GIBBSCAM | 2027 CAM for Production Machining

Version 2027 : September 2026

Installation

GIBBSCAM

Contents

Introduction 4
Welcome 4
Important Information About Security 4
System Requirements 4
Recommended System 5
Websites for GibbsCAM 5
Installation 6
Before Installing 6
If a Version of GibbsCAM Is Already Installed 6
Before Installing Network Licensing Option (NLO) 6
Before Installing With a Hardware Key 6
Before Installing Across a Network 7
About the Installer 7
File Locations 7
User Data Files 7
Global Data (Program Data) Files 8
Installation Data Files 8
Reporter File Locations 8
Existing Communications, CutDATA and Library Files 9
User Access To AppData Folders 9
Installing the System Files 9
Step-By-Step Instructions 9
Running Multiple Instances of the Product 10
Silent Installation Mode 10
Accepting All Defaults 10
Uninstalling 11
Customizing a Silent Installation: Using an *.ISS File 11
A. To create an ISS file 11
B. To silently install GibbsCAM using an ISS file 11
C. If you want to write out a log file 12
Registration 13
Registering GibbsCAM 13
Running the Registration Tool 13

Internet Registration 15
E-Mail Registration 15
Offline Registration 16
Completing E-Mail or Offline Registration 17
Registration Tools 19
Standalone Licensing Utility 19
Verifying Activation Server Connectivity 20
License Updates 21
Network Licensing 22
What Remains the Same As 2023 and Before 22
If You Use Cimatron Products 22
What Changed 22
Operating Systems Supporting RLM 24
Overview of Network License Installation 24
Condensed Steps: To Set Up the License Server 24
Condensed Steps: To Install The Client Software 25
NLO Step 1 - Setting Up The Server 25
NLO Step 2 - Install the Client Software On Each Node 26
Maintenance And Special Topics 28
Migrating from Previous Releases 28
Using the Migration Tool 28
Installing Post Packages 30
Undoing All Customizations 30
Using Command-Line Options 30
Command-Line Option for License Checkouts 30
License Options: GC* keywords 31
Conventions 32
Text 32
Graphics 32
Links To Online Resources 33

Introduction

- Welcome
- “System Requirements ” on page 4
- “Links to Online Resources” on page 33

Welcome

Congratulations on your purchase of GibbsCAM, the most productive CAM system available. This guide contains all the information you need to install the system and begin using the software. If you have any problems with the installation procedure, contact your reseller; they will be happy to assist you with the installation process.
Your order contains a Product Code. In the registration process, the Product Code and other information are supplied to obtain a license file. Licensing is secured by hardware key or Network License Option (NLO). All steps in this process are thoroughly explained in “Registration” on page 13.
If you want to migrate settings and preferences from a installation of GibbsCAM, run the Migration Tool ***before*** running the newly installed release for the first time. For complete information, see “Migrating from Previous Releases” on page 28.

Important Information About Security

GibbsCAM security is provided by a license file that is linked to unique information from your computing environment, such as the serial number of a hardware key or a unique identifier over a network. The license file authorizes use of GibbsCAM products only when the hardware key is present and recognized by the corresponding driver, or when the license server is running and it validates the unique identifier.
GibbsCAM security is normally activated through the Internet. If you do not have Internet access available, you can activate security using e-mail or regular mail. Please allow adequate time to have the license file sent to you.
Please contact your reseller for support.

System Requirements

The requirements to run GibbsCAM do not have specific values. The requirements vary depending upon the operating system you use and the complexity of your part. Basic guidelines, listed below, are common to all users.

Operating System	Windows 10, Windows 11, or Windows Server 2025. Please install the latest available OS service packs and patches through Windows Update.
Microsoft	This release requires Microsoft .NET Framework. Most machines will already

.NET Framework	have this (for example, if Office is installed), but if it is lacking, then the GibbsCAM installer will tell you what is needed.
Hardware	Minimum system requirements depend on the operating system. There are also recommended hardware requirements. Please remember that the more complex a part, the higher your system requirements. At least 8 GB of free disk space is required to install the software. For more information, see "Recommended System" on page 5.
Video Drivers	Please install the latest available driver for your video card. The standard Windows drivers are typically not adequate, because of the GibbsCAM application's advanced use of OpenGL and video RAM. We strongly recommend that you keep your system up-to-date with fully installed and updated drivers.
Network Licensing	The Network Licensing Option (NLO) can be set up on 64-bit versions of any of the following platforms: Windows Server (2016, 2019, 2022 or 2025); Windows 7, 8, 10, or 11. The current version of GibbsCAM uses Reprise License Manager (RLM), unlike GibbsCAM versions 2023, 2022, 14, and 13, which used Cimatron License Manager (CimLM).

Recommended System

A computer that matches or exceeds the following requirements will run GibbsCAM very comfortably. Please note that the larger or more complex your parts are, the more GibbsCAM will demand from your system.

Operating System	Windows 11, or Windows Server 2025
CPU	*Intel* : 13th/14th-gen Core i7/i9, or Core Ultra 7/9 *AMD* : Ryzen 7/9 5000-series or newer, or Threadripper 5000 series or newer
RAM	16+ GB
Video Card	Nvidia video card with 8+ GB of video memory

Websites for GibbsCAM

- The Gibbs website – http://www.GibbsCAM.com – This website contains company news, product information, and much more.
- The Gibbs Online page, https://online.gibbscam.com – This provides access to software releases and release notes, updates to user guides, continuously updated documentation of GibbsCAM macros, and many other services and tools.

Installation

- “Before Installing” on page 6
- “About the Installer” on page 7
- “File Locations ” on page 7
- “Installing the System Files ” on page 9

Before Installing

Before you install the software, ensure that you meet the system requirements and that you have installed the most recent service pack for your operating system and the latest drivers for your video card.

If a Version of GibbsCAM Is Already Installed

If you already have a version of GibbsCAM installed on your system:

- You should not uninstall the previous software.
- If you want to install multiple instances of the same version of GibbsCAM, see “Running Multiple Instances of the Product ” on page 10.
- Be aware that the installer associates all `.vnc` files with the *newly* installed version of GibbsCAM. If you want to open an existing part in an older version of GibbsCAM, simply drag the file to a shortcut or to the program window, or use the Open dialog.
- Also be aware that if an older file is opened and saved in a newer version of GibbsCAM, it can no longer be used in an older version. If necessary, you can work around this by using File > Save a Copy to save the part as an older version.
- Before starting a newly installed version of GibbsCAM, users may want to run the Migration Tool to migrate their settings and preferences from a previous release. The installation process ends with a link to Migration Tool.

Before Installing Network Licensing Option (NLO)

For complete information on GibbsCAM Network Licensing Option, see “Network Licensing ” on page 22.

Before Installing With a Hardware Key

If you have a hardware key, attach it before running the installer.

Before Installing Across a Network

When installing GibbsCAM across a network to a system that has never had a version of GibbsCAM or the hardware key drivers, we recommend that you install the drivers first, to avoid encountering errors. If you encounter this error, simply click OK and continue the installation process; then, after the process ends, install the hardware key drivers.

About the Installer

The installer lets you do any of the following:

- Repair or uninstall an existing installation of GibbsCAM 2027.
- Install the GibbsCAM 2027 base components and, optionally, one or more add-ins:
  - GibbsCAM add-ins include ProAXYZ Posting support.
  - CAD Transfer add-ins include Autodesk Inventor, Solid Edge, SOLIDWORKS, and many others.

When the base components are installed, the GibbsCAM PDFs and the Moorpark engraving font are automatically installed, and a desktop shortcut to the GibbsCAM 2027 application is created.

File Locations

The GibbsCAM installer writes files to three different locations, because different kinds of data are accessed for different purposes:

- *User data* changes with each user.
- *Global data* applies to all users.
- *Install data* includes generic data and unmodified Reporter templates.

The installer is the only program that writes install data. The installer and the GibbsCAM application write global data and install data. However, if the installer is re-run, it will not affect user data and global data files that have been changed by the application.
Folders containing the three types of data are detailed below. If you customize these files or upgrade your version of GibbsCAM frequently, then accessing and copying these files can become quite important. The GibbsCAM Migration Tool is the preferred method for migrating settings and preferences from previous GibbsCAM releases.
The following table shows the folder hierarchy.

User data	`C:\Users\<username>\AppData\Roaming\Gibbs\GibbsCAM\<version>`
Global data	`C:\ProgramData\Gibbs\GibbsCAM\<version>`
Install data	`C:\Program Files*\Gibbs\GibbsCAM\<version>`

User Data Files

User Data includes such files as: `sysdef.rsc` (entries in dialogs), `UIState.dat` (location and sizes of windows), and a `Plugins\` folder (data entered in plug-ins). Even users with limited

privileges can migrate User Data from a previous release using Migration Tool.

Global Data (Program Data) Files

Global data, also called *program data*, includes the bolt and tap tables, the CutDATA file (`Material.txt`), your communication setup data (`protocol.txt`), a file that stores the Hole Wizard data (`prefs.rsc`), a folder that contains your custom MDDs, the PostHASTE Library folder that contains PostHASTE library files, and Reporter templates that have been modified or customized.
The program data folder is the location where all customizable VMMs, MDDs, macros, and plug-ins should reside. Although the installation folder contains read-only *template* versions of these files – in other words, the original versions as shipped, before any customization – the intent is for each seat of GibbsCAM to have its own potentially customizable version of these files residing under the program data folder. Only users with Administrator privileges can migrate program data files from a previous release using Migration Tool.
The location of the CutDATA file can also customized within GibbsCAM: On the File menu, click Preferences and see the Files tab.

Installation Data Files

Installation files are read-only. They include generic versions of Global and User data files, the default user-interface (`*.cui`) files, and the Reporter templates. Generic Reporter templates are located in the `...\PlugIns\Data\Report\` folder.
Only users with Administrator privileges can migrate installation files from a previous release using the Migration Tool, and not all installation files can be migrated.

Reporter File Locations

Excel (`*.xlsx`) and text (`*.txt`) files can reside in up to three different locations:

- ***User data folder***. The default location of this folder is:
  `C:\Users\<username>\AppData\Roaming\Gibbs\GibbsCAM\<version>\PlugIns\Data\Report\`.
  If a particular user has Reporter files here, they take precedence over other Reporter files.
- ***Global data folder***. The default location of this folder is:
  `C:\ProgramData\Gibbs\GibbsCAM\<version>\PlugIns\Data\Report\`.
  If the Global data folder contains Reporter files, they will take precedence over Reporter files in the Installation data folder but will be overriden by Reporter files in the User data folder, if any.
- ***Installation data folder***. The default location of this folder is:
  `C:\Program Files*\Gibbs\GibbsCAM\<version>\PlugIns\Data\Report\`.
  Reporter files here are always present and cannot be deleted.

