

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

G⁰¹ FUNCTIONS

G21	Intermetric selection
G22	Establishes coordinate system, tool position
G23	Absolute
G24	Incremental
G25	Punch off
G26	Auto punch off with offset
G27	Pattern origin
G28	Line at angle
G29	I = spacing J = angle; + or - K = no. spaces
G30	Arc I = radius J = starting angle; + or - P = angle increment; + or - K = no. holes
G31	Slot hole circle I = radius J = starting angle; + or - K = no. holes
G32	Slot R/Side Y I = R spacing; + or - P = no. spaces X J = spacing; + or - K = no. spaces Y
G33	Slower punch starting J = slot length J = angle P = punch length; + or - Q = punch width; + or - Q = slot; + or -
G34	No slug window using R I = Window length in J direction measured from G22 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". Q = Angle of axis under tool, if applicable. T = Tool station number
G35	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
G36	Hobbing arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = hobbing pitch
G37	Hobbing line I = length J = angle P = punch, R_x , R_y , or zero Q = hobbing pitch

G⁰² FUNCTIONS

G38	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
G39	Punching line I = length J = angle; + or - P = punch, R_x , R_y , or zero Q = pitch Q = material thickness
G40	Minor image X...Y...R...Q...
G41	Auto repositioning
G42	Auto repositioning with offset
G43	Circle offset
G44	Drill function
G45	Return home, program end
G46	Program stop
G47	Optional stop
G48	Program end
G49	Punch delay effective
G50	Punch delay finish
G51	Hobbing start
G52	Hobbing stop
G53	Tapping start
G54	Single block storage
G55	Single block recall

MISCELLANEOUS FUNCTIONS

M01	Program stop
M02	Optional stop
M03	Program end
M04	Punch delay effective
M05	Punch delay finish
M06	Hobbing start
M07	Hobbing stop
M08	Tapping start
M09	Single block storage
M10	Single block recall
M11	Tapping rear
M12	Work chute open
M13	Work chute closed
M14	Slug selector left
M15	Slug selector right
M16	P-subprogram call
M17	Subprogram end
M18	"Cross" = punch speed char
M19	Feed rate control
M20	Block delete

MULTIPLE PART PROGRAMMING

G56	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: G56X100Y100I100J100P10K2)
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PUNCHING EXECUTION OF G56 MULTIPLE PARTS

G57	Execution of punching in horizontal direction (X direction).
G58	Execution of punching in vertical direction (Y direction).

MACROS = LRV

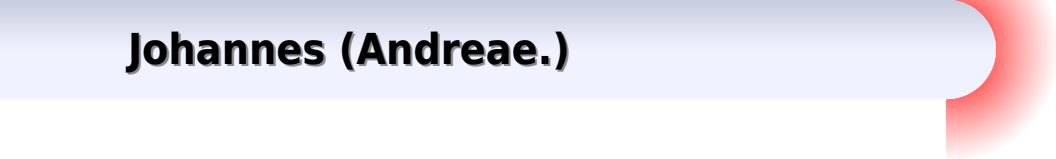
LRV	Multiple block store	0-99	Processes while start
LR	Multiple block recall	00-99	Display only
	Parameter M13 setting	90-99	Multiple macro store

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.



Amada Turret G Codes

Johannes (Andreae.)



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