

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

G⁰¹ FUNCTIONS

G21	Mathematical selection Establishes coordinate system, tool position
G22	Absolute
G23	Incremental
G24	Punch off
G24	Auto punch off with offset
G25	Pattern origin
G26	Line at angle
	I = spacing
	J = angle; + or -
	K = no. spaces
G27	Arc
	I = radius
	J = starting angle; + or -
	P = angle increment; + or -
	K = no. holes
G28	Slot hole circle
	I = radius
	J = starting angle; θ or °
	K = no. holes
G29	Slot R/Side Y
	I = R spacing; + or -
	P = no. spaces X
	J = Y spacing; + or -
	K = no. spaces Y
G30	Clear punch starting
	I = slot length
	J = angle
	P = punch length; + or - } Must be
	Q = punch width; + or - } same sign
	R = slot; + or -
G31	No slug window using R
	I = Window length in J direction measured from G10 zero. Positive value only.
	J = Angle measured from R degrees, positive angle only measured CW from R degrees.
	P = Tool length, positive or negative value (the tool dimension in the "Z" direction).
	Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
	R = Window length perpendicular to "I".
	C = Angle of auto loader tool, if applicable.
	T = Tool station number
G32	Rectangular cut-out
	I = hole length X axis; + or -
	J = hole length Y axis; + or -
	P = punch width Z axis
	Q = punch width R axis - optional
G33	Notching arc
	I = radius
	J = starting angle; + or -
	K = ending angle; + or -
	P = punch; θ, °, or zero
	Q = notching punch
G34	Notching line
	I = length
	J = angle
	P = punch; θ, °, or zero
	Q = notching punch

G⁰² FUNCTIONS

G35	Punching arc
	I = radius
	J = starting angle; + or -
	K = ending angle; + or -
	P = punch; θ, °, or zero
	Q = pitch
	R = material thickness
G36	Punching line
	I = length
	J = angle; + or -
	P = punch; θ, °, or zero
	Q = pitch
	R = material thickness
G37	Minor image X... Y... R... Q...
G38	Auto repositioning
G39	Auto repositioning with offset
G40	Circle offset
G41	Drill function
G42	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 break	M83	Slug selector right
M12	Feeding start	M88	Pre-subprogram call
M13	Feeding stop	M87	Subprogram end
M14	Tapping front	M99	"Goto" a punch speed char
A1	Single block storage	P	Feed rate control
R1	Single block recall	Z	Block delete

MULTIPLE PART PROGRAMMING

G98	Multiple part layout
	X... Y... Z... 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
	= distance between reference points in Z 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: G98X000Y000Z001R000L000P002K02)

PUNCHING EXECUTION OF G98 MULTIPLE PARTS

G99	Execution of punching in horizontal direction (X direction).
G98	Execution of punching in vertical direction (Z direction).

MACROS = LRV

L000	Multiple block store	0-99	Processes while store
R0	Multiple block recall	00-99	Output only
	Parameter/ID setting	90-99	Multiple block store

- T** Prepares which do not use software for multiple product punching. Trial punching with programs using software for multiple product punching.
- U** Remaining punch work after trial punching.
- V** Enter punch work of multiple product punching.



Amada G Code Manual

RJ Alexander



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