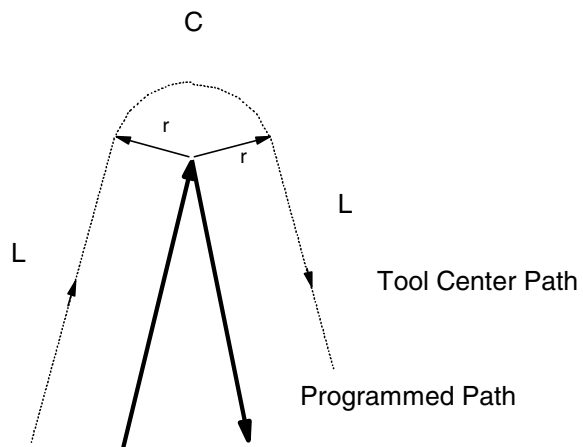


G CODE MOVES

Continuous Offset Move ... (for all linear and circular moves)	A-2
Blending S-curve Coordinated Moves.....	A-10
Straight Linear Move	A-11
S-Curve Linear Move	A-12
Startup Offset Move.....	A-13

Continuous Offset Moves

(A G-Code Strategy)

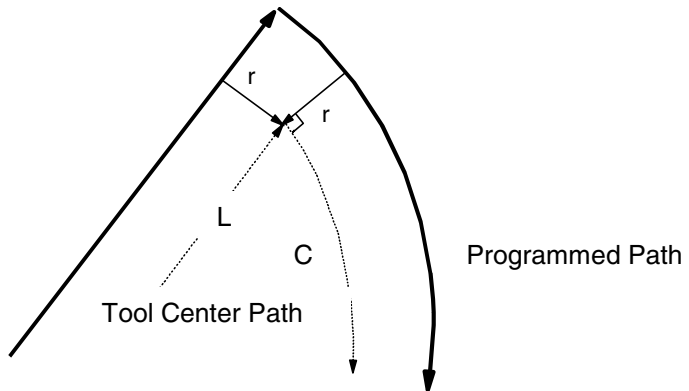


Moving around the outside of an acute angle. Going from one line to another

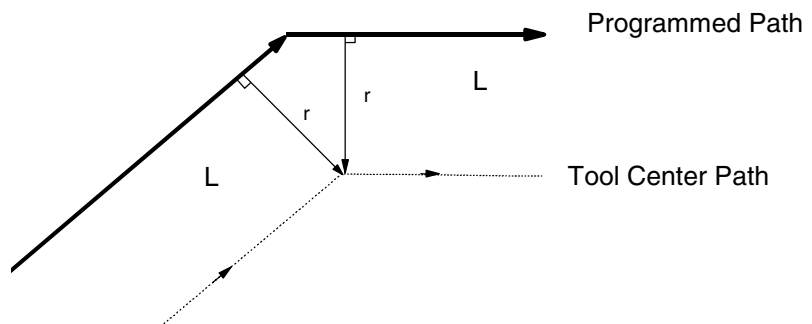
L: Linear
C: Circle
r: Radius

Continuous Offset Moves

(A G-Code Strategy)



