

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 index 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: G31X100Y100I100J100P10K2)

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	Multiple part layout
M11	X... Y... I... J... P... K...
M12	X = reference point for lower left hand part in X axis
M13	Y = reference point for lower left hand part in Y axis
M14	I = distance between reference points in X direction (note: add slotting tool width)
M15	J = distance between reference points in Y direction (note: add slotting tool width)
M16	P = number of parts in the X axis - excluding the bottom left part
M17	K = number of parts in the Y axis - excluding the bottom left part (Example: G31X100Y100I100J100P10K2)
M18	Tapping rear
M19	Work chute open
M20	Work chute closed
M21	Slug selector left
M22	Slug selector right
M23	P-subprogram call
M24	Subprogram end
M25	"Cross" = punch speed char
M26	Feed rate control
M27	Block delete

MULTIPLE PART PROGRAMMING

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: G31X100Y100I100J100P10K2)

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.



Amada G Code Manual

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counseling profession are interacting more with people from other cultures the U S sphere of influence throughout the world is spreading increasingly we are providing services to clients who are not Caucasian or of European heritage and our educational programs have been active in training both domestic students of diverse ethnic backgrounds as well as foreign students These factors combine to contribute to the need for those who provide counseling to understand the elements involved in interacting with a wide spectrum of people This book meets that need by providing a brief synopsis on such topics as common factors values universals cross cultural competence and models approaches and psychological perspectives of human behavior theories of personality The emphasis is on material that relies more on the use of the scientific method and data instead of anecdotal and experiential literature For the reader who is interested in obtaining information from which statements are derived there are references to investigate the material further Unlike other book that stress the barriers between counselor and client this book adds the perspective that there are factors that facilitate interactions between the two There are also frequent cross cultural examples in the book To facilitate awareness of similarities and differences in views of human behavior samples of African Arab Chinese and European American perspectives are represented There is also a relatively large section on applications This consists of such subjects as cross cultural aspects of psychological theories ethics research tests Euro American approaches and experiences client characteristics client and counselor interactions and therapeutic techniques Many other topics are covered as well Students and professionals in the fields of counseling and psychology will find this book to be an invaluable addition to their library **May 2022 - Surplus Record Machinery & Equipment Directory** Surplus Record,2022-05-01 SURPLUS RECORD is the leading independent business directory of new and used capital equipment machine tools machinery and industrial equipment listing over 95 000 industrial assets including metalworking and fabricating machine tools chemical and process equipment cranes air compressors pumps motors circuit breakers generators transformers turbines and more Over 1 100 businesses list with the SURPLUS RECORD May 2022 issue Vol 99 No 5 Psychology Wayne Weiten,1995 In this revision of his best selling text Wayne Weiten presents a text that is

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Ethics in Counseling and Psychotherapy Elizabeth Reynolds Welfel,1998 In Ethics in Counseling and Psychotherapy Standards Research and Emerging Issues Elizabeth Reynolds Welfel introduces you to the ethical standards of counseling and psychology and helps you develop an understanding of the ethical principles underlying those standards In addition the author presents her nine step model of ethical decision making for analyzing complex ethical problems in mental health practice In this book Welfel integrates current research on ethics fosters ethical sensitivity and examines the impact of recent changes in practice on responsible professional behavior Welfel also includes an often neglected topic how to take responsibility when one does engage in unethical behavior Through thoughtful guidance and illuminating applications Welfel helps readers understand their own vulnerability to unethical behavior and teaches ways to help reduce the risk of committing such violations

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Official Gazette of the United States Patent and Trademark Office United States. Patent and Trademark Office,2001

Sheet Metal Industries ,1987

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Conviction Oliver Rollins,2021-07-13 Exposing ethical dilemmas of neuroscientific research on violence this book warns against a dystopian future in which behavior is narrowly defined in relation to our biological makeup Biological explanations for violence have existed for centuries as has criticism of this kind of deterministic science haunted by a long history of horrific abuse Yet this program has endured because of and not despite its notorious legacy Today s scientists are well beyond the nature versus nurture debate Instead they contend that scientific progress has led to a nature and nurture biological and social stance that allows it to avoid the pitfalls of the past In Conviction Oliver Rollins cautions against this optimism arguing that the way these categories are imagined belies a dangerous continuity between past and present The late 1980s ushered in a wave of techno scientific advancements in the genetic and brain sciences Rollins focuses on an often

ignored strand of research the neuroscience of violence which he argues became a key player in the larger conversation about the biological origins of criminal violent behavior Using powerful technologies neuroscientists have rationalized an idea of the violent brain or a brain that bears the marks of predisposition toward dangerousness Drawing on extensive analysis of neurobiological research interviews with neuroscientists and participant observation Rollins finds that this construct of the brain is ill equipped to deal with the complexities and contradictions of the social world much less the ethical implications of informing treatment based on such simplified definitions Rollins warns of the potentially devastating effects of a science that promises to predict criminals before the crime is committed in a world that already understands violence largely through a politic of inequality

Index of Patents Issued from the United States Patent Office United States. Patent Office,1969

Catalog of Copyright Entries. Third Series Library of Congress. Copyright Office,1973

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