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On some cnc controls
while programming cnc
programmers have to put
decimal point at the end
of most numeric values
e.g. X100.0 Y10.0 While
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where you will get in-depth knowledge about the language.

10.1. Introduction - Custom Macro B

Custom Macro functionality can be utilized from within any CNC program, including main programs and sub-programs. You do not have to do anything special to use Custom

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Macro functions in a program. Programs can reside in CNC memory or on an external device, like a memory card or flash drive. FANUC controls will interpret CNC commands a bit differently than Custom Macro (arithmetic and logic) commands.

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