Moving around the inside of an acute angle. Going from line to circle



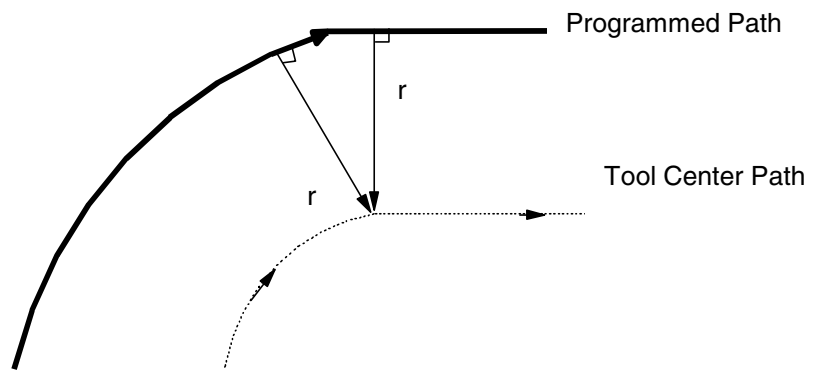
How The Moves Are Generated

Moving around the inside of an obtuse angle. Going from line to line

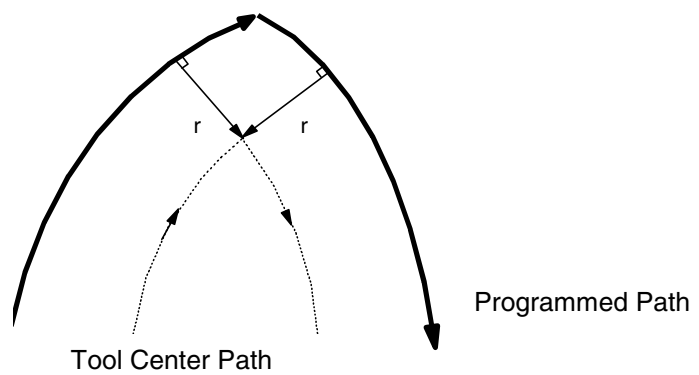
L: Linear
C: Circle

Continuous Offset Moves

(A G-Code Strategy)



Moving around the inside of an obtuse angle. Going from circle to line

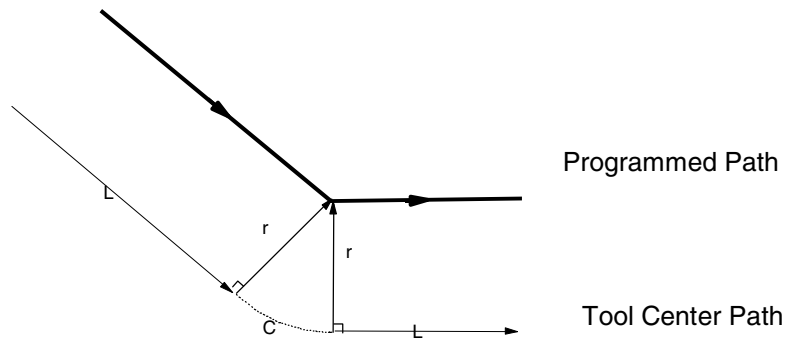


Moving around the inside of an acute angle. Going circle to circle

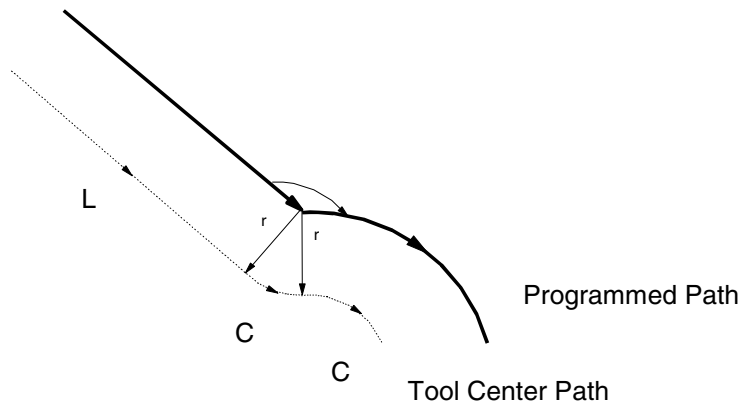
L: Linear
C: Circle

Continuous Offset Moves

(A G-Code Strategy)



