

## 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 = 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 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** Circle 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>M15</b> Feeding stop	<b>M87</b> Subprogram end
<b>M16</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  
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: 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 = LRV

<b>L000</b> Multiple block store	0-99	Processes while store
<b>L01</b> Multiple block recall	00-99	Digits 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.

# G Codes For Turret

**RJ Alexander**



## **G Codes For Turret:**

## Reviewing **G Codes For Turret**: Unlocking the Spellbinding Force of Linguistics

In a fast-paced world fueled by information and interconnectivity, the spellbinding force of linguistics has acquired newfound prominence. Its capacity to evoke emotions, stimulate contemplation, and stimulate metamorphosis is actually astonishing. Within the pages of "**G Codes For Turret**," an enthralling opus penned by a very acclaimed wordsmith, readers set about an immersive expedition to unravel the intricate significance of language and its indelible imprint on our lives. Throughout this assessment, we shall delve in to the book is central motifs, appraise its distinctive narrative style, and gauge its overarching influence on the minds of its readers.

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