

## 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 J = slot length J = angle P = punch length; + or - } Must be Q = punch width; + or - } same sign Q = tab; + or -
<b>G28</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". O = Angle of axis index tool, if applicable. T = Tool station number
<b>G31</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>G38</b>	Hobbing arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R, Y, or zero Q = hobbing pitch
<b>G39</b>	Hobbing line I = length J = angle P = punch, 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, Y, or zero Q = pitch Q = material thickness
<b>G29</b>	Punching line I = length J = angle; + or - P = punch, 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>G36</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: G36X100Y100I100J100P10K2)
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## PUNCHING EXECUTION OF G36 MULTIPLE PARTS

<b>G36</b>	Execution of punching in horizontal direction (X direction).
<b>G37</b>	Execution of punching in vertical direction (Y direction).

## MACROS = LRV

<b>LRV</b>	Multiple block store	0-99	Processes while start
<b>LR</b>	Multiple block recall	00-99	Display only
	Parameter M13 setting	90-99	Multiple macro store

<b>T</b>	Prepares which do not use software for multiple product punching.
<b>Q</b>	Try punching with program using software for multiple product punching.
<b>R</b>	Resuming punch work after trial punching.
<b>S</b>	Enter punch work of multiple product punching.



# G Codes For Turret

**David Kirk**



## G Codes For Turret:

**CNC Programming Handbook** Peter Smid, 2003 Comes with a CD ROM packed with a variety of problem solving projects

**GUIDE TO CNC LATHE MACHINE: PROGRAMMING EXAMPLES** Tran A, 2024-10-01 This comprehensive guide unlocks the power of CNC lathe machines Learn essential G code commands optimize toolpaths and troubleshoot common errors Clear explanations real world examples and step by step instructions make this book perfect for both beginners and experienced machinists

**Operator Advanced Machine Tool (Theory) - II** Mr. Rohit Manglik, 2024-05-18 EduGorilla Publication is a trusted name in the education sector committed to empowering learners with high quality study materials and resources Specializing in competitive exams and academic support EduGorilla provides comprehensive and well structured content tailored to meet the needs of students across various streams and levels

The Code of Federal Regulations of the United States of America, 2004 The Code of Federal Regulations is the codification of the general and permanent rules published in the Federal Register by the executive departments and agencies of the Federal Government

*Code of Federal Regulations*, 2001 Special edition of the Federal Register containing a codification of documents of general applicability and future effect with ancillaries

**The engineering telegraph code, by A.H. Blackburn and J. Stevens. The code words complying with the Telegraph convention rules, by G. Ager** Arthur Henry Blackburn, 1892

**German Light Cruisers 1939-45** Gordon Williamson, 2012-04-20 The German Navy of World War II was small in number but contained some of the most technologically advanced capital ships in the world This meant that although the Kriegsmarine never felt capable of encountering the might of the British Navy in a fleet action her ships were individually more than a match for the outdated vessels of the Royal Navy Nowhere was this more the case than in Germany's fleet of light cruisers There were only six vessels in this fleet the Emden Leipzig K In K nigsberg Karlsruhe and Nurnberg This book describes their design development and varied operational history throughout the course of the Second World War

**Skill Based Automated Production** Peter Kopacek, R. Genser, 1990-10-31 This volume will be of interest to all those who are involved in the development and integration of systems into the manufacturing and industrial process It draws together theoretical situations as well as many practical examples of systems which are currently in use in industry including computer integrated manufacturing CIM and flexible manufacturing systems FMS

**Cad/cam and Automation , Air Force Manual** United States. Department of the Air Force, 1973

**Directory of Metalworking Machinery** United States. Munitions Board. Cataloging Agency, 1956

**Virtual Machining Using CAMWorks 2021** Kuang-Hua Chang, 2021-07 Teaches you how to prevent problems reduce manufacturing costs shorten production time and improve estimating Designed for users new to CAMWorks with basic knowledge of manufacturing processes Covers the core concepts and most frequently used commands in CAMWorks Incorporates cutter location data verification by reviewing the generated G codes This book is written to help you learn the core concepts and steps used to conduct virtual machining using CAMWorks CAMWorks is a

