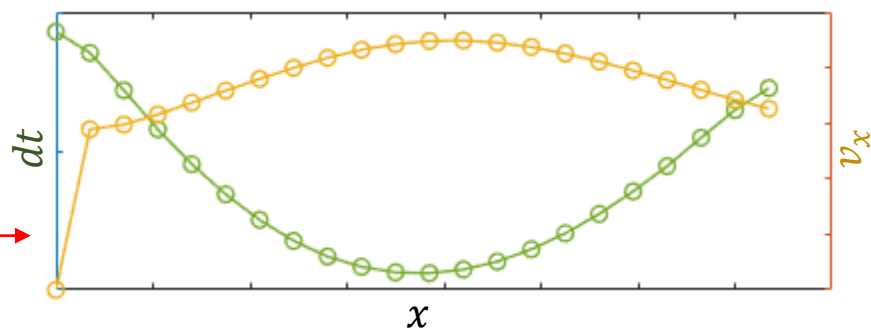
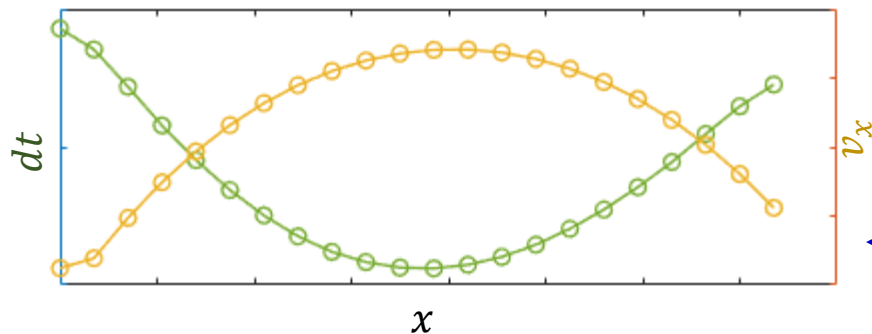


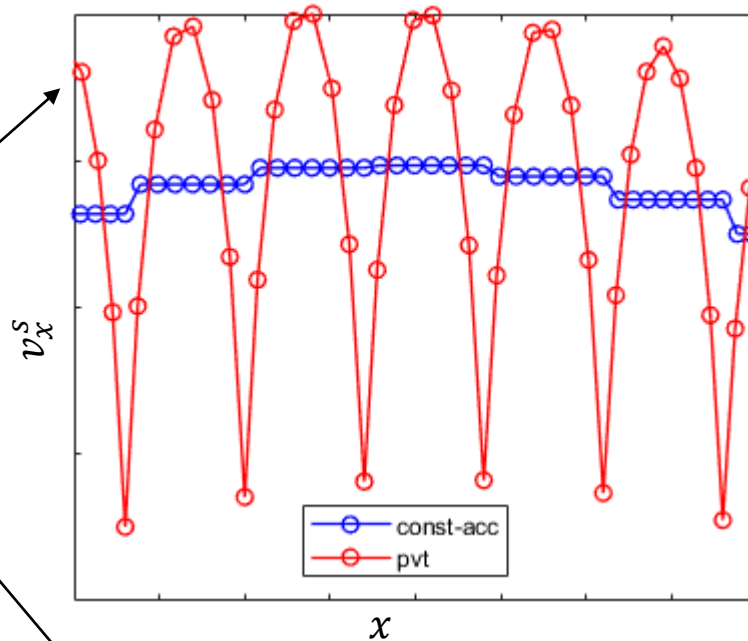
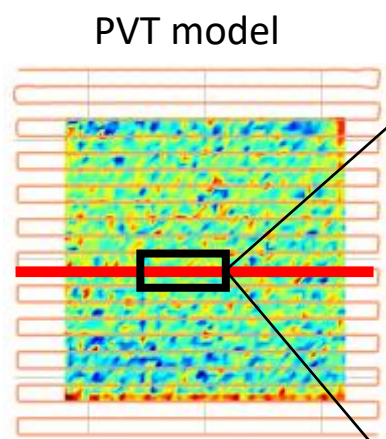
(a) Dwell time vs. feed rate: PVT model



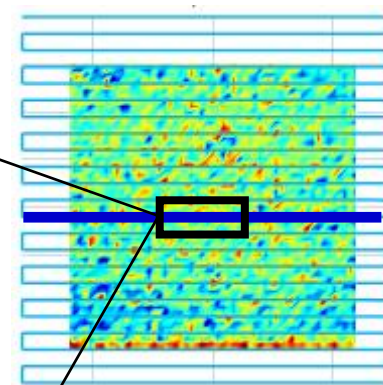
(b) Dwell time vs. feed rate: Const-acc model



(c) Comparison in federate simulation



Const-acc model



(d) Comparison in acceleration

