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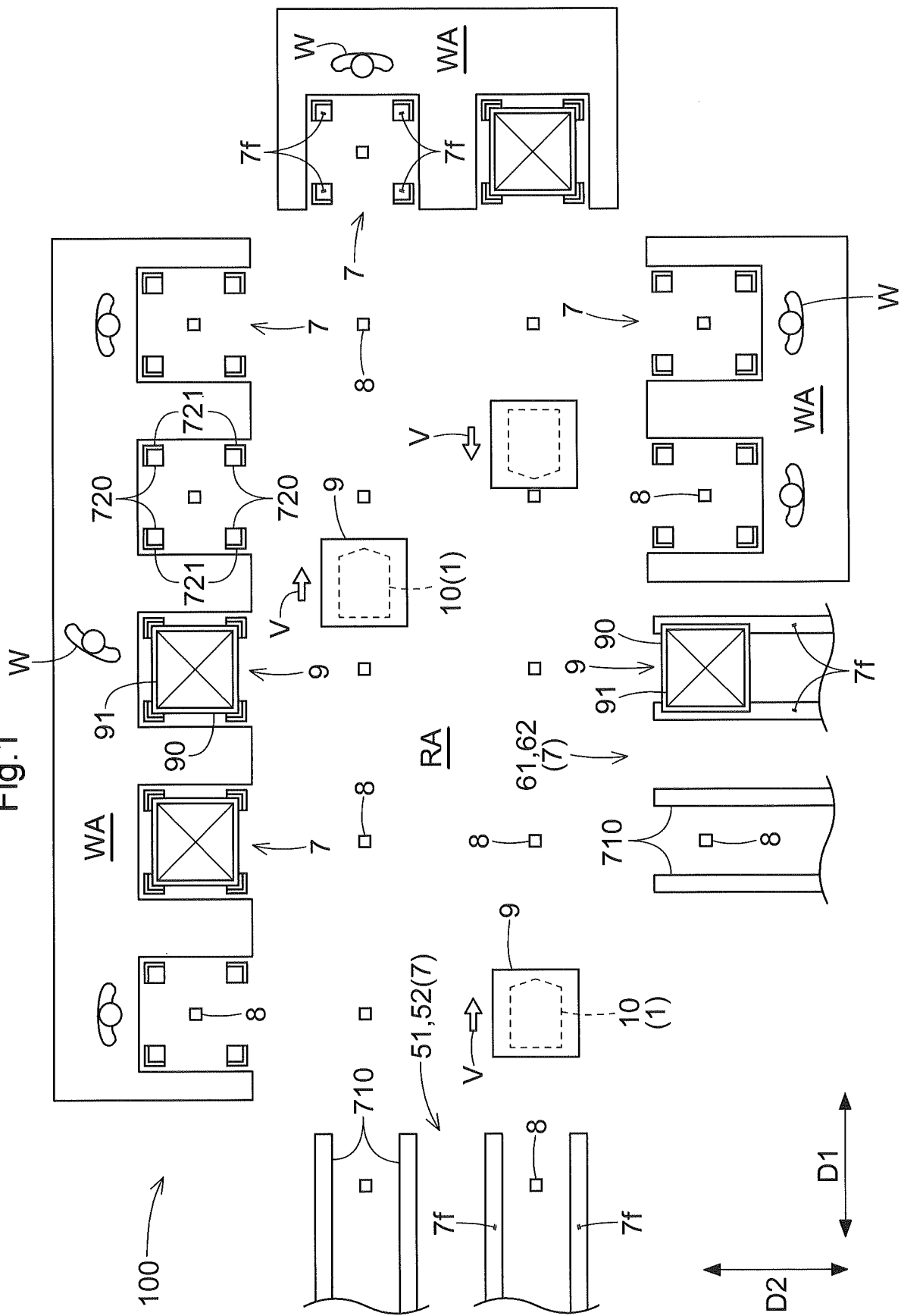


