

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

G⁰¹ FUNCTIONS

G01 Incremental selection
Establishes coordinate system, tool position

G00 Absolute

G01 Incremental

G02 Punch off

G03 Data punch off with offset

G04 Pattern origin

G05 Line at angle
I = spacing
J = angle; + or -
K = no. spaces

Arc:

I = radius
J = starting angle; + or -
K = angle increment; + or -
L = no. holes

G06 Slot hole circle
I = radius
J = starting angle; + or -
K = no. holes

G07 Slot R/Side Y
I = R spacing; + or -
P = no. spaces X
J = Y spacing; + or -
K = no. spaces Y

G08 Slant punch starting
I = slot length
J = angle
P = punch length; + or - (Must be same sign)
Q = punch width; + or - (Must be same sign)
D = hole; + or -

G09 No slug 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 O degrees.
P = Tool length, positive or negative value (the tool dimension in the "Z" direction).
Q = Tool width, positive or negative value (the tool dimension in the "X" direction).
K = Window length perpendicular to "Y".
C = Angle of auto loader tool, if applicable.
T = Tool station number

G10 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

G11 Notching arc
I = radius
J = starting angle; + or -
K = ending angle; + or -
P = punch; R, Y, or zero
Q = notching punch

G12 Notching line
I = length
J = angle
P = punch; R, Y, or zero
Q = notching punch

G⁰² FUNCTIONS

G02 Punching arc
I = radius
J = starting angle; + or -
K = ending angle; + or -
P = punch; R, Y, or zero
Q = pitch
D = material thickness

G03 Punching line
I = length
J = angle; + or -
P = punch; R, Y, or zero
Q = pitch
D = material thickness

G04 Mirror image X... Y... R... D...

G05 Auto repositioning

G06 Auto repositioning with offset

G07 Circle offset

G08 Drill function

G09 Return home, program end

MISCELLANEOUS FUNCTIONS

M00 Program stop	M15 Tapping rear
M01 Optional stop	M80 Work chute open
M02 Program end	M81 Work chute closed
M03 Punch delay effective	M82 Slug selector left
M04 Punch delay break	M83 Slug selector right
M10 Feeding start	M98 Pre-subprogram call
M12 Feeding stop	M97 Subprogram end
M14 Tapping front	M99 "Gross" + punch speed char
M1 Single block storage	P Feed rate control
M2 Single block recall	Z Block delete

MULTIPLE PART PROGRAMMING

G00 Multiple part layout
X... Y... Z... 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
J = distance between reference points in Z 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: G001000Y0000I10000000P10K2

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

G02 Execution of punching in horizontal direction (X direction).
G03 Execution of punching in vertical direction (Z direction).

MACROS - L/M

L/M1 Multiple block store	0-99	Processes while store
M Multiple block recall	00-99	Output only
Parameter/ID setting	90-99	Multiple block store

T Prepares which do not use software for multiple product punching. Trial punching with programs using software for multiple product punching.
Z Remaining punch work after trial punching.
M Enter punch work of multiple product punching.

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SB Merriam



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Table of Contents G Codes For Amada Turret Punch

1. Understanding the eBook G Codes For Amada Turret Punch
 - The Rise of Digital Reading G Codes For Amada Turret Punch
 - Advantages of eBooks Over Traditional Books
2. Identifying G Codes For Amada Turret Punch
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an G Codes For Amada Turret Punch
 - User-Friendly Interface
4. Exploring eBook Recommendations from G Codes For Amada Turret Punch
 - Personalized Recommendations
 - G Codes For Amada Turret Punch User Reviews and Ratings
 - G Codes For Amada Turret Punch and Bestseller Lists
5. Accessing G Codes For Amada Turret Punch Free and Paid eBooks
 - G Codes For Amada Turret Punch Public Domain eBooks
 - G Codes For Amada Turret Punch eBook Subscription Services
 - G Codes For Amada Turret Punch Budget-Friendly Options

6. Navigating G Codes For Amada Turret Punch eBook Formats
 - ePub, PDF, MOBI, and More
 - G Codes For Amada Turret Punch Compatibility with Devices
 - G Codes For Amada Turret Punch Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of G Codes For Amada Turret Punch
 - Highlighting and Note-Taking G Codes For Amada Turret Punch
 - Interactive Elements G Codes For Amada Turret Punch
8. Staying Engaged with G Codes For Amada Turret Punch
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers G Codes For Amada Turret Punch
9. Balancing eBooks and Physical Books G Codes For Amada Turret Punch
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection G Codes For Amada Turret Punch
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine G Codes For Amada Turret Punch
 - Setting Reading Goals G Codes For Amada Turret Punch
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of G Codes For Amada Turret Punch
 - Fact-Checking eBook Content of G Codes For Amada Turret Punch
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

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