

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

G⁰¹ FUNCTIONS

G00	Instantaneous selection
G00	Establishes coordinate system, tool position
G00	Absolute
G01	Incremental
G02	Punch off
G04	Delay punch off with offset
G05	Pattern origin
G06	Line at angle
G07	I = spacing
G08	J = angle; + or -
G09	K = no. spaces
G10	Arc
G11	I = radius
G12	J = starting angle; + or -
G13	P = angle increment; + or -
G14	K = no. holes
G15	Slot hole circle
G16	I = radius
G17	J = starting angle; + or -
G18	K = no. holes
G19	Slot R/Side Y
G20	I = R spacing; + or -
G21	P = no. spaces X
G22	J = R spacing; + or -
G23	K = no. spaces Y
G24	Slower punch starting
G25	I = slot length
G26	J = angle
G27	P = punch length; + or -
G28	Q = punch width; + or -
G29	R = slot; + or -
G30	No slug window using R
G31	I = Window length in J direction measured from G10 point. Positive value only.
G32	J = Angle measured from R degrees, positive angle only measured CCW from R degrees.
G33	P = Tool length, positive or negative value (the tool dimension in the "Z" direction).
G34	Q = Tool width, positive or negative value (the tool dimension in the "R" direction).
G35	K = Window length perpendicular to "I".
G36	O = Angle of axis index tool, if applicable.
G37	T = Tool station number
G38	Rectangular cut-out
G39	I = hole length X axis; + or -
G40	J = hole length Y axis; + or -
G41	P = punch width X axis
G42	Q = punch width Y axis; optional
G43	Holding arc
G44	I = radius
G45	J = starting angle; + or -
G46	K = moving angle; + or -
G47	P = punch, R, Y, or zero
G48	Q = holding pitch
G49	Holding line
G50	I = length
G51	J = angle
G52	P = punch, R, Y, or zero
G53	Q = holding pitch

G⁰² FUNCTIONS

G54	Punching arc
G55	I = radius
G56	J = starting angle; + or -
G57	K = moving angle; + or -
G58	P = punch, R, Y, or zero
G59	Q = pitch
G60	R = material thickness
G61	Punching line
G62	I = length
G63	J = angle; + or -
G64	P = punch, R, Y, or zero
G65	Q = pitch
G66	R = material thickness
G67	Minor image X... Y... R... Q...
G68	Auto repositioning
G69	Auto repositioning with offset
G70	Circle offset
G71	Drill function
G72	Return home, program end
G73	Program stop
G74	Optional stop
G75	Program end
G76	Punch delay effective
G77	Punch delay finish
G78	Holding start
G79	Holding stop
G80	Tapping start
G81	Single block storage
G82	Single block recall

MISCELLANEOUS FUNCTIONS

M00	Program stop
M01	Optional stop
M02	Program end
M03	Punch delay effective
M04	Punch delay finish
M05	Holding start
M06	Holding stop
M07	Tapping start
M08	Single block storage
M09	Single block recall
M10	Tapping rear
M11	Work chute open
M12	Work chute closed
M13	Slug selector left
M14	Slug selector right
M15	P-subprogram call
M16	Subprogram end
M17	"Cross" = punch speed char
M18	Feed rate control
M19	Block delete

MULTIPLE PART PROGRAMMING

M20	Multiple part layout
M21	X... Y... I... J... P... K...
M22	X = reference point for lower left hand part in X axis
M23	Y = reference point for lower left hand part in Y axis
M24	I = distance between reference points in X direction (note: add slotting tool width)
M25	J = distance between reference points in Y direction (note: add slotting tool width)
M26	P = number of parts in the X axis - excluding the bottom left part
M27	K = number of parts in the Y axis - excluding the bottom left part (Example: G001000Y0001000000000P002)

PUNCHING EXECUTION OF G08 MULTIPLE PARTS

G08	Execution of punching in horizontal direction (X direction).
G09	Execution of punching in vertical direction (Y direction).

MACROS = LRV

LRV	Multiple block store	0-99	Processes while start
LR	Multiple block recall	00-99	Signals only
	Parameter M13 setting	90-99	Multiple block store

T	Prepares which do not use software for multiple product punching.
T	Try punching with program using software for multiple product punching.
T	Resuming punch work after trial punching.
T	Enter punch work of multiple product punching.

