

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

G⁰¹ FUNCTIONS

| | |
|----------------|--|
| G21 | Intermetric selection Establishes coordinate system, tool position |
| G20 | Absolute |
| G91 | Incremental |
| G10 | Punch off |
| G14 | Auto punch off with offset |
| G15 | Pattern origin |
| G16 | Line at angle |
| G17 | I = spacing J = angle; + or - K = no. spaces |
| G18 | Arc I = radius J = starting angle; + or - P = angle increment; + or - K = no. holes |
| G19 | Slot hole circle I = radius J = starting angle; + or - K = no. holes |
| G20/G21 | Grid X/Y-Z I = X spacing; + or - P = no. spaces X J = Y spacing; + or - K = no. spaces Y |
| G22 | Slower punch starting J = slot length J = angle P = punch length; + or - } Must be Q = punch width; + or - } same sign Q = tab; + or - |
| G28 | 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 |
| G31 | 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 |
| G38 | Hobbing arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = hobbing pitch |
| G39 | Hobbing line I = length J = angle P = punch, R_x , R_y , or zero Q = hobbing pitch |

G⁰² FUNCTIONS

| | |
|------------|---|
| G28 | Punching arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = pitch Q = material thickness |
| G29 | Punching line I = length J = angle; + or - P = punch, R_x , R_y , or zero Q = pitch Q = material thickness |
| G30 | Minor image X...Y...R...Q... |
| G31 | Auto repositioning |
| G32 | Auto repositioning with offset |
| G33 | Circle offset |
| G34 | Drill function |
| G35 | Return home, program end |
| M00 | Program stop |
| M01 | Optional stop |
| M02 | Program end |
| M03 | Punch delay effective |
| M04 | Punch delay finish |
| M10 | Hobbing start |
| M11 | Hobbing stop |
| M12 | Tapping start |
| M13 | Single block storage |
| M14 | Single block recall |
| M15 | Tapping rear |
| M16 | Work chute open |
| M17 | Work chute closed |
| M18 | Slug selector left |
| M19 | Slug selector right |
| M20 | P-subprogram call |
| M21 | Subprogram end |
| M22 | "Cross" = punch speed char |
| M23 | Feed rate control |
| M24 | Block delete |

MISCELLANEOUS FUNCTIONS

| | |
|------------|----------------------------|
| M00 | Program stop |
| M01 | Optional stop |
| M02 | Program end |
| M03 | Punch delay effective |
| M04 | Punch delay finish |
| M10 | Hobbing start |
| M11 | Hobbing stop |
| M12 | Tapping start |
| M13 | Single block storage |
| M14 | Single block recall |
| M15 | Tapping rear |
| M16 | Work chute open |
| M17 | Work chute closed |
| M18 | Slug selector left |
| M19 | Slug selector right |
| M20 | P-subprogram call |
| M21 | Subprogram end |
| M22 | "Cross" = punch speed char |
| M23 | Feed rate control |
| M24 | Block delete |

MULTIPLE PART PROGRAMMING

| | |
|------------|---|
| G36 | 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) |
|------------|---|

PUNCHING EXECUTION OF G36 MULTIPLE PARTS

| | |
|------------|--|
| G36 | Execution of punching in horizontal direction (X direction). |
| G37 | Execution of punching in vertical direction (Y direction). |

MACROS = LRV

| | | | |
|------------|-----------------------|-------|-----------------------|
| LRV | Multiple block store | 0-99 | Processes while store |
| LR | Multiple block recall | 00-99 | Display only |
| | Parameter M13 setting | 90-99 | Multiple macro store |

| | |
|----------|---|
| T | Prepares which do not use software for multiple product punching. |
| T | Try punching with program using software for multiple product punching. |
| T | Resuming punch work after trial punching. |
| T | Enter punch work of multiple product punching. |



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ML Yell



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