

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

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G01	Establishes coordinate system, tool position
G02	Absolute
G03	Incremental
G04	Punch off
G14	Quick punch off with offset
G15	Pattern origin
G16	Line at angle
G17	I = spacing
G18	J = angle; + or -
G19	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

J = slot length
J = angle
P = punch length; + or -
Q = punch width; + or -
Q = 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).
K = Window length perpendicular to "I".
O = 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

G02	Punching arc
I = radius	
J = starting angle; + or -	
K = ending angle; + or -	
P = punch, R_x , R_y , or zero	
Q = pitch	
Q = material thickness	

Punching line

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

Auto repositioning

Auto repositioning with offset

Drift offset

Drift function

Return home, program end

MISCELLANEOUS FUNCTIONS

M00	Program stop	M15	Tapping rear
M01	Optional stop	M80	Work chute open
M02	Program end	M81	Work chute closed
M03	Punch delay effective	M82	Slug selector left
M04	Punch delay finish	M83	Slug selector right
M12	Hobbing start	M88	P-subprogram call
M13	Hobbing stop	M87	Subprogram end
M14	Tapping front	M99	"Cross" = punch speed char
A1	Single block storage	P	Feed rate control
R1	Single block recall	Z	Block delete

MULTIPLE PART PROGRAMMING

G08	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: G08X1000Y000I1000J000P0K2)	

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

Execution of punching in horizontal direction (X direction).

Execution of punching in vertical direction (Y direction).

MACROS = L/V

LC-1C	Multiple block store	0-59	Processes while store
RC	Multiple block recall	60-69	Display only
	Parameter M12 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.
P Resuming punch work after trial punching.
R Enter punch work of multiple product punching.



G Codes For Turret

Zhe Xu



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