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

———— G FUNCTIONS ————

G90/G91 Inch/metric selection
Establishes co-ordinate system, tool position

G90 Absolute

G91 Incremental

G70 Punch off

G74 Optic 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

G28 Shear proof slotting
I = slot length
J = angle
P = punch length; + or — } Must be
Q = punch width; + or —   } same sign
D = tab; + or —

G66 No stop 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 "Q" direction.
K = Window length perpendicular to "I".
C = Angle of auto index tool, if applicable.
T = Tool station number.

G67 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 = rotating angle; + or —
P = punch; +, —, or zero
Q = nibbling pitch

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

———— G FUNCTIONS ————

G75 Punching arc
I = radius
J = starting angle; + or —
K = rotating angle; + or —
P = punch; +, —, or zero
Q = pitch
D = material thickness

G76 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 Cancel offset

G04 Dwell function

G50 Return home, program end

———— MISCELLANEOUS FUNCTIONS ————

M00	Program stop	**M15**	Tapping rise
M01	Optional stop	**M80**	Work chute open
M02	Program end	**M81**	Work chute closed
M04	Punch delay effective	**M62**	Slug ejector left
M06	Punch delay finish	**M63**	Slug ejector right
M12	Nibbling start	**M98**	Sub/program call
M13	Nibbling stop	**M97**	Subprogram end
M14	Tapping feed	**M99**	"Cross" + punch speed chan
A1	Single block storage	**F**	Feed rate control
A1	Single block recall	**/**	Block delete

———— MULTIPLE PART PROGRAMMING ————

G98 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: G98X1000Y1000I1000J1000P5K2

———— 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 ————

1C-3C	Multiple block store	1-59	Process while store
9C	Multiple block recall	60-69	Register only
	Parameter 103 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.

10-1-86

[G Codes For Turret](#)

Zhe Xu

G Codes For Turret:

This book delves into G Codes For Turret. G Codes For Turret is a vital topic that needs to be grasped by everyone, ranging from students and scholars to the general public. This book will furnish comprehensive and in-depth insights into G Codes For Turret, encompassing both the fundamentals and more intricate discussions.

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    - Chapter 1: Introduction to G Codes For Turret
    - Chapter 2: Essential Elements of G Codes For Turret
    - Chapter 3: G Codes For Turret in Everyday Life
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    - Chapter 5: Conclusion

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The book is crafted in an easy-to-understand language and is complemented by engaging illustrations. It is highly recommended for anyone seeking to gain a comprehensive understanding of G Codes For Turret.

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