

## Table of Contents

### Preface 9

- Why you should buy this book 9
- What is parametric programming? 10
- A word about CAM systems 10
- Scope 10
  - Versions of Custom Macro 10
  - Machine types 10
  - Prerequisites 11
- Optional status 11
- Lessons structure 11

### Lesson 1 - Introduction to Custom Macro 13

- Objectives 13
- Introduction 13
  - Comparison to sub-programming 13
  - Comparison to canned cycles 14
  - Comparison to computer programming 15
  - All programs can use Custom Macro functions 15
- Application categories 15
  - Part-families 15
    - How are your drawings dimensioned? 16
    - Part-family program structure 17
  - User-created canned cycles 18
  - Utilities 20
    - An automatic tool changer test 20
    - A part counter 20
    - A jaw boring program 20
    - A manual corner pick-up utility 21
  - Complex motions and geometric shapes 21
    - Need more motion types? 22
  - Driving accessory devices 23
- Limitations 23
  - Commonly an option that must be purchased 24
  - Compatibility 24
  - Custom Macro programs must reside in the control 24
  - Execution time for certain commands 24
  - Program preparation time 24
  - Skill required 24
- Introduction to feature types 25
  - Computer-related features (lessons 2-5) 25
    - Variables (lesson 2) 25
    - Arithmetic (lesson 3) 25
    - Logic (lesson 4) 25
    - Looping (lesson 5) 25
  - CNC-related features (lessons 6-7) 25
    - Access to machine position (lesson 6) 25
    - Access to offsets (lesson 6) 25
    - Access to current modes (lesson 6) 25
    - Alarm generation (lesson 6) 26
    - Creation of G-, M-, and T-codes (lesson 7) 26
    - Access to control panel functions (lesson 6) 26
    - Timers (lesson 6) 26

Access to parameters (lesson 2)) 26

Surprised? 26

Key Points for Lesson 1: 26

Quiz 26

### Lesson 2 - Variables 29

- Objectives 29
- Introduction 29
- What are variables? 29
  - Comparison to offsets 29
  - Flexibility of variables 30
  - Comparison to memories in a calculator 30
- Variables types 31
  - Arguments 31
    - Arguments with user created canned cycle applications 31
    - Arguments with part-family applications 34
  - Local variables 36
    - Local variables with argument assignment number one 36
    - Local variables with argument assignment number two 38
    - How do you specify which argument assignment type you are using? 39
    - More on vacancy 39
    - Keeping track of local variables 40
    - Local variables at different program nest levels 40
    - Secondary purpose for local variables: general purpose calculations 41
    - Displaying local variable values 42
  - Common variables 42
    - To minimize redundant calculations 42
    - For general purpose calculations 42
    - As counters 43
    - As flags 43
    - Displaying common variables 43
  - Permanent common variables 43
    - Do you have a touch-probing system? 44
    - Creating your own system constants 44
    - Displaying permanent common variables 45
    - Offsets as variables 45
    - Write-protecting permanent common variables 45
    - Labeling permanent common variables 45
  - System variables 46
- Summary of Custom Macro variables 46
- Key Points for Lesson 2: 46
- Quiz 46