virtual machining tool designed to increase your productivity and efficiency by simulating machining operations on a computer before creating a physical product CAMWorks is embedded in SOLIDWORKS as a fully integrated module CAMWorks provides excellent capabilities for machining simulations in a virtual environment Capabilities in CAMWorks allow you to select CNC machines and tools extract or create machinable features define machining operations and simulate and visualize machining toolpaths In addition the machining time estimated in CAMWorks provides an important piece of information for estimating product manufacturing cost without physically manufacturing the product The book covers the basic concepts and frequently used commands and options you ll need to know to advance from a novice to an intermediate level CAMWorks user Basic concepts and commands introduced include extracting machinable features such as 2 5 axis features selecting machine and tools defining machining parameters such as feed rate generating and simulating toolpaths and post processing CL data to output G codes for support of CNC machining The concepts and commands are introduced in a tutorial style presentation using simple but realistic examples Both milling and turning operations are included One of the unique features of this book is the incorporation of the CL cutter location data verification by reviewing the G codes generated from the toolpaths This helps you understand how the G codes are generated by using the respective post processors which is an important step and an ultimate way to confirm that the toolpaths and G codes generated are accurate and useful This book is intentionally kept simple It primarily serves the purpose of helping you become familiar with CAMWorks in conducting virtual machining for practical applications This is not a reference manual of CAMWorks You may not find everything you need in this book for learning CAMWorks But this book provides you with basic concepts and steps in using the software as well as discussions on the G codes generated After going over this book you will develop a clear understanding in using CAMWorks for virtual machining simulations and should be able to apply the knowledge and skills acquired to carry out machining assignments and bring machining consideration into product design in general Who this book is for This book should serve well for self learners A self learner should have a basic physics and mathematics background We assume that you are familiar with basic manufacturing processes especially milling and turning In addition we assume you are familiar with G codes A self learner should be able to complete the ten lessons of this book in about forty hours This book also serves well for class instructions Most likely it will be used as a supplemental reference for courses like CNC Machining Design and Manufacturing Computer Aided Manufacturing or Computer Integrated Manufacturing This book should cover four to five weeks of class instructions depending on the course arrangement and the technical background of the students What is virtual machining Virtual machining is the use of simulation based technology in particular computer aided manufacturing CAM software to aid engineers in defining simulating and visualizing machining operations for parts or assembly in a computer or virtual environment By using virtual machining the machining process can be defined and verified early in the product design stage Some if not all of the less desirable design features in the context of part manufacturing

such as deep pockets holes or fillets of different sizes or cutting on multiple sides can be detected and addressed while the product design is still being finalized In addition machining related problems such as undesirable surface finish surface gouging and tool or tool holder colliding with stock or fixtures can be identified and eliminated before mounting a stock on a CNC machine at shop floor In addition manufacturing cost which constitutes a significant portion of the product cost can be estimated using the machining time estimated in the virtual machining simulation Virtual machining allows engineers to conduct machining process planning generate machining toolpaths visualize and simulate machining operations and estimate machining time Moreover the toolpaths generated can be converted into NC codes to machine functional parts as well as die or mold for part production In most cases the toolpath is generated in a so called CL data format and then converted to G codes using respective post processors

Table of Contents 1 Introduction to CAMWorks 2 A Quick Run Through 3 Machining 2 5 Axis Features 4 Machining a Freeform Surface 5 Multipart Machining 6 Multiplane Machining 7 Multiaxis Milling and Machine Simulation 8 Turning a Stepped Bar 9 Turning a Stub Shaft 10 Die Machining Application Appendix A Machinable Features Appendix B Machining Operations

*Aero-optics Code Development* Scott E. Sherer, 2009 Virtual Machining Using CAMWorks 2023 Kuang-Hua Chang, 2023-08 Teaches you how to prevent problems reduce manufacturing costs shorten production time and improve estimating Designed for users new to CAMWorks with basic knowledge of manufacturing processes Covers the core concepts and most frequently used commands in CAMWorks Incorporates cutter location data verification by reviewing the generated G codes This book is written to help you learn the core concepts and steps used to conduct virtual machining using CAMWorks CAMWorks is a virtual machining tool designed to increase your productivity and efficiency by simulating machining operations on a computer before creating a physical product CAMWorks is embedded in SOLIDWORKS as a fully integrated module CAMWorks provides excellent capabilities for machining simulations in a virtual environment Capabilities in CAMWorks allow you to select CNC machines and tools extract or create machinable features define machining operations and simulate and visualize machining toolpaths In addition the machining time estimated in CAMWorks provides an important piece of information for estimating product manufacturing cost without physically manufacturing the product The book covers the basic concepts and frequently used commands and options you'll need to know to advance from a novice to an intermediate level CAMWorks user Basic concepts and commands introduced include extracting machinable features such as 2 5 axis features selecting machine and tools defining machining parameters such as feed rate generating and simulating toolpaths and post processing CL data to output G codes for support of CNC machining The concepts and commands are introduced in a tutorial style presentation using simple but realistic examples Both milling and turning operations are included One of the unique features of this book is the incorporation of the CL cutter location data verification by reviewing the G codes generated from the toolpaths This helps you understand how the G codes are generated by using the respective post processors which is an important step and an ultimate way to confirm that the

