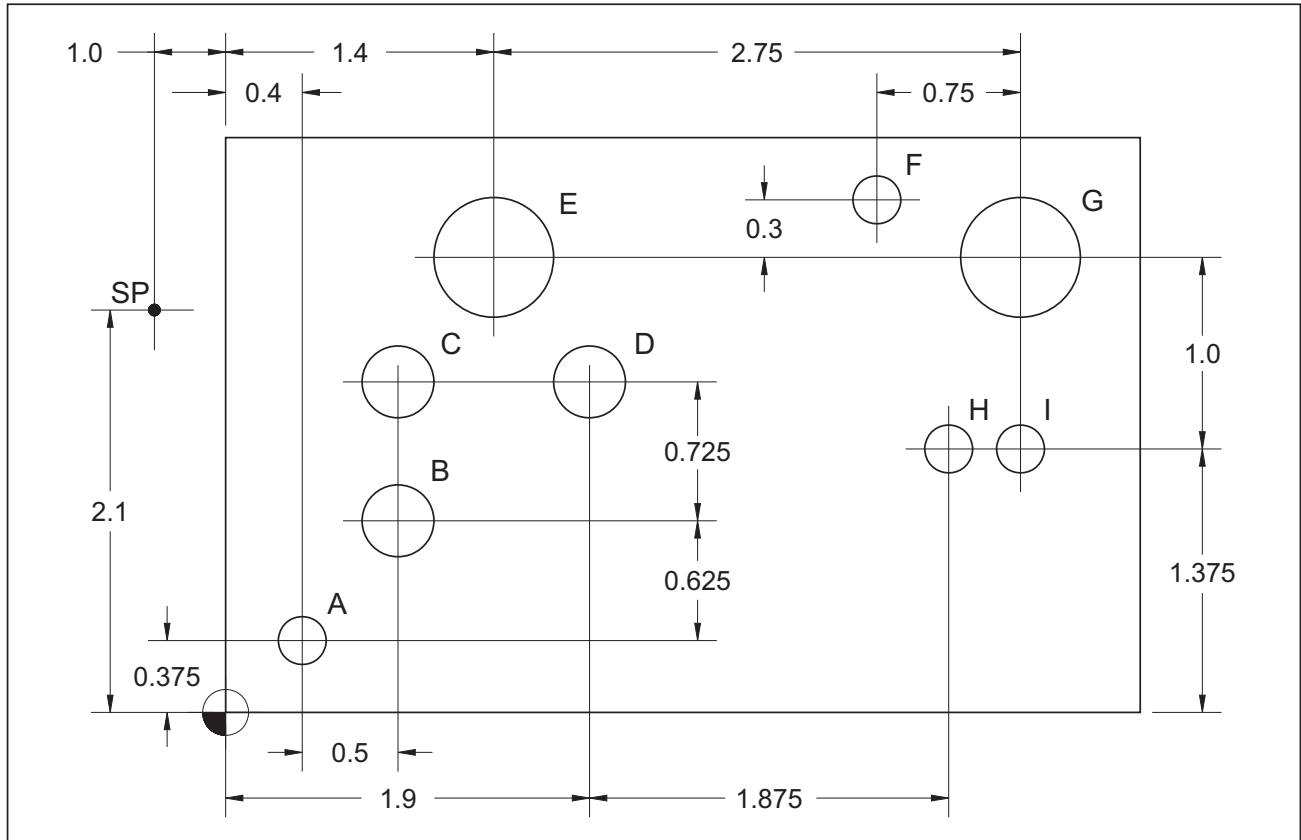


# 11-05

## Absolute and Incremental Mode

Fill in the XY program input for both the absolute and incremental modes of programming. Begin at the starting point *SP* and follow the holes starting from the hole *A* through the hole *I*, and back to the *SP* point.



G90 - ABSOLUTE MODE		
Hole	X-location	Y-location
SP		
A		
B		
C		
D		
E		
F		
G		
H		
I		
SP		

G91 - INCREMENTAL MODE		
Holes	X-motion	Y-motion
at SP	(0.0)	(0.0)
SP to A		
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 SP		