This specification defines the functionality of the postprocessor your company will order. It is needed for the final acceptance and the customer must sign this document with an authorized signature.

Please return this document to us and give us additional information with further information for

* Scheme of machine with definition of axes to be programmed
* List of G- and M-codes
* Sample program with program header, program trailer, tool change and all relevant commands needed. Please comment special commands and cycles.

## Customer data:

Company: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Street: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Postal Code: \_\_\_\_\_\_\_\_\_ Location:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Contact 1: Mr. / Mrs.: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Telephone 1: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

E-Mail 1: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Contact 2: Mr. / Mrs.: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Telephone 2: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

E-Mail 2: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Date: \_\_\_\_\_\_\_\_\_\_\_\_\_\_ / Signature:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

# Unique Machine/-control/vendor names:

Machine: (e.g.: CTX420) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Manufacturer: (e.g.: DMG) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Controller: (e.g.: S840D) \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

# Machining type:

[ ]  Turning

[ ]  Milling

[ ]  Drilling

[ ]  Other: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

**Configuration of axes**:

Linear axis (e.g. Z): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Rotation axis (e.g. C): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Linear axis (e.g. X): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Rotation axis (e.g. A): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Linear axis (e.g. Y): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Rotation axis: (e.g. B): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Coordinate axis for the spindle axis (e.g. Z)

\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

**Turning mode** [ ]

# Turrets, tool holders (channels)

##  Turret 1:

 Active Tools:

 [ ]  Yes

 [ ]  No

 Number of controlled axis: \_\_\_\_

 Name of axis: [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C [ ]  S \_\_ \_\_

 **Turret 2**:

 Active Tools:

 [ ]  Yes

 [ ]  No

 Number of controlled axis: \_\_\_\_

 Name of axis: [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C [ ]  S \_\_ \_\_

 **Turret 3**:

 Active Tools:

 [ ]  Yes

 [ ]  No

 Number of controlled axis: \_\_\_\_

 Name of axis: [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C [ ]  S \_\_ \_\_

# For additional turrets, tool holders, copy above and fill out blockSpindles:

##  Spindle 1:

 Number of controlled axis: \_\_\_\_

 Name of axis: [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C [ ]  S \_\_ \_\_

 **Spindle 2**:

 Number of controlled axis: \_\_\_\_

 Name of axis: [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C [ ]  S \_\_ \_\_

 **Spindle 3**:

 Number of controlled axis: \_\_\_\_

 Name of axis: [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C [ ]  S \_\_ \_\_

**For additional spindles, copy above and fill out block**

The axes naming for turrets, tool holder, spindles need to be accurately defined, e.g. X1, Y2, Z2, S3, etc.)

#

## Additional Axis (stationary support, tailstock, …) [ ]

##  Additional axis 1: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 Name of axis: : [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C \_\_ \_\_

 M / G function \_\_\_\_\_\_\_\_\_

## Additional axis 2: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 Name of axis: : [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C \_\_ \_\_

 M / G function \_\_\_\_\_\_\_\_\_

## Additional axis 3: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 Name of axis: : [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C \_\_ \_\_

 M / G function \_\_\_\_\_\_\_\_\_

## Additional axis 4: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 Name of axis: : [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C \_\_ \_\_

 M / G function \_\_\_\_\_\_\_\_\_

## Active tools [ ]

##  Axis direction 1: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 Name of axis: : [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C \_\_ \_\_

 M / G function \_\_\_\_\_\_\_\_\_

## Axis direction 2: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 Name of axis: : [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C \_\_ \_\_

 M / G function \_\_\_\_\_\_\_\_\_

# Milling mode [ ]

## Axis:

##  Number of controlled axis: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

##  Description of axis:

 Name of axis: [ ]  X [ ]  Y [ ]  Z [ ]  A [ ]  B [ ]  C \_\_ \_\_

 **Horizontal / vertical head**:

 [ ]  Yes

 [ ]  No

**When horizontal / vertical head is used, is it switched automatically? (e.g. M54)**

 [ ]  Yes

 [ ]  No

**If “yes“, which code to output**:

 [ ]  Horizontal M: \_\_\_\_\_

 [ ]  Vertical M: \_\_\_\_\_

**If “no“, what is standard:**

 [ ]  Horizontal

 [ ]  Vertikal

 **Axis mode**:

 [ ]  Positioning

 [ ]  Simultaneous

 **When positioning, what Code is used?**

 Cycle 19 / Cycle 800 / G7 / …: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 **When simultaneous, what Code is used?**

 Traori / M128 / …: \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

**Is the code for rotation axis customized for your machine and tested through you or the machine manufacturer?**

 [ ]  Yes

 [ ]  No

 **Rotation axes available?**

 [ ]  Yes

 [ ]  No

 **When rotation axes are available, where are these axis mounted (head or table)?**

 **What are the minimum/maximum limits?**

 **(e.g. A is turning around Y within range of - 30° to + 45°)?**

 [ ]  A [ ]  Head [ ]  Table \_\_\_\_\_\_\_\_\_\_\_

 [ ]  B [ ]  Head [ ]  Table \_\_\_\_\_\_\_\_\_\_\_

 [ ]  C [ ]  Head [ ]  Table \_\_\_\_\_\_\_\_\_\_\_

 [ ]  Other:\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

**Polar coordinate output needed?**

 [ ]  Yes

 [ ]  No

**Cylindrical mode needed**

 [ ]  Yes

 [ ]  No

 **For 5-axis machines only: Are the axis orthogonal (perpendicular)?**

 [ ]  Yes

 [ ]  No

 **Distance of turning axis to center, if needed:**

 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

**Kinematics:**

Please insert machine kinematics view/scheme, e.g. :


