

# Fanuc CNC Macro Programming (Custom Macro B) Codes

Fanuc's Custom Macro B is a powerful programming feature that allows for parametric programming, variables, logic operations, and complex calculations in CNC programs. Here are the key elements:

## Variables

- **#1-#33** - Local variables (volatile)
- **#100-#199** - Common variables (retain values after power off)
- **#500-#999** - Persistent common variables (retain values after power off)
- **#1000+** - System variables (read-only)

## Arithmetic Operations

```
text
#i = <expression> (Assignment)
+ (Addition)
- (Subtraction)
* (Multiplication)
/ (Division)
MOD (Module)
SIN (Sine)
COS (Cosine)
TAN (Tangent)
ATAN (Arctangent)
SQRT (Square root)
ABS (Absolute value)
ROUND (Rounding)
FIX (Truncate)
FUP (Round up)
```

## Control Statements

### Conditional Branches

```
text
IF [<conditional expression>] GOTO n
IF [<conditional expression>] THEN <assignment>
```

# Fanuc Cnc Macro Programming Manual

**RC Schank**



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