

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

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G00	Establishes coordinate system, tool position
G01	Absolute
G01	Incremental
G02	Punch off
G04	Delay punch off with offset
G04	Pattern origin
G05	Line at angle
	I = spacing
	J = angle; + or -
	K = no. spaces
G06	Arc
	I = radius
	J = starting angle; + or -
	P = angle increment; + or -
	K = no. holes
G08	Slot hole circle
	I = radius
	J = starting angle; + or -
	K = no. holes
G09	Grid X/Y-Z
	I = X spacing; + or -
	P = no. spaces X
	J = Y spacing; + or -
	K = no. spaces Y
G10	Linear punch starting
	I = slot length
	J = angle
	P = punch length; + or -
	Q = punch width; + or -
	R = slot; + or -
G11	No slot 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 "I" direction).
	Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
	K = Window length perpendicular to "I".
	O = Angle of axis index tool, if applicable.
	T = Tool station number
G12	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
G13	Hobbing arc
	I = radius
	J = starting angle; + or -
	K = moving angle; + or -
	P = punch, θ_1 , θ_2 or zero
	Q = hobbing pitch
G14	Hobbing line
	I = length
	J = angle
	P = punch, θ_1 , θ_2 or zero
	Q = hobbing pitch

G⁰² FUNCTIONS

G02	Punching arc
	I = radius
	J = starting angle; + or -
	K = moving angle; + or -
	P = punch, θ_1 , θ_2 or zero
	Q = pitch
	R = material thickness
G03	Punching line
	I = length
	J = angle; + or -
	P = punch, θ_1 , θ_2 or zero
	Q = pitch
	R = material thickness
G04	Minor image X...Y...R...Q...
G05	Auto repositioning
G06	Auto repositioning with offset
G07	Circle offset
G08	Drill function
G09	Return home, program end
M00	Program stop
M01	Optional stop
M02	Program end
M03	Punch delay effective
M04	Punch delay finish
M10	Hobbing start
M11	Hobbing stop
M12	Tapping start
M13	Single block storage
M14	Single block recall
M15	Tapping rear
M16	Work chute open
M17	Work chute closed
M18	Slug selector left
M19	Slug selector right
M20	P-subprogram call
M21	Subprogram end
M22	"Cross" = punch speed char
M23	Feed rate control
M24	Block delete

MISCELLANEOUS FUNCTIONS

M00	Program stop
M01	Optional stop
M02	Program end
M03	Punch delay effective
M04	Punch delay finish
M10	Hobbing start
M11	Hobbing stop
M12	Tapping start
M13	Single block storage
M14	Single block recall
M15	Tapping rear
M16	Work chute open
M17	Work chute closed
M18	Slug selector left
M19	Slug selector right
M20	P-subprogram call
M21	Subprogram end
M22	"Cross" = punch speed char
M23	Feed rate control
M24	Block delete

MULTIPLE PART PROGRAMMING

G00	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: G001000Y000I1000J000P0K2)

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

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

MACROS = L/V

L/V	Multiple block store	0-99	Processes while store
R	Multiple block recall	00-99	Display only
	Parameter M13 setting	90-99	Multiple block store

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



G Codes For Turret

LM Reder



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CNC Programming Handbook Peter Smid, 2003 Comes with a CD ROM packed with a variety of problem solving projects

GUIDE TO CNC LATHE MACHINE: PROGRAMMING EXAMPLES Tran A, 2024-10-01 This comprehensive guide unlocks the power of CNC lathe machines Learn essential G code commands optimize toolpaths and troubleshoot common errors Clear explanations real world examples and step by step instructions make this book perfect for both beginners and experienced machinists

Operator Advanced Machine Tool (Theory) - II Mr. Rohit Manglik, 2024-05-18 EduGorilla Publication is a trusted name in the education sector committed to empowering learners with high quality study materials and resources Specializing in competitive exams and academic support EduGorilla provides comprehensive and well structured content tailored to meet the needs of students across various streams and levels

The Code of Federal Regulations of the United States of America, 2004 The Code of Federal Regulations is the codification of the general and permanent rules published in the Federal Register by the executive departments and agencies of the Federal Government

Code of Federal Regulations, 2001 Special edition of the Federal Register containing a codification of documents of general applicability and future effect with ancillaries