Fig.2

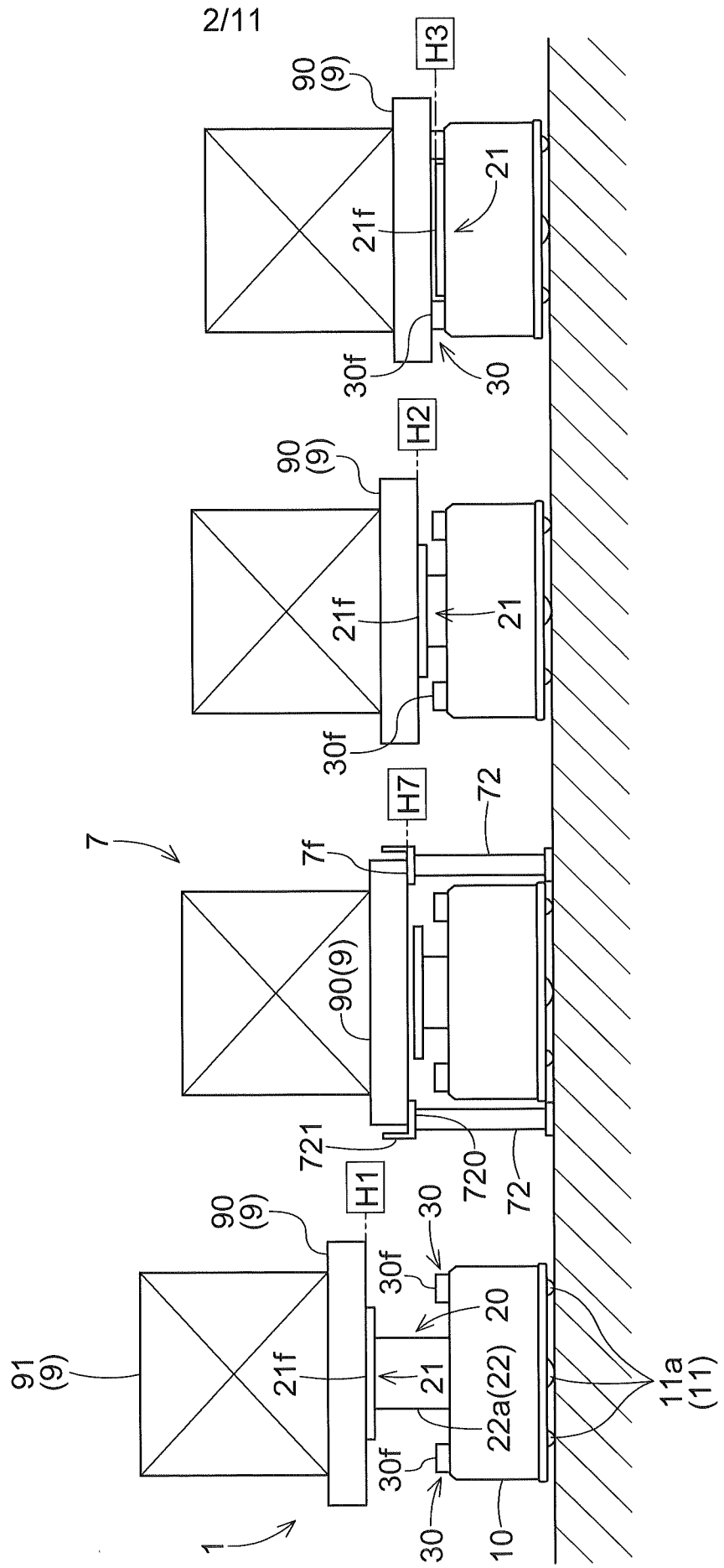


