

# CNC

# PROGRAMMING

## USING FANUC CUSTOM MACRO B

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

```
G21 G94; (Change to G21 for inch mode, and G95 for feed per revolution)
G91 G28 Z0; (Tool magazine sent to the home position, for changing tool)
G28 X0 Y0; (Desired tool placed in the spindle)
M06 T01; (Absolute coordinate mode selected)
G90; (XY positioning. Specify different coordinate values, if needed, in the center of the punch circle is 100 mm from the Y-datum)
G00 X0 Y0; (Compensation invoked. Tool at Z = 50 mm. It defines the initial Z-level for G81)
G43 H01 Z50; (Specify appropriate CW spindle speed)
M03 S1000; (Coolant starts)
M08;
O8021 (BOLT HOLES ON A FLANGE);
G81 Z[ABS[#26]] R#18 F#9 K0; (Arguments of G81 specified. Step 1 complete)
#100 = [360 / #11]; (Angle between subsequent holes calculated. A negative value for #11 implies left-hand holes. H is also permitted, but would
```

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