Imagine Company A, which prefers a custom Tool Summary report over the default GibbsCAM-supplied summary. Company A places the files `TlSum.txt` and `TlSum.xlsx` in the Global data folder (default `C:\ProgramData\...`). At company A, this is the version that most users will receive when they use the GibbsCAM Tool Summary command or they pick Tool Summary from the **Reporter** dialog. The Migration Tool will migrate this report from version to version.
Now imagine a user named Lee, who works for Company A. Lee has made additional changes to the Tool Summary Report, and saves these custom versions of `TlSum.txt` and `TlSum.xlsx` in the User data folder (default `C:\Users\Lee\AppData\`...). Whenever Lee uses the Tool

Summary command or picks Tool Summary from the **Reporter** dialog, the result will use these additional changes. The Migration Tool will migrate this report from version to version.

Existing Communications, CutDATA and Library Files

Installing a new version of GibbsCAM creates a default material database, a blank communications file, default PostHASTE library files, and default Reporter templates. Once the new version is installed, you can copy `protocol.txt`, `material.txt` and the `Library\` folder to the new GibbsCAM folder.

User Access To AppData Folders

Windows marks user `AppData\` folders as invisible; limited users cannot see them. If you do not use Migration Tool, you may need an administrator's assistance to find and modify these folders.

Installing the System Files

Before you install the software, be sure to review "Before Installing" on page 6.
If you will be using the Network Licensing Option (NLO):

- The GibbsCAM application software must be installed on each client machine, using either the interactive installation wizard or the installer run in "silent" mode. The application software must be installed before the license files generated by GibbsCAM are installed.

If you are upgrading from a previous release, consider running the GibbsCAM Migration Tool after you install but *before* your first launch of the newly installed software. For more information, see "Migrating from Previous Releases" on page 28.

Step-By-Step Instructions

The following instructions assume you want to use the fully interactive installation wizard. If, instead, you prefer to install non-interactively without the wizard, see "Silent Installation Mode " on page 10.
For more information on Migration Tool, see "Migrating from Previous Releases" on page 28.
If you are setting up a Network License installation, click Cancel and refer to "Network Licensing " on page 22.

To Install the System Files

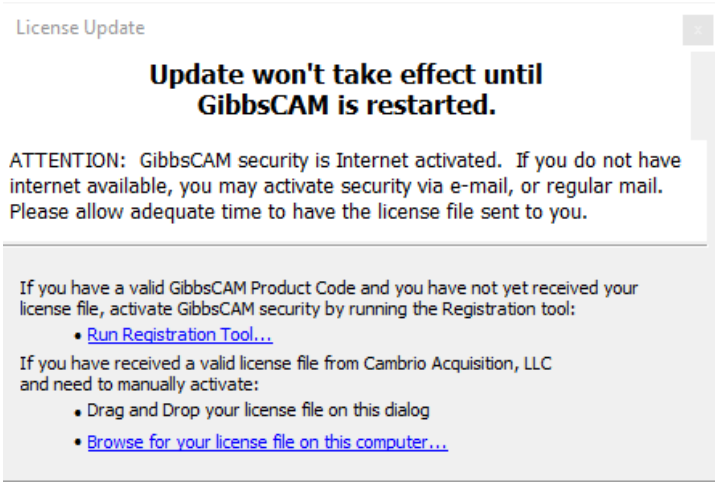
1. Navigate to the Gibbs Online page, https://online.gibbscam.com.
2. Navigate to the Software Downloads page.
3. Select and download the appropriate language for the machine operator.
4. Once download is complete, open the executable file.
5. Follow the onscreen prompts.

To Launch the Application

To launch the GibbsCAM application, do one of the following:

- In Start > Programs, select the GibbsCAM item.
- Double-click the desktop shortcut to the GibbsCAM executable.
- Double-click a `*.vnc` file.

The first time you launch GibbsCAM, the following dialog appears:



If you are installing GibbsCAM for the first time, you must register the software. For more detailed information on registering the software, see “Registering GibbsCAM” on page 13.

Running Multiple Instances of the Product

GibbsCAM 2027 natively supports simultaneously running multiple instances of the application – either different versions or different instances of the same version. If you want to install multiple instances of *the same version* GibbsCAM version, such as differently localized instances, make a copy of the existing instance in a different folder (such as `C:\Program Files\*\GibbsBackup\`, where "`*`" might be "`Gibbs`" or "`Gibbs`"), and then re-run the installer. First uninstall the previous instance, and then install the new one.
There is no problem running multiple versions of GibbsCAM at the same time. However, an earlier version might be unable to open parts saved in a later version. You can use the File > Save As Copy option to save the part as if it were a previous version. (But: See the Readme file about saving TMS files to versions before GibbsCAM 12.)
Reminder: For best results migrating settings and preferences from a previous release, each user should run the Migration Tool *before* starting a newly installed version of GibbsCAM. For more information, see “Migrating from Previous Releases” on page 28.

Silent Installation Mode

The process for installing in the background changed at GibbsCAM 12 to use InstallShield. Previously called “unattended” or “quiet” installation, it is now called "silent" installation.

Accepting All Defaults

The simplest and easiest way to use silent installation mode is to accept all defaults. To do this, you use the **`/s`** flag with no other flags or parameters, in this form:
`<installername>.exe /s`
For example, to silently install GibbsCAM 27.0.27.10 in English with all defaults:
`GibbsCAM_x64_v27.0.27.10_en-US.exe /s`

Uninstalling

To uninstall silently, use the `/x /s` flags, in this form:
`<installername>.exe /x /s`
For example, to silently uninstall Japanese-language GibbsCAM 27.0.29.2:
`GibbsCAM_x64_v27.0.29.2_ja-JP.exe /x /s`

Customizing a Silent Installation: Using an *.ISS File

You can also customize which options you install, which locations you install to, to not run Migration Tool, or other nondefault choices. To do this, you use an `*.ISS` file that contains the customizations, in conjunction with the GibbsCAM installer `*.exe` file. Note that when you perform a silent installation, the version of the installer executable must match the version of the installer executable that was used to record the `*.ISS` file.

- **To create an *.ISS:**
  Run the interactive GibbsCAM installer with the `/r` flag to record an `*.ISS` file. The file specified in the `/f1"<filename>.ISS"` flag captures all parameters and paths supplied in this interactive installation. For details, see below.
- **To install silently using an *ISS:**
  Run the GibbsCAM installer with the `/s` flag and the `/f1"<filename>.ISS"` flag. This silently installs GibbsCAM using parameters in the `*.ISS` file. For details, see below.

A. To create an ISS file

1. Run the installer with flags `/r` and `/f1` (and, optionally, `/f2`).
2. Supply information to the interactive installer.
3. When you click Finish, the `*.ISS` file is fully recorded and can be used for future silent installations.

Step 1 has the following form:
`<installername>.exe /r /f1"<path>\<ISSfilename>"`

- ***Example A1***
  To use the GibbsCAM 27.0.36.8 English-language installer to generate an ISS file named `Auto27368.ISS` located in folder `D:\temp\`, you would open a command prompt, change directories to the installer location, and enter the following command:
  `GibbsCAM_x64_v27.0.36.8_en-US.exe /r /f1"D:\temp\Auto27368.ISS"`
- ***Example A2***
  To use the GibbsCAM 27.0.30.0 French-language installer to generate an ISS file named `MonGC27.ISS` located in folder `H:\Gibbs\`, you would enter the following command:
  `GibbsCAM_x64_v27.0.30.0_fr-FR.exe /r /f1"H:\Gibbs\MonGC27.ISS"`

B. To silently install GibbsCAM using an ISS file

1. Run the installer with flags `/s` and `/f1` (and, optionally, `/f2`).
2. If necessary, authorize the UAC (user account control) to install to the location specified in the `*.ISS` file.

Step 1 has the following form:
`<installername>.exe /s /f1"<path>\<ISSfilename>"`

- ***Example B1***
  To use the GibbsCAM 27.0.28.2 Latin-American Spanish-language installer to silently install using the parameters in an ISS file named `myGC.ISS` located in the same folder as the installer, you would open a command prompt, change directories to the installer location, and enter the following command:
  `GibbsCAM_x64_v27.0.28.2_es-MX.exe /s /f1"myGC.ISS"`
- ***Example B2***
  To use the GibbsCAM 27.0.29.10 English-language installer to silently install using the parameters in an ISS file named `GC_SilentInstall.ISS` located in folder `F:\GibbsData\`, you would open a command prompt, change directories to the installer location, and enter the following command:
  `GibbsCAM_x64_v27.0.29.10_en-US.exe /s /f1"F:\GibbsData\GC_SilentInstall.ISS"`

C. If you want to write out a log file

If you want to log results of either the recorded (`/r`) installation or the silent (`/s`) installation, you can use an optional third flag, `/f2"<path>\<logfilename>"`.
For example:

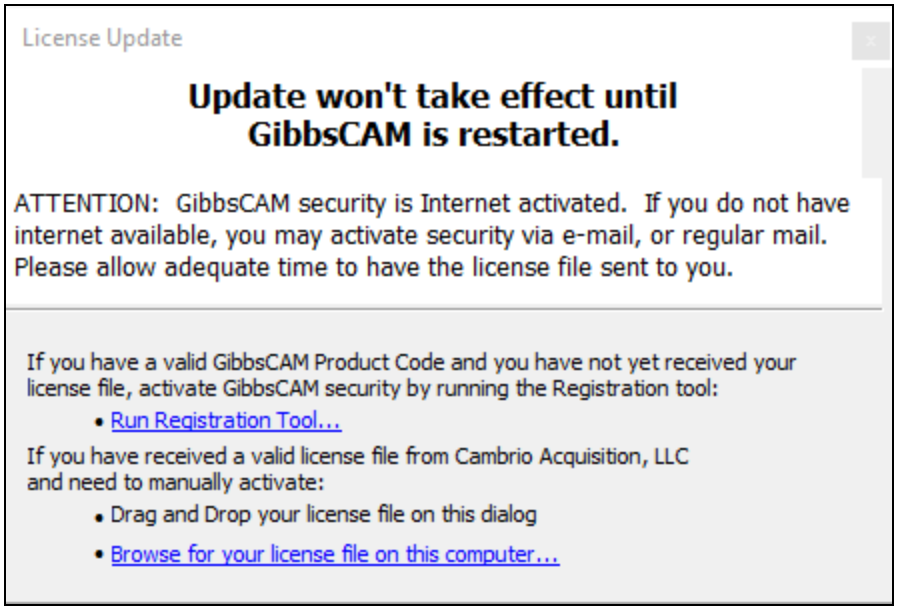
- `GibbsCAM_x64_v27.0.26.8_en-US.exe /r /f1"D:\temp\Auto27268.ISS" /f2"D:\temp\Log27268.txt"`
- `GibbsCAM_x64_v27.0.29.10_en-US.exe /s /f1"F:\GC_SilentInstall.ISS" /f2"tempLogFile.txt"`

Registration

- Registering GibbsCAM
- “Registration Tools” on page 19
- “License Updates” on page 21

Registering GibbsCAM

When a fresh installation of GibbsCAM is first started, it reports that no license file is found. After registration is complete, however, GibbsCAM will continue on to run as usual.