Fig.3

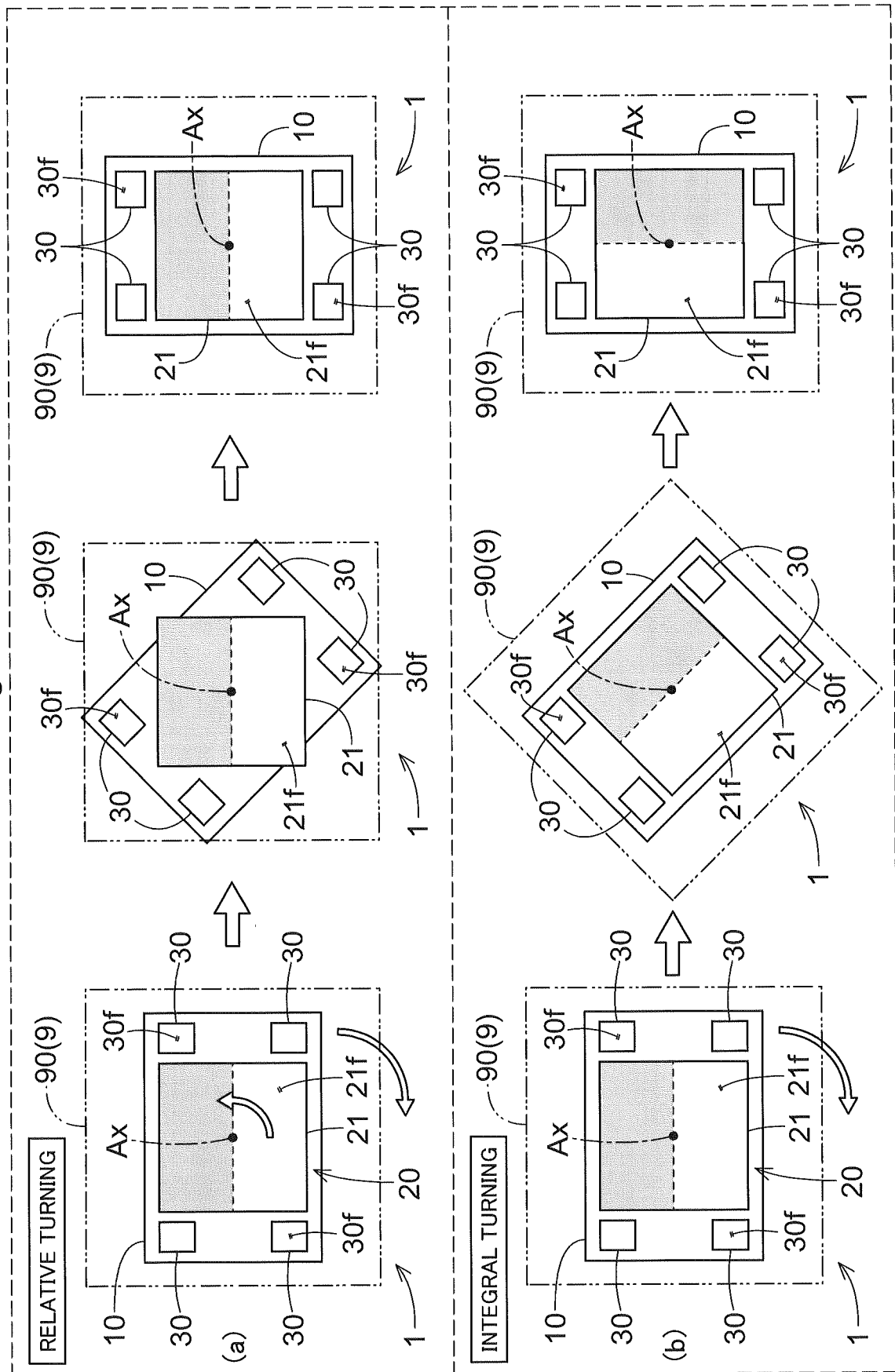


Fig.4

