



HRS ShopBot Router Post

Thank you for Downloading a **Hawk Ridge Systems** post!

Hawk Ridge Systems has decades of experience developing posts for CAMWorks and SolidWorksCAM.

Overview

This post Supports All 3 axis operations.

1. All post files must be in the same location.

Output file

The extension for this post is .SBP, changeable in the file .PINF. To edit this, open by right clicking on it and selecting "Open With" then select notepad.

Change the line "PostExtension = " to your preferred extension. Do not use a "." before it.

Posting Tab of Machine

Parameter	Value
Customer Name	
Program number	1
Operation Desc.	
Programmer	
Safe Z Height	2.00000"
Z Zero	Table Surface

1. Customer Name **Type= Characters, Default= Blank**
Will be posted in the code.
2. Program Number **Type=Number, Default= 1**
This is the Oxxxx number at the top of the program.
3. Operation Desc. **Type=Characters, Default= Blank**
Will not be posted. Reference only.
4. Programmer **Type=Characters, Default= Blank**
Will not be posted. Reference only.
5. Safe Z Height **Type=Decimal, Default= 2.00000"**
Default will be posted to the &PWSafeZ output in the code.



6. Z Zero

Type=Select, Default= **Table Surface**

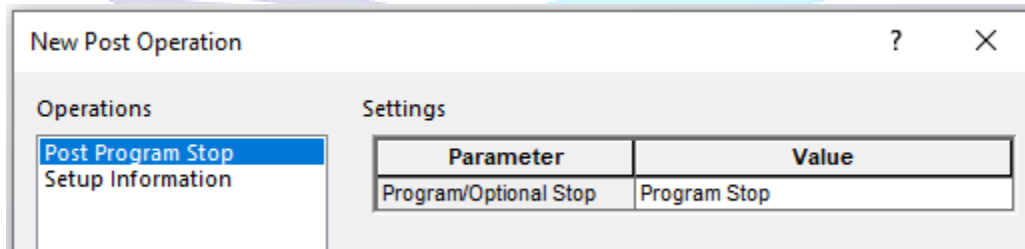
Table Surface or Part Surface can be selected for the &PWZorigin in the posted code.

Post Operation Insert

Right click on operations tree and select "Post Operation" from the menu

Post Program Stop

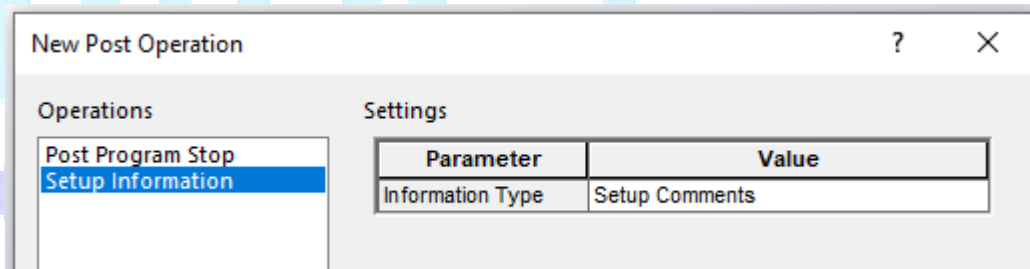
Inserts a Program or Option Stop.



1. Program/Optional Stop Type=Select, Default= **Program Stop**
Select between "Program Stop" (M00)
or "Optional Stop" (M01) output.

Setup Information

Will insert setup information in the posted code going to the machine.



In the operations tree Find the newly created post operation. Normally called 'Post OperationX[Setup Information]'.

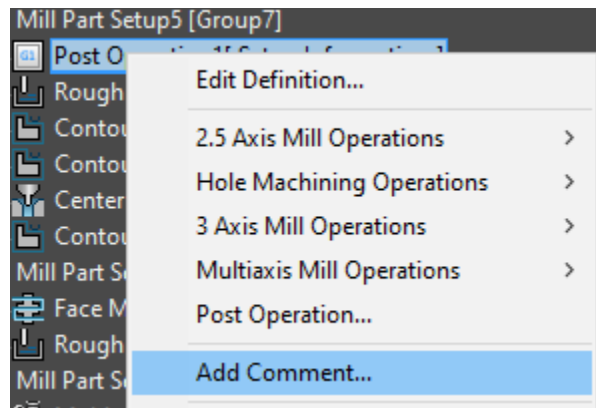
The 'X' represents the number after the post operation.

Right click on 'Post OperationX[Setup Information]' and select 'Add Comment'



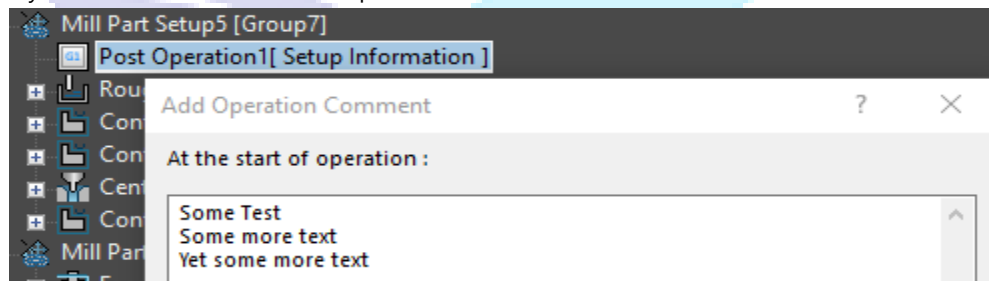
HAWK RIDGE SYSTEMS

Worldwide Post Processor Support and Development



In the top box in the add operation comment window.

Enter your comments. For a new line press CTRL + Enter.



How it works:

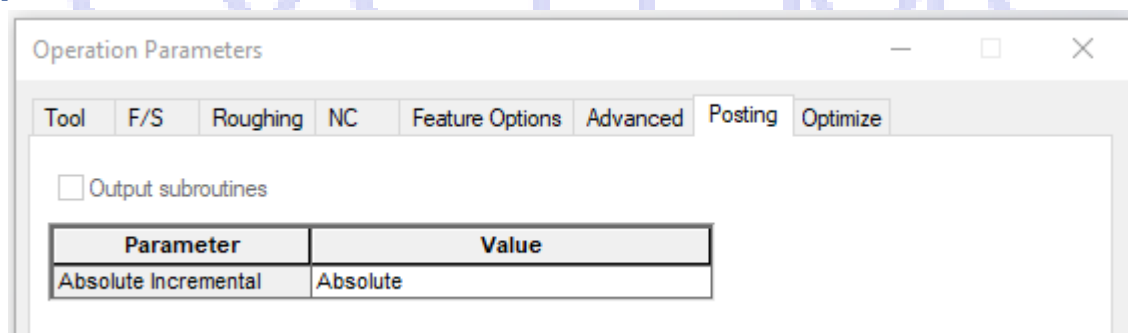
When you post, the system will output the comments you entered. This can go anywhere in the tree but most of the time it is at the top before the first operation in a setup.

Note: If you want to insert comments to an operation in CAMWorks start at letter 'c' above. Right click on the operation instead of the post operation.

Operation Post Tab

Double click on an operation or RBM (right button mouse) on the operation and select 'Edit Definition'

Mill Operation





1. Absolute Incremental

Type=Select, Default=**Absolute**

All Z moves are Absolute regardless of selection.

End User Agreement

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