Plot 2D (u,diff) Difference Feedrate Limit minus Current Feedrate 4x10⁻⁵ liff = (fratelimit - currfrate) > 0 3x10⁻⁵ 2x10⁻⁵ 1x10⁻⁵ 0 -1x10⁻⁵ 0.2 0.4 0.6 8.0 0 1 parameter (u)

diff-frate (mm/s)