LazyCam Post-Processor Variables

MODAL Vars

To make the modal settings change only when the value changes, use []'s. For example, using *[G{MODE}]* will only output the G{MODE} if it is not the same as the previous one that it output.

{MODE} - Sets the mode that the move or cycle should be done in.
        Usage: G{MODE}
        Example Output: G0

{XPOS} – Sets the endpoint in the X axis of the move.
        Usage: X{XPOS}
        Example Output: X12.3456

{YPOS} – Sets the endpoint in the Y axis of the move.
        Usage: Y{YPOS}
        Example Output: Y12.3456

{ZPOS} – Sets the endpoint in the Z axis of the move.
        Usage: Z{ZPOS}
        Example Output: Z12.3456

{IPOS} – Sets the center point of an arc in ABS or INC, depending on the setting on the "Posting Options" dialog.
        Usage: I{IPOS}
        Example Output: I12.3456

{JPOS} – Sets the center point of an arc in ABS or INC, depending on the setting on the "Posting Options" dialog.
        Usage: J{JPOS}
        Example Output: J12.3456

{FEED} – Sets the feed rate that is needed at the time. For moves in the X &Y axes, Cut Feed will be used; for moves in the Z axes, Plunge Feed will be used.
        Usage: F{FEED}
        Example Output: F1234.56

{RAPIDHEIGHT} - Sets the Rapid height for the chain that is being posted.
        Usage: Z{RAPIDHEIGHT}
        Example Output: Z12.3456

{STARTHEIGHT} - Sets the Start height for the chain that is being posted.
        Usage: Z{STARTHEIGHT}
        Example Output: Z12.3456

{SPINDLEON} - Outputs the direction and speed of the spindle.
        Usage: {SPEEDON}
        Example Output: M3 S1234

{SPINDLEOFF} - Stops the spindle.
      Usage: {SPEEDOFF}
      Example Output: M5

Non-Modal Vars

{TOOLNUM} – Sets the Tool Number for the chain that is going to be posted.
      Usage: T{TOOLNUM}
      Example Output: T1

{COOLANT} – Turns the coolant on if enabled in the "Posting Options" dialog.
      Usage: {COOLANT}
      Example Output: M8

{PIERCEDELAY} – Insert the code to delay the pierce for Plasma. This delay is set under the "Plasma Options" button of the "Posting Options" dialog.
      Usage: {PIERCEDELAY}
      Example Output: G4 P123

{LIFTDELAY} – Inserts the code to delay the lift for Plasma. This delay is set under the "Plasma Options" button of the "Posting Options" dialog.
      Usage: {LIFTDELAY}
      Example Output: G4 P124