

## Mastercam Custom Drill Cycle Requirements

In order to process requests to modify a post processor for the addition of custom drill cycles, it is necessary to provide all information listed below. This helps the post developer to verify how you are programming a drill operation in Mastercam, and to see exactly what you want your custom drill cycle to do and how it should be formatted.

### Requirements:

- **Zip2Go** – Program the drilling operation(s) how you normally would in Mastercam with the Post Processor selected that you want the changes made to. *It is suggested to also have more than one point selected so your example includes how you would want to treat retract moves in between two points in a single drilling operation.* Create a Zip2Go from this file and be sure to include it with your request.
- **Marked up Code** – From the part file you programmed, generate the code as usual and then hand edit the code to match the desired output for the custom cycle(s). *Be sure that the hand-edited codes has been tested or at least looked over carefully to ensure its accuracy as this will be used for reference to complete the customization to the post processor.*
- **Detailed Description** – It is important to provide a detailed description of the steps and order of events that you desire for your custom cycle. Depending on your requests this helps the post developer understand what you are trying to accomplish in the custom cycle and allows for any questions to be asked up front on how you would like it to be implemented. There are often several ways to control a custom cycle from Mastercam and this will help to identify the method that works best for the programmer.

### Additional Notes:

Keep in mind when you make your request, that if you wish to control certain elements of the custom drill cycle, they can be made into a variable that you can control when using the cycle. So be sure to identify anything that you may wish to control per operation compared to something that will just be output the same way every time.

An example of this would be for a deep hole drilling cycle. You may want to enter a pilot hole at a lower spindle speed and/or feed. This could be hard-coded to be the same every time, it could be output as a percentage of your programmed feed and speed or it could be 2 separate input boxes added to allow you to input the specific speed and feed you desire.

**If you have questions or need to discuss the options, you are welcome to contact our Post Department at [posts@fastechinc.net](mailto:posts@fastechinc.net) and we can call you back to discuss your needs.**