

Continuous Linear XY Motion 2

(22-04A - ABSOLUTE - A-B-C-...-I-J-A)

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N1 G20
N2 G90 G00 X0.375 Y0.375 (POINT A)
N3 G01 Y0.875 F5.0 (POINT B)
N4 X1.0 Y2.475 (POINT C)
N5 X1.775 Y1.875 (POINT D)
N6 X2.75 Y2.1 (POINT E)
N7 X2.55 Y1.175 (POINT F)
N8 X3.5 (POINT G)
N9 Y0.375 (POINT H)
N10 X1.75 Y0.675 (POINT I)
N11 Y0.375 (POINT J)
N12 X0.375 (POINT A)
N13 ...

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(22-04B - ABSOLUTE - A-J-I-...-C-B-A)

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N1 G20
N2 G90 G00 X0.375 Y0.375 (POINT A)
N3 G01 X1.75 F5.0 (POINT J)
N4 Y0.675 (POINT I)
N5 X3.5 Y0.375 (POINT H)
N6 Y1.175 (POINT G)
N7 X2.55 (POINT F)
N8 X2.75 Y2.1 (POINT E)
N9 X1.775 Y1.875 (POINT D)
N10 X1.0 Y2.475 (POINT C)
N11 X0.375 Y0.875 (POINT B)
N12 Y0.375 (POINT A)
N13 ...

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(22-04C - INCREMENTAL - A-B-C-...-I-J-A)

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N1 G20
N2 G90 G00 X0.375 Y0.375 (POINT A)
N3 G91 G01 Y0.5 F5.0 (POINT A TO B)
N4 X0.625 Y1.6 (POINT B TO C)
N5 X0.775 Y-0.6 (POINT C TO D)
N6 X0.975 Y0.225 (POINT D TO E)
N7 X-0.2 Y-0.925 (POINT E TO F)
N8 X0.95 (POINT F TO G)
N9 Y-0.8 (POINT G TO H)
N10 X-1.75 Y0.3 (POINT H TO I)
N11 Y-0.3 (POINT I TO J)
N12 X-1.375 (POINT J TO A)
N13 ...

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(22-04D - INCREMENTAL - A-J-I-...-C-B-A)

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N1 G20
N2 G90 G00 X0.375 Y0.375 (POINT A)
N3 G91 G01 X1.375 F5.0 (POINT A TO J)
N4 Y0.3 (POINT J TO I)
N5 X1.75 Y-0.3 (POINT I TO H)
N6 Y0.8 (POINT H TO G)
N7 X-0.95 (POINT G TO F)
N8 X0.2 Y0.925 (POINT F TO E)
N9 X-0.975 Y-0.225 (POINT E TO D)
N10 X-0.775 Y0.6 (POINT D TO C)
N11 X-0.625 Y-1.6 (POINT C TO B)
N12 Y-0.5 (POINT B TO A)

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