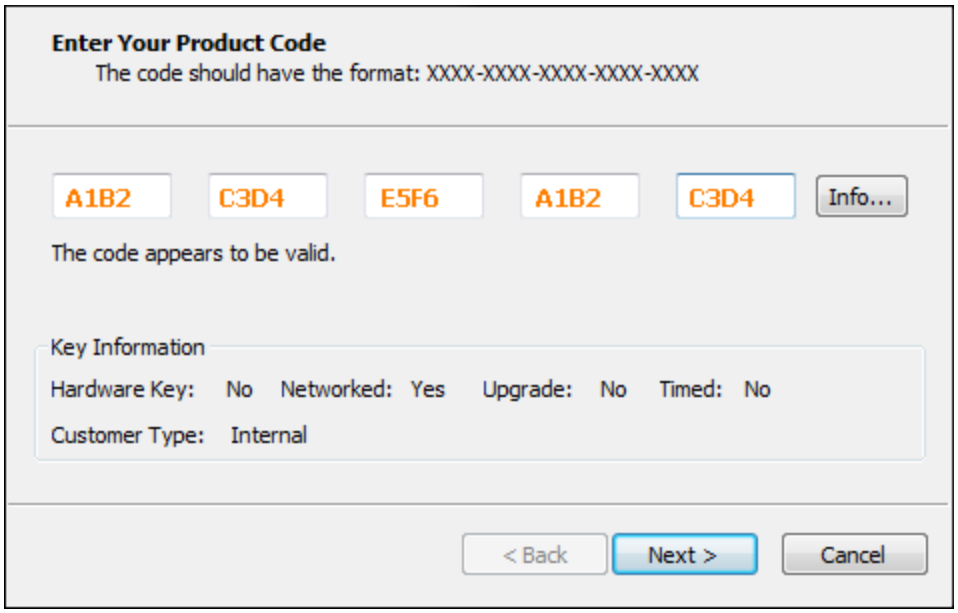


The License Installation or License Update dialog lets you drag an RLM license file (*.lic) onto the dialog for application installation, browse the computer for a license file (*.lic), or run the Registration Tool to obtain a license file (*.lic) through the Gibbs Activation Service.
Note that this release uses Reprise License Manager (RLM), not Cimatron License Server (CimLM). If you try to use a CimLM *.cml file instead of an RLM *.lic file, it will not work.

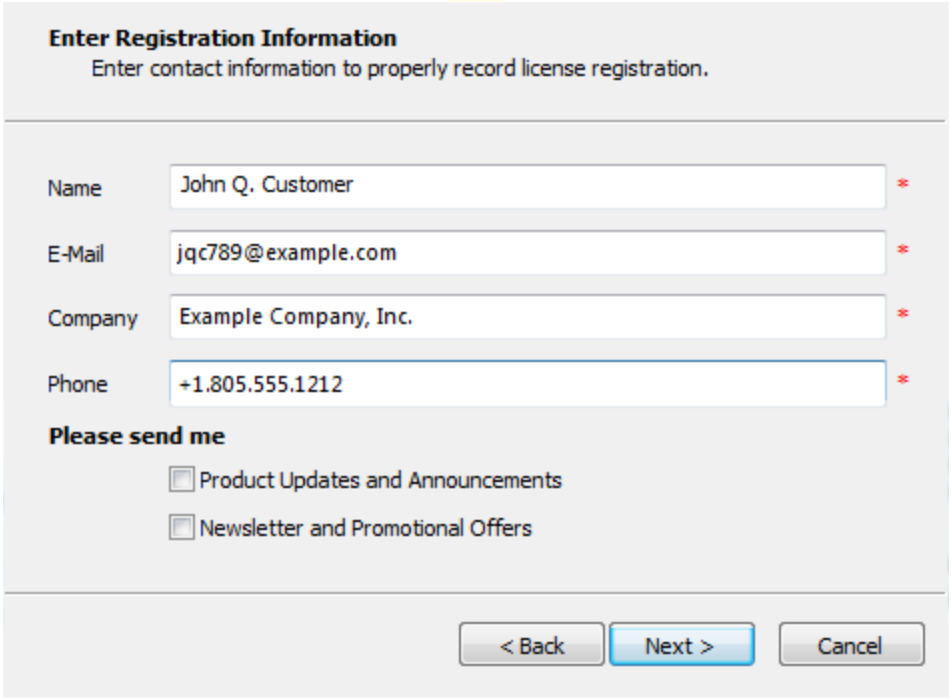
Reseller Activation - If your Reseller will be assisting you with your installation, have your registration files (and hardware keys, if any) ready in advance.

Running the Registration Tool

1. Click the Run Registration Tool... link.
2. Enter your Product Code from your order materials and click Next.



3. Enter your customer information and click Next.

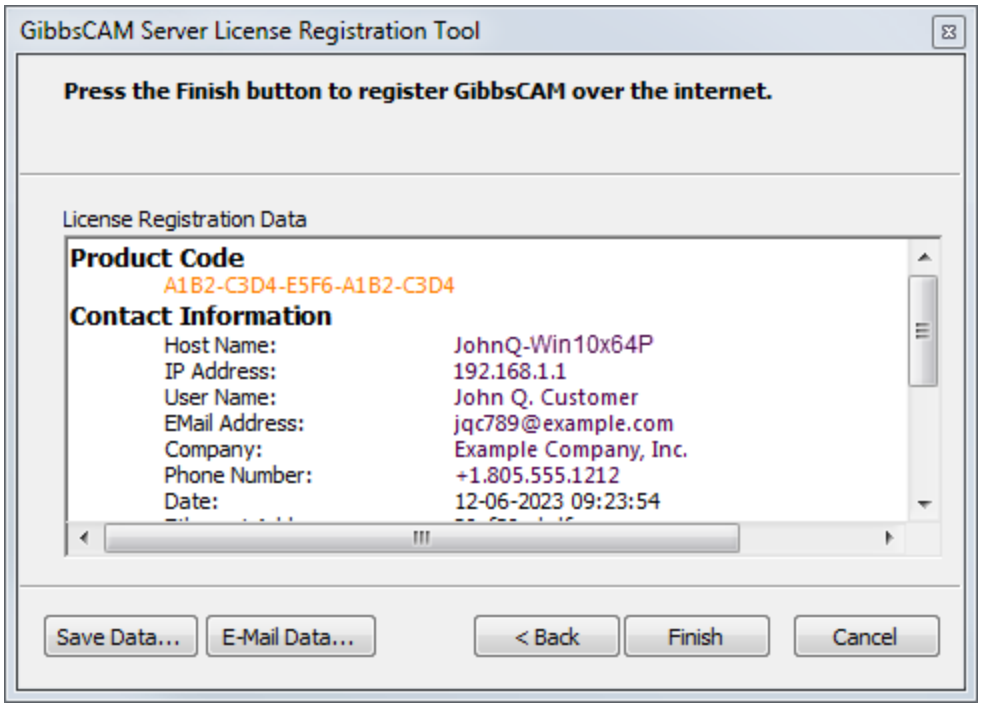


4. Complete your registration using one of the following methods. If you do not have an e-mail account, enter the e-mail address of your reseller.

Registration Type	Purpose
Internet Registration	Register online. This is the quickest, easiest way.
E-Mail Registration	If you are in a secured network environment.
Offline Registration	If you have no Internet access.

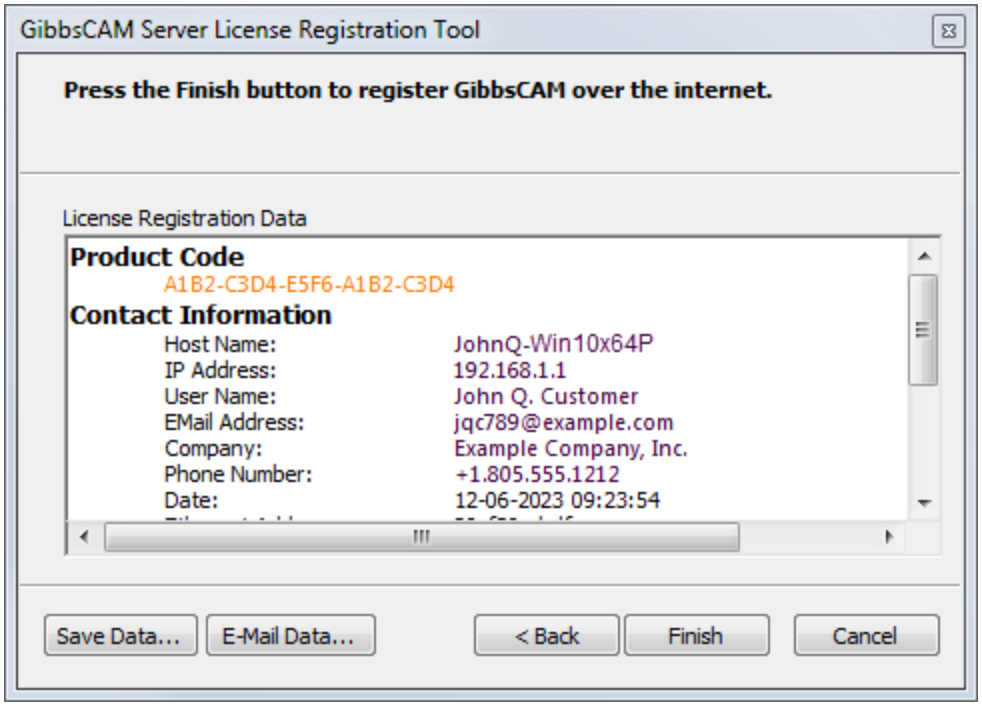
Internet Registration

If the Registration Tool determines that the computer can directly contact the Gibbs Activation Service, the final page of the Registration Tool lets you click Finish to automatically obtain a license file.

