McLua Work Offsets and Parameters:

Reference: B-63944EN_02.pdf Chapter 16 (Fanuc 31i manual)
Thanks to Tom Lamontagne for the reference manual and how
It is used in Mach4.

local FixOffset = mc.mcCntlGetPoundVar(inst, **4014**)
--Get current fixture offset number
This Parameter as of Mach4 version "2472" returns a decimal number instead of an integer number. So, to make the return value usuable multiple by 10.

G54 = .1
G55 = .2
G56 = .3
G57 = .4
G58 = .5
G59 = .6
G54.1 P1 = .7 -- G54.1 P1 – P120 if using the extended range
G54.1 P2 = .8
and so on
multiply by 10 to make it: 1, 2, 3, 4 etc.

Fixture offsets, G54, 55, 56 etc. have a Gap of 20 between them.
fixture offset values start with G54 at #5221
G54 X = #52**21**
G54 Y = #52**22**
G54 Z = #52**23**
G54 A = #52**24**
G54 B = #52**25**
G54 C = #52**26**
--20 point gap between G54 and G55, i.e. 522x to 524x
G55 X = #52**41**
G55 Y = #52**42**
G55 Z = #52**43**
G55 A = #52**44**
G55 B = #52**45**
G55 C = #52**46**

Fixture offsets, G54.1 P1, G54.1 P2, G54.1 P3 etc. have a Gap of 20 between 6 axis groups.
fixture offset values start with G54.1 P1 starts at #7001

G54.1 P1 X = #7001
G54.1 P1 Y = #7002
G54.1 P1 Z = #7003
G54.1 P1 A = #7004

G54.1 P1 B = #7005
G54.1 P1 C = #7006
--20 point gap between G54.1 P1-6 and G54.1 P7-12
G54.1 P2 X = #7021
G54.1 P2 Y = #7022
G54.1 P2 Z = #7023
G54.1 P2 A = #7024
G54.1 P2 B = #7025
G54.1 P2 C = #7026

So, in the extended range, you can have 120 more groups of 6 axis fixture offsets.

Enjoy,
Scott Shafer