

CNC PROGRAMMING

USING FANUC CUSTOM MACRO B

```
*I01 = *I01 + 1;
```

```
END 1;
```

```
G80;
```

```
M99;
```

If some conditions are not met, the program jumps to the line number specified in the following line.

```
IF [#2 EQ #0] THEN GOTO #100
```

```
IF [#19 EQ #0] THEN GOTO #100 (START ANGLE NOT SPECIFIED)
```

```
IF [#18 EQ #0] THEN GOTO #100 (K-POINT NOT SPECIFIED)
```

```
IF [#9 EQ #0] THEN GOTO #100 (FEEDRATE NOT SPECIFIED)
```

For making flange number 1, this macro may be called by a program such as the one given below.

```
G21 G94;
```

```
G91 G28 Z0;
```

```
G28 X0 Y0;
```

```
M06 T01;
```

```
G90;
```

```
G00 X0 Y0;
```

```
G43 H01 Z50;
```

```
M3 S1000;
```

```
M08;
```

```
O8021 (BOLT HOLES ON A FLANGE);
```

```
G81 Z[AB91#26] R#18 F#9 K0;
```

```
#100 = [360 / #11];
```

ready active. As long as it is not canceled by, say, G80, every axis displacement would cause a hole to be drilled at the new position, using G81. Step 5 complete)

(Hole counter incremented by 1, for drilling the next hole. Step 6 complete)

(End of the current loop, jumps to the line number specified in the following line)

(Cutting the next loop. Step 7 complete)

(G81 can be canceled by G80, G82, G83, G84, G85, G86, G87, G88, G89, G90, G91, G92, G93, G94, G95, G96, G97, G98, G99, G100, G101, G102, G103, G104, G105, G106, G107, G108, G109, G110, G111, G112, G113, G114, G115, G116, G117, G118, G119, G120, G121, G122, G123, G124, G125, G126, G127, G128, G129, G130, G131, G132, G133, G134, G135, G136, G137, G138, G139, G140, G141, G142, G143, G144, G145, G146, G147, G148, G149, G150, G151, G152, G153, G154, G155, G156, G157, G158, G159, G160, G161, G162, G163, G164, G165, G166, G167, G168, G169, G170, G171, G172, G173, G174, G175, G176, G177, G178, G179, G180, G181, G182, G183, G184, G185, G186, G187, G188, G189, G190, G191, G192, G193, G194, G195, G196, G197, G198, G199, G200, G201, G202, G203, G204, G205, G206, G207, G208, G209, G210, G211, G212, G213, G214, G215, G216, G217, G218, G219, G220, G221, G222, G223, G224, G225, G226, G227, G228, G229, G230, G231, G232, G233, G234, G235, G236, G237, G238, G239, G240, G241, G242, G243, G244, G245, G246, 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G579, G580, G581, G582, G583, G584, G585, G586, G587, G588, G589, G590, G591, G592, G593, G594, G595, G596, G597, G598, G599, G600, G601, G602, G603, G604, G605, G606, G607, G608, G609, G610, G611, G612, G613, G614, G615, G616, G617, G618, G619, G620, G621, G622, G623, G624, G625, G626, G627, G628, G629, G630, G631, G632, G633, G634, G635, G636, G637, G638, G639, G640, G641, G642, G643, G644, G645, G646, G647, G648, G649, G650, G651, G652, G653, G654, G655, G656, G657, G658, G659, G660, G661, G662, G663, G664, G665, G666, G667, G668, G669, G670, G671, G672, G673, G674, G675, G676, G677, G678, G679, G680, G681, G682, G683, G684, G685, G686, G687, G688, G689, G690, G691, G692, G693, G694, G695, G696, G697, G698, G699, G700, G701, G702, G703, G704, G705, G706, G707, G708, G709, G710, G711, G712, G713, G714, G715, G716, G717, G718, G719, G720, G721, G722, G723, G724, G725, G726, G727, G728, G729, G730, G731, G732, G733, G734, G735, G736, G737, G738, G739, G740, G741, G742, G743, G744, 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J Rink



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