

# CNC PROGRAMMING

## USING FANUC CUSTOM MACRO B

```
#101 = #101 + 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 10;
```

```
IF [#19 EQ #0] THEN GOTO 10; (START ANGLE NOT SPECIFIED)
```

```
IF [#18 EQ #0] THEN GOTO 10; (5-POINT NOT SPECIFIED)
```

```
IF [#9 EQ #0] THEN GOTO 10; (FEEDRATE NOT SPECIFIED)
```

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

```
G21 G94;
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```
G91 G28 Z0;
```

```
G28 X0 Y0;
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```
M06 T01;
```

```
G90;
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```
G00 X0 Y0;
```

```
G43 H01 Z50;
```

```
M3 S1000;
```

```
M08;
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```
O8021 (BOLT HOLES ON A FLANGE);
```

```
G81 Z[ABS#126] 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)

(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, G247, G248, G249, G250, G251, G252, G253, G254, G255, G256, G257, G258, G259, G260, G261, G262, G263, G264, G265, G266, G267, G268, G269, G270, G271, G272, G273, G274, G275, G276, G277, G278, G279, G280, G281, G282, G283, G284, G285, G286, G287, G288, G289, G290, G291, G292, G293, G294, G295, G296, G297, G298, G299, G300, G301, G302, G303, G304, G305, G306, G307, G308, G309, G310, G311, G312, G313, G314, G315, G316, G317, G318, G319, G320, G321, G322, G323, G324, G325, G326, G327, G328, G329, G330, G331, G332, G333, G334, G335, G336, G337, G338, G339, G340, G341, G342, G343, G344, G345, G346, G347, G348, G349, G350, G351, G352, G353, G354, G355, G356, G357, G358, G359, G360, G361, G362, G363, G364, G365, G366, G367, G368, G369, G370, G371, G372, G373, G374, G375, G376, G377, G378, G379, G380, G381, G382, G383, G384, G385, G386, G387, G388, G389, G390, G391, G392, G393, G394, G395, G396, G397, G398, G399, G400, G401, G402, G403, G404, G405, G406, G407, G408, G409, G410, G411, G412, G413, G414, G415, G416, G417, G418, G419, G420, G421, G422, G423, G424, G425, G426, G427, G428, G429, G430, G431, G432, G433, G434, G435, G436, G437, G438, G439, G440, G441, G442, G443, G444, G445, G446, G447, G448, G449, G450, G451, G452, G453, G454, G455, G456, G457, G458, G459, G460, G461, G462, G463, G464, G465, G466, G467, G468, G469, G470, G471, G472, G473, G474, G475, G476, G477, G478, G479, G480, G481, G482, G483, G484, G485, G486, G487, G488, G489, G490, G491, G492, G493, G494, G495, G496, G497, G498, G499, G500, G501, G502, G503, G504, G505, G506, G507, G508, G509, G510, G511, G512, G513, G514, G515, G516, G517, G518, G519, G520, G521, G522, G523, G524, G525, G526, G527, G528, G529, G530, G531, G532, G533, G534, G535, G536, G537, G538, G539, G540, G541, G542, G543, G544, G545, G546, G547, G548, G549, G550, G551, G552, G553, G554, G555, G556, G557, G558, G559, G560, G561, G562, G563, G564, G565, G566, G567, G568, G569, G570, G571, G572, G573, G574, G575, G576, G577, G578, 