

Simple Linear Motion 2

(22-02A - ABSOLUTE -A-B-C-...-J-K-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G01 Y2.0 F10.0         (POINT B)
X1.0 Y2.5              (POINT C)
X1.5 Y3.0              (POINT D)
Y4.0                   (POINT E)
X3.0                   (POINT F)
Y3.25                  (POINT G)
X2.5                   (POINT H)
Y2.25                  (POINT I)
X3.0                   (POINT J)
X2.25 Y0               (POINT K)
X0                     (POINT A)

```

(22-02B - ABSOLUTE - A-K-J-...-C-B-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G01 X2.25 F10.0        (POINT K)
X3.0 Y2.25             (POINT J)
X2.5                   (POINT I)
Y3.25                  (POINT H)
X3.0                   (POINT G)
Y4.0                   (POINT F)
X1.5                   (POINT E)
Y3.0                   (POINT D)
X1.0 Y2.5              (POINT C)
X0 Y2.0                (POINT B)
Y0                     (POINT A)

```

(22-02C - INCREMENTAL - A-B-C-...-J-K-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G91 G01 Y2.0 F10.0     (POINT A TO B)
X1.0 Y0.5              (POINT B TO C)
X0.5 Y0.5              (POINT C TO D)
Y1.0                   (POINT D TO E)
X1.5                   (POINT E TO F)
Y-0.75                 (POINT F TO G)
X-0.5                  (POINT G TO H)
Y-1.0                  (POINT H TO I)
X0.5                   (POINT I TO J)
X-0.75 Y-2.25          (POINT J TO K)
X-2.25                 (POINT K TO A)

```

(22-02D - INCREMENTAL - A-K-J-...-C-B-A)

```

G20
G90 G00 X0 Y0          (POINT A)
G91 G01 X2.25 F10.0    (POINT A TO K)
X0.75 Y2.25           (POINT K TO J)
X-0.5                  (POINT J TO I)
Y1.0                   (POINT I TO H)
X0.5                   (POINT H TO G)
Y0.75                  (POINT G TO F)
X-1.5                  (POINT F TO E)
Y-1.0                  (POINT E TO D)
X-0.5 Y-0.5           (POINT D TO C)
X-1. Y-0.5             (POINT C TO B)
Y-2.0                  (POINT B TO A)

```