

## Simple Linear Motion 1

(22-01A - ABSOLUTE - A-B-C-D-E-F-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G01 X0.5 Y1.0 F10.0    (POINT B)
X1.25                  (POINT C)
Y1.875                 (POINT D)
X2.5 Y1.625            (POINT E)
Y0                     (POINT F)
X0                     (POINT A)

```

(22-01B - ABSOLUTE - A-F-E-D-C-B-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G01 X2.5 Y1.0 F10.0    (POINT F)
Y1.625                 (POINT E)
X1.25 Y1.875           (POINT D)
Y1.0                   (POINT C)
X0.5                   (POINT B)
X0 Y0                  (POINT A)

```

(22-01C - INCREMENTAL - A-B-C-D-E-F-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G91 G01 X0.5 Y1.0 F10.0 (POINT A TO B)
X0.75                  (POINT B TO C)
Y0.875                 (POINT C TO D)
X1.25 Y-0.25           (POINT D TO E)
Y-1.625                (POINT E TO F)
X-2.5                  (POINT F TO A)

```

(22-01D - INCREMENTAL - A-F-E-D-C-B-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G91 G01 X2.5 Y1.0 F10.0 (POINT A TO F)
Y1.625                 (POINT F TO E)
X-1.25 Y0.25           (POINT E TO D)
Y-0.875                (POINT D TO C)
X-0.75                 (POINT C TO B)
X-0.5 Y-1.0            (POINT B TO A)

```