Amada Cnc Code G M Manual

R Bogdan



Amada Cnc Code G M Manual:

Skill Based Automated Production Peter Kopacek,R. Genser,1990-10-31 This volume will be of interest to all those who are involved in the development and integration of systems into the manufacturing and industrial process It draws together theoretical situations as well as many practical examples of systems which are currently in use in industry including computer integrated manufacturing CIM and flexible manufacturing systems FMS **Directory of Machine Tools, Manufacturing Machinery & Related Products** ,1992 *Current List of Medical Literature* ,1958 Includes section Recent book acquisitions varies Recent United States publications formerly published separately by the U S Army Medical Library **Monthly Catalog of United States Government Publications** United States. Superintendent of Documents,1976 February issue includes Appendix entitled Directory of United States Government periodicals and subscription publications September issue includes List of depository libraries June and December issues include semiannual index *Current List of Medical Literature* ,1958 **Predicasts F & S Index United States** Predicasts, inc,1989 A comprehensive index to company and industry information in business journals **American Machinist & Automated Manufacturing** ,1986 Thomas Register of American Manufacturers ,2003 Vols for 1970 71 includes manufacturers catalogs Paperbound Books in Print ,1970 Metals Abstracts ,1996 **Government Reports Announcements & Index** ,1995-10 *The New York Times Magazine* ,1965 **Subject Guide to Books in Print** ,1984 *Bibliography of Agriculture with Subject Index* ,1971 **The Tribune** ,1944 Index to Legal Periodicals & Books ,2002 Who's who in Finance and Business ,2008 **CNC LATHE G-CODE and M-CODE ILLUSTRATIVE HANDBOOK** Patrick Talverdi,2010-10 This handbook is a practical source to help the reader understand the G codes and M codes in CNC lathe programming It covers CNC lathe programming codes for everyday use by related industrial users such as managers supervisors engineers machinists or even college students The codes have been arranged in some logical ways started with the code number code name group number quick description command format notes and some examples Moreover the reader will find five complementary examples and plenty of helpful tables in appendix **Numerical Control Programming** George C. Stanton,1989-05-01 *Numerical Control Programming* George C. Stanton,1988-01-01

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Table of Contents Amada Cnc Code G M Manual

1. Understanding the eBook Amada Cnc Code G M Manual
 - The Rise of Digital Reading Amada Cnc Code G M Manual
 - Advantages of eBooks Over Traditional Books
2. Identifying Amada Cnc Code G M Manual
 - 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 Amada Cnc Code G M Manual
 - User-Friendly Interface
4. Exploring eBook Recommendations from Amada Cnc Code G M Manual
 - Personalized Recommendations
 - Amada Cnc Code G M Manual User Reviews and Ratings
 - Amada Cnc Code G M Manual and Bestseller Lists

5. Accessing Amada Cnc Code G M Manual Free and Paid eBooks
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 - Amada Cnc Code G M Manual Budget-Friendly Options
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 - ePub, PDF, MOBI, and More
 - Amada Cnc Code G M Manual Compatibility with Devices
 - Amada Cnc Code G M Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Amada Cnc Code G M Manual
 - Highlighting and Note-Taking Amada Cnc Code G M Manual
 - Interactive Elements Amada Cnc Code G M Manual
8. Staying Engaged with Amada Cnc Code G M Manual
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Amada Cnc Code G M Manual
9. Balancing eBooks and Physical Books Amada Cnc Code G M Manual
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Amada Cnc Code G M Manual
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Amada Cnc Code G M Manual
 - Setting Reading Goals Amada Cnc Code G M Manual
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Amada Cnc Code G M Manual
 - Fact-Checking eBook Content of Amada Cnc Code G M Manual
 - 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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in the united states canada great britain and ireland the modern legend of santa claus typically includes diminutive elves at christmas green clad elves with pointy ears and pointy hats as santa s employees assistants they make the toys in santa s workshop located in the north pole in recent years other toys usually high tech toys like computers video games dvds and dvd pl

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