

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

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G00	Establishes coordinate system, tool position
G00	Absolute
G01	Incremental
G02	Punch off
G04	Delay punch off with offset
G05	Pattern origin
G06	Line at angle
G07	I = spacing
G08	J = angle; + or -
G09	K = no. spaces
G10	Arc
G11	I = radius
G12	J = starting angle; + or -
G13	P = angle increment; + or -
G14	K = no. holes
G15	Slot hole circle
G16	I = radius
G17	J = starting angle; + or -
G18	K = no. holes
G19	Slot R/Side Y
G20	I = R spacing; + or -
G21	P = no. spaces X
G22	J = R spacing; + or -
G23	K = no. spaces Y
G24	Slower punch starting
G25	I = slot length
G26	J = angle
G27	P = punch length; + or -
G28	Q = punch width; + or -
G29	R = slot; + or -
G30	No slug window using R
G31	I = Window length in J direction measured from QTD point. Positive value only.
G32	J = Angle measured from R degrees, positive angle only measured CCW from Q degrees.
G33	P = Tool length, positive or negative value (the tool dimension in the "I" direction).
G34	Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
G35	K = Window length perpendicular to "I".
G36	O = Angle of axis index tool, if applicable.
G37	T = Tool station number
G38	Rectangular cut-out
G39	I = hole length X axis; + or -
G40	J = hole length Y axis; + or -
G41	P = punch width X axis
G42	Q = punch width Y axis; optional
G43	Holding arc
G44	I = radius
G45	J = starting angle; + or -
G46	K = moving angle; + or -
G47	P = punch, R, Y, or zero
G48	Q = holding pitch
G49	Holding line
G50	I = length
G51	J = angle
G52	P = punch, R, Y, or zero
G53	Q = holding pitch

G⁰² FUNCTIONS

G54	Punching arc
G55	I = radius
G56	J = starting angle; + or -
G57	K = moving angle; + or -
G58	P = punch, R, Y, or zero
G59	Q = pitch
G60	R = material thickness
G61	Punching line
G62	I = length
G63	J = angle; + or -
G64	P = punch, R, Y, or zero
G65	Q = pitch
G66	R = material thickness
G67	Minor image X... Y... R... Q...
G68	Auto repositioning
G69	Auto repositioning with offset
G70	Circle offset
G71	Drill function
G72	Return home, program end
G73	Program stop
G74	Optional stop
G75	Program end
G76	Punch delay effective
G77	Punch delay finish
G78	Holding start
G79	Holding stop
G80	Tapping start
G81	Single block storage
G82	Single block recall

MISCELLANEOUS FUNCTIONS

M00	Program stop
M01	Optional stop
M02	Program end
M03	Punch delay effective
M04	Punch delay finish
M05	Holding start
M06	Holding stop
M07	Tapping start
M08	Single block storage
M09	Single block recall
M10	Tapping rear
M11	Work chute open
M12	Work chute closed
M13	Slug selector left
M14	Slug selector right
M15	P-subprogram call
M16	Subprogram end
M17	"Cross" = punch speed char
M18	Feed rate control
M19	Block delete

MULTIPLE PART PROGRAMMING

M20	Multiple part layout
M21	X... Y... I... J... P... K...
M22	X = reference point for lower left hand part in X axis
M23	Y = reference point for lower left hand part in Y axis
M24	I = distance between reference points in X direction (note: add slotting tool width)
M25	J = distance between reference points in Y direction (note: add slotting tool width)
M26	P = number of parts in the X axis—excluding the bottom left part
M27	K = number of parts in the Y axis—excluding the bottom left part (Example: G9001000Y0001000000000P0002)

PUNCHING EXECUTION OF G98 MULTIPLE PARTS

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

MACROS = LRV

L0-L9	Multiple block store	0-99	Processes while start
R0-R9	Multiple block recall	00-99	Signals only
P0-P9	Parameter/IO setting	00-99	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 G Code Manual

RS Peters



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