Moving around the outside of an obtuse angle. Going from line to line

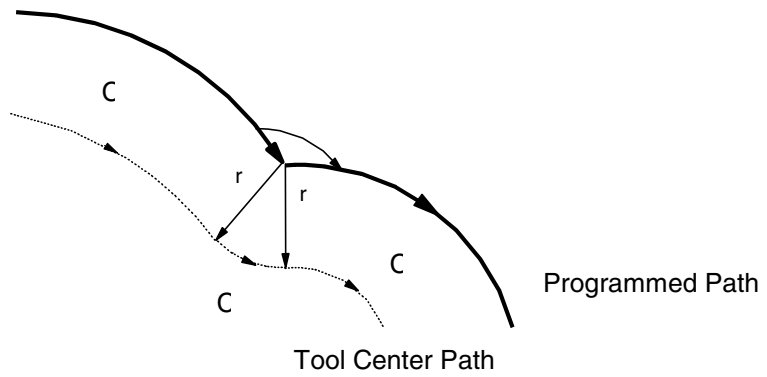


Moving around the outside of an obtuse angle. Going from line to circle

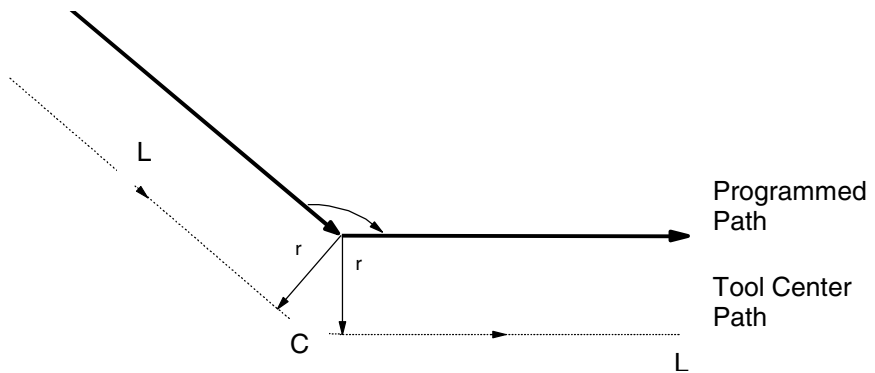
L: Linear
C: Circle

Continuous Offset Moves

(A G-Code Strategy)



Moving around the outside of an obtuse angle. Going from circle to circle

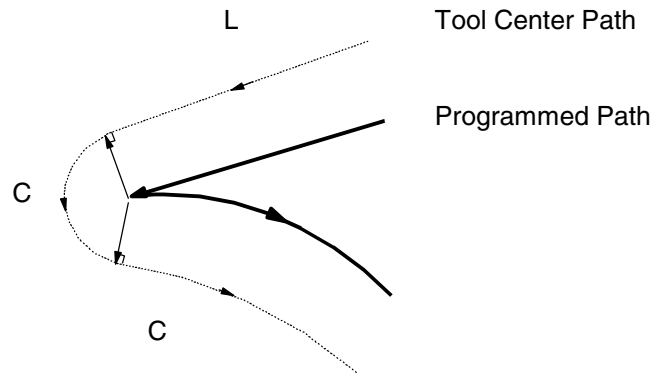


Moving around the outside of an obtuse angle. Going from line to line

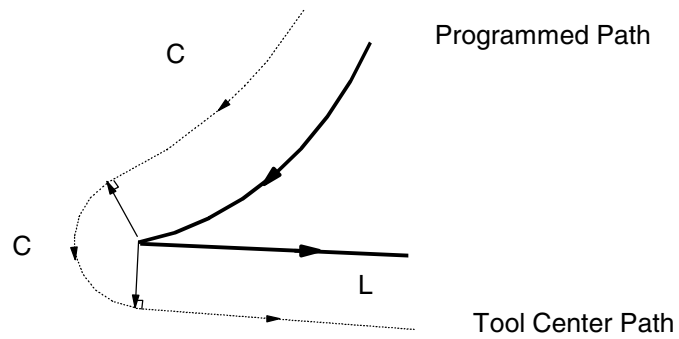
L: Linear
C: Circle

Continuous Offset Moves

(A G-Code Strategy)