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, G745, G746, G747, G748, G749, G750, G751, G752, G753, G754, G755, G756, G757, G758, G759, G760, G761, G762, G763, G764, G765, G766, G767, G768, G769, G770, G771, G772, G773, G774, G775, G776, G777, G778, G779, G780, G781, G782, G783, G784, G785, G786, G787, G788, G789, G790, G791, G792, G793, G794, G795, G796, G797, G798, G799, G800, G801, G802, G803, G804, G805, G806, G807, G808, G809, G810, G811, G812, G813, G814, G815, G816, G817, G818, G819, G820, G821, G822, G823, G824, G825, G826, G827, G828, G829, G830, G831, G832, G833, G834, G835, G836, G837, G838, G839, G840, G841, G842, G843, G844, G845, G846, G847, G848, G849, G850, G851, G852, G853, G854, G855, G856, G857, G858, G859, G860, G861, G862, G863, G864, G865, G866, G867, G868, G869, G870, G871, G872, G873, G874, G875, G876, G877, G878, G879, G880, G881, G882, G883, G884, G885, G886, G887, G888, G889, G890, G891, G892, G893, G894, G895, G896, G897, G898, G899, G900, G901, G902, G903, G904, G905, G906, G907, G908, G909, G910, G911, G912, G913, G914, G915, G916, G917, G918, G919, G920, G921, G922, G923, G924, G925, G926, G927, G928, G929, G930, G931, G932, G933, G934, G935, G936, G937, G938, G939, G940, G941, G942, G943, G944, G945, G946, G947, G948, G949, G950, G951, G952, G953, G954, G955, G956, G957, G958, G959, G960, G961, G962, G963, G964, G965, G966, G967, G968, G969, G970, G971, G972, G973, G974, G975, G976, G977, G978, G979, G980, G981, G982, G983, G984, G985, G986, G987, G988, G989, G990, G991, G992, G993, G994, G995, G996, G997, G998, G999, G1000, G1001, G1002, G1003, G1004, G1005, G1006, G1007, G1008, G1009, G1010, G1011, G1012, G1013, G1014, G1015, G1016, G1017, G1018, G1019, G1020, G1021, G1022, G1023, G1024, G1025, G1026, G1027, G1028, G1029, G1030, G1031, G1032, G1033, G1034, G1035, G1036, G1037, G1038, G1039, G1040, G1041, G1042, G1043, G1044, G1045, G1046, G1047, G1048, G1049, G1050, G1051, G1052, G1053, G1054, G1055, G1056, G1057, G1058, G1059, G1060, G1061, G1062, G1063, G1064, G1065, G1066, G1067, G1068, G1069, G1070, G1071, G1072, G1073, G1074, G1075, G1076, G1077, G1078, G1079, G1080, G1081, G1082, G1083, G1084, G1085, G1086, G1087, G1088, G1089, G1090, G1091, G1092, G1093, G1094, G1095, G1096, G1097, G1098, G1099, G1100, G1101, G1102, G1103, G1104, G1105, G1106, G1107, G1108, G1109, G1110, G1111, G1112, G1113, G1114, G1115, G1116, G1117, G1118, G1119, G1120, G1121, G1122, G1123, G1124, G1125, G1126, G1127, G1128, G1129, G1130, G1131, G1132, G1133, G1134, G1135, G1136, G1137, G1138, G1139, G1140, G1141, G1142, G1143, G1144, G1145, G1146, G1147, G1148, G1149, G1150, G1151, G1152, G1153, G1154, G1155, G1156, G1157, G1158, G1159, G1160, G1161, G1162, G1163, G1164, G1165, G1166, G1167, G1168, G1169, G1170, G1171, G1172, G1173, G1174, G1175, G1176, G1177, G1178, G1179, G1180, G1181, G1182, G1183, G1184, G1185, G1186, G1187, G1188, G1189, G1190, G1191, G1192, G1193, G1194, G1195, G1196, G1197, G1198, G1199, G1200, G1201, G1202, G1203, G1204, G1205, G1206, G1207, G1208, G1209, G1210, G1211, G1212, G1213, G1214, G1215, G1216, G1217, G1218, G1219, G1220, G1221, G1222, G1223, G1224, G1225, G1226, G1227, G1228, G1229, G1230, G1231, G1232, G1233, G1234, G1235, G1236, G1237, G1238, G1239, G1240, G1241, G1242, G1243, G1244, G1245, G1246, G1247, G1248, G1249, G1250, G1251, G1252, G1253, G1254, G1255, G1256, G1257, G1258, G1259, G1260, G1261, G1262, G1263, G1264, G1265, G1266, G1267, G1268, G1269, G1270, G1271, G1272, G1273, G1274, G1275, G1276, G1277, G1278, G1279, G1280, G1281, G1282, G1283, G1284, G1285, G1286, G1287, G1288, G1289, G1290, G1291, G1292, G1293, G1294, G1295, G1296, G1297, G1298, G1299, G1300, G1301, G1302, G1303, G1304, G1305, G1306, G1307, G1308, G1309, G1310, G1311, G1312, G1313, G1314, G1315, G1316, G1317, G1318, G1319, G1320, G1321, G1322, G1323, G1324, G1325, G1326, G1327, G1328, G1329, G1330, G1331, G1332, G1333, G1334, G1335, G1336, G1337, G1338, G1339, G1340, G1341, G1342, G1343, G1344, G1345, G1346, G1347, G1348, G1349, G1350, G1351, G1352, G1353, G1354, G1355, G1356, G1357, G1358, G1359, G1360, G1361, G1362, G1363, G1364, G1365, G1366, G1367, G1368, G1369, G1370, G1371, G1372, G1373, G1374, G1375, G1376, G1377, G1378, G1379, G1380, G1381, G1382, G1383, G1384, G1385, G1386, G1387, G1388, G1389, G1390, G1391, G1392, G1393, G1394, G1395, G1396, G1397, G1398, G1399, G1400, G1401, G1402, G1403, G1404, G1405, G1406, G1407, G1408, G1409, G1410, G1411, G1412, G1413, G1414, G1415, G1416, G1417, G1418, G1419, G1420, G1421, G1422, G1423, G1424, G1425, G1426, G1427, G1428, G1429, G1430, G1431, G1432, G1433, G1434, G1435, G1436, G1437, G1438, G1439, G1440, G1441, G1442, G1443, G1444, G1445, G1446, G1447, G1448, G1449, G1450, G1451, G1452, G1453, G1454, G1455, G1456, G1457, G1458, G1459, G1460, G1461, G1462, G1463, G1464, G1465, G1466, G1467, G1468, G1469, G1470, G1471, G1472, G1473, G1474, G1475, G1476, G1477, G1478, G1479, G1480, G1481, G1482, G1483, G1484, G1485, G1486, G1487, G1488, G1489, G1490, G1491, G1492, G1493, G1494, G1495, G1496, G1497, G1498, G1499, G1500, G1501, G1502, G1503, G1504, G1505, G1506, G1507, G1508, G1509, G1510, G1511, G1512, G1513, G1514, G1515, G1516, G1517, G1518, G1519, G1520, G1521, G1522, G1523, G1524, G1525, G1526, G1527, G1528, G1529, G1530, G1531, G1532, G1533, G1534, G1535, G1536, G1537, G1538, G1539, G1540, G1541, G1542, G1543, G1544, G1545, G1546, G1547, G1548, G1549, G1550, G1551, G1552, G1553, G1554, G1555, G1556, G1557, G1558, G1559, G1560, G1561, G1562, G1563, G1564, G1565, G1566, G1567, G1568, G1569, G1570, G1571, G1572, G1573, G1574, G1575, G1576, G1577, G1578, G1579, G1580, G1581, G1582, G1583, G1584, G1585, G1586, G1587, G1588, G1589, G1590, G1591, G1592, G1593, G1594, G1595, G1596, G1597, G1598, G1599, G1600, G1601, G1602, G1603, G1604, G1605, G1606, G1607, G1608, G1609, G1610, G1611, G1612, G1613, G1614, G1615, G1616, G1617, G1618, G1619, G1620, G1621, G1622, G1623, G1624, G1625, G1626, G1627, G1628, G1629, G1630, G1631, G1632, G1633, G1634, G1635, G1636, G1637, G1638, G1639, G1640, G1641, G1642, G1643, G1644, G1645, G1646, G1647, G1648, G1649, G1650, G1651, G1652, G1653, G1654, G1655, G1656, G1657, G1658, G1659, G1660, G1661, G1662, G1663, G1664, G1665, G1666, G1667, G1668, G1669, G1670, G1671, G1672, G1673, G1674, G1675, G1676, G1677, G1678, G1679, G1680, G1681, G1682, G1683, G1684, G1685, G1686, G1687, G1688, G1689, G1690, G1691, G1692, G1693, G1694, G1695, G1696, G1697, G1698, G1699, G1700, G1701, G1702, G1703, G1704, G1705, G1706, G1707, G1708, G1709, G1710, G1711, G1712, G1713, G1714, G1715, G1716, G1717, G1718, G1719, G1720, G1721, G1722, G1723, G1724, G1725, G1726, G1727, G1728, G1729, G1730, G1731, G1732, G1733, G1734, G1735, G1736, G1737, G1738, G1739, G1740, G1741, G1742, G1743, G1744, G1745, G1746, G1747, G1748, G1749, G1750, G1751, G1752, G1753, G1754, G1755, G1756, G1757, G1758, G1759, G1760, G1761, G1762, G1763, G1764, G1765, G1766, G1767, G1768, G1769, G1770, G1771, G1772, G1773, G1774, G1775, G1776, G1777, G1778, G1779, G1780, G1781, G1782, G1783, G1784, G1785, G1786, G1787, G1788, G1789, G1790, G1791, G1792, G1793, G1794, G1795, G1796, G1797, G1798, G1799, G1800, G1801, G1802, G1803, G1804, G1805, G1806, G1807, G1808, G1809, G1810, G1811, G1812, G1813, G1814, G1