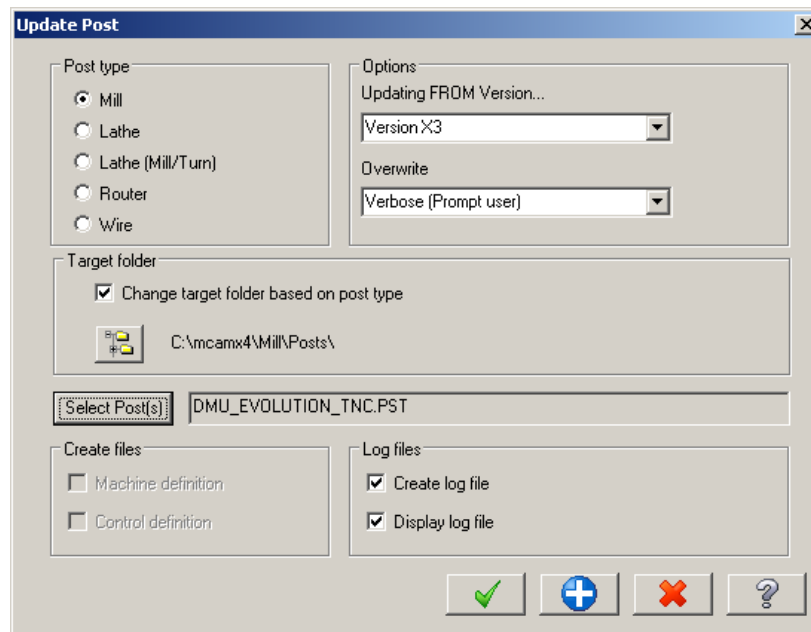


Mastercam X4 Post Update

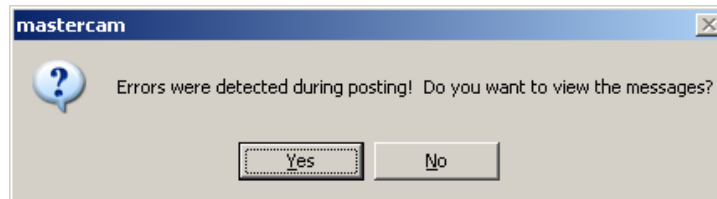
With the new release of X4, the error reporting capabilities of Mastercam for the post are **significantly improved**. This means that Mastercam will pick up a lot of warnings and/or errors, that you may have had for a long time, but were never reported.

- **This does not mean, that your post is not working properly, but simply that the error was never reported.**
- To update your post, run the Chook (Alt + C), Updatepost.dll



- During posting, Mastercam may let you know that some errors/warnings have been found

```
Post processor file name: C:\MCAMX4\MILL\POSTS\DMU_EVOLUTION_TNC.PST
UPDATEPOST Version 13. is processing this file.
The post is targeted to run with Mastercam Version 13.
The post product type is Mill.
PST LINE (2014) - Missing a matching open bracket
PST LINE (2184) - Missing a matching close bracket
PST LINE (2036) - Missing a matching open bracket
PST LINE (2206) - Missing a matching close bracket
Writing the post was successful.
PARAMETER DATA - - This 'parameter read' postblock was found in the post:
PARAMETER DATA - - Possibly incorrect parameter number detected: 17044. P
PST LINE (2058) - Missing a matching open bracket
PST LINE (2207) - Missing a matching close bracket
***** End of update processing *****
```



