

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

G¹ FUNCTIONS

G21	Isometric selection Establishes coordinate system, tool position
G22	Absolute
G23	Incremental
G24	Punch off
G25	Auto punch off with offset
G26	Pattern origin
G27	Line at angle
G28	I = spacing J = angle; + or - K = no. spaces
G29	Arc I = radius J = starting angle; + or - P = angle increment; + or - K = no. holes
G30	Slot hole circle I = radius J = starting angle; + or - K = no. holes
G31	Grid X/Y-Z I = X spacing; + or - P = no. spaces X J = Y spacing; + or - K = no. spaces Y
G32	Slower punch starting I = slot length J = angle P = punch length; + or - Must be Q = punch width; + or - same sign O = tab; + or -
G33	No slug window using R I = Window length in J direction measured from G29 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
G34	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
G35	Hobbing arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = hobbing pitch
G36	Hobbing line I = length J = angle P = punch, R_x , R_y , or zero Q = hobbing pitch

G² FUNCTIONS

G37	Punching arc I = radius J = starting angle; + or - K = moving angle; + or - P = punch, R_x , R_y , or zero Q = pitch O = material thickness
G38	Punching line I = length J = angle; + or - P = punch, R_x , R_y , or zero Q = pitch O = material thickness
G39	Minor image X...Y...R...Q...
G40	Auto repositioning
G41	Auto repositioning with offset
G42	Circle offset
G43	Drill function
G44	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	Slug selector left
M19	Slug 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	Slug selector left
M19	Slug selector right
M20	P-subprogram call
M21	Subprogram end
M22	"Cross" = punch speed char
M23	Feed rate control
M24	Block delete

MULTIPLE PART PROGRAMMING

G39	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: G39X100Y100I100J100P10K2)
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PUNCHING EXECUTION OF G39 MULTIPLE PARTS

G39	Execution of punching in horizontal direction (X direction).
G40	Execution of punching in vertical direction (Y direction).

MACROS = LRV

M00	Multiple block store	0-99	Processes while start
M01	Multiple block recall	00-99	Display only
M02	Parameter M02 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.



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