

NC TURRET PUNCH PRESS

ARIES-245 

PROGRAMMING MANUAL

 **AMADA**

ARIES245 PRO-E03-199111

CONTENTS

PROGRAMMING BASICS

PROCESS FOR THE PRODUCTS	1-1
PROGRAMMING	1-2
CALCULATION OF COORDINATES	1-3
BASIC FUNCTION CODES	1-4
TAPE FORMAT	1-4
G92 - ESTABLISHING COORDINATE SYSTEM	1-4
G90 - ABSOLUTE PROGRAMMING	1-5
G91 - INCREMENTAL PROGRAMMING	1-5
G70 - PUNCH OFF (NO PUNCHING)	1-5
G27 - AUTO REPOSITIONING	1-6
G25 - AUTO REPOSITIONING	1-7
G50 - HOME RETRACT	1-7
M00 - PROGRAM STOP	1-8
M01 - OPTIONAL STOP	1-8
M08 - PUNCH DELAY START, M09 - PUNCH DELAY CANCEL	1-8
M12 - NIBBLING START, M13 - NIBBLING CANCEL	1-9
T00 - DESIGNATION OF TOOL NUMBER	1-9
N0000 - SEQUENCE NUMBER	1-9
F0 - DESIGNATION OF AXIS FEED SPEED	1-10
PROGRAM NAME	1-10
PROGRAMMING PROCEDURE	1-11
HINTS ON PROCESSING	1-13
CALCULATING LONG RECTANGULAR HOLE	1-15
CALCULATING LARGE RECTANGULAR OPENING	1-17
CALCULATING RECTANGULAR OPENING WITH ROUNDED CORNERS	1-19
CALCULATING 45° NOTCH	1-22
HINTS ON PROGRAMMING	1-25
HINTS ON AUTO REPOSITIONING	1-26

BASIC SOFTWARE

G72 - DESIGNATION OF PATTERN ORIGIN 2-1
G22 - LINE AT DISTANCE 2-2
G28 - LINE AT ANGLE 2-3
G29 - ARC 2-5
G26 - BOLT HOLE CIRCLE 2-7
G36 - GRID-X, G37 - GRID-Y 2-9
G66 - SHEAR PROOF 2-11
G67 - SQUARE 2-13
G68 - NIBBLING ARC 2-15
G69 - NIBBLING LINE 2-17
G78 - PUNCHING ARC 2-19
G79 - PUNCHING LINE 2-21
PATTERN MEMORY AND PATTERN RECALL 2-22
G93 - OFFSET 2-24
MACRO FUNCTION 2-26
G73 - SYMMETRY 2-33
G77 - ROTATION 2-34
SUBPROGRAM 2-35
BLOCK DELETION 2-36
INPUT OF DECIMAL POINT 2-36

MULTIPLE PART PUNCHING

GENERAL DESCRIPTION AND PROGRAMMING EXAMPLE 3-1
G98 - SETTING OF REFERENCE POINT AND LAYOUT FOR
MULTIPLE PART PUNCHING 3-4
U00 TO V00 - STORING OF PART PROGRAM 3-8
G75, G76 W00 Q0 - RECALLING AND EXECUTION OF
PART PROGRAM 3-10
TRIAL PUNCHING, POST-TRIAL PUNCHING, AND FULL PUNCHING 3-14

AUTO-INDEX PROGRAMMING

PROGRAM EXAMPLE (1) 4-2
PROGRAM EXAMPLE (2) 4-2
PROGRAM EXAMPLE (3) 4-3
PROGRAM EXAMPLE (4) 4-4

CLAMP DEAD ZONE DIAGRAM

CLAMP DEAD ZONE 5-1
HOW TO USE DEAD ZONE DIAGRAMS 5-2
DEAD ZONE DIAGRAMS 5-3

(APPENDIX) PROGRAMMING EXAMPLE

EX. 1 GENERAL PUNCHING 6-1
EX. 2 PUNCHING WITH AUTO REPOSITIONING 6-6
EX. 3 MULTIPLE PART PUNCHING 6-11

(APPENDIX) DISPLAYED FORMAT ON CRT 7-1