- If you do have such errors, please verify the error log. This will indicate to you in detail, which area of the post is causing the error. This will also give you a detail on the type of error reported, and you will be able to verify if this error is fatal or not.

```

CIMCO Edit v5.5 - [C:\MCAMX4\MILL\NC\SK68A325945-2005.err]
File Edit UIC Functions Transmission CNC-Calc Badplot File Compare Setup Window Help
ISO Mill
G28 Machine coordinate mode
UPDATEPOST.LOG | DMU_EVOLUTION_TNC.pst | SK68A325945-2005.err | SK68A325945-2005.NC
08 Jul 2009 10:51:06 AM - <0> - Report created.
08 Jul 2009 10:51:06 AM - <2> - Initialize posting log file
08 Jul 2009 10:51:06 AM - <2> - Using MP run version 13.00 and post components version 10.00
08 Jul 2009 10:51:06 AM - <2> - Initiate opening the post processor file(s)
08 Jul 2009 10:51:06 AM - <2> - Post processor file name: C:\MCAMX4\MILL\POSTS\DMU_EVOLUTION_TNC.PST
08 Jul 2009 10:51:06 AM - <2> - The post processor file has been successfully opened.
08 Jul 2009 10:51:06 AM - <2> - The post processor file has finished the read process.
08 Jul 2009 10:51:06 AM - <2> - Post version information (input):
08 Jul 2009 10:51:06 AM - <2> - UPDATEPOST Version 13. was used to modify this file.
08 Jul 2009 10:51:06 AM - <2> - The file was modified by this product on 08 Jul 09 10:28:51
08 Jul 2009 10:51:06 AM - <2> - The post was written to run with Mastercam Version 13.
08 Jul 2009 10:51:06 AM - <2> - The post product type is Mill.
08 Jul 2009 10:51:07 AM - <2> - Initialization of pre-defined post variables, strings, postblocks was successful.
08 Jul 2009 10:51:07 AM - <2> - Search for defined post variables, strings, postblocks was successful.
08 Jul 2009 10:51:09 AM - <2> - PST LINE (2014) - Missing a matching open bracket
08 Jul 2009 10:51:09 AM - <2> - PST LINE (2183) - Missing a matching close bracket
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'maxnccomment$' was re-initialized from 256. to 120.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'dec_seq_left$' was re-initialized from 3. to 4.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'sub_seq_typ$' was re-initialized from 0. to 1.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'tplanemode$' was re-initialized from 2. to 1.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'nobrks$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'nobrkkz$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'nobrkyz$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'lnobrks$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'lnobrkkz$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'lnobrkyz$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'arctype$' was re-initialized from 5. to 2.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'arcoutput$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'arctypez$' was re-initialized from 5. to 2.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'arcoutputz$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'arctypeyz$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'larctoutput$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'larctypez$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'larctoutputz$' was re-initialized from 1. to 0.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'breakarcs$' was re-initialized from 0. to 1.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'breakarcsz$' was re-initialized from 0. to 1.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'breakarcsyz$' was re-initialized from 0. to 1.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'lbreakarcs$' was re-initialized from 0. to 1.
08 Jul 2009 10:51:09 AM - <2> - CONTROL DEFINITION - - Post variable 'lbreakarcsz$' was re-initialized from 0. to 1.
Machine 1
Licensed to DEMO - NOT FOR RESALE - In-House Solutions Inc. Ln1/88, Col 1, 6,010 bytes INS 10:51:47 AM

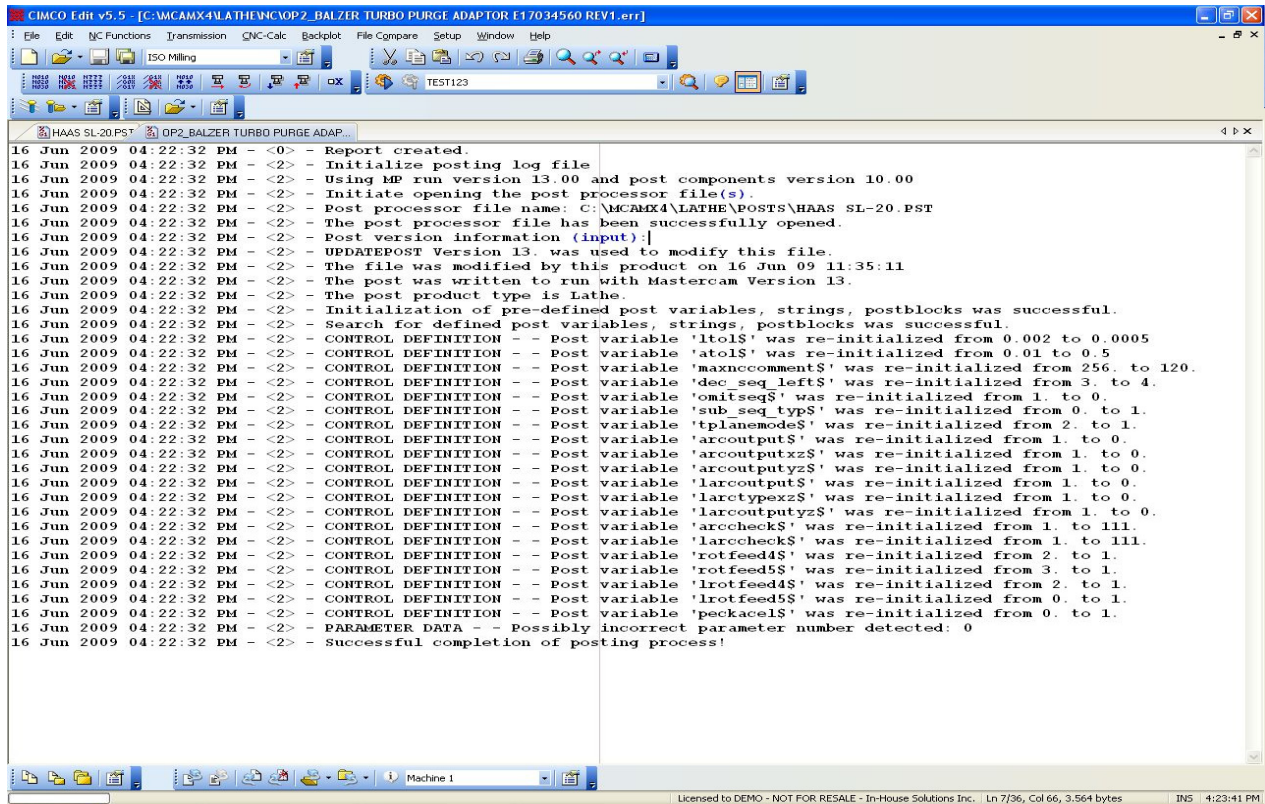
```

```

The post was written to run with Mastercam Version 13.
The post product type is Mill.
Initialization of pre-defined post variables, strings, postblocks was successful.
Search for defined post variables, strings, postblocks was successful.
PST LINE (2014) - Missing a matching open bracket
PST LINE (2183) - Missing a matching close bracket
CONTROL DEFINITION - - Post variable 'maxnccomment$' was re-initialized from 256.
CONTROL DEFINITION - - Post variable 'dec_seq_left$' was re-initialized from 3. t