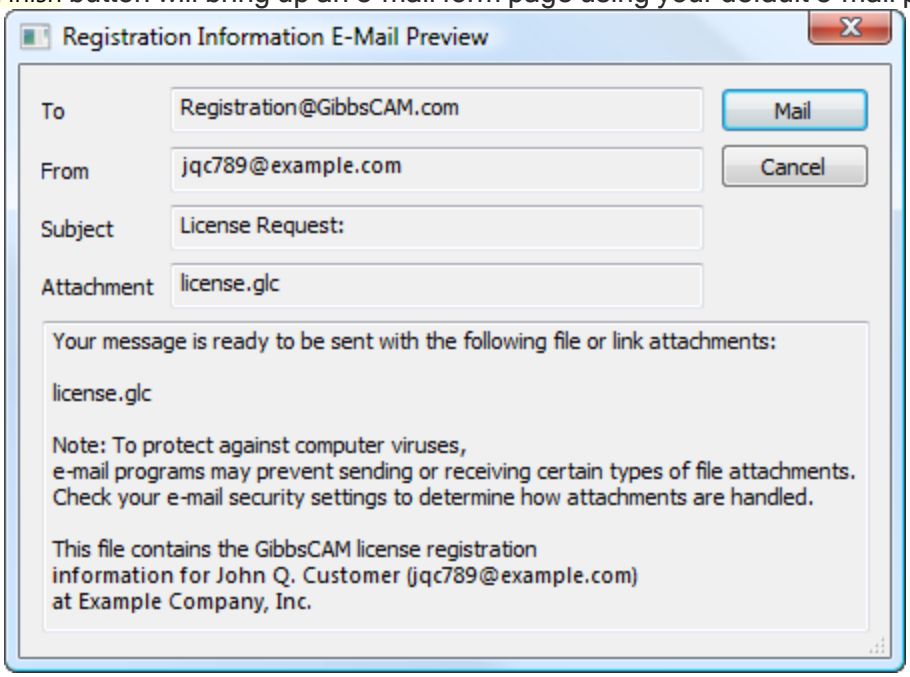


E-Mail Registration

If the Registration Tool determines that the computer cannot directly contact the Gibbs Activation Service but has access to e-mail, the final page of the Registration Tool lets you click Finish to send the license registration data to Gibbs as an e-mail attachment.



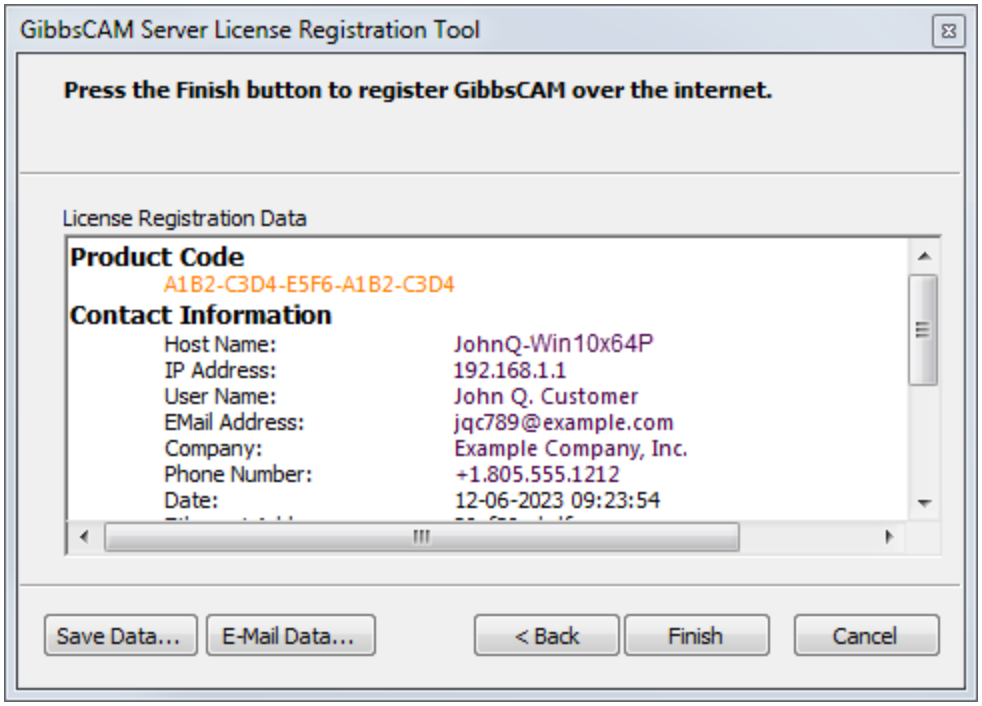
Clicking the Finish button will bring up an e-mail form page using your default e-mail program.



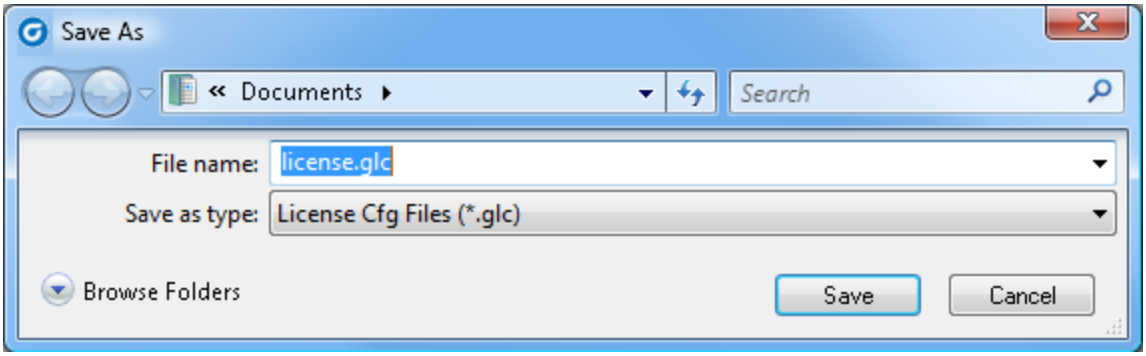
Follow the e-mail program's directions to send the license registration data. GibbsCAM will process your license registration as quickly as possible. When you receive it, see Completing E-Mail or Offline Registration.

Offline Registration

If the Registration tool determines that the computer cannot directly contact the Gibbs Activation Service and lacks access to e-mail, then the Registration Tool will prompt you to click Finish to save license registration data to a file:



When you click Finish, the Save As dialog prompts you to save your license registration data to a file:

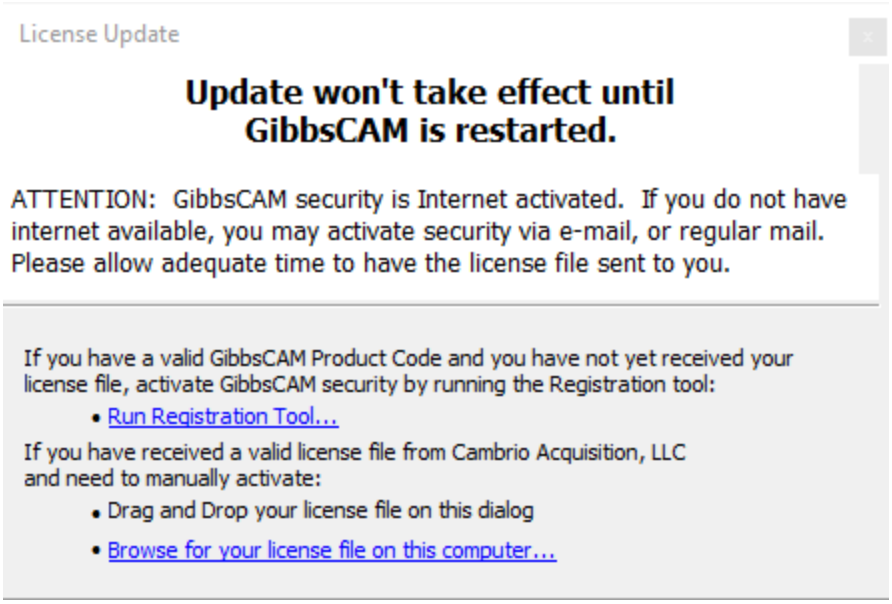


After you save your registration data file, you can send it to GibbsCAM in several ways:

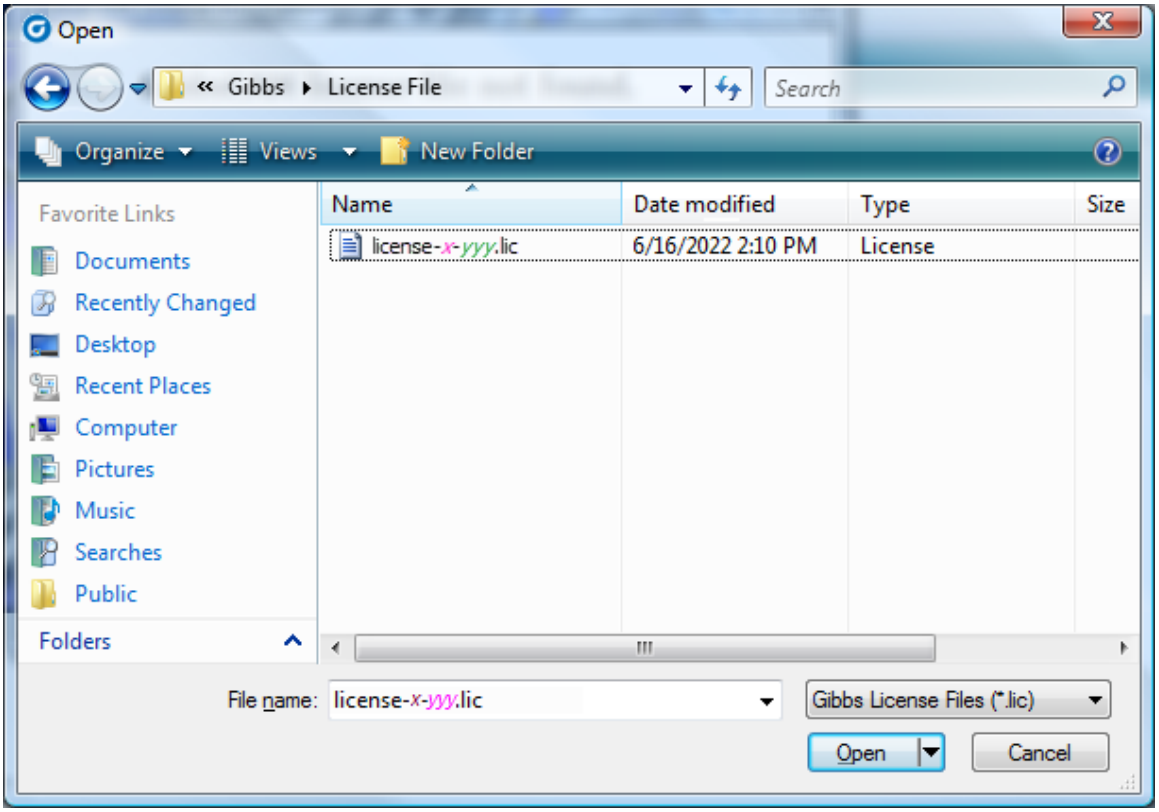
A computer with e-mail access	E-mail the file to Registration@GibbsCAM.com.
Your Reseller	Your Reseller may be able to assist you in your activation. If your Reseller can assist you, have your registration files and (and hardware keys, if any) ready in advance.

