

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 #1] THEN GOTO #3
```

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

```
IF [#18 EQ #0] THEN GOTO #9 (5-POINT NOT SPECIFIED)
```

```
IF [#9 EQ #0] THEN GOTO #8 (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[ABS#126] R#18 F#9 K0;
```

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

ready active. As long as it's 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 to start the second loop)

(G81 can't be canceled, so G80 is canceled and G01 is used, such as

G00 and G01. If the program is canceled, it returns to the line number specified in Step 9

complete)

(Change to G20 for inch mode, G95 for inch feed per revolution)

(Tool magazine sent to the home position for change; then

assigned tool placed in the spindle)

(Absolute coordinate mode selected)

(XY positioning. Specify the start coordinate values. If #126 is 0, in the center of the flange, #126 is from the XY-datum)

(Function invoked. Tool length of Z = 50 mm. It defines the initial Z-level for G81)

(Specify appropriate CW spindle speed)

(Coolant starts)

(Arguments of G81 specified. Step 1 complete)

(Angle between subsequent holes calculated. A negative value for the angle of holes, H, is also permitted that would drill the holes in the opposite direction

S.K. SINHA

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Mike Jess

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