

Mastercam Post Processor Installation

Please use the following document for instruction on installing Mastercam Post Processor files. The instructions will apply to new installations as well as replacing files that have been updated with requested changes. If you are new to this process, it is highly recommend to review the first two sections of this document. This will ensure that you understand the importance of how to handle the Post Processor files. If you have any problems with these steps or any questions, please contact FASTech at support@fastechinc.net or give our Tech Support a call at (419) 425-2233.

Index:

[Section 1 – File Type Definitions](#)

[Section 2 – Important Notes](#)

[Section 3 – Installing/Replacing Files](#)

[Section 4 – Adding Post Processor to “Machine Type” List](#)

[Section 5 – Reloading Machine Definition](#)

[Section 6 – Adding ‘Open Shared Folder’ Shortcut \(2017 or Newer\)](#)

Section 1 - File Type Definitions

- **.mmd** – Mill Machine Definition (**.mcam-mmd** *New for Mastercam 2017/2018*)
- **.lmd** – Lathe Machine Definition (**.mcam-lmd** *New for Mastercam 2017/2018*)
- **.wmd** – Wire Machine Definition (**.mcam-wmd** *New for Mastercam 2017/2018*)
- **.rmd** – Router Machine Definition (**.mcam-rmd** *New for Mastercam 2017/2018*)
- **.control** – Control Definition (**.mcam-control** *New for Mastercam 2017/2018*)
- **.pst** – Post File (If a **.psb** or **.txt** file is present it should always stay with the **.pst** file)
- **.psb** – This is an encrypted file that needs to remain in the same location as the **.pst**. (You will have one of these files if your post processor comes from a 3rd Party Developer or if you have a highly customized post from FASTech. This also means the post processor will only run on your Mastercam sim numbers)

*Every machine will have 1 *machine definition*, 1 *control definition* and 1 *post file* (some will also have an extra **.mmd** for a metric machine and others might have a *.psb* and/or *.txt* file as well to go along with the post).

Section 2 - Important Notes

- The instructions below are specifically for users who store their posting files in the Mastercam Shared folders (default locations). If the posting files are stored in any other location we typically suggest placing all the files together in the same folder. It is best to contact FASTech if you intend to do this so we can ensure that the files are properly configured to use in this location.
- If you intend to have any of your files renamed or moved to a new location, please contact FASTech Support first so that we can ensure this is done properly. When the process is not implemented correctly, files can lose their association. This can cause changes in the output of your posted code.
- If you have any concerns about losing previous customization or if you have made changes on your own that FASTech is not aware of, please be sure to back up your files before installing the new files from FASTech. FASTech keeps a backup of the latest files on our server if they have been changes requested through our email system.
- If only installing the **.PST** and or **.PSB** file, please skip steps 3-5 below.
- If changes are made to the Machine or Control Definition Files, it will be necessary to follow the instructions below in order to import all of the new settings or changes into any part files that you have been saved prior to the updated Machine/Control Definitions. These steps are not necessary if you are starting a new file.

Section 3 - Installing/Replacing Files

If your Post Processor files are located and used from a folder on your server (example: V:\Mastercam\X9\Posts\), you will simply copy all of the provided files into the designated folder on the server and replace the files that are already there. If you are placing the files for the first time on the server and have not notified FASTech that you intend to do this, please let us know that you intend to locate your files outside of the Mastercam default location as we will need to ensure the files are properly configured. Otherwise, you can follow the instructions below for installing in the default location.