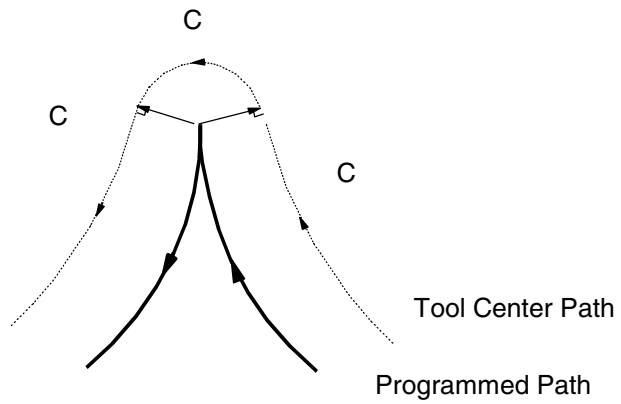
Moving around the outside of an acute angle. Going from line to circle



Moving around the outside of an acute angle. Going from circle to line

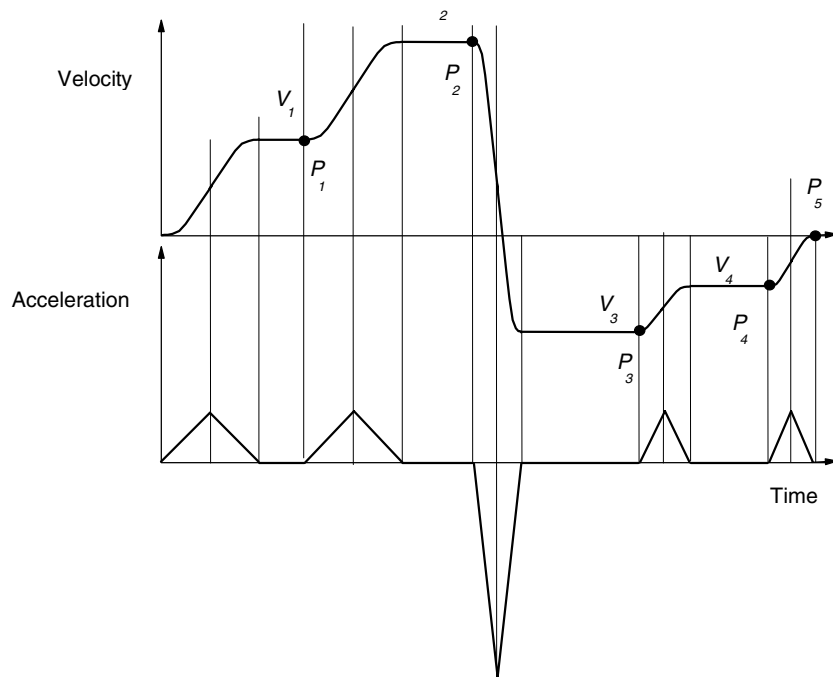
Continuous Offset Moves

(A G-Code Strategy)



Moving around the outside of an acute angle. Going from circle to circle

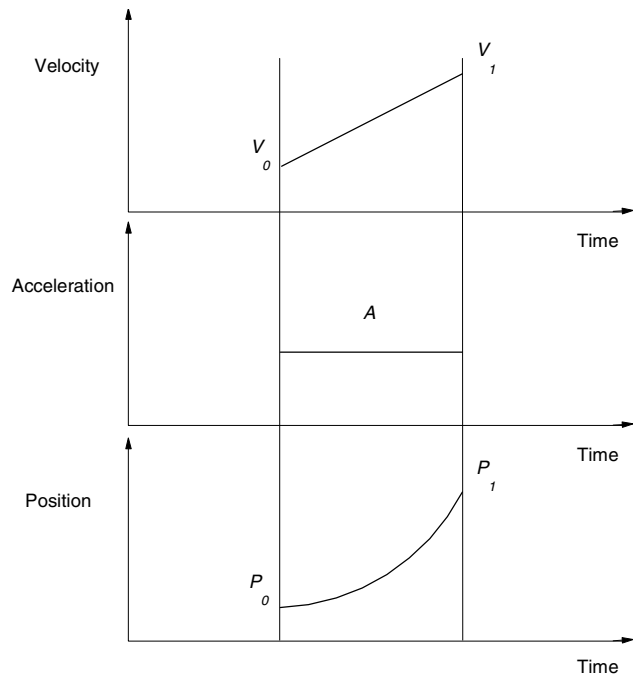
Blending Moves



Either one of the DSPL Segment Moves, (segment or segment_s) can be used in blending move applications. Blending allows the migration of one move to another at an exact programmed position without a need to stop the motion.

