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 (Modulo)
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

Rachel S Tattersall

Fanuc Cnc Macro Programming Manual:

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