

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

G<sup>01</sup> 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 = tab; + 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 CW 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 Z axis  
Q = punch width R 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

G<sup>02</sup> 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** Offset offset

**G08** Drill function

**G09** Return home, program end

## MISCELLANEOUS FUNCTIONS

<b>M00</b> Program stop	<b>M15</b> Tapping rear
<b>M01</b> Optional stop	<b>M80</b> Work chute open
<b>M02</b> Program end	<b>M81</b> Work chute closed
<b>M03</b> Punch delay effective	<b>M82</b> Slug selector left
<b>M04</b> Punch delay break	<b>M83</b> Slug selector right
<b>M10</b> Feeding start	<b>M88</b> Pre-subprogram call
<b>M12</b> Feeding stop	<b>M87</b> Subprogram end
<b>M14</b> Tapping front	<b>M99</b> "Gense" a punch speed change
<b>M1</b> Single block storage	<b>P</b> Feed rate control
<b>M2</b> Single block recall	<b>Z</b> 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  
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: G001000Y0000Z10000000P10K2

## 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

<b>L/M1</b> Multiple block store	0-99	Processes while store
<b>M</b> Multiple block recall	00-99	Output only
Parameter 000 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.  
**Z** Remaining punch work after trial punching.  
**M** Enter punch work of multiple product punching.

# M Codes For Amada Laser

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