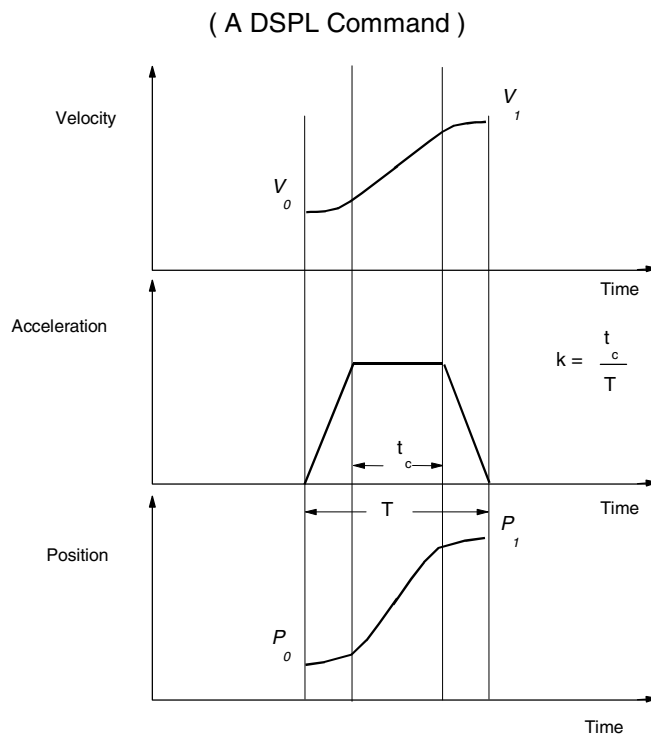
Linear Move

(A DSPL Command)



Constrained by a programmed maximum acceleration, the “linear_move” command will linearly ramp the speed from its initial value to a new programmed value at a programmed position.

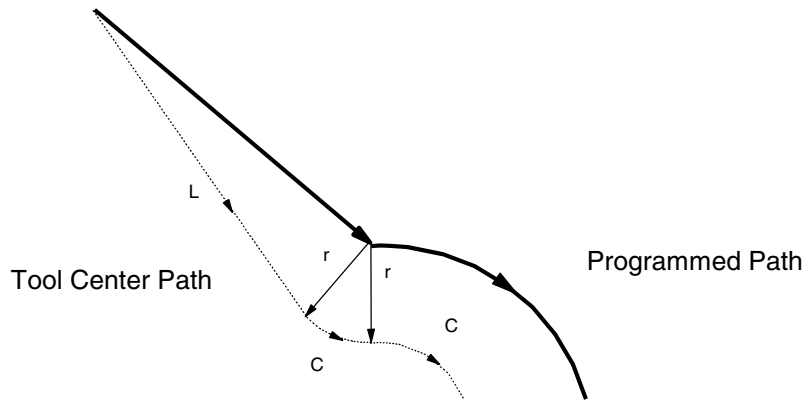
"S" Curve Linear Move



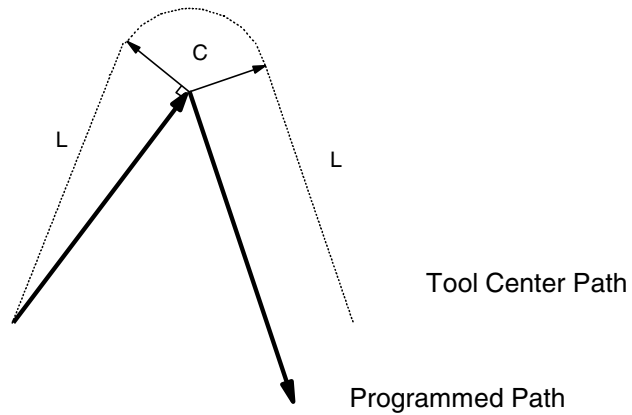
Constrained by a programmed maximum acceleration, the "linear_move" command will linearly ramp the speed from its initial value to a new programmed value at a programmed position. The acceleration used with this command is "s" curve and its jerk is determined by: a , k and T .

