

# NX Post Configurator

## 007 – Debugging II

# Typical questions/ ToDo at start



## General

- Is a general programming manual available (a must for 5axis!)?
- Is a kinematic model available? (Yes/ **No**)
- Which OOTB controller is very similar to the requested postprocessor?
- What is the kinematic configuration of the machine tool?
- Is a list of G- and M-commands available, e.g. for clamping?

## Customer/ machine tool specific settings (all postprocessors)

- What are the defined Home position values?
- Is there a difference between OOTB G-M-commands
- What is the max. spindle speed and does customer needs a Tool preselect?
- Any specific requests to the Tool change, e.g. ToolchangeByName, ToolChangeByNumber?
- How the circular output should be outputted?
- Any requests for additional motions, like behavior at the end of program or Toolchange?
- Does customer needs any specific output in program header or start of path?

## Customer/ machine tool specific settings (all postprocessor >3axes)

- If 5axis, any limitations to the 4th and 5th axis/ vector directions?
- If 5axis, what is the output of swiveling plane/ supported planes?
- If 5axis, what is the output for TCPM mode?

## Clamping 3+2

### Clamp commands for 3+2 operations

My machine tool needs a special kind of clamping for fourth and fifth axis.

- Clamp with M323, unclamp with M325 for fourth axis
- Clamp with M324, unclamp with M326 for fifth axis
- Before I can clamp I need for both axis a M-command (M320 to activate the automatic clamping process)
- Before I unclamp I need for both axis a M-command (M321 to deactivate the automatic clamping process)
- The clamp should happens after the positioning of rotary axis
- In each end of operation the axis should be unclamp (only for 3+2 operations)

## Q&A

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### Thomas Jenensch

Product Portfolio Lead NX CAM Infrastructure  
Manufacturing Engineering Software

Nonnendammallee 101 5. OG, Bauteil C  
D-13629 Berlin, Germany  
Tel. :+49 (30) 46777 535

[thomas.jenensch@siemens.com](mailto:thomas.jenensch@siemens.com)

[www.siemens.com/plm](http://www.siemens.com/plm)

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