

Continuous Linear XY Motion 1

(22-03A - ABSOLUTE - A-B-C-...-I-J-A)

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N1 G20
N2 G90 G00 X0.5 Y0.5      (POINT A)
N3 G01 Y1.0 F5.0          (POINT B)
N4 X1.0 Y2.5              (POINT C)
N5 X1.625 Y2.125          (POINT D)
N6 X2.5                   (POINT E)
N7 X2.3 Y1.3              (POINT F)
N8 X3.5                   (POINT G)
N9 Y0.5                   (POINT H)
N10 X1.75 Y0.8            (POINT I)
N11 Y0.5                  (POINT J)
N12 X0.5                   (POINT A)
N13 ...

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(22-03B - ABSOLUTE - A-J-I-...-C-B-A)

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N1 G20
N2 G90 G00 X0.5 Y0.5      (POINT A)
N3 G01 X1.75 F5.0         (POINT J)
N4 Y0.8                   (POINT I)
N5 X3.5 Y0.5              (POINT H)
N6 Y1.3                   (POINT G)
N7 X2.3                   (POINT F)
N8 X2.5 Y2.125            (POINT E)
N9 X1.625                 (POINT D)
N10 X1.0 Y2.5             (POINT C)
N11 X0.5 Y1.0             (POINT B)
N12 Y0.5                  (POINT A)
N13 ...

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(22-03C - INCREMENTAL - A-B-C-...-I-J-A)

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N1 G20
N2 G90 G00 X0.5 Y0.5      (POINT A)
N3 G91 G01 Y0.5 F5.0      (POINT A TO B)
N4 X0.5 Y1.5              (POINT B TO C)
N5 X0.625 Y-0.375         (POINT C TO D)
N6 X0.875                 (POINT D TO E)
N7 X-0.2 Y-0.825          (POINT E TO F)
N8 X1.2                   (POINT F TO G)
N9 Y-0.8                  (POINT G TO H)
N10 X-1.75 Y0.3           (POINT H TO I)
N11 Y-0.3                 (POINT I TO J)
N12 X-1.25                (POINT J TO A)
N13 ...

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(22-03D - INCREMENTAL - (A-J-I-...-C-B-A)

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N1 G20
N2 G90 G00 X0.5 Y0.5      (POINT A)
N3 G91 G01 X1.25 F5.0     (POINT A TO J)
N4 Y0.3                   (POINT J TO I)
N5 X1.75 Y-0.3            (POINT I TO H)
N6 Y0.8                   (POINT H TO G)
N7 X-1.2                  (POINT G TO F)
N8 X0.2 Y0.825            (POINT F TO E)
N9 X-0.875                (POINT E TO D)
N10 X-0.625 Y0.375        (POINT D TO C)
N11 X-0.5 Y-1.5           (POINT C TO B)
N12 Y-0.5                 (POINT B TO A)
N13 ...

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