

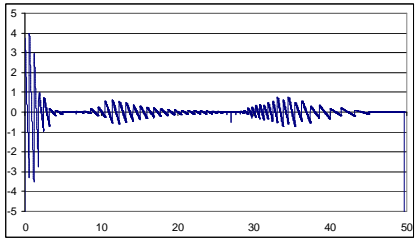
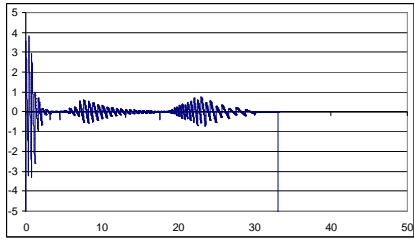
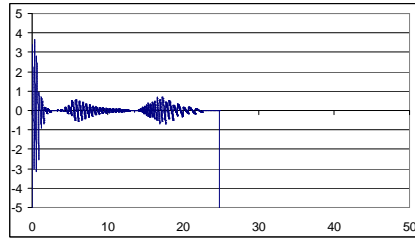
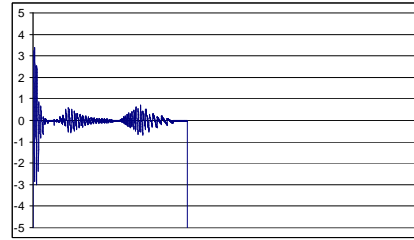
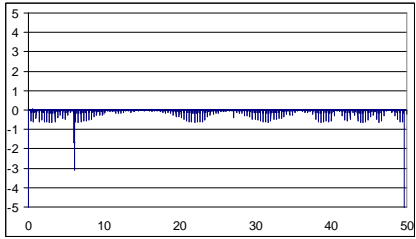
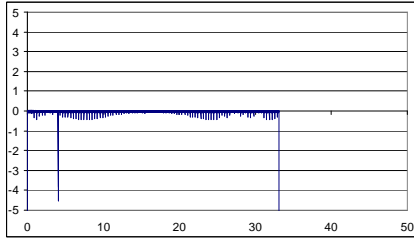
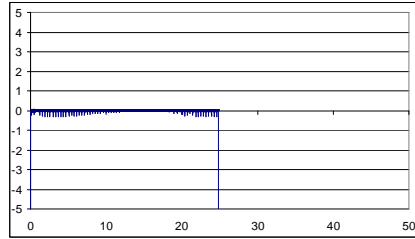
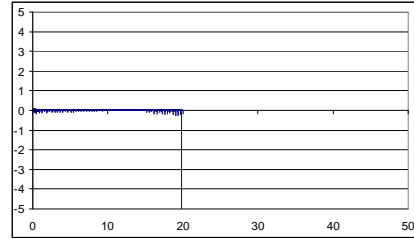
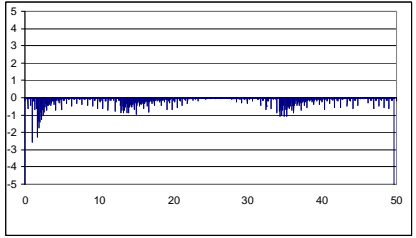
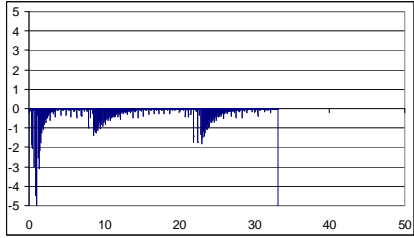
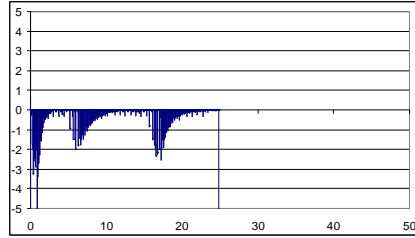
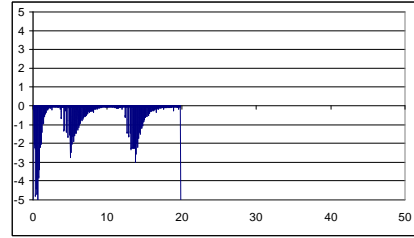
Feedrate error in percentage value				
NURBS interpolation method	$V=200 \frac{mm}{min}$	$V=300 \frac{mm}{min}$	$V=400 \frac{mm}{min}$	$V=500 \frac{mm}{min}$
with constant increments the u parameter				
with increments of constant displacement through linear movement				
with increments of constant displacement through linear movement				

Tabella 1- (Path toll Curve-Mazatrol) Feedrate error in percentage value with respect to time [s]

	NURBS interpolation method of the current software version LinuxCNC	NURBS interpolation method with constant increments the u parameter	NURBS interpolation method with increments of constant displacement through linear movement	NURBS interpolation method with increments of constant displacement through linear movement
Curve	$T_{G5.2/G5.3}$ [s]	$T_{G6.2_u}$ [s]	$T_{G6.2_B}$ [s]	$T_{G6.2_L}$ [s]
<i>order</i> =4 $N_{control\ point}$ =13	0.31	<0.01	0.12	0.10
<i>order</i> =5 $N_{control\ point}$ =32	1.94	0.01	0.30	0.29
<i>order</i> =5 $N_{control\ point}$ =50	7.72	0.04	0.65	0.54
<i>order</i> =4 $N_{control\ point}$ =119	112.23	0.05	0.65	0.63
<i>order</i> =4 $N_{control\ point}$ =231	884.89	0.11	1.19	1.12
<i>order</i> =6 $N_{control\ point}$ =589	Time required unsustainable.	0.38	15.81	14.02

Table 2-time processing