Completing E-Mail or Offline Registration

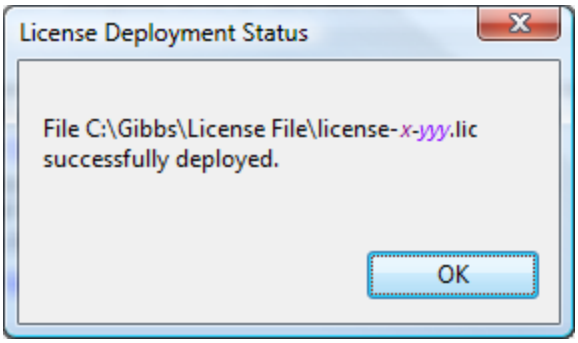
5. After you receive your license file from GibbsCAM, save it on your computer and launch GibbsCAM. On first startup, the following dialog appears:



6. You can either drag and drop the license file onto that dialog or click the Browse for your license file on this computer... link, which opens a dialog that lets you navigate to the file and select it:



7. After you locate and open the license file, you should see a message dialog resembling the following:



8. When you click OK, GibbsCAM starts; your installation of GibbsCAM 2027 has been authenticated.

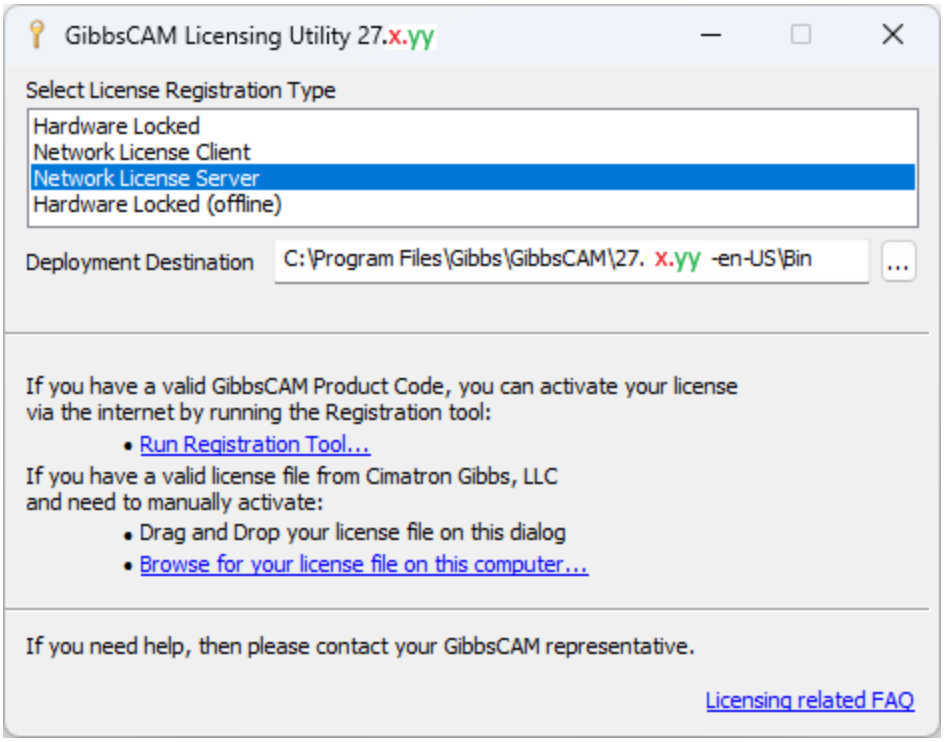
Registration Tools

Two registration utilities are provided:

- `RegistrationTool.exe` – See Standalone Licensing Utility
- `ActivationCheck.exe` – See "Verifying Activation Server Connectivity " on page 20

Standalone Licensing Utility

The Registration Process can also be activated without running GibbsCAM. Look for `Registration Tool` in the `GibbsCAM\` folder in the Windows Start menu. You can also access the standalone registration from the GibbsCAM installation folder. You can do this easily by searching for `RegistrationTool.exe`.

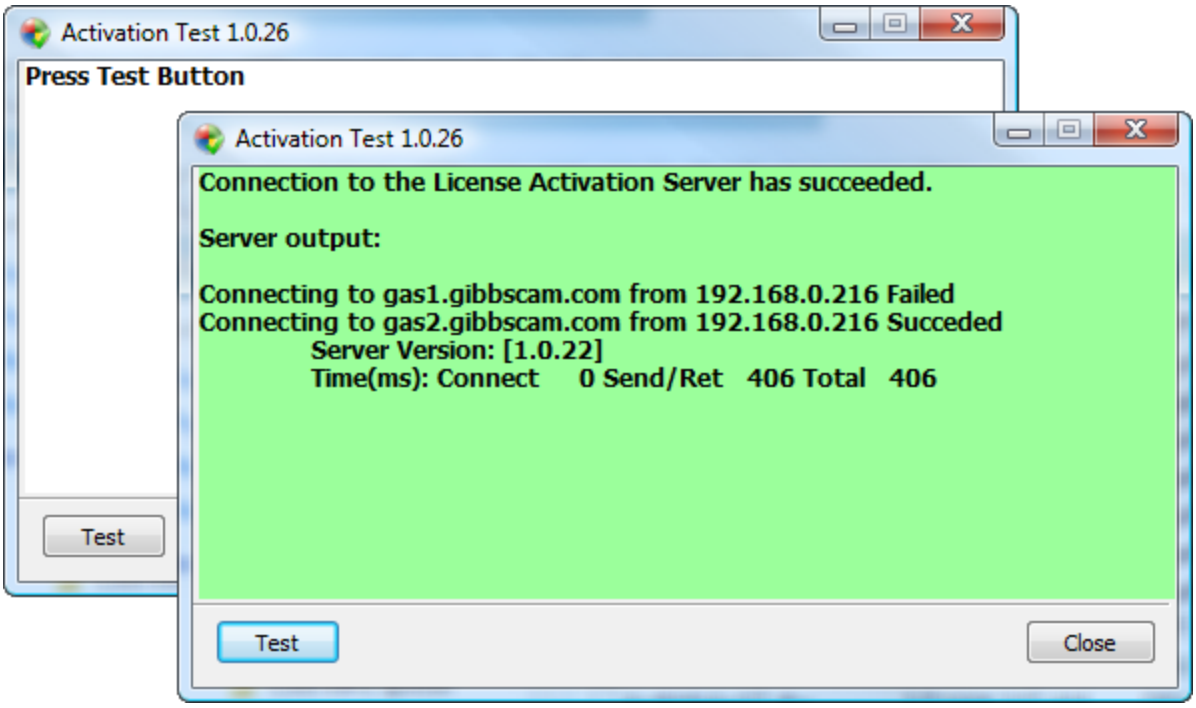


The Licensing Utility allows you to send license registration data and obtain and manage licenses for several different types of GibbsCAM installations:

- The Hardware Locked type is equivalent to the license installation from running GibbsCAM from a non-NLO GibbsCAM installation.
- The Network License Client type is equivalent to the license installation from running GibbsCAM from an NLO GibbsCAM installation.
- The Network License Server type installs the NLO server and license to a folder you specify.
- The Hardware Locked (offline) type installs a non-NLO client license to a folder you specify. This may be useful when pre-generating licenses for computers that may not have Internet access and can only be used with removable hardware key licenses. To generate an offline license, follow these steps:
  a. Specify a deployment destination for the offline license in Licensing Utility.
  b. Attach the hardware key that you intend to use on the offline computer.
  c. Click the Run Registration Tool... link and generate the offline license file following instructions in "Running the Registration Tool" on page 13. This action generates a license file in the specified folder.
  d. Move the generated `license-x.xxx.clm` file to the offline computer.
  e. Start GibbsCAM.
  f. Drag and drop the license file onto the GibbsCAM License Installation dialog (or use the Browse for your license file on this computer... link).

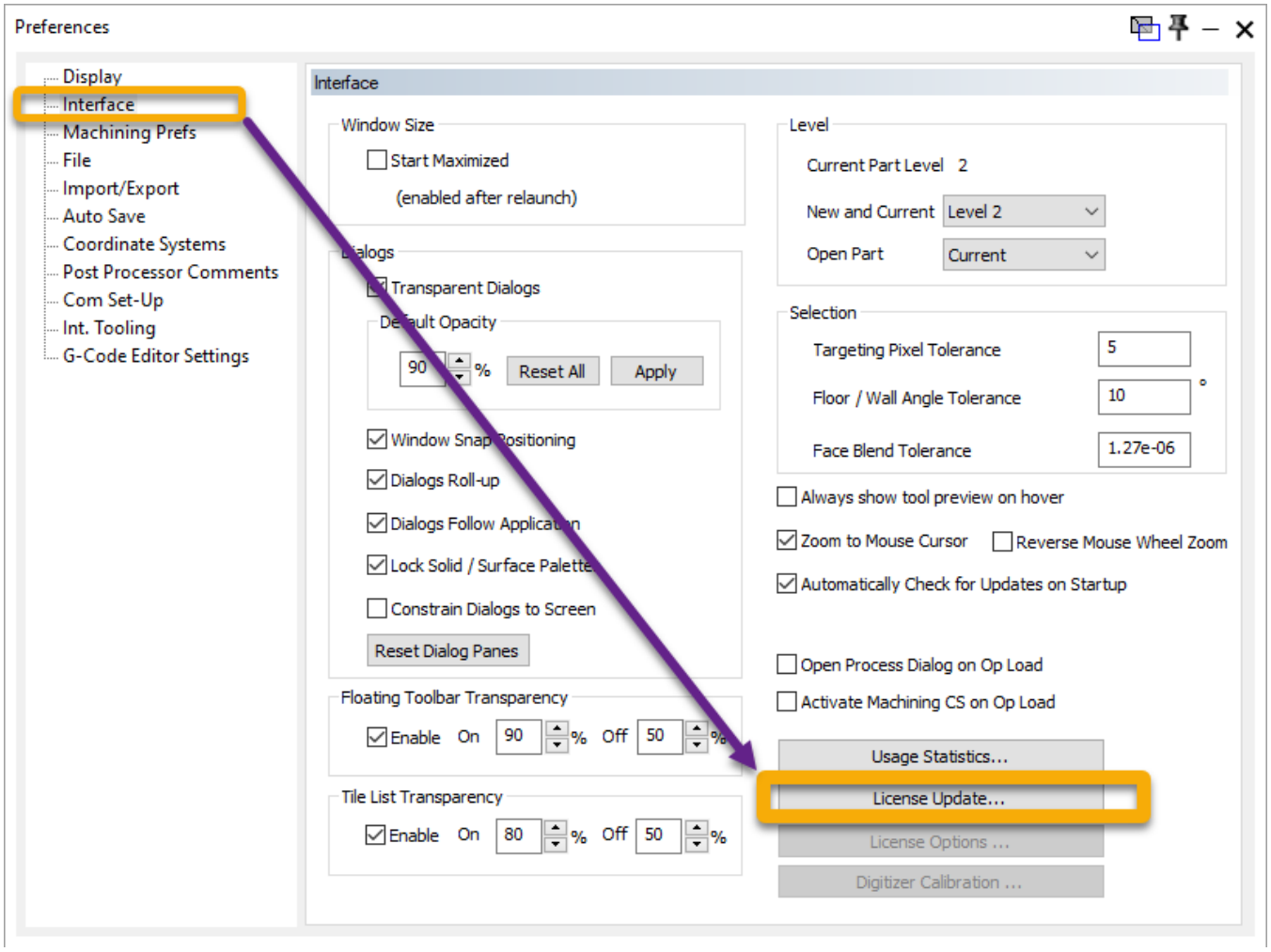
Verifying Activation Server Connectivity

