

Absolute and Incremental Mode

Location	G90 - ABSOLUTE MODE	
	X	Y
A	X1.4000	Y0.0000
B	X1.2124	Y0.7000
C	X0.7000	Y1.2124
D	X0.0000	Y1.4000
E	X-0.7000	Y1.2124
F	X-1.2124	Y0.7000
G	X-1.4000	Y0.0000
H	X-1.2124	Y-0.7000
I	X-0.7000	Y-1.2124
J	X0.0000	Y-1.4000
K	X0.7000	Y-1.2124
L	X1.2124	Y-0.7000

Distance	G91 - INCREMENTAL MODE	
	X	Y
A to B	X-0.1876	Y0.7000
B to C	X-0.5124	Y0.5124
C to D	X-0.7000	Y0.1876
D to E	X-0.7000	Y-0.1876
E to F	X-0.5124	Y-0.5124
F to G	X-0.1876	Y-0.7000
G to H	X0.1876	Y-0.7000
H to I	X0.5124	Y-0.5124
I to J	X0.7000	Y-0.1876
J to K	X0.7000	Y0.1876
K to L	X0.5124	Y0.5124
(L to A)	X0.1876	Y0.7000