##  Working planes:

 [ ]  G17 (+XY)

 [ ]  –G17 (-XY)

 [ ]  G18 (XZ)

 [ ]  –G18 (-XZ)

 [ ]  G19 (YZ)

 [ ]  –G19 (-YZ)

##  Tool change:

 [ ]  Automatic Code (e.g. M6): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 [ ]  Manual Code (e.g. M66): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

##  Tool preselection:

 [ ]  Yes Code: (e.g. M66): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 [ ]  No

##  Pallet change/loading robot:

 [ ]  No
[ ]  Yes code output only (e.g. M60): \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 [ ]  Yes separate list/file output needed – attach list/file with description

**Drilling mode**  [ ]

## Used standard drilling cycles:

 [ ]  Drilling

 [ ]  Drilling with delay

 [ ]  Breakchip drilling

 [ ]  Peck drilling

 [ ]  Tapping

 [ ]  Reaming

 [ ]  Other drilling cycle (please name and describe, sample output)

 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

**Description of working area:** \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

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## The scope of features and functions correspond with the possibilities of the NX-CAM Programming system.

**NX standard-postprocessors include the following functionalities:**

Linear and rotational movements (rapid and with feeds/speeds) and 5 axes positioning

Simultaneous movements

Tool change

Retract moves

## G - functions:

Delay (e.g. G04)

Toolpath offset (e.g. G41,G42)

Standard drilling cycles (e.g. G81)

Origin definition (e.g. G54–G59)

Positioning absolute or incremental (e.g. G90/G91)

## M - functions:

Programmed stop (e.g. M00)

Spindle direction, Spindle stop (e.g. M03,M04,M05)

Toolchange (e.g. M06 T1)

Coolant code normal or through tool (e.g. M07,M08)

Axis clamp or unclamp as M-function

## Requirements for other NON NX standard functionalities:

## On Machine Probing:

 [ ]  Yes

 [ ]  No

If yes, please select option and attach sample program

[ ]  Option UDE

Programming through positioning moves and cycle definition with menue
input (UserDefinedEvent). No tool path simulation

 [ ]  Option UserCycle
 Programming through cycle operations with cycle parameter
 input and tool path simulation

[ ]  Option Renishaw Productivity+
 Programming through the integrated module
 Productivity Plus from Renishaw
 Special Renishaw cycles with tool path simulation
[ ]  Option Blum Probing Cycles (BL9700)
 Programming through Pt2Pt and UDE output, no tool path simulation
 [ ]  With machine simulation

 [ ]  Other probing cycle programming/output
 Please attach separate specification and meaningful program sample

## Tool calibration:

 [ ]  Yes

 [ ]  No

If yes, please select option and attach sample program

[ ]  Blum cycles
 Programming through positioning moves and cycle definition with menue

input (UserDefinedEvent). No tool path simulation

[ ]  Other cycleprogramming/-output
 Please attach separate specification or meaningful program sample

## Angled heads

 [ ]  Yes

 [ ]  No

If yes, please select option and attach sample program

 1. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 2. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 3. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 4. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 5. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 6. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 7. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

**Simultaneous Turning 3-Axis:**

 [ ]  Yes

 [ ]  No

If yes, please select option and attach sample program..
Customer please check function on machine.

1. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

## Subprogramming:

 [ ]  Yes

 [ ]  No

 When “yes”, please attach a demo program.

## User- and special cycles:

 [ ]  Yes

 [ ]  No

 When “yes”, please attach a sample program output

 With cycle description

**Additional output of processing time table:**

 [ ]  Yes

 [ ]  No

 If Yes, what requirements?
 Availability of according machine parameters?
 (Rapid feed values, M-Code times, etc.)

 1. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 2. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 3. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

## Output of additional lists:

 [ ]  Yes (e.g. list of origins, toollist …)

 [ ]  No

 When “yes”, which lists are needed? Attach sample list

 1. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 2. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 3. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 4. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 5. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 6. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

 7. \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

Please attach a sample

## Other requirements:

\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

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## NX Version:

 [ ]  NX7

 [ ]  NX8

 [ ]  NX9

 [ ]  NX10

 [ ]  NX11

 [ ]  NX12

 [ ]  \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_

## Operating System:

 [ ]  Windows XP (32 bit)

 [ ]  Windows XP (64 bit)

 [ ]  Windows 7 (32 bit)

 [ ]  Windows 7 (64 bit)

 [ ]  Windows 8/8.1 (64 bit)

[ ]  Windows 10 (64 bit)

 [ ]  \_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_\_