

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

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G01	Establishes coordinate system, tool position
G02	Absolute
G03	Incremental
G04	Punch off
G14	Quick punch off with offset
G15	Pattern origin
G16	Line at angle
G17	I = spacing
G18	J = angle; + or -
G19	K = no. spaces
G20	Arc
G21	I = radius
G22	J = starting angle; + or -
G23	P = angle increment; + or -
G24	K = no. holes
G25	Slot hole circle
G26	I = radius
G27	J = starting angle; + or -
G28	K = no. holes
G29	Grid X/Y-Z
G30	I = X spacing; + or -
G31	P = no. spaces X
G32	J = Y spacing; + or -
G33	K = no. spaces Y
G34	Slower punch starting
G35	I = slot length
G36	J = angle
G37	P = punch length; + or -
G38	Q = punch width; + or -
G39	D = hole; + or -
G40	No slug window using R
G41	I = Window length in J direction measured from G10 point. Positive value only.
G42	J = Angle measured from R degrees, positive angle only measured CCW from R degrees.
G43	P = Tool length, positive or negative value (the tool dimension in the "Z" direction).
G44	Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
G45	K = Window length perpendicular to "I".
G46	C = Angle of axis under tool, if applicable.
G47	T = Tool station number
G48	Rectangular cut-out
G49	I = hole length X axis; + or -
G50	J = hole length Y axis; + or -
G51	P = punch width X axis
G52	Q = punch width Y axis; optional
G53	Holding arc
G54	I = radius
G55	J = starting angle; + or -
G56	K = moving angle; + or -
G57	P = punch, R, Y, or zero
G58	Q = holding pitch
G59	Holding line
G60	I = length
G61	J = angle
G62	P = punch, R, Y, or zero
G63	Q = holding pitch

G⁰² FUNCTIONS

G02	Punching arc
G03	I = radius
G04	J = starting angle; + or -
G05	K = moving angle; + or -
G06	P = punch, R, Y, or zero
G07	Q = pitch
G08	D = material thickness
G09	Punching line
G10	I = length
G11	J = angle; + or -
G12	P = punch, R, Y, or zero
G13	Q = pitch
G14	D = material thickness
G15	Minor image X... Y... R... D...
G16	Auto repositioning
G17	Auto repositioning with offset
G18	Circle offset
G19	Drill function
G20	Return home, program end
G21	Program stop
G22	Optional stop
G23	Program end
G24	Punch delay effective
G25	Punch delay finish
G26	Holding start
G27	Holding stop
G28	Tapping start
G29	Single block storage
G30	Single block recall
G31	Multiple part layout
G32	X... Y... I... J... P... K...
G33	X = reference point for lower left hand part in X axis
G34	Y = reference point for lower left hand part in Y axis
G35	I = distance between reference points in X direction (note: add slotting tool width)
G36	J = distance between reference points in Y direction (note: add slotting tool width)
G37	P = number of parts in the X axis - excluding the bottom left part
G38	K = number of parts in the Y axis - excluding the bottom left part (Example: G38X1000Y000I1000J000P10K2)

MULTIPLE PART PROGRAMMING

G39	Multiple part layout
G40	X... Y... I... J... P... K...
G41	X = reference point for lower left hand part in X axis
G42	Y = reference point for lower left hand part in Y axis
G43	I = distance between reference points in X direction (note: add slotting tool width)
G44	J = distance between reference points in Y direction (note: add slotting tool width)
G45	P = number of parts in the X axis - excluding the bottom left part
G46	K = number of parts in the Y axis - excluding the bottom left part (Example: G38X1000Y000I1000J000P10K2)

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

G08	Execution of punching in horizontal direction (X direction).
G09	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.
P	Try punching with program using software for multiple product punching.
R	Resuming punch work after trial punching.
S	Enter punch work of multiple product punching.



G Codes For Turret

**Kenneth W. Evans, John
Polywka, Stanley Gabrel**



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