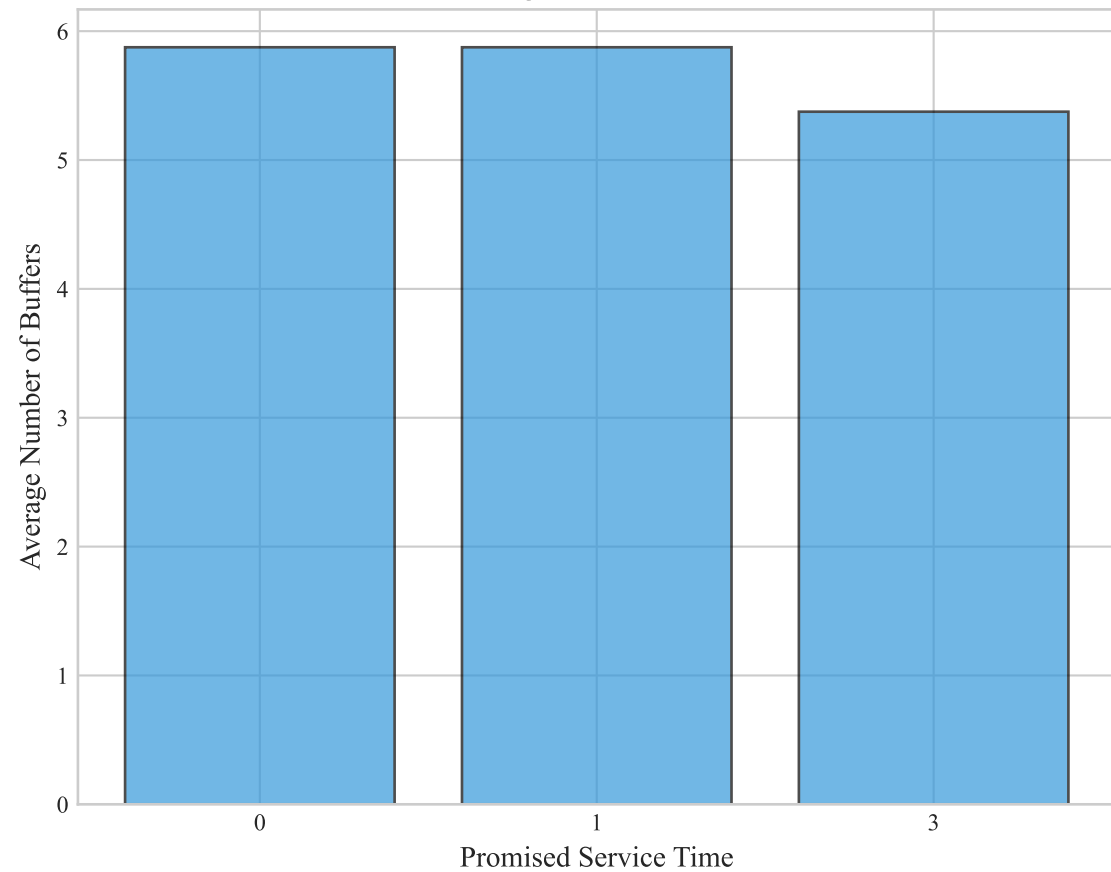


Buffer Positioning vs Service Time Constraint



Cost Impact of Service Time Constraint