The engineering telegraph code, by A.H. Blackburn and J. Stevens. The code words complying with the Telegraph convention rules, by G. Ager Arthur Henry Blackburn, 1892

German Light Cruisers 1939-45 Gordon Williamson, 2012-04-20 The German Navy of World War II was small in number but contained some of the most technologically advanced capital ships in the world This meant that although the Kriegsmarine never felt capable of encountering the might of the British Navy in a fleet action her ships were individually more than a match for the outdated vessels of the Royal Navy Nowhere was this more the case than in Germany's fleet of light cruisers There were only six vessels in this fleet the Emden Leipzig K In K nigsberg Karlsruhe and Nurnberg This book describes their design development and varied operational history throughout the course of the Second World War

Skill Based Automated Production Peter Kopacek, R. Genser, 1990-10-31 This volume will be of interest to all those who are involved in the development and integration of systems into the manufacturing and industrial process It draws together theoretical situations as well as many practical examples of systems which are currently in use in industry including computer integrated manufacturing CIM and flexible manufacturing systems FMS

Cad/cam and Automation , Air Force Manual United States. Department of the Air Force, 1973

Directory of Metalworking Machinery United States. Munitions Board. Cataloging Agency, 1956

Virtual Machining Using CAMWorks 2021 Kuang-Hua Chang, 2021-07 Teaches you how to prevent problems reduce manufacturing costs shorten production time and improve estimating Designed for users new to CAMWorks with basic knowledge of manufacturing processes Covers the core concepts and most frequently used commands in CAMWorks Incorporates cutter location data verification by reviewing the generated G codes This book is written to help you learn the core concepts and steps used to conduct virtual machining using CAMWorks CAMWorks is a

virtual machining tool designed to increase your productivity and efficiency by simulating machining operations on a computer before creating a physical product CAMWorks is embedded in SOLIDWORKS as a fully integrated module CAMWorks provides excellent capabilities for machining simulations in a virtual environment Capabilities in CAMWorks allow you to select CNC machines and tools extract or create machinable features define machining operations and simulate and visualize machining toolpaths In addition the machining time estimated in CAMWorks provides an important piece of information for estimating product manufacturing cost without physically manufacturing the product The book covers the basic concepts and frequently used commands and options you ll need to know to advance from a novice to an intermediate level CAMWorks user Basic concepts and commands introduced include extracting machinable features such as 2 5 axis features selecting machine and tools defining machining parameters such as feed rate generating and simulating toolpaths and post processing CL data to output G codes for support of CNC machining The concepts and commands are introduced in a tutorial style presentation using simple but realistic examples Both milling and turning operations are included One of the unique features of this book is the incorporation of the CL cutter location data verification by reviewing the G codes generated from the toolpaths This helps you understand how the G codes are generated by using the respective post processors which is an important step and an ultimate way to confirm that the toolpaths and G codes generated are accurate and useful This book is intentionally kept simple It primarily serves the purpose of helping you become familiar with CAMWorks in conducting virtual machining for practical applications This is not a reference manual of CAMWorks You may not find everything you need in this book for learning CAMWorks But this book provides you with basic concepts and steps in using the software as well as discussions on the G codes generated After going over this book you will develop a clear understanding in using CAMWorks for virtual machining simulations and should be able to apply the knowledge and skills acquired to carry out machining assignments and bring machining consideration into product design in general Who this book is for This book should serve well for self learners A self learner should have a basic physics and mathematics background We assume that you are familiar with basic manufacturing processes especially milling and turning In addition we assume you are familiar with G codes A self learner should be able to complete the ten lessons of this book in about forty hours This book also serves well for class instructions Most likely it will be used as a supplemental reference for courses like CNC Machining Design and Manufacturing Computer Aided Manufacturing or Computer Integrated Manufacturing This book should cover four to five weeks of class instructions depending on the course arrangement and the technical background of the students What is virtual machining Virtual machining is the use of simulation based technology in particular computer aided manufacturing CAM software to aid engineers in defining simulating and visualizing machining operations for parts or assembly in a computer or virtual environment By using virtual machining the machining process can be defined and verified early in the product design stage Some if not all of the less desirable design features in the context of part manufacturing

