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OVERVIEW Writing a CNC program is the final result of manual programming. This last step requires a sheet of paper, or many sheets of paper, that contain the part program. Program itself is composed of individual instructions related to machining and arranged in a series of sequential blocks.

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In absolute programming, the G90 command indicates to the computer and MCU that the programming is in the absolute mode. Point-to-Point or Continuous Path CNC programming falls into two distinct categories (Fig. 8). The difference between the two categories was once very distinct. Now, however, most control units are able to handle both point-to-

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