

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 J = slot length J = angle P = punch length; + or - Q = punch width; + or - Q = 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". Q = Angle of axis under 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 Q = material thickness
G38	Punching line I = length J = angle; + or - P = punch, R_x , R_y , or zero Q = pitch Q = 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

M10	Program stop
M11	Optional stop
M12	Program end
M13	Punch delay effective
M14	Punch delay finish
M15	Hobbing start
M16	Hobbing stop
M17	Tapping start
M18	Single block storage
M19	Single block recall
M20	Tapping rear
M21	Work chute open
M22	Work chute closed
M23	Slug selector left
M24	Slug selector right
M25	P-subprogram call
M26	Subprogram end
M27	"Cross" = punch speed char
M28	Feed rate control
M29	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 block 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.



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Kuang-Hua Chang



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