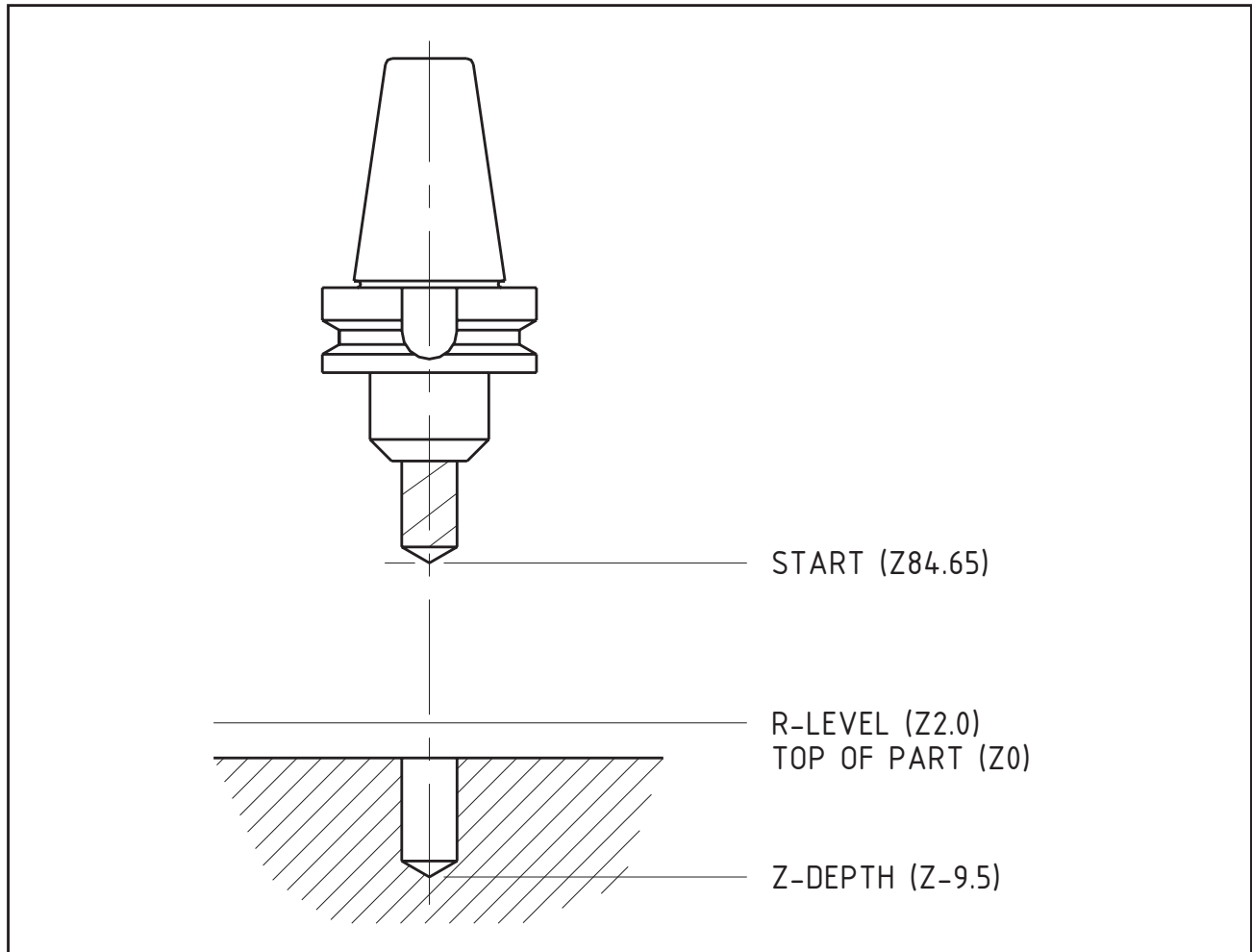


Z-axis Motions

G00 is a rapid motion, G01 is a linear motion. R-level is a clearance above part for fixed cycles.



ABSOLUTE	
G-code	Z-value
G00	Z2.0
G01	Z-9.5
G00	Z84.65

INCREMENTAL	
G-code	Z-value
G00	Z-82.65
G01	Z-11.5
G00	Z94.15