

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

## GPI FUNCTIONS

Tool selection  
Establishes coordinate system, tool position  
Absolute  
Establishes tool  
Programs part  
Digital part off with offset  
Program origin  
Lines and angles  
X = positive  
J 100 degrees = 100  
R = tool, degrees

Part  
X = positive  
J = absolute, negative = 100  
P = part, coordinate = 000  
R = tool, degrees

Part  
X = positive  
J = absolute, negative = 100  
P = part, coordinate = 000

Part  
X = positive  
J = absolute, negative = 100  
P = part, coordinate = 000  
R = tool, degrees

Part  
X = positive  
J = absolute, negative = 100  
P = part, coordinate = 000  
R = tool, degrees  
X = positive  
J = absolute, negative = 100  
P = part, coordinate = 000  
R = tool, degrees

Part  
X = absolute length or J absolute measured.  
Enter G70 part Positive value only.  
J = Angle measured from 0 degrees, positive  
angle with measured G70 from 0 degrees.  
R = Tool length, positive or negative value.  
Other tool dimensions for the G70 command.  
P = Tool radius, Positive or negative value.  
Other tool dimensions for the "P" dimension.  
X = Absolute length perpendicular to "Y".  
R = Angle of tool leader tool, if applicable.  
T = Tool station number

Part  
X = positive length X axis dimension  
J = positive length Y axis dimension  
P = part, coordinate 000  
R = part, radius 000 = negative

Part  
X = absolute  
J = absolute, negative = 100  
R = tool, degrees = 100  
P = part, coordinate 000  
Q = tooling pitch

Part  
X = absolute  
J = absolute  
P = part, coordinate 000  
Q = tooling pitch

## GPI FUNCTIONS

Punching seq.  
X = positive  
J = absolute, negative = 100  
P = part, coordinate = 000  
R = positive or negative  
Q = part  
R = material thickness

Punching seq.  
X = positive  
J = absolute, negative = 100  
P = part, coordinate 000  
R = part  
R = material thickness

Material usage X = 100  
W = 100

Auto repositioning  
Auto repositioning with offset  
Offset select  
Overall rotation  
Platen move, program used

Program stop M15 Tapping rate  
Optional stop M800 Work cycle open  
Program end M81 Work cycle closed  
Part set delay effective M82 Work selection left  
Platen velocity limits M83 Work selection right  
Holding start M84 Program start  
Holding stop M85 Program end  
Tapping limit M86 "Cyclic" = part speed chain  
Single stroke, average M87 Feed rate selected  
Single stroke recall / Hold & release

## MULTIPLE PART PROGRAMMING

Multiple part layout  
X = Y = Z = 000  
X = reference point for bottom left tool part in X axis  
Y = reference point for bottom left tool part in Y axis  
Z = reference bottom reference points in Z direction  
These tool selection tool related  
X = reference bottom and bottom points in Y direction  
These tool selection tool related  
Y = number of parts in the X axis - including the bottom left part  
Z = number of parts in the Y axis - including the bottom left part  
Example: G00010000001 M000000000002

PUNCHING EXECUTION OF G00 MULTIPLE PARTS  
Execution of parting in horizontal direction (X direction).  
Execution of parting in vertical direction (Y direction).

## MATERIAL = UNIT

M00 Multiple block stop 0-000 Processing while stop  
M00 Multiple block recall 000-000 Cyclic only  
M00-000 Material recall 000-000 Multiple repeat when

Programs multiple part use software for multiple part punching.  
Trial punching with programs using software for multiple part punching.  
Punching part works after trial punching.  
Enter punch work of multiple part punching.

# G Codes For Turret

**AW Chickering**

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*General Machinery Catalogue* Niles Tool Works Company,1898    Programming for Numerical Control Machines Arthur D. Roberts,Richard C. Prentice,1968    American Machinist ,1902    Control & Instrumentation ,1971    **Machinery and Production Engineering** ,1918    **Water Code List** ,1984    **Advances in Machine Tool Design and Research** ,1974  
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