

Absolute and Incremental Mode

This project is a continuation of the previous project, *11-05*. It shows the change for the *F* hole location (highlighted in both modes).

Note that only *one* change was required for the absolute mode, whereby *two* changes were required for the incremental mode. This is quite typical to these two modes of programming.

In the table below, most holes are as per original drawing, except those highlighted - they represent the *necessary program change*, because of the drawing revision (change between *11-05* and *11-06*).

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	X3.275	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	X1.875	Y0.3
F to G	X0.875	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