

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

G⁰¹ FUNCTIONS

G01 Incremental selection
Establishes coordinate system, tool position

G00 Absolute

G01 Incremental

G10 Punch off

G14 Data punch off with offset

G15 Pattern origin

G16 Line at angle

I = spacing
J = angle; + or -
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

Linear punch starting

I = slot length
J = angle
P = punch length; + or - } Must be
Q = punch width; + or - } same sign
R = tab; + 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).
R = Window length perpendicular to "I".
T = Angle of axis index tool, if applicable.
V = 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 = ending 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

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

Punching line

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

Mirror image X...Y...R...Q...

Auto repositioning
Auto repositioning with offset
Circle offset
Drill 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

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: G001000Y000100000000P0K2)

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

G08 Execution of punching in horizontal direction (X direction).
G09 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	60-99	Display only
Parameter M13 setting	90-99	Multiple macro store

T Prepares which do not use software for multiple product punching.
T1 Trial punching with programs using software for multiple product punching.
T2 Resuming punch work after trial punching.
T3 Enter punch work of multiple product punching.



G Codes For Turret

Victor M. Corman



G Codes For Turret:

CNC Programming Handbook Peter Smid,2003 Comes with a CD ROM packed with a variety of problem solving projects *CNC Lathe machine guide: Practical programming examples* Tran A ,2024-10-01 CNC Lathe machine guide Practical programming examples is the ultimate resource for anyone looking to master CNC lathe programming This book provides clear step by step examples that will help you understand the core concepts of CNC lathe operations and how to apply them effectively in real world scenarios Whether you re a beginner or an experienced machinist this guide breaks down complex programming techniques into simple easy to follow instructions With practical examples and tips you ll learn how to optimize your CNC lathe machine s capabilities improve precision and increase productivity Ideal for students professionals and hobbyists alike this book is your go to reference for mastering the art of CNC lathe programming and taking your machining skills to the next level *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 [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 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 *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 **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

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 ln K nigsberg Karlsruhe and Nurnberg This book describes their design development and varied operational history throughout the course of the Second World War

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CAMWorks 2016 Kuang-Hua Chang,2018-01-04 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

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