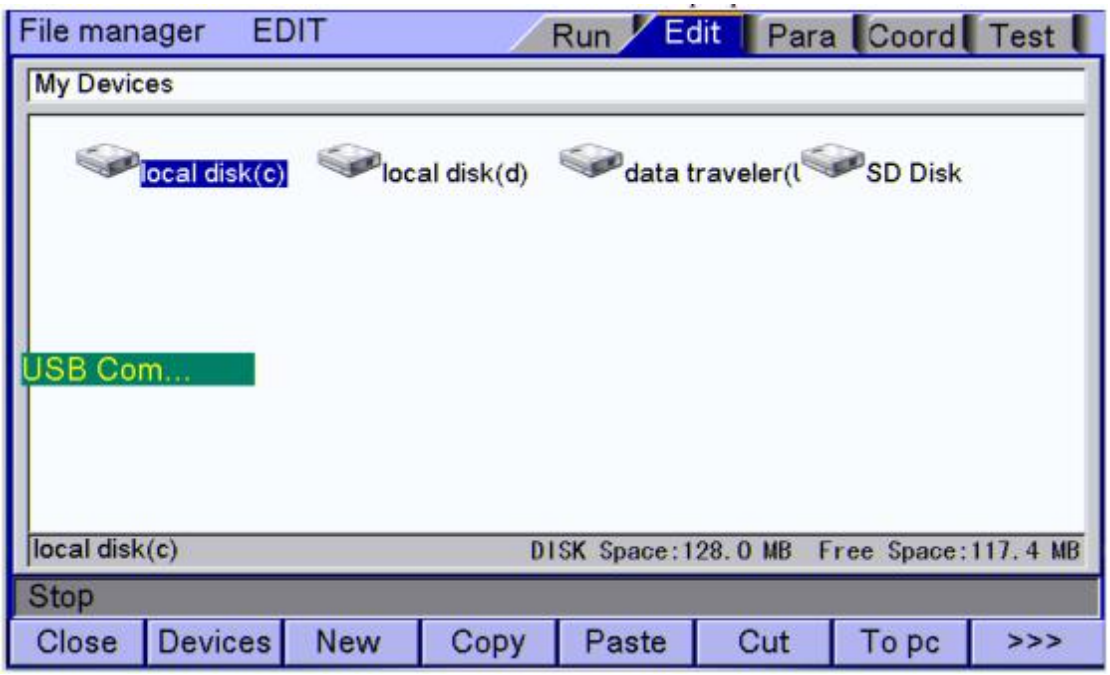
MACRO TRAINING

1) CNC4 Series controller using macro for all logic control .
Customer can easily using macro to edit some input / output signals logic and axis moving
All the I/O like spindle ,coolant , lubricating are all in FUNC.NC file.
Customer can edit and save this file to controller Disk D / MACRO folder and change
Management parameter 023 to User-define , then reboot controller ,it will be working



2) MACRO COMMAND

\+ - * / == != >= <= > <

Basic command

WHILE

DO

IF

GOTO

E.g.: check input signal IN23 within (time 5s) , if get signal will execute next line(Coolant open), if not will alarm

```
O0001
#1=0
WHILE[1]DO1
IF[#1023==0]GOTO1
IF[#1>=5000]
{
#3000=1 (TIME IS OVER!)
}
G4P10
#1=#1+10 (count)
END1
N1
M8
M30
```

User-defined M code

In FUNC.NC File O0068-O0101 can using for user - defined M code

O0068-O0101= M0068 -M0101

E. G.

```
O0068
(备用输出开 OUT32)
#2=1400+32
##2=1
M3000
%
```

This is original code from FUNC.NC File

If we command M68 , OUT32 will Active. Also we can edit some other logic inside

For example , if run M68, OUT32 ON and after 1 second A axis rotating 90° ,after A axis stop , delay 1 second to turn off OUT32

```
O0068
(备用输出开 OUT32)
M89P23L1
G4X1
G91G1A90
G4X1
M89P23L0
M3000
%
```

Read controller status and do some logic

F. g.　　Using F1 Key for OUT23 ON and OFF,　but it can only working in JOG mode.

Original code in FUNC.NC file is this

```
O0055
O0054
(F1 开 OUT19)
#2=1400+19
##2=1
#1848=1
M3000
%
```

So we can change to

```
O0054
(F1 开 OUT19)
IF[#3906==2]
{
#2=1400+19
##2=1
#1848=1
}
M3000
%
```