such as deep pockets holes or fillets of different sizes or cutting on multiple sides can be detected and addressed while the product design is still being finalized In addition machining related problems such as undesirable surface finish surface gouging and tool or tool holder colliding with stock or fixtures can be identified and eliminated before mounting a stock on a CNC machine at shop floor In addition manufacturing cost which constitutes a significant portion of the product cost can be estimated using the machining time estimated in the virtual machining simulation Virtual machining allows engineers to conduct machining process planning generate machining toolpaths visualize and simulate machining operations and estimate machining time Moreover the toolpaths generated can be converted into NC codes to machine functional parts as well as die or mold for part production In most cases the toolpath is generated in a so called CL data format and then converted to G codes using respective post processors

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Aero-optics Code Development Scott E. Sherer, 2009 [Virtual Machining Using CAMWorks 2023](#) Kuang-Hua Chang, 2023-08 Teaches you how to prevent problems reduce manufacturing costs shorten production time and improve estimating Designed for users new to CAMWorks with basic knowledge of manufacturing processes Covers the core concepts and most frequently used commands in CAMWorks Incorporates cutter location data verification by reviewing the generated G codes This book is written to help you learn the core concepts and steps used to conduct virtual machining using CAMWorks CAMWorks is a virtual machining tool designed to increase your productivity and efficiency by simulating machining operations on a computer before creating a physical product CAMWorks is embedded in SOLIDWORKS as a fully integrated module CAMWorks provides excellent capabilities for machining simulations in a virtual environment Capabilities in CAMWorks allow you to select CNC machines and tools extract or create machinable features define machining operations and simulate and visualize machining toolpaths In addition the machining time estimated in CAMWorks provides an important piece of information for estimating product manufacturing cost without physically manufacturing the product The book covers the basic concepts and frequently used commands and options you'll need to know to advance from a novice to an intermediate level CAMWorks user Basic concepts and commands introduced include extracting machinable features such as 2 5 axis features selecting machine and tools defining machining parameters such as feed rate generating and simulating toolpaths and post processing CL data to output G codes for support of CNC machining The concepts and commands are introduced in a tutorial style presentation using simple but realistic examples Both milling and turning operations are included One of the unique features of this book is the incorporation of the CL cutter location data verification by reviewing the G codes generated from the toolpaths This helps you understand how the G codes are generated by using the respective post processors which is an important step and an ultimate way to confirm that the

toolpaths and G codes generated are accurate and useful This book is intentionally kept simple It primarily serves the purpose of helping you become familiar with CAMWorks in conducting virtual machining for practical applications This is not a reference manual of CAMWorks You may not find everything you need in this book for learning CAMWorks But this book provides you with basic concepts and steps in using the software as well as discussions on the G codes generated After going over this book you will develop a clear understanding in using CAMWorks for virtual machining simulations and should be able to apply the knowledge and skills acquired to carry out machining assignments and bring machining consideration into product design in general Who this book is for This book should serve well for self learners A self learner should have a basic physics and mathematics background We assume that you are familiar with basic manufacturing processes especially milling and turning In addition we assume you are familiar with G codes A self learner should be able to complete the ten lessons of this book in about forty hours This book also serves well for class instructions Most likely it will be used as a supplemental reference for courses like CNC Machining Design and Manufacturing Computer Aided Manufacturing or Computer Integrated Manufacturing This book should cover four to five weeks of class instructions depending on the course arrangement and the technical background of the students

Official Gazette of the United States Patent Office United States. Patent Office,1904 Catalogue ,1900 Programming of Computer Numerically Controlled Machines Kenneth W. Evans,John Polywka,Stanley Gabrel,2001 Provides descriptions of many operation and programming functions and their practical application to turning and milling machines End of chapter study questions make the book suitable for use as a textbook The second edition adds two chapters on CAD CAM and conversational programming Annotation c Book News Inc Portland OR booknews com

