

## How to Get Your GibbsCAM Post Processor Modified

Follow the steps outlined below to ensure your post processor is modified to your desired specifications.

1. Mark-up a g-code program with comments turned on ([watch video tutorial](#))
2. Create a Pack and Go (.gcpkg) using the file that was used to create the g-code program ([watch video tutorial](#))
3. Send an email with your request and the above files attached to SouthernCAM at [posts@southerncam.com](mailto:posts@southerncam.com).  
**Include your company name and the machine make and model in the subject line.**

If you need any assistance, please reach out to our Support team at [support@southerncam.com](mailto:support@southerncam.com).

When modifying the program highlight the changes by using different color fonts and adding notes:

Removed words or codes in red

Moved words or codes in blue

Added words or codes in green

\*\*\* remove this line

\*\*\* move this command to this location

\*\*\* add this code in this location

---

### Example:

```

G28U0.W0.          *** Add this line here - all instances
N58G99M41         *** Remove G99
N59G54
N60G97S500M3T0404
N61G0X6.6Z.1826M8
N62Z.2908
N63X6.3
N64G76P010060Q10R.001          *** move this line here
N65G76X6.0548Z-1.75I0.P886Q150F.1575          *** make single line canned cycle
G76X6.0548Z-1.75D150P4A30.K.0886F.1574M24          *** delete this line
N66G0X6.6N67Z.1826
N68M9
N69 X20.Z10.05 G28U0.W0 M5          *** Remove X, Z and change to G28U0.W0
    
```

---

### To create a Pack and Go file:

- File Tab
- Exchange Tab
- Click **Pack and Go**

(Watch a video tutorial for how to create a Pack and Go file [here](#).)

