

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

G⁰¹ FUNCTIONS

G21	Intermetric selection Establishes coordinate system, tool position
G20	Absolute
G91	Incremental
G10	Punch off
G14	Auto punch off with offset
G15	Pattern origin
G16	Line at angle
G17	I = spacing J = angle; + or - K = no. spaces
G18	Arc I = radius J = starting angle; + or - P = angle increment; + or - K = no. holes
G19	Slot hole circle I = radius J = starting angle; + or - K = no. holes
G20/G21	Grid X/Y-Z I = X spacing; + or - P = no. spaces X J = Y spacing; + or - K = no. spaces Y
G22	Slower punch starting I = slot length J = angle P = punch length; + or - Must be Q = punch width; + or - same sign Q = hole; + or -
G23	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 "J" direction) Q = Tool width, positive or negative value (the tool dimension in the "R" direction) K = Window length perpendicular to "I" T = Angle of axis index tool, if applicable V = Tool station number
G24	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
G25	Hobbing arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = hobbing pitch
G26	Hobbing line I = length J = angle P = punch, R_x , R_y , or zero Q = hobbing pitch

G⁰² FUNCTIONS

G28	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
G29	Punching line I = length J = angle; + or - P = punch, R_x , R_y , or zero Q = pitch Q = material thickness
G30	Minor image X...Y...R...Q...
G31	Auto repositioning
G32	Auto repositioning with offset
G33	Circle offset
G34	Drill function
G35	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

G28	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 G28 MULTIPLE PARTS

G28	Execution of punching in horizontal direction (X direction).
G29	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	Trial punching with programs using software for multiple product punching.
R	Resuming punch work after trial punching.
L	Enter punch work of multiple product punching.



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Business Marketing ,1990 **American Machinist** ,1981 Portal 106 Georgina Fatseas,2019-06-10 The galaxies of Oberon and Amada have been at peace for over a thousand years but now their civilization has come under threat by an aggressive race of humanoid lizards the Lacertians The people of Oberon and Amada look to Prince Alcyn a figurehead leader who is more interested in research into the use of neutrino travel technology than the complexities of politics to save the two galaxies Jed Lawson owns a horse stud in South East Queensland Australia He is accidently sucked up through Alcyn s neutrino viewer in portal 106 Alcyn appeals to Jed and ultimately to Earth to assist him to save the people of the two galaxies who have lost their ability to fight Realizing the two galaxies can never win against their enemies the planets begin mass evacuations Alcyn carries the burden of the beginnings of the war into space by attacking mother ships and as a result the Lacertians place a bounty on his head Not all the readers questions will be answered in this book Some are answered in the sequel the Pleiadean Experiment Index of Patents Issued from the United States Patent and Trademark Office ,1988

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