

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

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G00	Establishes coordinate system, tool position
G01	Absolute
G01	Incremental
G02	Punch off
G04	Delay punch off with offset
G04	Pattern origin
G05	Line at angle
	I = spacing
	J = angle; + or -
	K = no. spaces
G06	Arc
	I = radius
	J = starting angle; + or -
	P = angle increment; + or -
	K = no. holes
G08	Slot hole circle
	I = radius
	J = starting angle; + or -
	K = no. holes
G09	Grid X/Y-Z
	I = X spacing; + or -
	P = no. spaces X
	J = Y spacing; + or -
	K = no. spaces Y
G10	Linear punch starting
	I = slot length
	J = angle
	P = punch length; + or -
	Q = punch width; + or -
	R = slot; + or -
G11	No slot 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
G12	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
G13	Hobbing arc
	I = radius
	J = starting angle; + or -
	K = moving angle; + or -
	P = punch, θ_1 , θ_2 , or zero
	Q = hobbing pitch
G14	Hobbing line
	I = length
	J = angle
	P = punch, θ_1 , θ_2 , or zero
	Q = hobbing pitch

G⁰² FUNCTIONS

G02	Punching arc
	I = radius
	J = starting angle; + or -
	K = moving angle; + or -
	P = punch, θ_1 , θ_2 , or zero
	Q = pitch
	R = material thickness
G03	Punching line
	I = length
	J = angle; + or -
	P = punch, θ_1 , θ_2 , or zero
	Q = pitch
	R = material thickness
G04	Minor image X...Y...R...Q...
G05	Auto repositioning
G06	Auto repositioning with offset
G07	Circle offset
G08	Drill function
G09	Return home, program end
M00	Program stop
M01	Optional stop
M02	Program end
M03	Punch delay effective
M04	Punch delay finish
M10	Hobbing start
M11	Hobbing stop
M12	Tapping start
M13	Single block storage
M14	Single block recall
M15	Tapping rear
M16	Work chute open
M17	Work chute closed
M18	Slag selector left
M19	Slag selector right
M20	P-subprogram call
M21	Subprogram end
M22	"Cross" = punch speed char
M23	Feed rate control
M24	Block delete

MISCELLANEOUS FUNCTIONS

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

MULTIPLE PART PROGRAMMING

G00	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

G08	Execution of punching in horizontal direction (X direction).
G09	Execution of punching in vertical direction (Y direction).

MACROS = L/V

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

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



Amada Turret G Codes

Minjie Lin

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the author's name.

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