

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

G10 Punch off

G14 Data punch off with offset

G15 Pattern origin

G16 Line at angle

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

Arc:

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

Slot hole circle

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

Grid X/Y-Z

I = X spacing; + or -
P = no. spaces X
J = Y spacing; + or -
K = no. spaces Y

Slower punch starting

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

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 "I" direction).
Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
R = Window length perpendicular to "I".
S = Angle of axis index tool, if applicable.
T = Tool station number

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

Hobbing arc

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

Hobbing line

I = length
J = angle
P = punch, R_x , R_y , or zero
Q = hobbing pitch

G⁰² FUNCTIONS

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

Punching line

I = length
J = angle; + or -
P = punch, R_x , R_y , or zero
Q = pitch
R = material thickness

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

Auto repositioning
Auto repositioning with offset
Circle offset
Drill function
Return home, program end

MISCELLANEOUS FUNCTIONS

M01 Program stop	M15 Tapping rear
M02 Optional stop	M80 Work chute open
M03 Program end	M81 Work chute closed
M04 Punch delay effective	M82 Slug selector left
M05 Punch delay finish	M83 Slug selector right
M12 Hobbing start	M88 P-subprogram call
M13 Hobbing stop	M87 Subprogram end
M14 Tapping front	M90 "Cross" = punch speed char
A1 Single block storage	P Feed rate control
R1 Single block recall	Z Block delete

MULTIPLE PART PROGRAMMING

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: G001000Y000100000000P0K2)

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

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

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



G Codes For Turret

Yijin Wang

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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