Plot 2D (u,diff) Difference Feedrate Limit minus Current Feedrate 4x10<sup>-5</sup> diff = (fratelimit - currfrate) > 03x10<sup>-5</sup> 2x10<sup>-5</sup> diff-frate (mm/s) 1x10<sup>-5</sup> 0 -1x10<sup>-5</sup> 0.2 0.4 0.6 8.0 0 1 parameter (u)