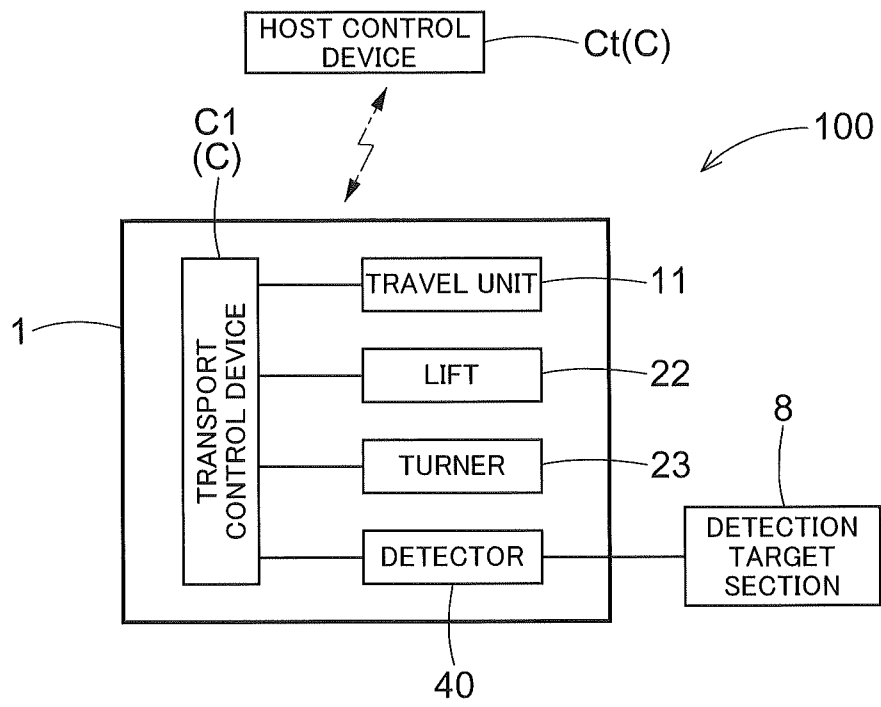


Fig. 5.

