

QUICK REFERENCE FOR PROGRAMMING U.S. AMADA CNC TURRET PUNCH PRESSES

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G01	Establishes coordinate system, tool position
G02	Absolute
G03	Incremental
G04	Punch off
G14	Quick punch off with offset
G15	Pattern origin
G16	Line at angle
G17	I = spacing
G18	J = angle; + or -
G19	K = no. spaces

Arc:

G02	I = radius
G03	J = starting angle; + or -
G04	P = angle increment; + or -
G05	K = no. holes

Slot hole circle

G06	I = radius
G07	J = starting angle; + or -
G08	K = no. holes

Grid X/Y-Z

G09	I = X spacing; + or -
G10	P = no. spaces X
G11	J = Y spacing; + or -
G12	K = no. spaces Y

Slower punch starting

G13	I = slot length
G14	J = angle
G15	P = punch length; + or -
G16	Q = punch width; + or -
G17	R = hole; + or -

No slug window using R

G18	I = Window length in J direction measured from G10 point. Positive value only.
G19	J = Angle measured from R degrees, positive angle only measured CCW from R degrees.
G20	P = Tool length, positive or negative value (the tool dimension in the "Z" direction).
G21	Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
G22	K = Window length perpendicular to "I".
G23	O = Angle of axis index tool, if applicable.
G24	T = Tool station number

Rectangular cut-out

G25	I = hole length X axis; + or -
G26	J = hole length Y axis; + or -
G27	P = punch width X axis
G28	Q = punch width Y axis - optional

Hobbing arc

G29	I = radius
G30	J = starting angle; + or -
G31	K = moving angle; + or -
G32	P = punch, R_x , R_y , or zero
G33	Q = hobbing pitch

Hobbing line

G34	I = length
G35	J = angle
G36	P = punch, R_x , R_y , or zero
G37	Q = hobbing pitch

G⁰² FUNCTIONS

G38	Punching arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = pitch R = material thickness
G39	Punching line I = length J = angle; + or - P = punch, R_x , R_y , or zero Q = pitch R = material thickness
G40	Minor image X...Y...R...Q...
G41	Auto repositioning
G42	Auto repositioning with offset
G43	Circle offset
G44	Drill function
G45	Return home, program end

MISCELLANEOUS FUNCTIONS

M00	Program stop	M15	Tapping rear
M01	Optional stop	M20	Work chute open
M02	Program end	M21	Work chute closed
M03	Punch delay effective	M22	Slug selector left
M04	Punch delay finish	M23	Slug selector right
M12	Hobbing start	M24	P-subprogram call
M13	Hobbing stop	M25	Subprogram end
M14	Tapping front	M26	"Cross" = punch speed char
M1	Single block storage	P	Feed rate control
M2	Single block recall	Z	Block delete

MULTIPLE PART PROGRAMMING

G46	Multiple part layout X...Y...I...J...P...K...
G47	X = reference point for lower left hand part in X axis
G48	Y = reference point for lower left hand part in Y axis
G49	I = distance between reference points in X direction (note: add slotting tool width)
G50	J = distance between reference points in Y direction (note: add slotting tool width)
G51	P = number of parts in the X axis - excluding the bottom left part
G52	K = number of parts in the Y axis - excluding the bottom left part (Example: G46X100Y100I100J100P10K2)

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

G53	Execution of punching in horizontal direction (X direction).
G54	Execution of punching in vertical direction (Y direction).

MACROS = LRV

LC-1C	Multiple block store	1-58	Processes while store
LC	Multiple block recall	60-69	Display only
	Parameter M13 setting	90-99	Multiple block store

T	Prepares which do not use software for multiple product punching.
Z	Trial punching with programs using software for multiple product punching.
R	Resuming punch work after trial punching.
M	Enter punch work of multiple product punching.



G Codes For Turret

J Rink



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Table of Contents G Codes For Turret

1. Understanding the eBook G Codes For Turret
 - The Rise of Digital Reading G Codes For Turret
 - Advantages of eBooks Over Traditional Books
2. Identifying G Codes For Turret
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an G Codes For Turret
 - User-Friendly Interface
4. Exploring eBook Recommendations from G Codes For Turret
 - Personalized Recommendations
 - G Codes For Turret User Reviews and Ratings
 - G Codes For Turret and Bestseller Lists
5. Accessing G Codes For Turret Free and Paid eBooks
 - G Codes For Turret Public Domain eBooks
 - G Codes For Turret eBook Subscription Services
 - G Codes For Turret Budget-Friendly Options
6. Navigating G Codes For Turret eBook Formats

- ePub, PDF, MOBI, and More
- G Codes For Turret Compatibility with Devices
- G Codes For Turret Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of G Codes For Turret
 - Highlighting and Note-Taking G Codes For Turret
 - Interactive Elements G Codes For Turret
- 8. Staying Engaged with G Codes For Turret
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers G Codes For Turret
- 9. Balancing eBooks and Physical Books G Codes For Turret
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection G Codes For Turret
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine G Codes For Turret
 - Setting Reading Goals G Codes For Turret
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of G Codes For Turret
 - Fact-Checking eBook Content of G Codes For Turret
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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