

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
G24.2	Pattern origin
G25	Line at angle I = spacing J = angle; + or - K = no. spaces
G26	Arc I = radius J = starting angle; + or - P = angle increment; + or - K = no. holes
G27	Slot hole circle I = radius J = starting angle; θ or - K = no. holes
G28	Slot R/Side Y I = R spacing; + or - P = no. spaces X J = Y spacing; + or - K = no. spaces Y
G29	Slower speed 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 -
G30	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 "R" direction). K = Window length perpendicular to "Y". C = Angle of auto loader tool, if applicable. T = Tool station number
G31	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
G32	Notching arc I = radius J = starting angle; + or - K = ending angle; + or - P = punch; θ, γ, or zero Q = notching pitch
G33	Notching line I = length J = angle P = punch; θ, γ, or zero Q = notching pitch

G⁰² FUNCTIONS

G34	Punching arc I = radius J = starting angle; + or - K = ending angle; + or - P = punch; θ, γ, or zero Q = pitch D = material thickness
G35	Punching line I = length J = angle; + or - P = punch; θ, γ, or zero Q = pitch D = material thickness
G36	Minor image X... Y... R... D...
G37	Auto repositioning
G38	Auto repositioning with offset
G39	Circle offset
G40	Event function
G41	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
M12	Feeding start	M88	Pre-subprogram call
M13	Feeding stop	M87	Subprogram end
M14	Tapping front	M99	"Goto" a punch speed char
A1	Single block storage	P	Feed rate control
R1	Single block recall	Z	Block delete

MULTIPLE PART PROGRAMMING

G99	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: G991000Y000Z10000000P10K2)

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 = LRV

LR01	Multiple block store	0-99	Processes while start
LR	Multiple block recall	00-99	Output only
	Parameter/CR 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.
- U** Remaining punch work after trial punching.
- V** Enter punch work of multiple product punching.



M Codes For Amada Laser

Patrick Vollmar



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Table of Contents M Codes For Amada Laser

1. Understanding the eBook M Codes For Amada Laser
 - The Rise of Digital Reading M Codes For Amada Laser
 - Advantages of eBooks Over Traditional Books
2. Identifying M Codes For Amada Laser
 - 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 M Codes For Amada Laser
 - User-Friendly Interface
4. Exploring eBook Recommendations from M Codes For Amada Laser
 - Personalized Recommendations
 - M Codes For Amada Laser User Reviews and Ratings
 - M Codes For Amada Laser and Bestseller Lists
5. Accessing M Codes For Amada Laser Free and Paid eBooks
 - M Codes For Amada Laser Public Domain eBooks

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

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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