

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

G<sup>01</sup> FUNCTIONS

<b>G00</b>	Instantaneous selection
<b>G00</b>	Establishes coordinate system, tool position
<b>G01</b>	Absolute
<b>G01</b>	Incremental
<b>G02</b>	Punch off
<b>G04</b>	Delay punch off with offset
<b>G04</b>	Pattern origin
<b>G05</b>	Line at angle
	I = spacing
	J = angle; + or -
	K = no. spaces
<b>G06</b>	Arc
	I = radius
	J = starting angle; + or -
	P = angle increment; + or -
	K = no. holes
<b>G08</b>	Slot hole circle
	I = radius
	J = starting angle; + or -
	K = no. holes
<b>G09</b>	Slot R/Side Y
	I = R spacing; + or -
	P = no. spaces X
	J = Y spacing; + or -
	K = no. spaces Y
<b>G10</b>	Slower punch starting
	I = slot length
	J = angle
	P = punch length; + or -
	Q = punch width; + or -
	R = slot; + or -
<b>G11</b>	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).
	K = Window length perpendicular to "I".
	O = Angle of axis index tool, if applicable.
	T = Tool station number
<b>G12</b>	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
<b>G13</b>	Hobbing arc
	I = radius
	J = starting angle; + or -
	K = moving angle; + or -
	P = punch, $\theta$ , $\gamma$ , or zero
	Q = hobbing pitch
<b>G14</b>	Hobbing line
	I = length
	J = angle
	P = punch, $\theta$ , $\gamma$ , or zero
	Q = hobbing pitch

G<sup>02</sup> FUNCTIONS

<b>G02</b>	Punching arc
	I = radius
	J = starting angle; + or -
	K = moving angle; + or -
	P = punch, $\theta$ , $\gamma$ , or zero
	Q = pitch
	R = material thickness
<b>G03</b>	Punching line
	I = length
	J = angle; + or -
	P = punch, $\theta$ , $\gamma$ , or zero
	Q = pitch
	R = material thickness
<b>G04</b>	Minor image X...Y...R...Q...
<b>G05</b>	Auto repositioning
<b>G06</b>	Auto repositioning with offset
<b>G07</b>	Drill offset
<b>G08</b>	Drill function
<b>G09</b>	Return home, program end
<b>M00</b>	Program stop
<b>M01</b>	Optional stop
<b>M02</b>	Program end
<b>M03</b>	Punch delay effective
<b>M04</b>	Punch delay finish
<b>M10</b>	Hobbing start
<b>M11</b>	Hobbing stop
<b>M12</b>	Tapping start
<b>M13</b>	Single block storage
<b>M14</b>	Single block recall
<b>M15</b>	Tapping rear
<b>M16</b>	Work chute open
<b>M17</b>	Work chute closed
<b>M18</b>	Slug selector left
<b>M19</b>	Slug selector right
<b>M20</b>	P-subprogram call
<b>M21</b>	Subprogram end
<b>M22</b>	"Cross" = punch speed char
<b>M23</b>	Feed rate control
<b>M24</b>	Block delete

## MISCELLANEOUS FUNCTIONS

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

## MULTIPLE PART PROGRAMMING

<b>G00</b>	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: G001000Y000I1000J000P0K2)

## PUNCHING EXECUTION OF G08 MULTIPLE PARTS

<b>G08</b>	Execution of punching in horizontal direction (X direction).
<b>G09</b>	Execution of punching in vertical direction (Y direction).

## MACROS = L/V

<b>L/V</b>	Multiple block store	0-99	Processes while store
<b>R</b>	Multiple block recall	00-99	Display only
	Parameter M13 setting	90-99	Multiple macro store

<b>T</b>	Prepares which do not use software for multiple product punching.
<b>P</b>	Try punching with programs using software for multiple product punching.
<b>R</b>	Resuming punch work after trial punching.
<b>L</b>	Enter punch work of multiple product punching.



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