815, G1816, G1817, G1818, G1819, G1820, G1821, G1822, G1823, G1824, G1825, G1826, G1827, G1828, G1829, G1830, G1831, G1832, G1833, G1834, G1835, G1836, G1837, G1838, G1839, G1840, G1841, G1842, G1843, G1844, G1845, G1846, G1847, G1848, G1849, G1850, G1851, G1852, G1853, G1854, G1855, G1856, G1857, G1858, G1859, G1860, G1861, G1862, G1863, G1864, G1865, G1866, G1867, G1868, G1869, G1870, G1871, G1872, G1873, G1874, G1875, G1876, G1877, G1878, G1879, G1880, G1881, G1882, G1883, G1884, G1885, G1886, G1887, G1888, G1889, G1890, G1891, G1892, G1893, G1894, G1895, G1896, G1897, G1898, G1899, G1900, G1901, G1902, G1903, G1904, G1905, G1906, G1907, G1908, G1909, G1910, G1911, G1912, G1913, G1914, G1915, G1916, G1917, G1918, G1919, G1920, G1921, G1922, G1923, G1924, G1925, G1926, G1927, G1928, G1929, G1930, G1931, G1932, G1933, G1934, G1935, G1936, G1937, G1938, G1939, G1940, G1941, G1942, G1943, G1944, G1945, G1946, G1947, G1948, G1949, G1950, G1951, G1952, G1953, G1954, G1955, G1956, G1957, G1958, G1959, G1960, G1961, G1962, G1963, G1964, G1965, G1966, G1967, G1968, G1969, G1970, G1971, G1972, G1973, G1974, G1975, G1976, G1977, G1978, G1979, G1980, G1981, G1982, G1983, G1984, G1985, G1986, G1987, G1988, G1989, G1990, G1991, G1992, G1993, G1994, G1995, G1996, G1997, G1998, G1999, G2000, G2001, G2002, G2003, G2004, G2005, G2006, G2007, G2008, G2009, G2010, G2011, G2012, G2013, G2014, G2015, G2016, G2017, G2018, G2019, G2020, G2021, G2022, G2023, G2024, G2025, G2026, G2027, G2028, G2029, G2030, G2031, G2032, G2033, G2034, G2035, G2036, G2037, G2038, G2039, G2040, G2041, G2042, G2043, G2044, G2045, G2046, G2047, G2048, G2049, G2050, G2051, G2052, G2053, G2054, G2055, G2056, G2057, G2058, G2059, G2060, G2061, G2062, G2063, G2064, G2065, G2066, G2067, G2068, G2069, G2070, G2071, G2072, G2073, G2074, G2075, G2076, G2077, G2078, G2079, G2080, G2081, G2082, G2083, G2084, G2085, G2086, G2087, G2088, G2089, G2090, G2091, G2092, G2093, G2094, G2095, G2096, G2097,

# Fanuc 0t Macro B Guide

**Daniel F McAuley**



## **Fanuc 0t Macro B Guide:**

Fanuc 0t Macro B Guide: Bestsellers in 2023 The year 2023 has witnessed a remarkable surge in literary brilliance, with numerous engrossing novels captivating the hearts of readers worldwide. Lets delve into the realm of bestselling books, exploring the fascinating narratives that have enthralled audiences this year. The Must-Read : Colleen Hoover's "It Ends with Us" This poignant tale of love, loss, and resilience has gripped readers with its raw and emotional exploration of domestic abuse. Hoover skillfully weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can succeed. Fanuc 0t Macro B Guide : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This captivating historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids compelling storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens "Where the Crawdads Sing" This evocative coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens crafts a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These top-selling novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of captivating stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a brilliant and gripping novel that will keep you guessing until the very end. The novel is a cautionary tale about the dangers of obsession and the power of evil.

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