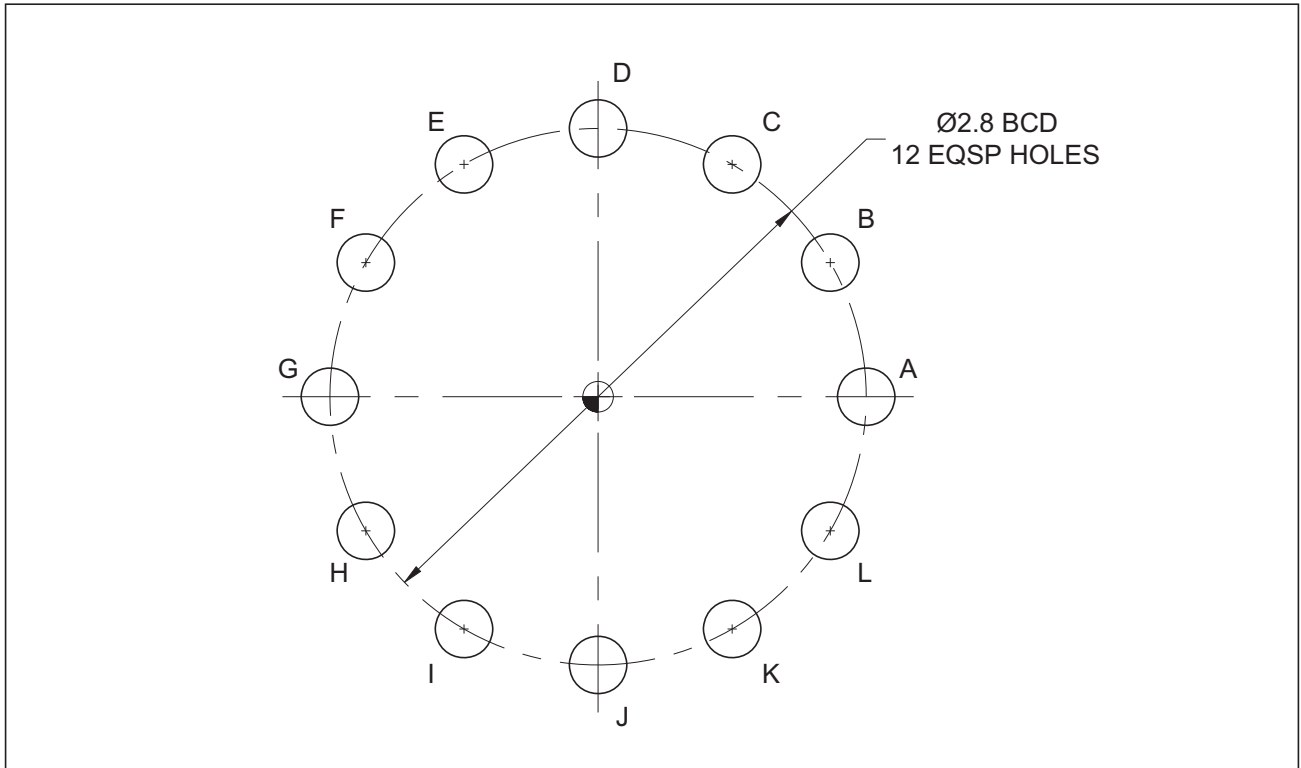


11-04

Absolute and Incremental Mode

Calculate all *XY* coordinates *and* motions to *four* decimal places. Points are identified from *A* to *L*. Start at point *A* and continue sequentially in the counterclockwise direction, through all points.



Location	G90 - ABSOLUTE MODE	
	X	Y
A		
B		
C		
D		
E		
F		
G		
H		
I		
J		
K		
L		

Distance	G91 - INCREMENTAL MODE	
	X	Y
A to B		
B to C		
C to D		
D to E		
E to F		
F to G		
G to H		
H to I		
I to J		
J to K		
K to L		
-	-	-