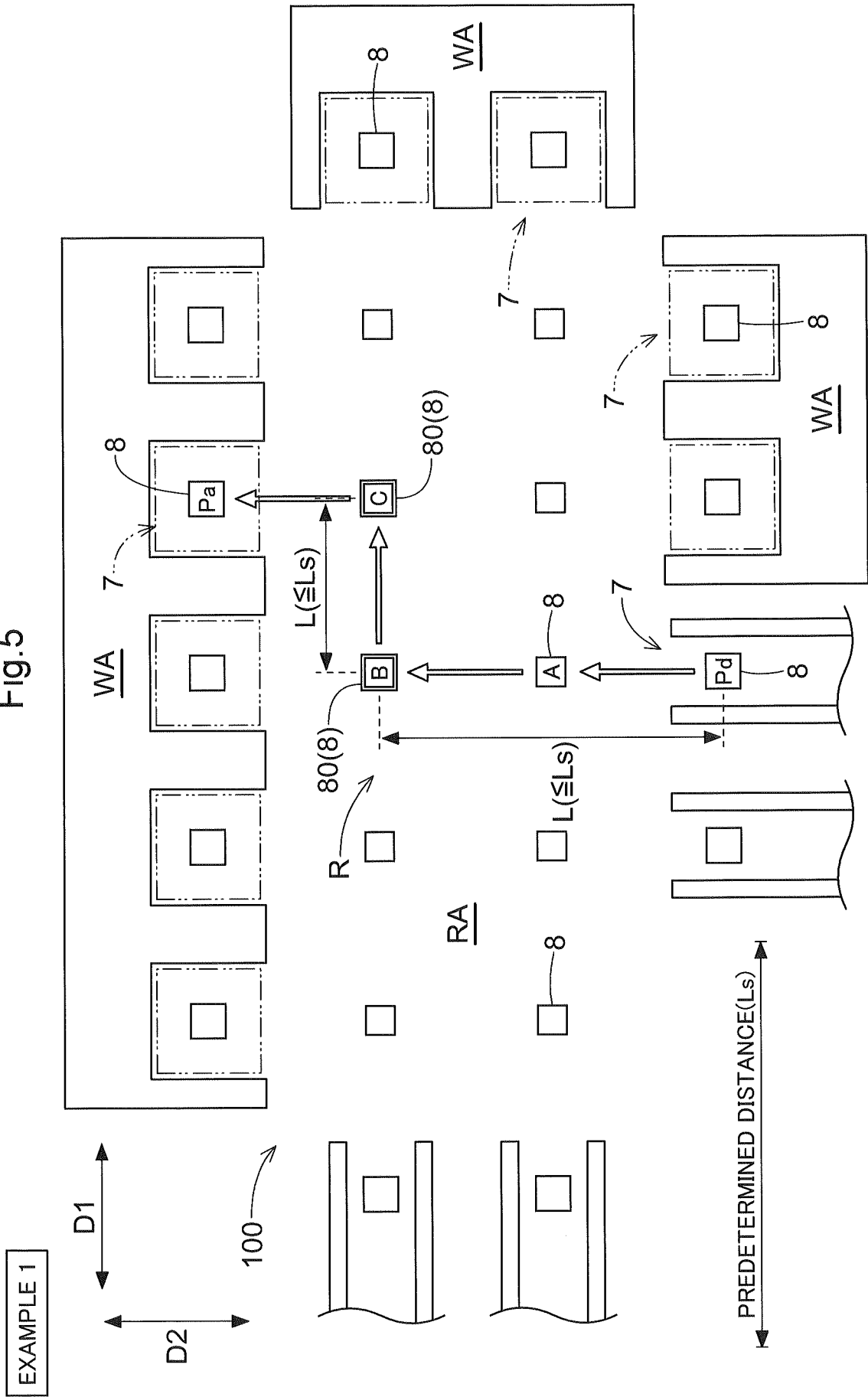


Fig.6

EXAMPLE 1

| POINT                     | Pd    | Pd→A  | A    | B                   | C                   | C→Pa  | Pa    |
|---------------------------|-------|-------|------|---------------------|---------------------|-------|-------|
| SUPPORT<br>SURFACE HEIGHT | H3→H1 | H1→H2 | H2   | H2                  | H2                  | H2→H1 | H1→H3 |
| SET SPEED                 | V<Vs  | V<Vs  | V<Vs | V<Vs                | V<Vs                | V<Vs  | V<Vs  |
| OPERATION                 |       |       |      | RELATIVE<br>TURNING | RELATIVE<br>TURNING |       |       |

