

## 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> | Grid X/Y-Z                                                                             |
|            | I = X spacing; + or -                                                                  |
|            | P = no. spaces X                                                                       |
|            | J = Y spacing; + or -                                                                  |
|            | K = no. spaces Y                                                                       |
| <b>G10</b> | Linear punch starting                                                                  |
|            | I = slot length                                                                        |
|            | J = angle                                                                              |
|            | P = punch length; + or -                                                               |
|            | Q = punch width; + or -                                                                |
|            | R = slot; + or -                                                                       |
| <b>G11</b> | 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 "J" 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, $\theta_1$ , $\theta_2$ or zero                                             |
|            | Q = hobbing pitch                                                                      |
| <b>G14</b> | Hobbing line                                                                           |
|            | I = length                                                                             |
|            | J = angle                                                                              |
|            | P = punch, $\theta_1$ , $\theta_2$ 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, $\theta_1$ , $\theta_2$ or zero |
|            | Q = pitch                                  |
|            | R = material thickness                     |
| <b>G03</b> | Punching line                              |
|            | I = length                                 |
|            | J = angle; + or -                          |
|            | P = punch, $\theta_1$ , $\theta_2$ 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> | Circle 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> | Slag selector left                         |
| <b>M19</b> | Slag 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> | Slag selector left         |
| <b>M19</b> | Slag 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 = LRV

|              |                       |       |                       |
|--------------|-----------------------|-------|-----------------------|
| <b>LC-10</b> | Multiple block store  | 0-99  | Processes while store |
| <b>RC</b>    | Multiple block recall | 00-99 | Display only          |
|              | Parameter M13 setting | 90-99 | Multiple block store  |

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



# Amada G Code Manual

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both challenging to think about and easy to learn from both visually stunning and conceptually integrated and both scientifically sound and fun to read Well respected in the field for its fresh original approach its attention to teaching learning issues and its impeccable scholarship Psychology Themes and Variations Third Edition offers much that is new new studies new topics new applications as well as a new theme culture influences behavior In a writing style users have termed near perfect Weiten emphasizes ideas instead of isolated facts and shows how research and application work in harmony Now using seven integrative themes to emphasize the connections between different areas of research in psychology Weiten challenges students to grapple with the big issues and tough questions while at the same time helping them master the basic concepts of psychology Throughout the book Weiten emphasizes the unity in psychology s intellectual heritage the themes as well as psychology s immense diversity the variations

**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

*Skill Based Automated Production* Peter Kopacek,R. Genser,1990-10-31 This volume will be of interest to all those who are involved in the development and integration of systems into the manufacturing and industrial process It draws together theoretical situations as well as many practical examples of systems which are currently in use in industry including computer integrated manufacturing CIM and flexible manufacturing systems FMS

**Official Gazette of the United States Patent and Trademark Office** United States. Patent and Trademark Office,2001 Sheet Metal Industries ,1987 **Moody's International Manual** ,1995

*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      *Directory of Machine Tools, Manufacturing Machinery & Related Products* ,1992

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