

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

G⁰¹ FUNCTIONS

G21	Intermetric selection Establishes coordinate system, tool position
G22	Absolute
G23	Incremental
G24	Punch off
G25	Auto punch off with offset
G26	Pattern origin
G27	Line at angle
G28	I = spacing J = angle; + or - K = no. spaces
G29	Arc I = radius J = starting angle; + or - P = angle increment; + or - K = no. holes
G30	Slot hole circle I = radius J = starting angle; + or - K = no. holes
G31	Grid X-Y-Z I = X spacing; + or - P = no. spaces X J = Y spacing; + or - K = no. spaces Y
G32	Slower punch starting I = slot length J = angle P = punch length; + or - Q = punch width; + or - R = slot; + or -
G33	No slug window using R I = Window length in J direction measured from G29 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 "J" direction). Q = Tool width, positive or negative value (the tool dimension in the "R" direction). K = Window length perpendicular to "I". L = Angle of axis index tool, if applicable. T = Tool station number
G34	Rectangular cut-out I = hole length X axis; + or - J = hole length Y axis; + or - P = punch width X axis Q = punch width Y axis - optional
G35	Hobbing arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = hobbing pitch
G36	Hobbing line I = length J = angle P = punch, R_x , R_y , or zero Q = hobbing pitch

G⁰² FUNCTIONS

G37	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
G38	Punching line I = length J = angle; + or - P = punch, R_x , R_y , or zero Q = pitch R = material thickness
G39	Minor image X...Y...R...Q...
G40	Auto repositioning
G41	Auto repositioning with offset
G42	Circle offset
G43	Drill function
G44	Return home, program end
G45	Program stop
G46	Optional stop
G47	Program end
G48	Punch delay effective
G49	Punch delay finish
G50	Hobbing start
G51	Hobbing stop
G52	Tapping start
G53	Single block storage
G54	Single block recall

MISCELLANEOUS FUNCTIONS

M01	Program stop
M02	Optional stop
M03	Program end
M04	Punch delay effective
M05	Punch delay finish
M06	Hobbing start
M07	Hobbing stop
M08	Tapping start
M09	Single block storage
M10	Single block recall
M11	Tapping rear
M12	Work chute open
M13	Work chute closed
M14	Slug selector left
M15	Slug selector right
M16	P-subprogram call
M17	Subprogram end
M18	"Cross" = punch speed char
M19	Feed rate control
M20	Block delete

MULTIPLE PART PROGRAMMING

G40	Multiple part layout X...Y...I...J...P...K... X = reference point for lower left hand part in X axis Y = reference point for lower left hand part in Y axis I = distance between reference points in X 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 K = number of parts in the Y axis - excluding the bottom left part (Example: G28X100Y100I100J100P10K2)
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PUNCHING EXECUTION OF G38 MULTIPLE PARTS

G38	Execution of punching in horizontal direction (X direction).
G39	Execution of punching in vertical direction (Y direction).

MACROS = LRV

LRV	Multiple block store	0-99	Processes while start
LR	Multiple block recall	00-99	Display only
	Parameter M13 setting	90-99	Multiple macro store

T	Prepares which do not use software for multiple product punching.
T	Try punching with program using software for multiple product punching.
T	Resuming punch work after trial punching.
T	Enter punch work of multiple product punching.

G Codes For Turret

Kuang-Hua Chang



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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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