`ActivationCheck.exe` is a simple utility that checks for connectivity with the Gibbs Activation Service. You can find this application in the `Bin\` folder of your GibbsCAM installation folder or by using the Start button's Search feature.



License Updates

If you need to update or change your license file to add options to your license, you can connect to the Gibbs Activation Service from the File > Preferences dialog, Interface tab.



Click the License Update button to open the Update Registration dialog.
To update your Product key and license, follow the steps for “Running the Registration Tool” on page 13.

Network Licensing

The current version of GibbsCAM uses Reprise License Manager (RLM), unlike GibbsCAM versions 2023, 2022, 14, and 13, which used Cimatron License Manager (CimLM). **This affects all customers using GibbsCAM NLO.**

What Remains the Same As 2023 and Before

As in GibbsCAM 2023 and before, Network Licensing (NLO) establishes a network license server that maintains a software key for each GibbsCAM product option purchased from GibbsCAM. These software keys (or "licenses") are distributed to nodes across a network to enable the workstations (nodes with installed GibbsCAM application software) to run the purchased module options. NLO is an alternative to hardware keys: When a client runs the GibbsCAM application software, a software key is "checked out" from the license server. There is no limit to the number of GibbsCAM seats installed on the network, only a limit to the number that can be used concurrently with each license server. Each client's license file can be created and installed through the Internet or, if the workstation lacks Internet access, by electronic or physical mail.

If You Use Cimatron Products

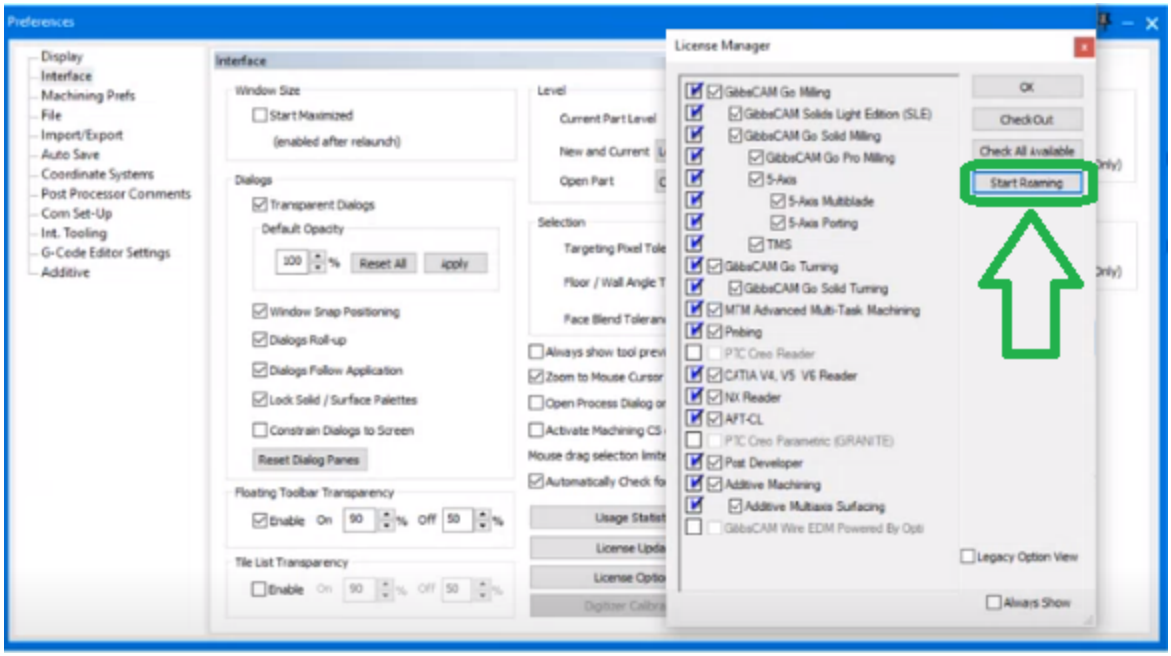
If you use Cimatron products as well as GibbsCAM products, you can continue to use the Cimatron license-server machine to serve Cimatron licenses. For GibbsCAM products, either you can install the RLM software on this machine (the two can coexist without conflicting), or you can install the RLM software on a different license-server machine.
Note (unrelated to NLO): Cimatron hardware keys cannot serve GibbsCAM licenses. If you use both hardware keys for both Cimatron and GibbsCAM products, you must use separate sets of hardware keys. This is a very rare case; most customers who use NLO do not use hardware keys.

What Changed

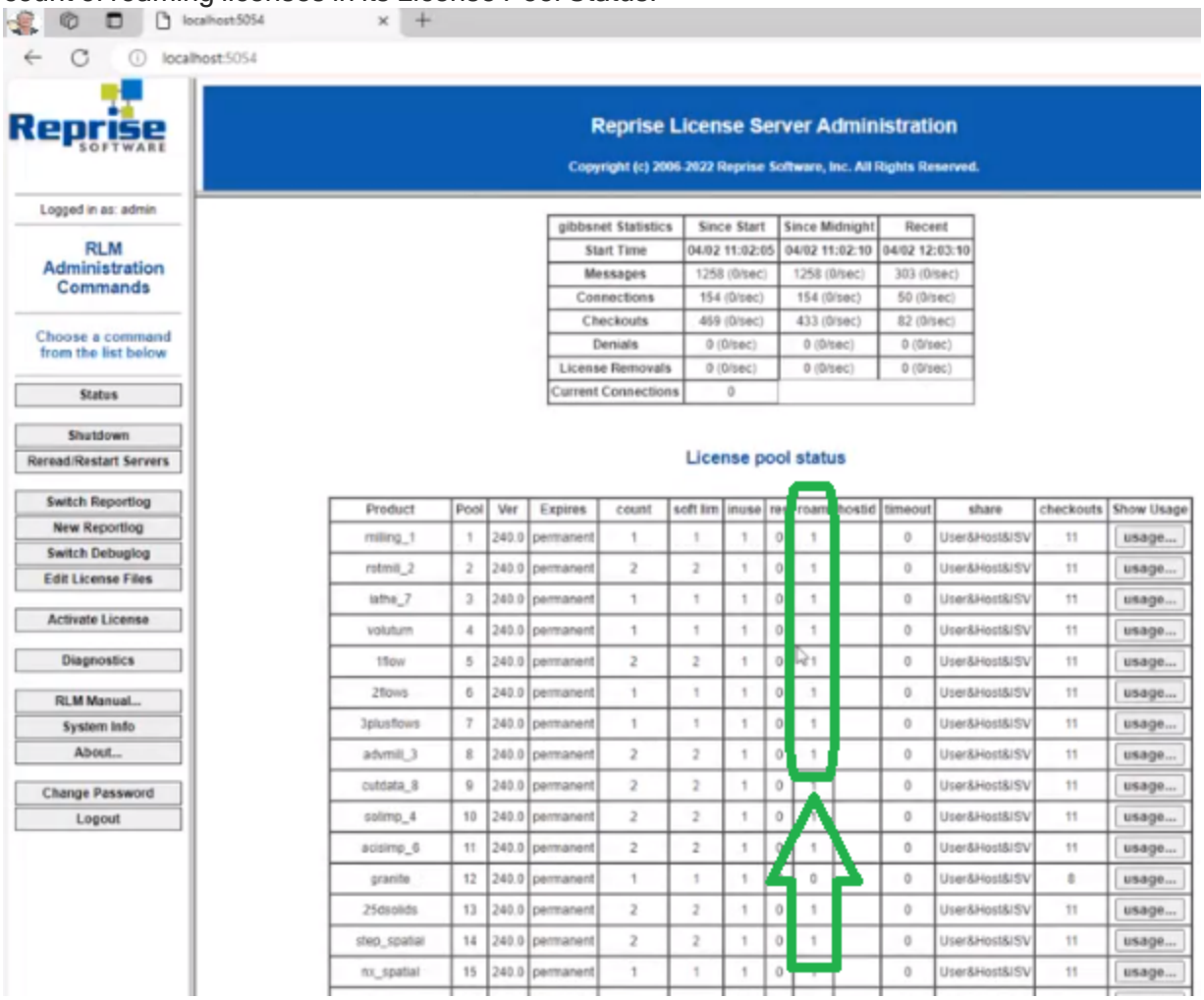
The first time you install this release of GibbsCAM NLO, you will use an initial one-time administrator password. ***You must change this password within ten minutes or else the service will terminate.***

NLO License borrowing with checkout/return/expiry parameters

Users can now check out an NLO license for a specified time period, then disconnect from the network. This allows users to borrow licenses, disconnect, move their laptop, and keep using the GibbsCAM products even when the license server is stopped. Borrowed licenses can be returned manually, or they can be set to expire after a set time.
Where users can find this option: Under **File** > **Preferences** > Interface, click License Options; then, in the **License Manager** dialog, click Start Roaming.



How administrators can support this option: Reprise License Server Administration shows the count of roaming licenses in its License Pool Status:



Operating Systems Supporting RLM

Reprise License Manager requires Windows Server 2008 R2 or Windows 7 ("NT 6.1") or later. Although this includes desktop platforms like Windows 8 ("NT 6.2"), Windows 8.1 ("NT 6.3"), Windows 10, and Windows 11, we recommend Windows Server: 2008 R2, 2012, 2012 R2, 2016, or (best) 2019 if more than five users will be simultaneously connected to the license server.