toolpaths and G codes generated are accurate and useful This book is intentionally kept simple It primarily serves the purpose of helping you become familiar with CAMWorks in conducting virtual machining for practical applications This is not a reference manual of CAMWorks You may not find everything you need in this book for learning CAMWorks But this book provides you with basic concepts and steps in using the software as well as discussions on the G codes generated After going over this book you will develop a clear understanding in using CAMWorks for virtual machining simulations and should be able to apply the knowledge and skills acquired to carry out machining assignments and bring machining consideration into product design in general Who this book is for This book should serve well for self learners A self learner should have a basic physics and mathematics background We assume that you are familiar with basic manufacturing processes especially milling and turning In addition we assume you are familiar with G codes A self learner should be able to complete the ten lessons of this book in about forty hours This book also serves well for class instructions Most likely it will be used as a supplemental reference for courses like CNC Machining Design and Manufacturing Computer Aided Manufacturing or Computer Integrated Manufacturing This book should cover four to five weeks of class instructions depending on the course arrangement and the technical background of the students

*Official Gazette of the United States Patent Office United States. Patent Office,1904 Catalogue ,1900 Programming of Computer Numerically Controlled Machines Kenneth W. Evans,John Polywka,Stanley Gabrel,2001* Provides descriptions of many operation and programming functions and their practical application to turning and milling machines End of chapter study questions make the book suitable for use as a textbook The second edition adds two chapters on CAD CAM and conversational programming Annotation c Book News Inc Portland OR booknews com

**Virtual Machining Using CAMWorks 2020** Kuang-Hua Chang,2020-07-16 This book is written to help you learn the core concepts and steps used to conduct virtual machining using CAMWorks CAMWorks is a virtual machining tool designed to increase your productivity and efficiency by simulating machining operations on a computer before creating a physical product CAMWorks is embedded in SOLIDWORKS as a fully integrated module CAMWorks provides excellent capabilities for machining simulations in a virtual environment Capabilities in CAMWorks allow you to select CNC machines and tools extract or create machinable features define machining operations and simulate and visualize machining toolpaths In addition the machining time estimated in CAMWorks provides an important piece of information for estimating product manufacturing cost without physically manufacturing the product The book covers the basic concepts and frequently used commands and options you ll need to know to advance from a novice to an intermediate level CAMWorks user Basic concepts and commands introduced include extracting machinable features such as 2 5 axis features selecting machine and tools defining machining parameters such as feed rate generating and simulating toolpaths and post processing CL data to output G codes for support of CNC machining The concepts and commands are introduced in a tutorial style presentation using simple but realistic examples Both milling and turning operations are included One of the

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## **Table of Contents G Codes For Turret**

1. Understanding the eBook G Codes For Turret
  - The Rise of Digital Reading G Codes For Turret
  - Advantages of eBooks Over Traditional Books
2. Identifying G Codes For Turret
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an G Codes For Turret
  - User-Friendly Interface
4. Exploring eBook Recommendations from G Codes For Turret
  - Personalized Recommendations
  - G Codes For Turret User Reviews and Ratings
  - G Codes For Turret and Bestseller Lists
5. Accessing G Codes For Turret Free and Paid eBooks
  - G Codes For Turret Public Domain eBooks
  - G Codes For Turret eBook Subscription Services
  - G Codes For Turret Budget-Friendly Options
6. Navigating G Codes For Turret eBook Formats

- ePub, PDF, MOBI, and More
- G Codes For Turret Compatibility with Devices
- G Codes For Turret Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of G Codes For Turret
  - Highlighting and Note-Taking G Codes For Turret
  - Interactive Elements G Codes For Turret
- 8. Staying Engaged with G Codes For Turret
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers G Codes For Turret
- 9. Balancing eBooks and Physical Books G Codes For Turret
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection G Codes For Turret
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine G Codes For Turret
  - Setting Reading Goals G Codes For Turret
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of G Codes For Turret
  - Fact-Checking eBook Content of G Codes For Turret
  - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
- 14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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