Start-up Offset Moves

(A G-Code Strategy)



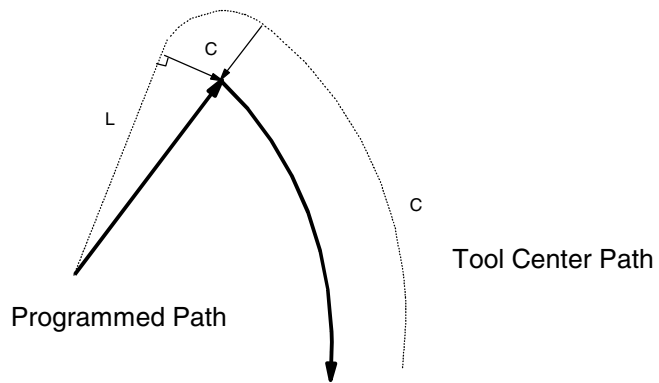
Starting around the outside of an obtuse angle. Going from line to circle



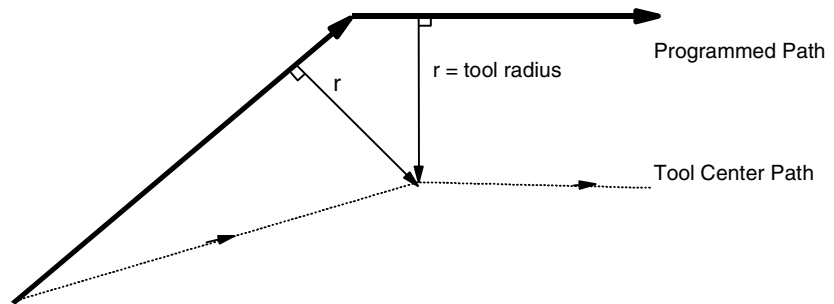
Starting around the outside of an acute angle. Going from line to line

Start-up Offset Moves

(A G-Code Strategy)



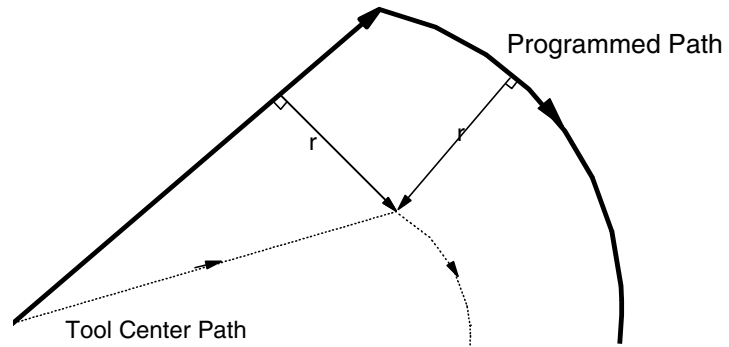
Starting around the outside of an acute angle. Going from line to circle



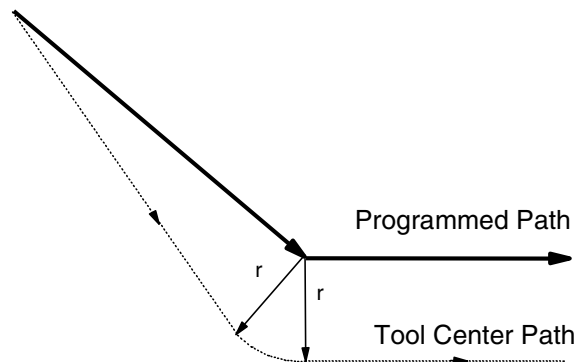
Starting around the inside of an obtuse angle. Going from line to line

Start-up Offset Moves

(A G-Code Strategy)



Starting around the inside of an obtuse angle. Going from line to line



Starting around the inside of an obtuse angle. Going from line to line