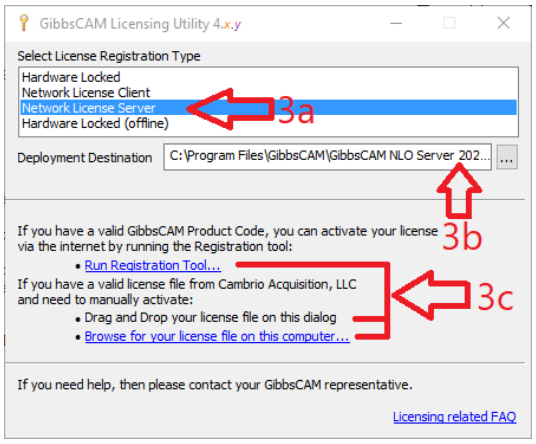
Overview of Network License Installation

Installation of the Network License Option (NLO) is a two-phase process: In Phase 1, you set up the Reprise License server. In Phase 2, you install and register the client software on each node. For condensed steps, see below; for details, see "NLO Step 1 - Setting Up The Server " on page 25.

Condensed Steps: To Set Up the License Server

1. With Administrator privileges, on the machine that will be serving GibbsCAM licenses, run the installer setup file:
   `GibbsCAMNLOServer-24.<x>.<y>.<z>.exe`
   to install the License Server software, Registration Tool, and support files.
   This installer setup file can be downloaded from Gibbs Online (online.gibbscam.com) and elsewhere.
2. On the server machine, open this URL
   `http://localhost:5054/`
   using the following initial one-time credentials:
   username .... `admin`
   password .... `admin`
   Important: ***You must change this password within ten minutes or else the service will terminate.***
3. From the folder where you installed the License Server software (default `C:\Program Files\GibbsCAM\GibbsCAM NLO Server 2027\`), run `RegistrationTool.exe`
4. When the **Licensing Utility** window appears:
   a. For License Registration Type, choose **Network License Server** (the *third* choice).
   b. For Deployment Destination, enter or browse to a writable folder.
   c. Either:
      - Browse for an existing `*.lic` license file on your computer.

      Or, if you do not yet have a `*.lic` file:
      - Click the Run Registration Tool link and then, in the Server License Registration



Tool window, enter (or copy-and-paste) your 20-character product license code.
For details, see “NLO Step 1 - Setting Up The Server ” on page 25.

Condensed Steps: To Install The Client Software

1. Install the GibbsCAM application software on the client machine. For instructions on installing the software, see “Installing the System Files ” on page 9.
2. Ensure that the License Server is running on the license server machine and that the client can connect to it, and then register GibbsCAM on the client machine.

For details, see “NLO Step 2 - Install the Client Software On Each Node” on page 26.

NLO Step 1 - Setting Up The Server

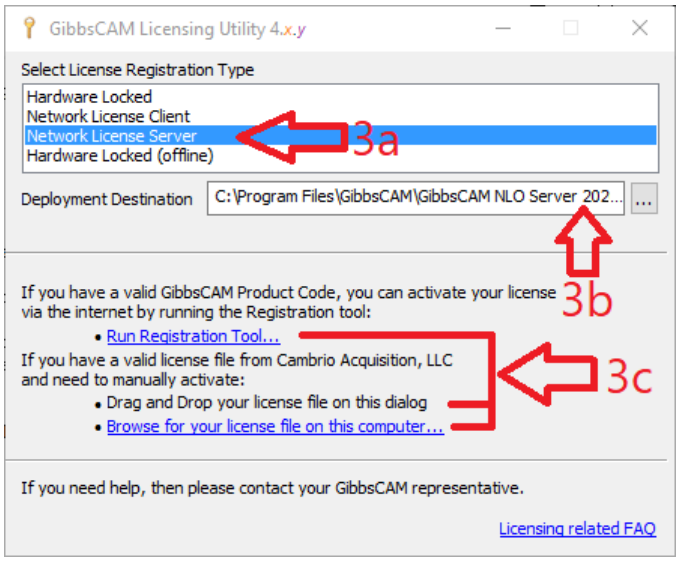
The first time you install this release of GibbsCAM NLO, you will use an initial one-time administrator password. ***You must change this password within ten minutes or else the service will terminate.***

Before you begin: On the machine where you will install the License Server, you must have administrator privileges. The installer setup file
`GibbsCAMNLOServer-24.<x>.<y>.<z>.exe`
must be available. This file can be downloaded from https://online.gibbscam.com (under **Software Downloads**, click the Tools link), or it can be loaded from the product media in folder `\Content\NLO Registration\`.
Before installing or modifying NLO Server, ensure that the firewall service is started (Services (Local) > Windows Firewall, Status = Started). Then, run the NLO installer. After the installation/modification is complete, you can stop your firewall service if necessary.

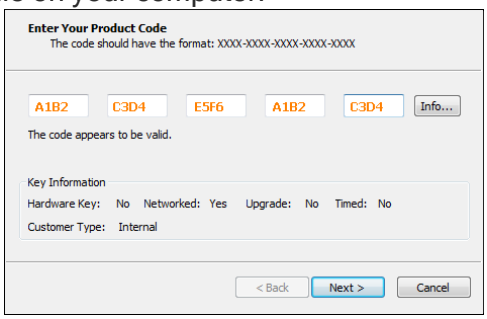
1. With Administrator privileges, on the machine that will be serving GibbsCAM licenses, run the executable to install the License Server software.
   `GibbsCAMNLOServer-24.<x>.<y>.<z>.exe`
   The steps are as follows:
   (a) UAC: Yes
   (b) Select the language you prefer
   (c) For **Welcome**: Click Next
   (d) Accept the License Agreement and click Next
   (e) For **Destination Folder**: Browse to or accept a folder and click Next
   (f) Click Install.
2. In a browser window on the server machine, open this URL
   `http://localhost:5054/`
   using the following initial one-time credentials:
   username .... `admin`
   password .... `admin`
   Important: ***You must change this password within ten minutes or else the service will terminate.***
   Note: After you install the server software, the service (GibbsRLMServer) might be set to Manual startup. It is a good idea to set the service so that its **Startup Type** is Automatic instead of Manual.

3. From the folder where you installed the License Server software (by default, this is `"C:\Program Files\GibbsCAM\GibbsCAM NLO Server 2027\`), run `RegistrationTool.exe`.
   Note: If, when you launch Registration Tool, you receive an error message saying that `vcruntime140_1.dll` is missing, do the following:
   - Download and install the Microsoft Visual C++ Redistributable Package: `https://aka.ms/vs/17/release/vc_redist.x64.exe`
   - Ensure that all updates and patches to Microsoft Windows have been installed and applied.

4. When the **Licensing Utility** window appears :
   a. For License Registration Type, choose **Network License Server** (the *third* choice).
   b. For Deployment Destination, enter or browse to a writable folder.
   c. Do one of the following:
      - If you already have a `*.lic` license file on your computer, use the Browse link to find and select it. The current version of GibbsCAM uses Reprise License Manager (RLM), unlike GibbsCAM versions 2023, 2022, 14, and 13, which used Cimatron License Manager (CimLM). If you try to use a CimLM `*.cml` file instead of an RLM `*.lic` file, it will not work.



      - Or, if you do not already have a `*.lic` license file on your computer:
        Click the Run Registration Tool link and then, in the Server License Registration Tool window, enter (or copy-and-paste) your 20-character product license code.
        When the activation is complete, a license file, `license-<customer_id>-<server_number>.lic`, is created in your deployment directory.



NLO Step 2 - Install the Client Software On Each Node

Before you begin: Make sure the license server machine is running the RLM License Server software and that the client machine (workstation) has a network connection to it.

Note: If a client machine cannot connect to the server after registration, ensure that ports 2764 and 2765 are not blocked and, if necessary, adjust the HOST name in the licensefile:

To adjust the HOST name in the licensefile, use Notepad to open the client's *.lic file and make sure the HOST name is correct, using one of the following examples.
Example 1: If the license file references the server by hostname (such as "*myServer*"):

```
#LSHOST=myServer
HOST myServer
```

Example 2: If the license file references the server by IP address (such as "*10.101.102.103*"):

```
#LSHOST=10.101.102.103
HOST 10.101.102.103
```

Steps

1. On the client machine (workstation), install the GibbsCAM software, using the same product code that was used for installing the server. For step-by step-instructions, see “Installing the System Files ” on page 9.
2. Register GibbsCAM for this client workstation.
   You can do this manually at any time by running the Registration Tool. Or, if you launch GibbsCAM, it will display the License Installation dialog to prompt you for the product code. Use the same product code that was used for the server. On NLO client machines, you are not prompted for contact information.
3. After you enter the product code, click Activate Product to complete the license deployment. The license data will be retrieved from the Gibbs Activation Service and placed in the appropriate Activation Data folder.
4. Repeat the previous steps (installing the GibbsCAM software and registering the product code) for each GibbsCAM client of the RLM license server machine.

Maintenance and Special Topics

The following are miscellaneous topics that can be helpful in some circumstances after you have installed GibbsCAM.

- Migrating from Previous Releases
- “Installing Post Packages” on page 30
- “Undoing All Customizations” on page 30
- “Using Command-Line Options” on page 30

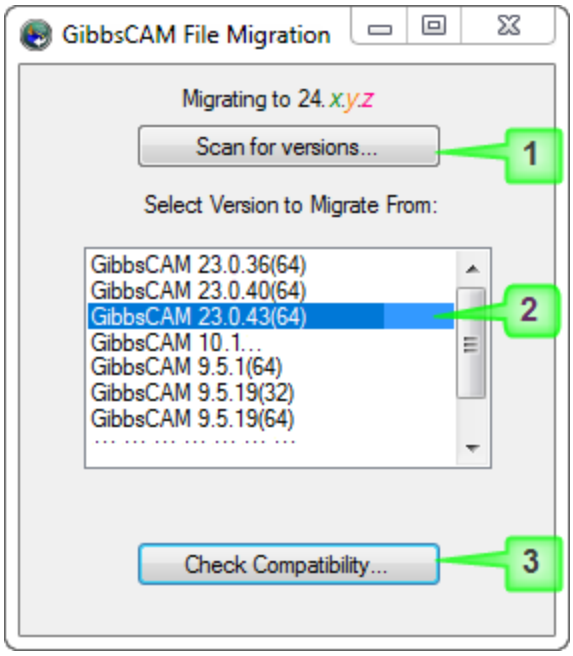
Migrating from Previous Releases

The GibbsCAM Migration Tool lets you detect all previously installed versions of GibbsCAM and copy compatible settings and preferences – UI and display settings, custom MDDs and VMMs, HSM settings, bolt and tap table data, macro configuration file, machine models, and so forth – from a specified previous version to the current release. The previous version is not modified. For best results, run the Migration Tool before the first time you start a newly installed release of GibbsCAM. This allows old files to be migrated before they are blocked by new files created in the newly installed version.