### Lesson 3 - Arithmetic 49

Objectives 49

Introduction 49

Basic functions 49	Testing with multiple logical expressions using AND and OR 79
Combining operations to form an expression 49	Applications for conditional branching 80
Referencing the value of a previously assigned variable 50	Argument flags 80
Referencing a variable's value within its own assigning command 50	To control coolant 80
Advanced arithmetic functions 51	To climb or conventional mill 81
Trigonometry functions 51	More possibilities for argument flags 81
An application 52	Global flags 81
A note about older versions of Custom Macro 53	Argument error trapping 82
Rounding functions 53	Testing mandatory arguments 82
Applications for rounding 54	Testing for erroneous argument settings 84
Other arithmetic functions 55	What about program execution time? 84
Square root 55	Setting default values 84
Absolute value 55	Other kinds of error trapping 85
Power 56	Looping 86
Add decimal point 56	Conditional branching example 86
Natural logarithm and exponent using base e (2.718...) 58	Key Points for Lesson 4: 89
Binary and binary coded decimal conversions 58	Quiz 89
Reading parameter values 58	
What if you do not have a needed arithmetic function? 59	<b>Lesson 5 - Creating Loops 91</b>
Priority of arithmetic operations 59	Objectives 91
Summary of arithmetic capabilities 60	Introduction 91
Basic functions: 60	Steps to looping 91
Advanced functions 60	The IF statement loop explained 93
Example programs 61	The WHILE statement loop explained 93
About program organization 61	Which is better? 93
Milling an outside rectangular shape 61	Getting stuck in a loop 93
A one-plunge grooving cycle 64	Creating multiple loops in a Custom Macro 94
An internal thread milling cycle 66	Nesting Loops 95
Warning about the example programs 68	Solving challenges related to loops 96
Key Points for Lesson 2: 68	When is a loop required? 96
Quiz 69	To minimize commands 96
	When the number of loop repetitions is itself a variable 97
<b>Lesson 4 - Logic and Program Flow Control 71</b>	How many times must the loop be executed? 97
Objectives 71	What else must be initialized and stepped? 99
Introduction 71	Are there any other constants required for the loop? 100
Statement labels 71	Are approach motions required prior to the loop? 100
Unconditional branching 72	What must be done during each loop execution? 100
Unconditional branching versus program execution time 72	Loop examples 102
Applications for unconditional branching 72	Bolt-hole circle example 102
Changing the machining order 73	Multiple-pass grooving example 104
Using optional block skip to exit a program 75	Nesting loops 107
With conditional branching 76	A grid pattern example 107
Conditional branching 76	A taper thread milling Custom Macro program 110
Syntax for conditional branching statements 76	Key Points for Lesson 5: 112
The conditional expression 76	Quiz 113
The universal conditional branching command format 76	
Using THEN for true conditions 78	<b>Lesson 6 - System Variables 115</b>
	Objectives 115
	Introduction 115

Introducing system variables 116	Suppressing feed hold, feed-rate override, and exact stop check 151
Variations in system variable numbering 116	All-in-one system variable 151
Access to tool offsets 116	Separate system variable for each function 151
Machining center tool length and cutter radius compensation offsets 116	Applications 151
The advantage of using the system variable name (instead of its number) 119	For feed hold and feed-rate override 151
Machining center workpiece coordinate system offsets 119	Access to timer and clock (date/time) 152
Turning center wear offsets 120	Timing events with the timers 152
Turning center geometry offsets 121	The beginning of a time-based tool life monitor 152
A trick with system variable numbers 121	Understanding the values for date and time 153
Do you have more offsets? 123	Access to input and output signals 154
Applications for offset access 123	Access to modal information 155
As extra variables 123	Modal G-code access for machining centers 155
Improving upon compensation types 123	An application 156
Adding wear offsets to machining centers that do not have them 124	Modal words for machining centers 156
Automating sizing adjustments during unattended operation 125	For turning centers 157
Transferring wear offsets to geometry offsets after first workpiece inspection 126	Other system variables of note 157
Streamline the testing of machining center offsets 127	A test to confirm system variable numbers and names 157
Simplifying sizing adjustments 128	Null system variable 157
User-created compensation types 129	Other system constants 157
Other ideas? 131	PI (3.14159265358979323846) 157
Access to current position 132	Base of natural logarithm (2.718281828459045235360) 157
Understanding with and without compensation 132	Work shift offsets on turning centers 157
About axis number 133	Access to commonly changed parameters 158
For a three axis machining center 133	Status of mirror image 158
For a two axis turning center: 134	Status during restart of a program 158
Applications for axis position access 134	Total number of parts and number of parts required 158
Assuming initial position in user-created canned cycles 134	Type of tool compensation memory 158
A tool length measuring Custom Macro program (machining centers) 136	Main program number 158
A program zero measuring and assigning Custom Macro program (machining centers) 137	Access to currently instated offset values 158
Access to alarm generation 138	A few more system variables 159
A part counting Custom Macro program 139	Key Points for Lesson 6: 159
A tool life manager with a difference 139	Quiz 159
A pallet changer testing program 142	
Minimizing the time required for error trapping 143	
Using optional block skip 145	
Using a check sum test 146	
Stop with message 148	
Applications for stop with message 149	
Suppressing single block and waiting for auxiliary functions 149	
An application for suppressing single block 150	
An application for not waiting for M-codes 150	
	<b>Lesson 7 - Other Features of Custom Macro 161</b>
	Objectives 161
	Introduction 161
	Protecting important programs 161
	Naming permanent common variables 162
	Notes about SETVN: 162
	Modal calling commands 163
	Modal calling command G66.1 163
	Modal calling command G66 166
	Creating user-defined G-, M-, and T-codes 167
	Creating user-defined G-codes 167
	Creating a series of user-defined G-codes 169
	Creating user-defined M-codes 169
	M-codes allowing letter-address arguments 169
	M-codes not allowing arguments 170
	Creating a series of user-defined M-codes 171