```

After updating an **Mplmaster (Lathe)** based post from X3 to X4, you may receive the following error messages:



```

16 Jun 2009 04:22:32 PM - <0> - Report created.
16 Jun 2009 04:22:32 PM - <2> - Initialize posting log file
16 Jun 2009 04:22:32 PM - <2> - Using MP run version 13.00 and post components version 10.00
16 Jun 2009 04:22:32 PM - <2> - Initiate opening the post processor file(s).
16 Jun 2009 04:22:32 PM - <2> - Post processor file name: C:\MCMX4\LATHE\POSTS\HAAS SL-20.PST
16 Jun 2009 04:22:32 PM - <2> - The post processor file has been successfully opened.
16 Jun 2009 04:22:32 PM - <2> - Post version information (input):
16 Jun 2009 04:22:32 PM - <2> - UPDATEPOST Version 13- was used to modify this file.
16 Jun 2009 04:22:32 PM - <2> - The file was modified by this product on 16 Jun 09 11:35:11
16 Jun 2009 04:22:32 PM - <2> - The post was written to run with Mastercam Version 13.
16 Jun 2009 04:22:32 PM - <2> - The post product type is Lathe.
16 Jun 2009 04:22:32 PM - <2> - Initialization of pre-defined post variables, strings, postblocks was successful.
16 Jun 2009 04:22:32 PM - <2> - Search for defined post variables, strings, postblocks was successful.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'lto1S' was re-initialized from 0.002 to 0.0005
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'atolS' was re-initialized from 0.01 to 0.5
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'maxnccommentS' was re-initialized from 256. to 120.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'dec_seq_leftS' was re-initialized from 3. to 4.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'omitseqS' was re-initialized from 1. to 0.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'sub_seq_ttypS' was re-initialized from 0. to 1.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'tplanemodeS' was re-initialized from 2. to 1.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'arcoutputS' was re-initialized from 1. to 0.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'arcoutputxzS' was re-initialized from 1. to 0.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'arcoutputyzS' was re-initialized from 1. to 0.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'larcoutputS' was re-initialized from 1. to 0.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'larcotypexzS' was re-initialized from 1. to 0.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'larcoutputyzS' was re-initialized from 1. to 0.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'arccheckS' was re-initialized from 1. to 111.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'larccheckS' was re-initialized from 1. to 111.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'rotfeed4S' was re-initialized from 2. to 1.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'rotfeed5S' was re-initialized from 3. to 1.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'lrotfeed4S' was re-initialized from 2. to 1.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'lrotfeed5S' was re-initialized from 0. to 1.
16 Jun 2009 04:22:32 PM - <2> - CONTROL DEFINITION - - Post variable 'peckacelS' was re-initialized from 0. to 1.
16 Jun 2009 04:22:32 PM - <2> - PARAMETER DATA - - Possibly incorrect parameter number detected: 0
16 Jun 2009 04:22:32 PM - <2> - Successful completion of posting process!

```

```

<2> - PARAMETER DATA - - Possibly incorrect parameter number detected: 0
<2> - Successful completion of posting process!

```

- To remove the error message file, open up the post (c:\mcamx4\lathe\post\mplmaster.pst) and search for the post block **pprep\$**.
- The line containing **rd_params\$** needs to be commented out (#), like following:

```

pprep$      #Pre-process postblock - Allows post instructions after the post is parsed but before the NC and NCI
file are opened.
#DO NOT ATTEMPT TO OUTPUT TO THE NC FILE IN THIS POSTBLOCK (OR ANY POSTBLOCKS YOU MAY CALL FROM
HERE) BECAUSE THE NC OUTPUT FILE IS NOT YET OPENED!
  rd_cd$      #Read CD Parameters
  rd_mch_ent_no$ = 0 #Read only the machine base parameters (use to collect common parameters from
CNC_MACHINE_TYPE)
  rd_md$      #Read machine definition parameters
  rd_tlpathgrp$
# rd_params$
  if write_ops = 0, result=mprint(writeopseerror, 2) #Write NC Operation information MUST be enabled in CD

```