onParameter Function

9.4.12 onRapid

function onRapid(_x, _y, _z) {

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>_x, _y, _z</td>
<td>The tool position.</td>
</tr>
</tbody>
</table>

The onRapid function handles positioning moves, which do not extrude the additive material. The output of the onRapid function usually outputs a single block for the positioning move.

function onRapid(_x, _y, _z) {
    var x = xOutput.format(_x);
}
Additive Capabilities and Post Processors

9.13 onLinearExtrude

```javascript
function onLinearExtrude(_x, _y, _z, _f, _e) {
    var x = xOutput.format(_x);
    var y = yOutput.format(_y);
    var z = zOutput.format(_z);
    var f = feedOutput.format(_f);
    var e = eOutput.format(_e);
    if (x || y || z || f || e) {
        writeBlock(gMotionModal.format(1), x, y, z, f, e);
    }
}
```

### Sample onLinearExtrude Function

The `onLinearExtrude` function handles linear moves that extrude the additive material. The tool position, feedrate and length of material to extrude are passed as the arguments.

9.5 Common Additive Functions

There are non-entry functions that are common to Additive post processors. Some of these are defined in the post processor kernel and some in the post processor itself. The following sections describes these functions.

9.5.1 getExtruder

```javascript
function getExtruder(id) {
    // Function implementation
}
```

### Sample getExtruder Function

<table>
<thead>
<tr>
<th>Arguments</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>id</td>
<td>Extruder number to get information about.</td>
</tr>
</tbody>
</table>

Sample onLinearExtrude Function

9.5.2...
The `getExtruder` function returns the Extruder variable, which includes information about the specified extruder. Unlike the entry functions were the extruder base is 0, in the `getExtruder` function the first extruder is referenced as `id=1`, the second as `id=2`, etc.

```java
writeComment("Material used: " + dimensionFormat.format(getExtruder(1).extrusionLength));
writeComment("Material name: " + getExtruder(1).materialName);
writeComment("Filament diameter: " + dimensionFormat.format(getExtruder(1).filamentDiameter));
writeComment("Nozzle diameter: " + dimensionFormat.format(getExtruder(1).nozzleDiameter));
```

Sample Calls to `getExtruder`

### 9.5.2 isAdditive

```java
function isAdditive() {

Returns true if any of the operations in the part are Additive in nature.
```

### 9.5.3 getPrinterGeometry()

```java
function getPrinterGeometry() {

The `getPrinterGeometry` function is defined in the post processor and it sets the variables local to the post processor based on the Machine Configuration. It is called at the start of post processing from the `onOpen` function.

function getPrinterGeometry() {
    machineConfiguration = getMachineConfiguration();

    // Get the printer geometry from the machine configuration
    printerLimits.x.min = 0 - machineConfiguration.getCenterPositionX();
    printerLimits.y.min = 0 - machineConfiguration.getCenterPositionY();
    printerLimits.z.min = 0 + machineConfiguration.getCenterPositionZ();

    printerLimits.x.max = machineConfiguration.getWidth() - machineConfiguration.getCenterPositionX();
    printerLimits.y.max = machineConfiguration.getDepth() - machineConfiguration.getCenterPositionY();
    printerLimits.z.max = machineConfiguration.getHeight() + machineConfiguration.getCenterPositionZ();

    // Can be used in the post for documenting purpose.
    bedCenter.x = (machineConfiguration.getWidth() / 2.0) - machineConfiguration.getCenterPositionX();
    bedCenter.y = (machineConfiguration.getDepth() / 2.0) - machineConfiguration.getCenterPositionY();
    bedCenter.z = machineConfiguration.getCenterPositionZ();
```

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// Get the extruder configuration
extruderOffsets[0][0] = machineConfiguration.getExtruderOffsetX(1);
extruderOffsets[0][1] = machineConfiguration.getExtruderOffsetY(1);
extruderOffsets[0][2] = machineConfiguration.getExtruderOffsetZ(1);
if (numberOfExtruders > 1) {
    extruderOffsets[1] = [];
    extruderOffsets[1][0] = machineConfiguration.getExtruderOffsetX(2);
    extruderOffsets[1][1] = machineConfiguration.getExtruderOffsetY(2);
    extruderOffsets[1][2] = machineConfiguration.getExtruderOffsetZ(2);
}

Sample getPrinterGeometry Function

### 9.5.4 setFeedRate

```javascript
function setFeedRate(value) {
    feedOutput.reset();
    writeBlock(gFormat.format(1), feedOutput.format(value));
}
```

Sample setFeedRate Function

The *setFeedRate* function is defined in the post processor and is used to output the feedrate used for positioning moves when the Additive material is not being used. It is normally called with the value passed in the *feedRate* parameter defined in the *onParameter* function.
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