Creating user-defined T-codes 171	Step three - Be sure you have solved all problems related to the application 197
Creating user-defined sub-program calls with other letter-addresses 172	Step four - Write the Custom Macro program 197
Applications for user-defined G-, M-, and T-codes 173	Step five - Error trap potential mistakes 200
Making programs for similar machines more compatible 173	Step six - Eliminate the execution of redundant commands 202
Commanding two or more functions from one M-code 174	Approaching user-created canned cycle applications 205
Improving the automatic tool changer command for machining centers 174	Step one - Determine what your user-created canned cycle must do 206
Error trapping an automatic tool changer obstruction 174	Step two - Consider default values and flags 208
Interfacing an accessory device with input/output system variables (#1000 and #1100 series) 175	Step three - Consider error trapping 208
Changing the function of commands with which you do not agree 175	Step four - Be sure you have solved all of the problems 208
Creating G-codes to make a FANUC control compatible to another control 177	Step five - Write the Custom Macro program 209
Monitoring the tool in the spindle (user-defined T-code application) 178	Approaching complex motions and shapes applications 210
Totaling spindle run time 180	Step one - Solve the arithmetic problems of your application 212
Sending data out through the serial communications port 180	Step two - Determine your arguments 213
Backing up workpiece coordinate system offsets 181	Step three - Write an example calling program 214
The application 181	Step four - Write the Custom Macro program 214
Conclusion to other CNC-related features of Custom Macro 183	Approaching utility applications 215
Understanding argument assignment number two 183	Locate a challenge and come up with a solution 215
Local variable assignments used with argument assignment number two 183	Approaching accessory device applications 217
How does the control know the difference? 184	A spindle touch-probe 217
When to use argument assignment number two 184	Verifying Custom Macro programs 218
A circular cam application 185	Mistakes beginners are prone to making 218
How will the Custom Macro know when to stop? 186	Syntax mistakes 218
Other potential applications for argument assignment number two 187	Simple evaluation mistakes 221
Key Points for Lesson 7: 188	A drastic mistake in your solution to the problem 221
Quiz 188	Key Points for Lesson 8: 221
<b>Lesson 8 - Approaching and Verifying Custom Macro Applications 189</b>	<b>Appendix A - Two Detailed Part-Family Application Examples 223</b>
Objectives 189	Objectives 223
Introduction 189	Introduction 223
Approaching applications 190	Defining ideal part-family applications 223
Approaching part-family applications 190	Why are you handling your part-family application with Custom Macro? 224
Step one - Develop a process that can be used for the entire family 191	Process and workpiece revisions 224
Step two - Choose the required arguments 192	Consistency 224
	Separating process from workpiece definition 225
	Getting the setup person involved with programming 225
	Our example part-family (machining center example) 225
	How will arguments be specified? 227

More on input data 228	Machining programs 262
Use lots of system constants 229	Machining center example using the second type of part definition program 266
Keep track of variables 230	Handling what-ifs 268
Error trap input variables 230	What if the four slots are too deep too completely machine in on pass? 268
Saving program execution time 230	What if some of the workpieces in the family don't have slots? 269
Another suggestion for input variables 233	What if some left hand tools are used? 269
Local versus common variable usage 235	What if some materials used do not allow coolant? 272
What if you're running out of variables? 236	What if some of the raw material comes in the form of solid bar, not tubing? 273
Handling raw material issues 238	Verifying your part-family application 275
Handling cutting tool issues 241	Using machine flags 275
Handling work holding and program zero assignment issues 244	More about error trapping 276
Getting ready to create the machining commands 246	Incorporating current Custom Macro programs in your part-family application 276
Tool startup program 246	Program listings 283
Tool ending program 248	Machining center example using first method of part definition: 283
Machining commands 248	Turning center example: 287
Program organization 251	<b>Appendix B - Introduction to Spindle Touch-Probes 301</b>
Protecting programs 252	Objectives 301
Managing programs 252	Introduction 301
Going from job to job 252	Skip cutting command (G31) 301
Documentation issues: 252	Understanding overshoot and droop 301
A template part definition program 253	Skip-signal position system variables 302
Cutting tool documentation 254	The corner pick-up program revisited 302
Cutting conditions documentation 254	Is it good enough? 303
Work-holding setup and program zero documentation 254	Applications 303
Drawings and instructions 254	A trial machining spindle touch-probing program 304
Turning center example 255	<b>Programming Activities 305</b>
Machining (main) program 255	
The part definition program 256	
The get everything ready program 257	
The system constants program 258	
The error trapping program 258	
Cutting conditions program 259	
Tool station selection program 261	
Clear all common variables program 261	
Tool startup program 262	
Tool ending program 262	

