

Absolute and Incremental Mode

This project is tied up with the next project, 11-06. The purpose of the two examples is to demonstrate how a program input changes, when only one hole location is changed in the drawing. This is a typical situation when a drawing is revised because of an engineering change.

In the table below, all holes are as per original drawing (*original drawing - no revision*):

G90 - ABSOLUTE MODE		
Hole	X-location	Y-location
SP	X-1.0	Y2.1
A	X0.4	Y0.375
B	X0.9	Y1.0
C	X0.9	Y1.725
D	X1.9	Y1.725
E	X1.4	Y2.375
F	X3.4	Y2.675
G	X4.15	Y2.375
H	X3.775	Y1.375
I	X4.15	Y1.375
SP	X-1.0	Y2.1

G91 - INCREMENTAL MODE		
Holes	X-motion	Y-motion
at SP	(0.0)	(0.0)
SP to A	X1.4	Y-1.725
A to B	X0.5	Y0.625
B to C	X0	Y0.725
C to D	X1.0	Y0
D to E	X-0.5	Y0.65
E to F	X2.0	Y0.3
F to G	X0.75	Y-0.3
G to H	X-0.375	Y-1.0
H to I	X0.375	Y0
I to SP	X-5.15	Y0.725