EXAMPLE 2

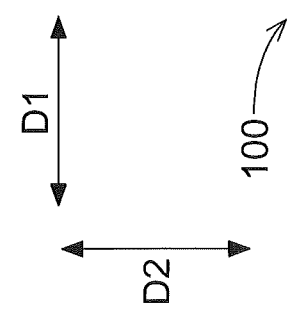


Fig.7

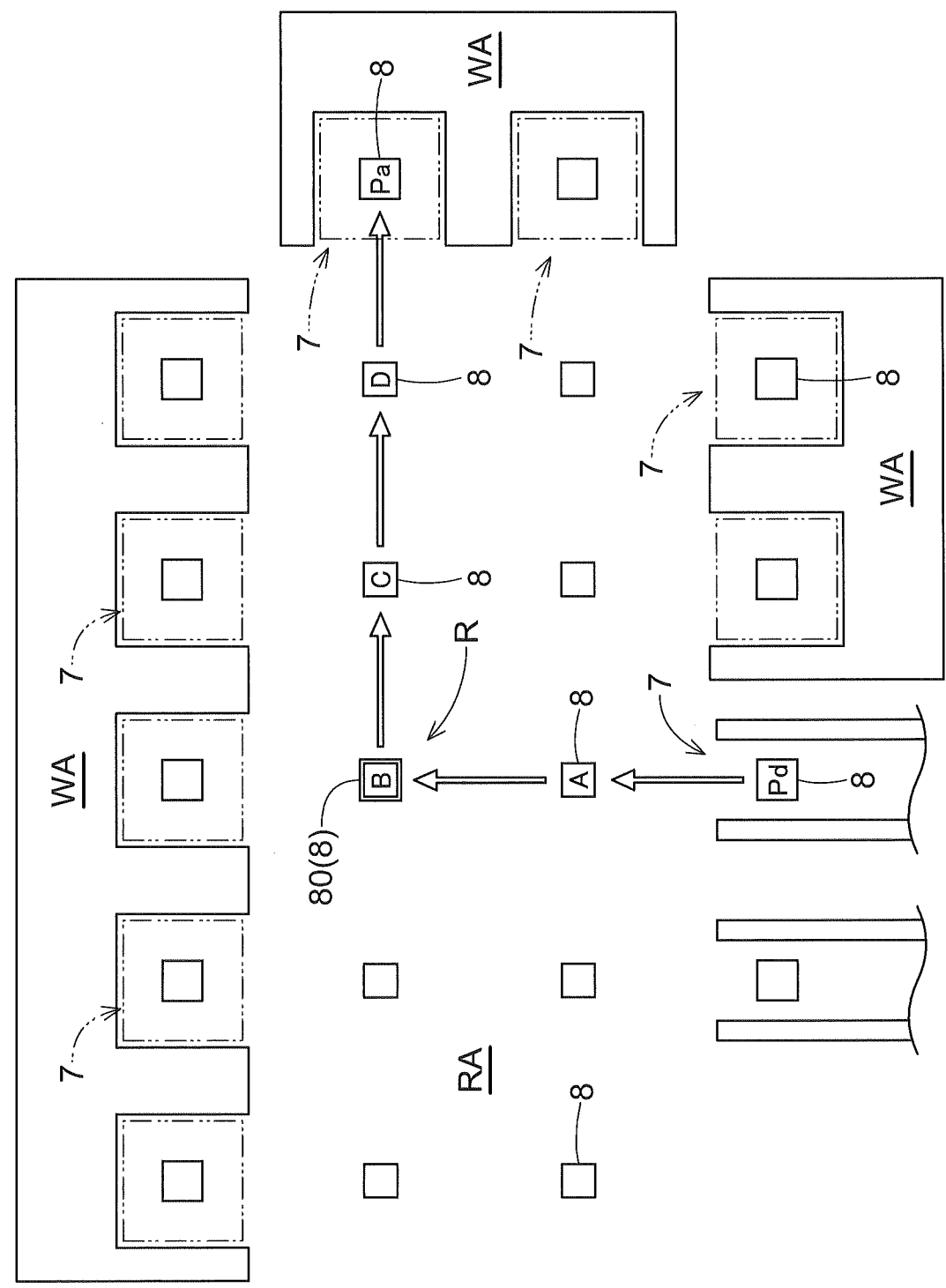


Fig.8

EXAMPLE 2

| POINT                     | Pd        | Pd→A      | A         | B                   | C         | D         | D→Pa      | Pa        |
|---------------------------|-----------|-----------|-----------|---------------------|-----------|-----------|-----------|-----------|
| SUPPORT<br>SURFACE HEIGHT | H3→H1     | H1→H3     | H3        | H3                  | H3        | H3        | H3→H1     | H1→H3     |
| SET SPEED                 | $V < V_s$ | $V < V_s$ | $V = V_s$ | $V < V_s$           | $V = V_s$ | $V = V_s$ | $V < V_s$ | $V < V_s$ |
| OPERATION                 |           |           |           | INTEGRAL<br>TURNING |           |           |           |           |

