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

─── G** FUNCTIONS ───

G92(?) Inch-metric selection
Establishes co-ordinate system, tool position

G90 Absolute

G91 Incremental

G70 Punch off

G74 Gala punch off with offset

G72 Pattern origin

G26 Line at angle
I = spacing
J = angle; + or −
K = no. spaces

G22 Arc
I = radius
J = starting angle; + or −
P = angle increment; + or −
K = no. holes

G24 Bolt hole circle
I = radius
J = starting angle; + or −
K = no. holes

G26/G27 Grid X-field Y
I = X spacing; + or −
P = no. spaces X
J = Y spacing; + or −
K = no. spaces Y

G66 Shear proof slotting
I = slot length
J = angle
P = punch length; + or − } Must be
Q = punch width; + or − } same sign
D = tab; + or −

G68 No slug window using X
I = Window length in J direction measured
from G72 point. Positive value only.
J = Angle measured from X degrees, positive
angle only measured CCW from 0 degrees.
P = Tool length, positive or negative value
(the tool dimension in the "P" direction).
Q = Tool width. Positive or negative value
(the tool dimension in the "D" direction).
K = Window length perpendicular to "I".
C = Angle of auto index tool, if applicable.
T = Tool station number.

G69 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

G68 Nibbling arc
I = radius
J = starting angle; + or −
K = moving angle; + or −
P = punch; +, −, or zero
Q = nibbling pitch

G69 Nibbling line
I = length
J = angle
P = punch; +, −, or zero
Q = nibbling pitch

G78 Punching arc
I = radius
J = starting angle; + or −
K = moving angle; + or −
P = punch; +, −, or zero
Q = pitch
D = material thickness

G79 Punching line
I = length
J = angle; + or −
P = punch; +, −, or zero
Q = pitch
D = material thickness

G25 Mirror image X... Y... W... Q...

G42 Auto repositioning

G45 Auto repositioning with offset

G43 Delete offset

G04 Dwell function

G50 Return home, program end

─── MISCELLANEOUS FUNCTIONS ───

M00	Program stop	**M15**	Tapping rev
M01	Optional stop	**M60**	Work chute open
M02	Program end	**M61**	Work chute closed
M04	Punch delay effective	**M62**	Slug selector left
M05	Punch delay finish	**M63**	Slug selector right
M12	Nibbling start	**M98**	Fixed program call
M13	Nibbling stop	**M97**	Subprogram end
M15	Tapping feed	**M99**	"Comic" punch speed change
A1	Single block storage		Feed rate control
A2	Single block recall	/	Block delete

─── MULTIPLE PART PROGRAMMING ───

G98 Multiple part layout
X... Y... I... J... 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: G98X1000Y1000I500J500P3K2

─── PUNCHING EXECUTION OF G98 MULTIPLE PARTS ───

G75 Execution of punching in horizontal direction (X direction)

G76 Execution of punching in vertical direction (Y direction)

─── MACROS − U/V ───

LC/SC	Multiple block store	1-59	Processes while start
SC	Multiple block recall	60-69	Registers only
	Parameter 133 setting	90-99	Multiple block store

Programs which do not use software for multiple product punching.
Trial punching with programs using software for multiple product punching.
Remaining punch work after trial punching.
Entire punch work of multiple product punching.

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