Haas Logo
Coordinate Pair Graphing, with G02, G03 Arcs

Plot each point on the axes and connect them in order. Do not connect the shapes to each other.

Refer to the "9-Lines" Document to add the essential codes needed to run this on a Haas Simulator or Machine.

Shape 1
(-.532, -.550) Lines
(-.346, -.550)
(.300, .557)
(.038, .557)
(-.321, -.057)
(-.763, -.057)
(.552, .530) CW Arc Endpoint, .765 radius
(.209, -.057) Lines
(.021, -.057)
(-.116, -.288)
(.074, -.288)
(-.078, -.550)
(.184, -.550)
(.694,-.323)
(-.532, -.550) CW Arc Endpoint, .765 radius

Shape 2
(-.709, -.288) Lines
(-.456, -.288)
(-.579, -.500)
(-.709, -.288) CW Arc Endpoint, .765 radius

(Shape 3)
(-.998, -.057) Lines
(-1.131, -.057)
(-1.267, -.288)
(-.958, -.288)
(-.998, -.057) * CCW Arc Endpoint, 1.0 radius

Image to be plotted, Haas Logo

* Note. For arcs of less than 180°, we use positive R values (ex. R.765). For arcs that exceed 180°, closer to a full circle, we use negative R values (ex. R-1.0).

Example Program Solution:

```
%
O00547 (HAAS LOGO, WITH ARCS)
M06 T1
M03 S7500
G54 G00 G90 G17
X-0.532 Y-0.55
G43 H01 Z0.1 M08
G01 Z-0.01 F10.

(SHAPE 1)
X-.346 F20.
X0.3 Y0.557
X0.038
X-0.321 Y-0.057
X-0.763
G02 X0.552 Y0.53 R0.765
G01 X0.209 Y-0.057
X.0205
X-0.116 Y-.288
X0.074
X-0.078 Y-0.55
X0.184
X0.694 Y0.323
G02 X-.532 Y-0.55 R0.765
G00 Z.1

(SHAPE 2)
X-0.709 Y-.288
G01 Z-.01 F10.
X-0.456 F20.
X-0.579 Y-0.5
G02 X-0.709 Y-.288 R0.765
G00 Z.1

(SHAPE 3)
X-0.998 Y-0.057
G01 Z-.01 F10.
X-1.131 F20.
X-1.267 Y-.288
X-0.958
G03 X-0.998 Y-0.057 R-1.

G00 Z2.
M30

%
```