### EXAMPLE 3

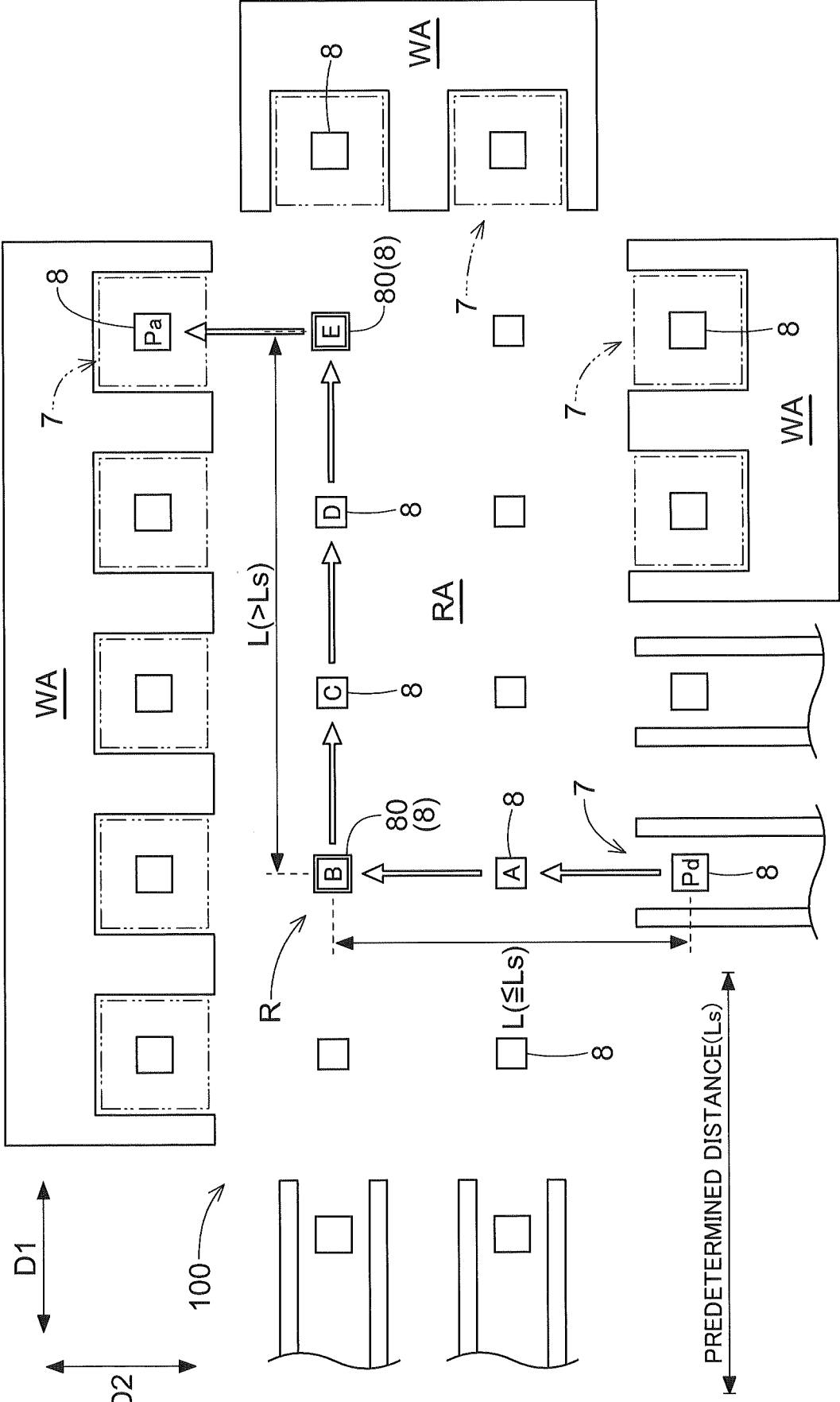


Fig.10

EXAMPLE 3

| POINT                     | Pd    | Pd→A  | A    | B                   | B→C   | C    | D    | D→E   | E                   | E→Pa  | Pa    |
|---------------------------|-------|-------|------|---------------------|-------|------|------|-------|---------------------|-------|-------|
| SUPPORT<br>SURFACE HEIGHT | H3→H1 | H1→H2 | H2   | H2                  | H2→H3 | H3   | H3   | H3→H2 | H2                  | H2→H1 | H1→H3 |
| SET SPEED                 | V<Vs  | V<Vs  | V<Vs | V<Vs                | V=Vs  | V=Vs | V=Vs | V=Vs  | V<Vs                | V<Vs  | V<Vs  |
| OPERATION                 |       |       |      | RELATIVE<br>TURNING |       |      |      |       | RELATIVE<br>TURNING |       |       |

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Fig.11

