

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

G<sup>01</sup> FUNCTIONS

<b>G21</b>	Intermetric selection Establishes coordinate system, tool position
<b>G20</b>	Absolute
<b>G91</b>	Incremental
<b>G10</b>	Punch off
<b>G14</b>	Auto punch off with offset
<b>G15</b>	Pattern origin
<b>G16</b>	Line at angle
<b>G17</b>	I = spacing J = angle; + or - K = no. spaces
<b>G18</b>	Arc I = radius J = starting angle; + or - P = angle increment; + or - K = no. holes
<b>G19</b>	Slot hole circle I = radius J = starting angle; + or - K = no. holes
<b>G20/G21</b>	Grid X/Y-Z I = X spacing; + or - P = no. spaces X J = Y spacing; + or - K = no. spaces Y
<b>G22</b>	Slower punch starting I = slot length J = angle P = punch length; + or - Must be Q = punch width; + or - same sign Q = hole; + or -
<b>G23</b>	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
<b>G24</b>	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
<b>G25</b>	Hobbing arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, $R_x$ , $R_y$ , or zero Q = hobbing pitch
<b>G26</b>	Hobbing line I = length J = angle P = punch, $R_x$ , $R_y$ , or zero Q = hobbing pitch

G<sup>02</sup> FUNCTIONS

<b>G28</b>	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
<b>G29</b>	Punching line I = length J = angle; + or - P = punch, $R_x$ , $R_y$ , or zero Q = pitch Q = material thickness
<b>G30</b>	Minor image X...Y...R...Q...
<b>G31</b>	Auto repositioning
<b>G32</b>	Auto repositioning with offset
<b>G33</b>	Circle offset
<b>G34</b>	Drill function
<b>G35</b>	Return home, program end
<b>M00</b>	Program stop
<b>M01</b>	Optional stop
<b>M02</b>	Program end
<b>M03</b>	Punch delay effective
<b>M04</b>	Punch delay finish
<b>M10</b>	Hobbing start
<b>M11</b>	Hobbing stop
<b>M12</b>	Tapping start
<b>M13</b>	Single block storage
<b>M14</b>	Single block recall
<b>M15</b>	Tapping rear
<b>M16</b>	Work chute open
<b>M17</b>	Work chute closed
<b>M18</b>	Slug selector left
<b>M19</b>	Slug selector right
<b>M20</b>	P-subprogram call
<b>M21</b>	Subprogram end
<b>M22</b>	"Cross" = punch speed char
<b>M23</b>	Feed rate control
<b>M24</b>	Block delete

## MISCELLANEOUS FUNCTIONS

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

## MULTIPLE PART PROGRAMMING

<b>G28</b>	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

<b>G28</b>	Execution of punching in horizontal direction (X direction).
<b>G29</b>	Execution of punching in vertical direction (Y direction).

## MACROS = L/V

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

<b>T</b>	Prepares which do not use software for multiple product punching.
<b>P</b>	Trial punching with programs using software for multiple product punching.
<b>R</b>	Resuming punch work after trial punching.
<b>L</b>	Enter punch work of multiple product punching.



# M Codes For Amada Laser

**Surplus Record**



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**Operation, Maintenance, and Repair of Land-Based Gas Turbines** Hiyam Farhat,2021-06-16 Operation Maintenance and Repair of Land Based Gas Turbines provides a toolkit for practitioners seeking to make technoeconomic decisions on life extension of power turbine equipment The work describes essential degradation modes affecting critical components and proven methods of restoration Sections discuss key elements of life extensions for aging units and components together with critical reviews of available methodologies Coverage includes advanced nondestructive testing methods essential for effective life extension programs including lessons learned from firsthand experience working with multiple machine designs classes and operating conditions The final sections cover a body of solutions intended to refocus ORM processes on overcoming the shortfalls caused by volatilities and system restructuring Reviews best practices for practitioners seeking to make decisions on gas turbine maintenance repair and operations Analyzes components and major sections in terms of functionality critical features residual properties and service caused damages Explains the applicability and limitations of special processes and advanced non destructive testing methods     **Index of Patents Issued from the United States Patent Office** United States. Patent Office,1970     **Machinery Buyers' Guide** ,2002

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- Chapter 5: Conclusion

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