

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

G⁰¹ FUNCTIONS

G01 Incremental selection
Establishes coordinate system, tool position

G00 Absolute

G01 Incremental

G02 Punch off

G03 Data punch off with offset

G04 Pattern origin

G05 Line at angle
I = spacing
J = angle; + or -
K = no. spaces

Arc:

I = radius
J = starting angle; + or -
K = angle increment; + or -
L = no. holes

G06 Slot hole circle
I = radius
J = starting angle; + or -
K = no. holes

G07 Slot R/Side Y
I = R spacing; + or -
P = no. spaces X
J = Y spacing; + or -
K = no. spaces Y

G08 Slant punch starting
I = slot length
J = angle
P = punch length; + or - } Must be
Q = punch width; + or - } same sign
R = tab; + or -

G09 No slug window using R
I = Window length in J direction measured from G10 point. Positive value only.
J = Angle measured from R degrees, positive angle only measured CCW from R degrees.
P = Tool length, positive or negative value (the tool dimension in the "Z" direction).
Q = Tool width, positive or negative value (the tool dimension in the "X" direction).
R = Window length perpendicular to "Y".
C = Angle of auto loader tool, if applicable.
T = Tool station number

G10 Rectangular cut-out
I = hole length X axis; + or -
J = hole length Y axis; + or -
P = punch width Z axis
Q = punch width R axis - optional

G11 Notching arc
I = radius
J = starting angle; + or -
K = ending angle; + or -
P = punch; R, Y, or zero
Q = notching punch

G12 Notching line
I = length
J = angle
P = punch; R, Y, or zero
Q = notching punch

G⁰² FUNCTIONS

G02 Punching arc
I = radius
J = starting angle; + or -
K = ending angle; + or -
P = punch; R, Y, or zero
Q = pitch
R = material thickness

G03 Punching line
I = length
J = angle; + or -
P = punch; R, Y, or zero
Q = pitch
R = material thickness

G04 Mirror image X... Y... R... Q...

G05 Auto repositioning

G06 Auto repositioning with offset

G07 Offset offset

G08 Drill function

G09 Return home, program end

MISCELLANEOUS FUNCTIONS

M00 Program stop	M15 Tapping rear
M01 Optional stop	M80 Work chute open
M02 Program end	M81 Work chute closed
M03 Punch delay effective	M82 Slug selector left
M04 Punch delay break	M83 Slug selector right
M10 Feeding start	M88 Pre-subprogram call
M15 Feeding stop	M87 Subprogram end
M16 Tapping front	M99 "Gense" a punch speed char
M1 Single block storage	P Feed rate control
M2 Single block recall	Z Block delete

MULTIPLE PART PROGRAMMING

G00 Multiple part layout
X... Y... Z... J... P... R...
X = reference point for lower left hand part in X axis
Y = reference point for lower left hand part in Y axis
Z = distance between reference points in Z direction (note: add slotting tool width)
J = distance between reference points in Y direction (note: add slotting tool width)
P = number of parts in the X axis - excluding the bottom left part
R = number of parts in the Y axis - excluding the bottom left part
Example: G001000Y000Z100000000P1000

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

G08 Execution of punching in horizontal direction (X direction).
G09 Execution of punching in vertical direction (Z direction).

MACROS = LRV

L000 Multiple block store	0-99	Processes while store
L01 Multiple block recall	00-99	Digits only
Parameter 000 setting	00-99	Multiple block store

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

G Codes For Turret

Kuang-Hua Chang



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