Virtual Machining Using CAMWorks 2020 Kuang-Hua Chang,2020-07-16 This book is written to help you learn the core concepts and steps used to conduct virtual machining using CAMWorks CAMWorks is a virtual machining tool designed to increase your productivity and efficiency by simulating machining operations on a computer before creating a physical product CAMWorks is embedded in SOLIDWORKS as a fully integrated module CAMWorks provides excellent capabilities for machining simulations in a virtual environment Capabilities in CAMWorks allow you to select CNC machines and tools extract or create machinable features define machining operations and simulate and visualize machining toolpaths In addition the machining time estimated in CAMWorks provides an important piece of information for estimating product manufacturing cost without physically manufacturing the product The book covers the basic concepts and frequently used commands and options you ll need to know to advance from a novice to an intermediate level CAMWorks user Basic concepts and commands introduced include extracting machinable features such as 2 5 axis features selecting machine and tools defining machining parameters such as feed rate generating and simulating toolpaths and post processing CL data to output G codes for support of CNC machining The concepts and commands are introduced in a tutorial style presentation using simple but realistic examples Both milling and turning operations are included One of the

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web complete any calculations on the data table answer all lab questions on the lab do the following if the total time for onion root tip cell cycle is 1 440 minutes determine the amount of time each cell spends in prophase metaphase anaphase and telophase using the data from the data table how much time is spent in m phase and interphase

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web to find time minutes in this lab you can base your calculation on a total cell cycle of 24 hours of those 24 hours it takes about 80 minutes to go through mitosis calculate the actual time for each mitotic phase by taking your percentage of the phase and dividing it by 100 and then multiplying that by 80 minutes record your data in table 1

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web introduction mitosis is considered nuclear division since its main stages deal strictly with the nucleus and its contents dna mitosis consists of 4 major stages prophase metaphase anaphase and telophase mitosis is part of a larger process called the cell cycle when a living organism needs new cells to repair damage grow or just

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web chromatin condenses into visible chromosomes the mitotic spindle also forms from microtubules the nucleolus disappears and the nuclear membrane breaks down name the stages of mitosis from longest to shortest duration interphase prophase telophase metaphase and anaphase how does the timing of the complete cell cycle differ in

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web movement through mitosis cell cycle division mitosis beads diagram prophase during this phase the chromatids and the set of replicated chromosomes are lines up beside each other horizontally the sister chromatids have 20 beads each 5 beads on each of the four strands the replicated chromosomes had 12 beads each 3 beads on each

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web mitosis consists of four basic phases prophase metaphase anaphase and telophase some textbooks list five breaking prophase into an early phase called prophase and a late phase called prometaphase these phases occur in strict sequential order and cytokinesis the process of dividing the cell contents to make two new cells starts

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web mitosis introduction in this lab you will examine the dividing root tip cells of an onion you will examine the specimen to identify the various phases of the cell cycle to see which phases cells spend more time in and you will answer related analysis questions to further your understanding of the eukaryotic cell cycle pre lab

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web during this phase chromosomes line up in the middle mitosis worksheet the diagram below shows six cells in various phases of the cell cycle note the cells are not arranged in the order in which mitosis occurs and one of the phases of mitosis occurs twice use the diagram to answer questions 1 7 1 cells a and d show an early and a late stage

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web hands on lab activity 1 2 days in this lab students investigate if all phases of mitosis require the same amount of time for completion students respond to this research question by counting the number of onion root tip cells in the four phases of

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web pre lab questions 1 provide the correct order for the stages of mitosis interphase prophase metaphase anaphase
telophase 2 why are root tips excellent observation points for mitosis answers will vary sample answer the root tip of a plant
contains actively dividing cells making root tips excellent observation points for mitosis

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web table 1 mitosis predictions predictions my prediction is that interphase will take the longest time of the cell cycle for
approximately 20 hours and mitotic phase will take 4 hours supporting evidence my supporting evidence for this claim is that
interphase is the longest phase and can take up to 18 20 hours

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web 68 minutes how do cancer cells differ in total time required for mitosis cancer cells produce 117 minutes faster than
regular cells how do cancer cells differ from normal cells in time spent for each phase normal cells require 640 minutes
during interphase cancer cells only need 380 for prophase cancerous cells need 15 minutes less than

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web introduction every somatic cell undergoes a phase called mitosis mitosis is the division of the nucleus time for mitosis
lab 16 answer key time for metaphase 109 980 720 minutes 80 minutes time for mitosis lab 16 answer keydata table for
example if there were 8 percent of the cells

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