

TB021 (Rev1) - Configuring the MasterCAM Post Processor for Metric Use

Overview

This document describes the steps required to enable the metric conversion in the post processor for MasterCAM. After going through the following steps, the values entered into MasterCAM will post G-Codes as metric values for each line. Be sure the Centroid Control is configured for metric as well.

Required Steps:

1. From the main screen of Centroid's CNC7 software, press **F2 - Load**.
2. Type the following: `c:\nc\m4_mp.pst` press **Enter**
3. If there were not any typing errors, CNC7 will load this file and return to the main menu. Press **F6 - Edit**.
4. From the editor program press **F3 - Search** and type **G20** press **Enter**
5. This will bring you to the line in the MasterCAM post processor that determines what G-Code is posted, where G20 is for inches and G21 is for metric. Change the G20 to G21 and also edit the "inch measurements" to be "metric measurements".
6. Press **F10 - Quit**. When prompted to save changes, press **Y - Enter**.

Configuring Centroid Control to display Metric

If your Centroid Control is not already configured to display metric measurements;

1. Press **F1 - Setup**.
2. Press **F3 - Config**.
3. Type **137** press - **Enter** for the password.
4. Press **F1 - Control**.
5. Use the space bar to change **DRO display units** and **Machine units** to Millimeters.
6. Press **F10 - Save**.
7. Press **Esc** to get back to the main screen.

Additional Notes:

* To change back to inches, perform the above steps and change G21 back to G20.

* If the control is configured to use a different editor program, searching for the G20 or G21 code will be different.

Document History

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