

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

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G00	Establishes coordinate system, tool position
G00	Absolute
G00	Incremental
G00	Punch off
G00	Quick punch off with offset
G00	Pattern origin
G00	Line at angle
G00	I = spacing
G00	J = angle; + or -
G00	K = no. spaces
G00	Arc
G00	I = radius
G00	J = starting angle; + or -
G00	P = angle increment; + or -
G00	K = no. holes
G00	Slot hole circle
G00	I = radius
G00	J = starting angle; + or -
G00	K = no. holes
G00	Grid X/Y-Z
G00	I = X spacing; + or -
G00	P = no. spaces X
G00	J = Y spacing; + or -
G00	K = no. spaces Y
G00	Slower punch starting
G00	I = slot length
G00	J = angle
G00	P = punch length; + or -
G00	Q = punch width; + or -
G00	D = hole; + or -
G00	No slug window using R
G00	I = Window length in J direction measured from G70 point. Positive value only.
G00	J = Angle measured from R degrees, positive angle only measured CCW from R degrees.
G00	P = Tool length, positive or negative value (the tool dimension in the "Z" direction).
G00	Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
G00	K = Window length perpendicular to "I".
G00	C = Angle of axis index tool, if applicable.
G00	T = Tool station number
G00	Rectangular cut-out
G00	I = hole length X axis; + or -
G00	J = hole length Y axis; + or -
G00	P = punch width X axis
G00	Q = punch width Y axis; optional
G00	Hobbing arc
G00	I = radius
G00	J = starting angle; + or -
G00	K = moving angle; + or -
G00	P = punch, R_x , R_y , or zero
G00	Q = hobbing pitch
G00	Hobbing line
G00	I = length
G00	J = angle
G00	P = punch, R_x , R_y , or zero
G00	Q = hobbing pitch

G⁰² FUNCTIONS

G02	Punching arc
G02	I = radius
G02	J = starting angle; + or -
G02	K = moving angle; + or -
G02	P = punch, R_x , R_y , or zero
G02	Q = pitch
G02	D = material thickness
G02	Punching line
G02	I = length
G02	J = angle; + or -
G02	P = punch, R_x , R_y , or zero
G02	Q = pitch
G02	D = material thickness
G02	Minor image X...Y...R...D...
G02	Auto repositioning
G02	Auto repositioning with offset
G02	Circle offset
G02	Drill function
G02	Return home, program end
G02	Program stop
G02	Optional stop
G02	Program end
G02	Punch delay effective
G02	Punch delay finish
G02	Hobbing start
G02	Hobbing stop
G02	Tapping start
G02	Single block storage
G02	Single block recall

MISCELLANEOUS FUNCTIONS

M00	Program stop
M01	Optional stop
M02	Program end
M03	Punch delay effective
M04	Punch delay finish
M05	Hobbing start
M06	Hobbing stop
M07	Tapping start
M08	Single block storage
M09	Single block recall
M10	Tapping rear
M11	Work chute open
M12	Work chute closed
M13	Slug selector left
M14	Slug selector right
M15	P-subprogram call
M16	Subprogram end
M17	"Cross" = punch speed char
M18	Feed rate control
M19	Block delete

MULTIPLE PART PROGRAMMING

G00	Multiple part layout
G00	X...Y...I...J...P...K...
G00	X = reference point for lower left hand part in X axis
G00	Y = reference point for lower left hand part in Y axis
G00	I = distance between reference points in X direction (note: add slotting tool width)
G00	J = distance between reference points in Y direction (note: add slotting tool width)
G00	P = number of parts in the X axis - excluding the bottom left part
G00	K = number of parts in the Y axis - excluding the bottom left part (Example: G001000Y0001000000000P0K2)

PUNCHING EXECUTION OF G00 MULTIPLE PARTS

G00	Execution of punching in horizontal direction (X direction).
G00	Execution of punching in vertical direction (Y direction).

MACROS = LRV

LRV	Multiple block store	0-99	Processes while store
LRV	Multiple block recall	00-99	Display only
LRV	Parameter M13 setting	00-99	Multiple macro store

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



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