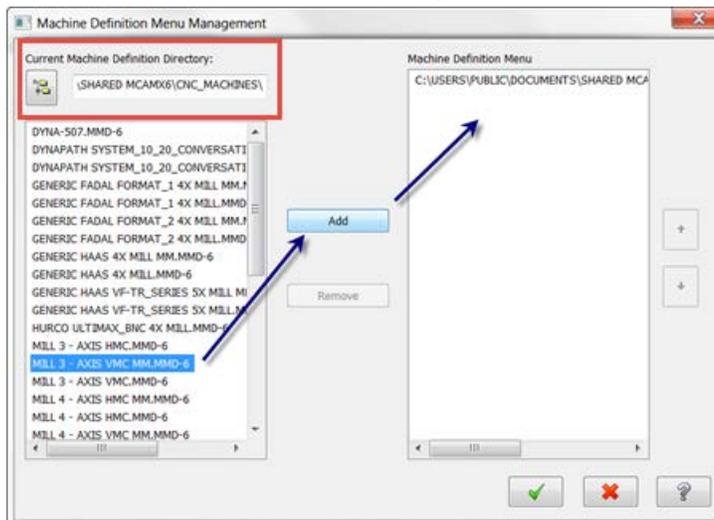
New for Mastercam 2017/2018 Release: The 'Open Shared Folder' shortcut has been removed from the default software **File** menu (*it can be added back in, Section 6 of this document*). In order to get to the initial Shared directory, open a File Explorer window on your system and navigate to **C:\Users\Public\Documents** (*depending on your Windows OS you might just be able to use your 'Documents' shortcut*). Here you will find your **shared Mcam[version]** folder. Then proceed to Step 3 below.

1. Open Mastercam. (*For X4 and earlier, go to C:\mcamx(mcamx2, mcamx4...ect) and move to **Step 3.***)
2. From the top Menu select **File** and then select **Open Shared Folder**. (This Folder will be named *shared mcamx[version number]*)
3. From the files you received, move/copy the **Machine Definition** and the **Control Definition** files into the **cnc_machines** folder.
4. Then open the folder that corresponds to the machine type of your post. (**Mill, Lathe, Wire, Router**).
5. Move/copy the Post (**.pst**) and **.psb** (if you have one) into the **Post** folder.

**When replacing updated files please remember to "Replace/Overwrite" existing files in these locations to be sure you are implementing any changes that may have been made to the files you received.*

Section 4 - Adding Post Processor to “Machine Type” List

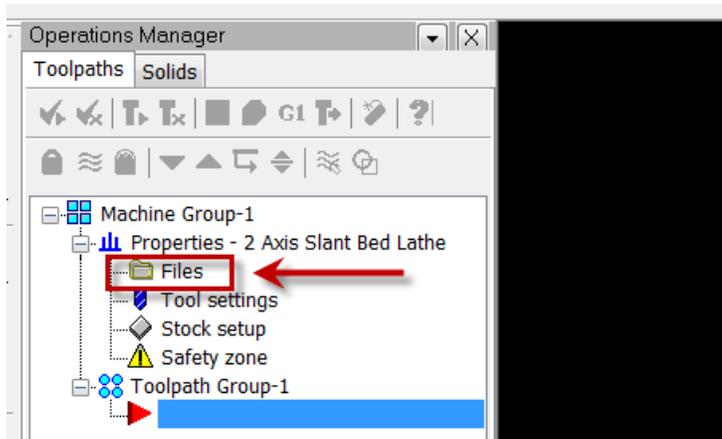
1. In Mastercam at the top menu select **Machine Type** and select the corresponding type (*Mill, Lathe, Wire or Router*). For Mastercam 2017/2018, first select the ‘MACHINE’ ribbon bar along the top. Here you will find the **Machine Type** drop downs.
2. Then highlight the corresponding machine type and select **Manage List**.
3. Select the machine from the left-hand side and click **Add**. (If your Machine/Post files are kept in a location outside of the Shared Folders, you will need to select the **browse** button in the upper left corner under the **Current Machine Definition Directory** and navigate to the proper folder. Your Machine Definition files will then become visible in the list on the left hand side.)



