

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

G⁰¹ FUNCTIONS

G21	Mathematical selection Establishes coordinate system, tool position
G22	Absolute
G23	Incremental
G24	Punch off
G24.1	Auto punch off with offset
G25	Pattern origin
G26	Line of angle
G27	I = spacing
J	angle; + or -
K	no. spaces
G28	ARC
I	= radius
J	= starting angle; + or -
P	= angle increment; + or -
K	= no. holes
G29	Slot hole circle
I	= radius
J	= starting angle; θ or °
K	= no. holes
G30	Slot R/Side Y
I	= R spacing; + or -
P	= no. spaces X
J	= Y spacing; + or -
K	= no. spaces Y
G31	Slower speed starting
I	= slot length
J	= angle
P	= punch length; + or -
Q	= punch width; + or -
D	= hole; + or -
G32	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 R 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 "R" direction).
R	= Window length perpendicular to "I".
C	= Angle of auto loader tool, if applicable.
T	= Tool station number
G33	Rectangular cut-out
I	= hole length X axis; + or -
J	= hole length Y axis; + or -
P	= punch width Z axis
Q	= punch width R axis - optional
G34	Notching arc
I	= radius
J	= starting angle; + or -
K	= ending angle; + or -
P	= punch θ, °, or zero
Q	= notching pitch
G35	Notching line
I	= length
J	= angle
P	= punch θ, °, or zero
Q	= notching pitch

G⁰² FUNCTIONS

G36	Punching arc
I	= radius
J	= starting angle; + or -
K	= ending angle; + or -
P	= punch θ, °, or zero
Q	= pitch
D	= material thickness
G37	Punching line
I	= length
J	= angle; + or -
P	= punch θ, °, or zero
Q	= pitch
D	= material thickness
G38	Minor image X...Y...R...D...
G39	Auto repositioning
G40	Auto repositioning with offset
G41	Circle offset
G42	Event function
G43	Return home, program end
MISCELLANEOUS FUNCTIONS	
M00	Program stop
M01	Optional stop
M02	Program end
M03	Punch delay effective
M04	Punch delay break
M05	Feeding start
M06	Feeding stop
M07	Tapping start
M08	Single block storage
M09	Single block recall
M15	Tapping rear
M80	Work chute open
M81	Work chute closed
M82	Slug selector left
M83	Slug selector right
M84	Pre-subprogram call
M87	Subprogram end
M99	"Gense" = punch speed change
P	Feed rate control
Z	Block delete

MULTIPLE PART PROGRAMMING

G44	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
Z	= 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: G44X100Y100Z100I100J100P10K2	

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

G08	Execution of punching in horizontal direction (X direction).		
G09	Execution of punching in vertical direction (Z direction).		
MACROS = G17			
G17.1	Multiple block store	0-99	Processes while start
G17.2	Multiple block recall	00-99	Output only
	Parameter 018 setting	00-99	Multiple block store

- T** Prepares which do not use software for multiple product punching. Trial punching with programs using software for multiple product punching.
- 01** Remaining punch work after trial punching.
- 02** Enter punch work of multiple product punching.



G Codes For Amada Turret Punch

Michael Brown



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