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G-Code is not really a full fledged computer language, it 's more a recording of a series of manual steps. That 's useful, but computers and CNC controllers are capable of a lot more. A word about Fanuc Macro B. Fanuc Macro B is by far the most common Macro Programming Dialect. Fanuc Makino Mill Program Manual

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safely removed the tools from the arm, but now I need to send the arm back to home position in order to reset the toolchanger.

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This is a question for the Fanuc Parameter gurus.. On my little Sharp 2412 with Fanuc OMiC I would like to be able to manually remove a tool from the spindle in MDI mode. Right now I have to switch to Jog or Handle.. The Haas lets me do this and it makes loading tools quick. I looked through the Yellow book for a bit but nothing jumped out at me...

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