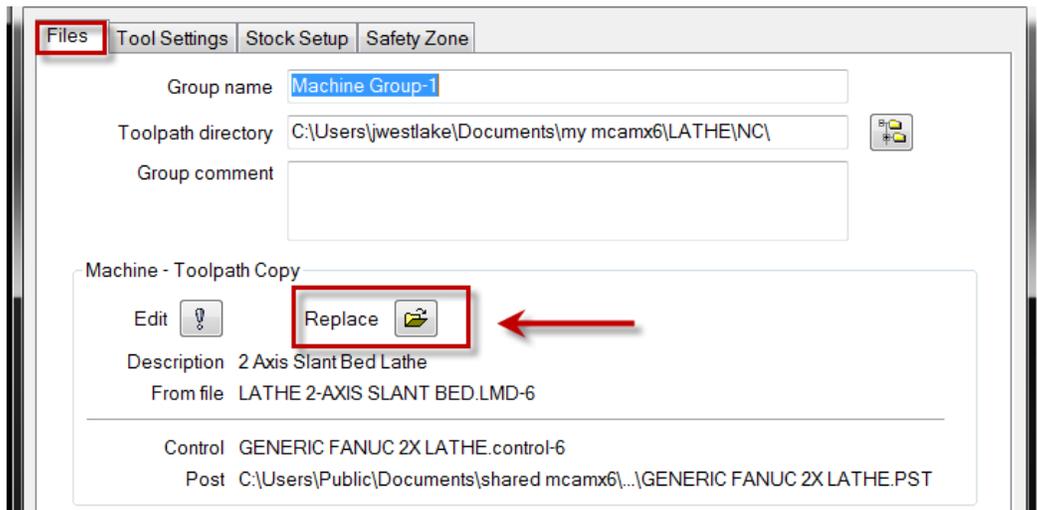
4. If you wish to remove a machine from the list, select it from the right-hand side and click **Remove**.
5. When you are done adding the Machines to your lists, you can hit the Green Check and your Machines will be available from the Machine Type Lists. (If your files have been renamed or moved to a new location, the Machine List(s) must be redone so that the files being selected are the correct name and location.)

Section 5 - Reloading Machine Definition

1. Open your part file.
2. In the *Operations Manager* go under the *Machine Group Properties* and select **Files**.



3. Click on the Replace button.

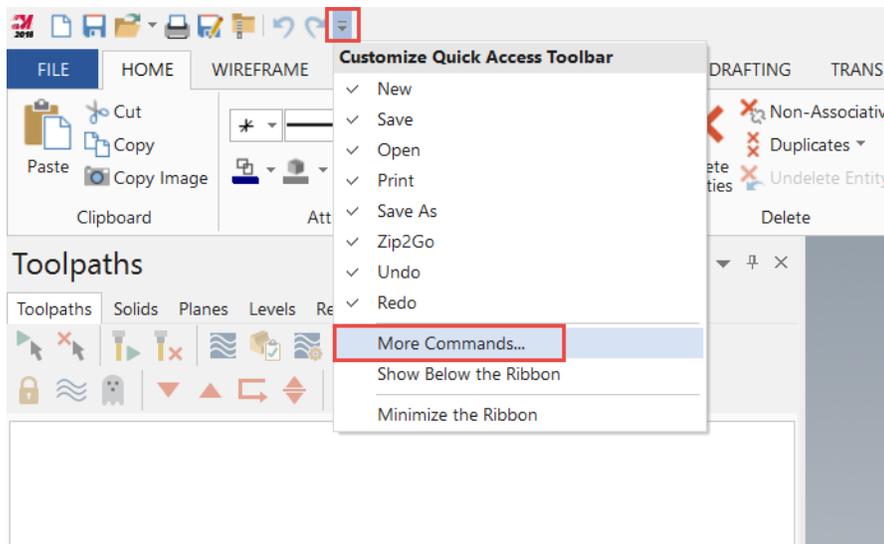


4. Then select the machine that you just added/updated from the machine definition files.
5. Click the Green check.
6. If a message comes up stating that you will need to **Regen** some of the toolpaths then select **OK**. You should be able to just regenerate the dirty operations with no problem. (This would happen if there were differences in how the machine handles certain parts of the toolpaths.)