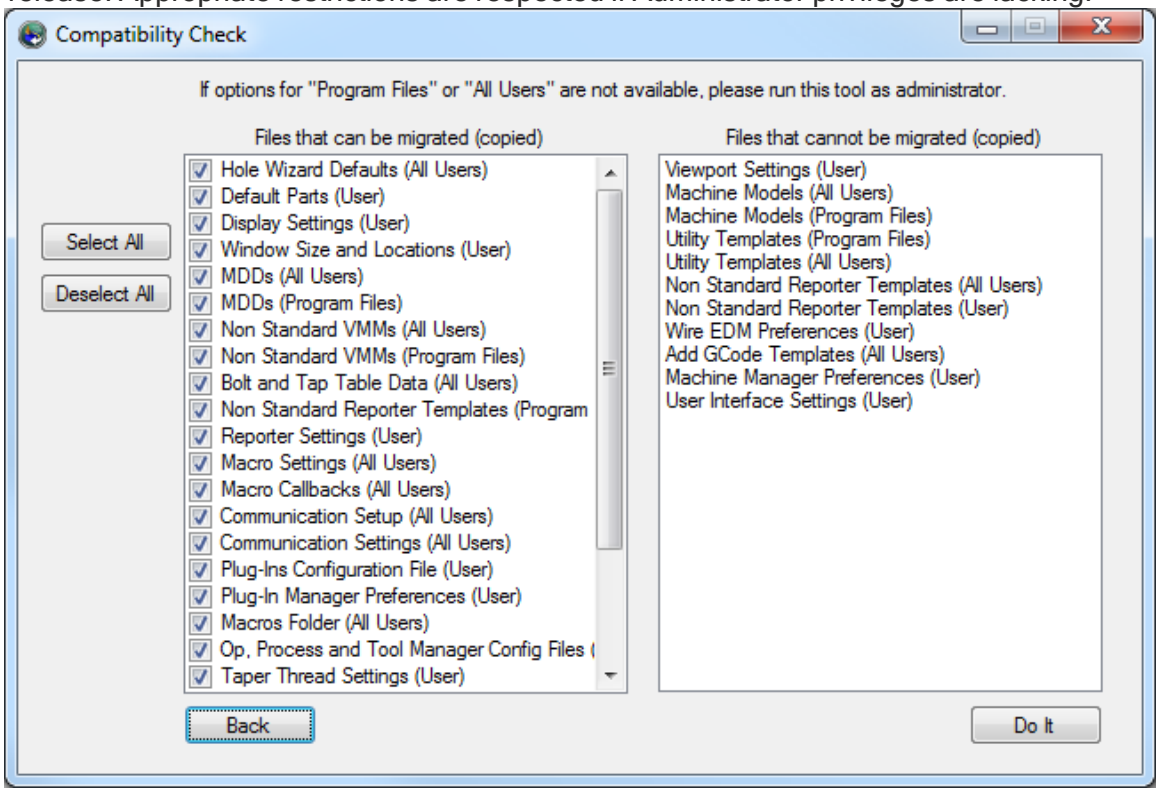
Using the Migration Tool

You can launch the tool from the Start menu: GibbsCAM > Migration Tool 2027.*x.y.z*. To run this tool with Administrator privileges (recommended), navigate to its parent folder (default `C:\Program Files\Gibbs\...\Bin\`), right-click the filename `GibbsMigrationTool.exe`, and choose context menu option Run as administrator.

1. The first dialog lets you scan your system for installed versions of GibbsCAM, select one from the list, and check it for compatibility.



2. The second dialog shows you the files that can and cannot be copied forward to the current release. Appropriate restrictions are respected if Administrator privileges are lacking.



Note: There is no ability to migrate plug-ins or material databases from previous releases. However, settings for Plug-In Manager can be migrated.

Installing Post Packages

When you receive a post processor package as a `.zip` file from the GibbsCAM Post department, you can install it simply by dragging it onto a running instance of GibbsCAM or using File > Open. This extracts the contents of the package and copies files to the appropriate locations under the `ProgramData\` folder:

- MDDs are extracted to the `MDD\` subfolder of the global data folder – normally `C:\ProgramData\Gibbs\GibbsCAM\<version>\MDD\`
- VMMs are extracted to the `VMM\` subfolder of the global data folder – normally `C:\ProgramData\Gibbs\GibbsCAM\<version>\VMM\`
- Post files are extracted to the `Posts\` subfolder of the global data folder – normally `C:\ProgramData\Gibbs\GibbsCAM\<version>\Posts\`
- Certain other special-purpose files (such as `.txt` files for `GCode Files\` and macro files for `CustomDrillCycles\`) are also extracted to the correct folders.

When a post package is installed in this way, if the target folder already contains `.mdd` or `.vmm` files with identical names, the pre-existing versions are overwritten.

Undoing All Customizations

Sometimes circumstances arise when you want to restore the as-shipped “factory” settings. For example, a particular user might want to remove all user-set preferences, such as customized defaults for interface background or lighting, or customized plug-in settings. Or, more broadly, a site might want to remove all site-customizable items, including the materials database, all custom MDDs and VMMs, and so forth.

Use this method only if you want to undo all customizations. Before wiping out extensive customizations, it is usually advisable to create a backup copy.

- To undo *user* customizations, simply delete/move/rename the **user data** folder: `C:\Users\<username>\AppData\Roaming\Gibbs\GibbsCAM\<version>`.
  Note: In releases prior to Version 11, the grandparent folder was named `Gibbs\` rather than `Gibbs`. For example, to suppress the customizations made by user “ChrisM” on GibbsCAM version 10.0.97, you could move this folder:
  `C:\Users\ChrisM\AppData\Roaming\Gibbs\GibbsCAM\10.0.97\`
- To undo *site* customizations, delete/move/rename the **global program data** folder: `C:\ProgramData\Gibbs\GibbsCAM\<version>`.
  For example, to undo the site customizations made to GibbsCAM version 12.9.99, you could rename this folder:
  `C:\ProgramData\Gibbs\GibbsCAM\12.9.99\`

Using Command-Line Options

Command-Line Option for License Checkouts

You can start GibbsCAM with the `-lo` command-line option to specify a license option file. For example, this command line:

```
virtual.exe -lo MyLicenseOptions.txt
```

will attempt to check out the licenses specified in the `MyLicenseOptions.txt` file and, if successful, start GibbsCAM.
If any of the requested options cannot be checked out, then the user is notified, none of the specified licenses are checked out, and GibbsCAM exits.
The `*.txt` file specified by the `-lo` option uses this syntax:
Lines beginning with `#` or `//` are comment lines; they have no effect on execution.
Lines beginning with a valid GC* keyword (see below) will check out the corresponding license on startup.

License Options: GC* keywords

GCMGoMilling GCMGoSolidMilling GCMGoProMilling GCMGoTurning GCMGoSolidTurning GCM5Axis GCM5AxisMultiblade GCM5AxisPorting GCMMTM GCMTMS GCMProbing GCMPTCCreoSpatial GCMCATIASpatial GCMNXSpatial GCMAPTCL GCMPostDeveloper GCMEDM GCMEDM_PartialPocketing GCMEDM_4AxisPocketing GCMEDM_MachAC_Cut_2030 GCMEDM_MachAC_Cut_X00 GCMEDM_MachAC_Cut_EXX0 GCMEDM_MachAccutex GCMEDM_MachExcetek GCMEDM_MachFanuc GCMEDM_MachJoemars GCMEDM_MachMakino GCMEDM_MachMitsubishi GCMEDM_MachSeibu GCMEDM_MachMSeibu GCMEDM_MachONA GCMEDM_MachSodick GCMEDM_MachAC_Fanuc GCMEDM_MachAC_Millenium GCMEDM_MachAC_Orange GCMEDM_MachAC_Vision GCMEDM_MachAC_Cut_Uniqua GCMEDM_MachAgie_100123 GCMEDM_MachAC_Robofil GCMEDM_MachBrother GCMEDM_MachCHMER GCMEDM_MachHitachi GCMEDM_MachJapax GCMEDM_MachGeneric

Conventions

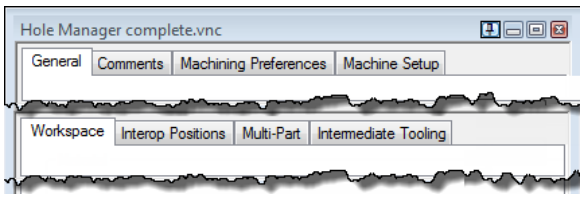
GibbsCAM documentation uses two special fonts to represent `screen text` and `keystrokes or mouse actions`. Other conventions in text and graphics are used to allow quick skimming, to suppress irrelevancy, or to indicate links.

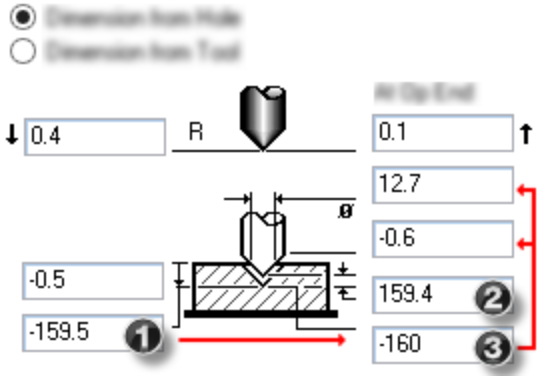
Text

`Screen text`. Text with `this appearance` indicates text that appears in GibbsCAM or on your monitor. Typically this is a button or text for a dialog.
`Keystroke/Mouse`. Text with `this appearance` indicates a keystroke or mouse action, such as `Ctrl+C` or `right-click`.
`Code`. Text with `this appearance` indicates computer code, such as lines in a macro or a block of G-code.

Graphics

Some graphics are altered so as to de-emphasize irrelevant information. A “torn” edge signifies an intentional omission. Portions of a graphic might be blurred or dimmed to highlight the item being discussed. For example:





Annotations on a graphic are usually numbered callouts (as seen above), and sometimes include green circles, arrows, or tie-lines to focus attention on a particular portion of the graphic.

Links to Online Resources

Please contact your reseller for support.

Link	URL	Action / Description
Go	http://www.GibbsCAM.com	Opens the main website for GibbsCAM.
Go	https://online.gibbscam.com	Opens Gibbs Online page to download GibbsCAM and all supported material.