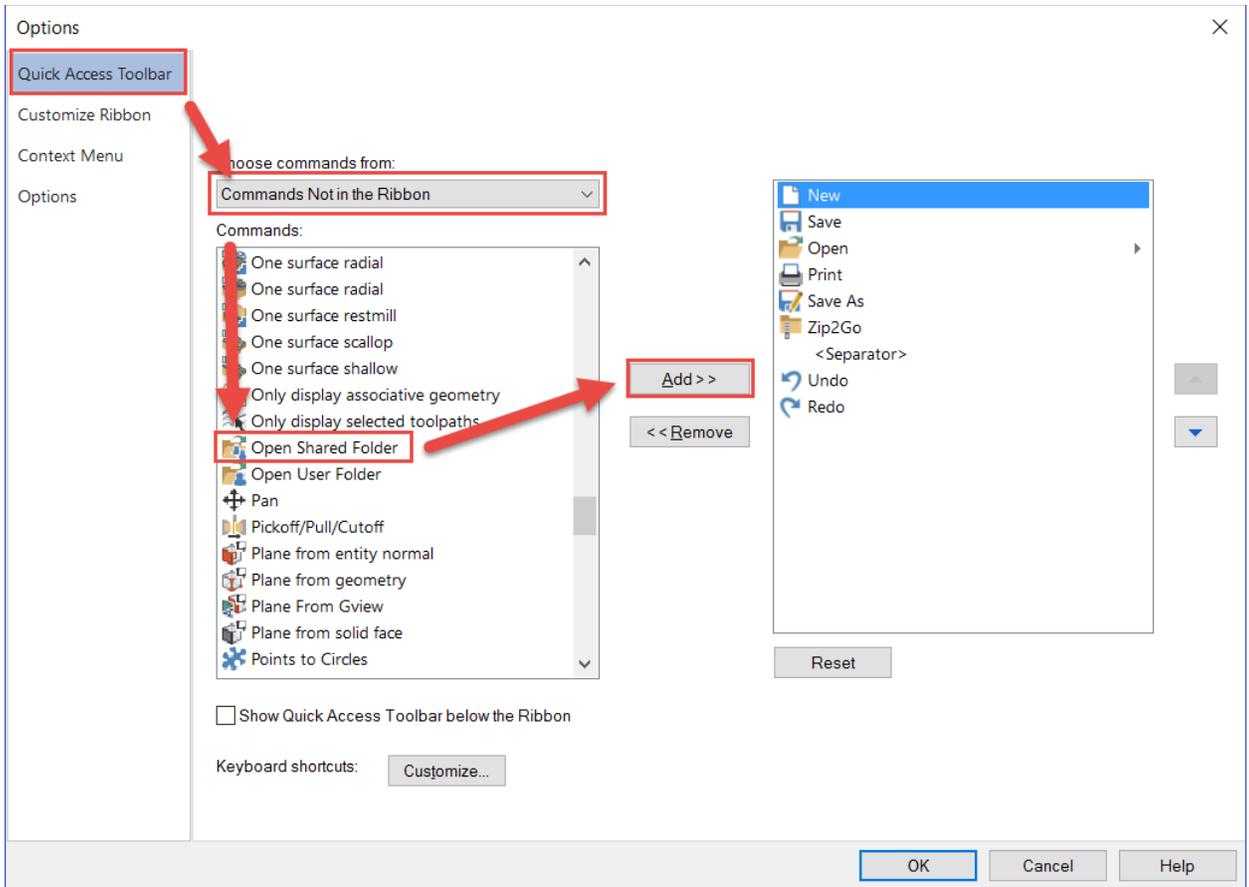
Section 6 – Adding ‘Open Shared Folder’ Shortcut (2017 and newer)

For users that keep their Post Processor files located in Mastercam’s default “*Shared Folder*” location, you may have been accustomed to using the ***Open Shared Folder*** shortcut that was found in the Mastercam **File** Menu. With the major interface changes starting in Mastercam 2017, this shortcut is no longer found in any of the default menus. It can however be added back in. Below are the steps to do so for Mastercam 2017 and newer.

1. With Mastercam 2017 (or newer) open, go to the upper left-hand area of the window to access your **Quick Access Toolbar**.
2. Select the dropdown arrow, then choose the **More Commands** option (see below).



3. Verify that you are on the **Quick Access Toolbar** tab of the **Options** window and that you are selecting from **Commands Not in the Ribbon**. In the options below, scroll down until you find the ***Open Shared Folder*** option, highlight it and then use the **Add** button to move it into your current menu items (see below).



4. Once it has been added you can also reorder any items by using the arrows to the right-hand side (see below).

