

1984

Master production scheduling system under a GT cell

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Iowa State University

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Master production scheduling system
under a GT cell

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Seung-Ryeol Kim

A Dissertation Submitted to the
Graduate Faculty in Partial Fulfillment of the
Requirements for the Degree of
DOCTOR OF PHILOSOPHY

Department: Industrial Engineering

Major: Engineering Valuation

Approved:

Signature was redacted for privacy.

In Charge of Major Work

Signature was redacted for privacy.

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Signature was redacted for privacy.

For the Graduate College

Members of the Committee:

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1984

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TABLE OF CONTENTS

	PAGE
CHAPTER 1. INTRODUCTION	1
Preface	1
Background	3
Production planning process	3
A formal planning system	3
Aggregate production plan	5
Master production schedule	6
Rough Cut Capacity Plan (RCCP)	9
MRP and GT	10
MRP	10
Group technology	12
A GT based MRP system	12
Need for the Study	14
Research Scope and Objectives	17
Research objectives	18
Uniqueness of the MPS under a GT Based MRP System	20
CHAPTER 2. LITERATURE REVIEW	22
Aggregate Production Plan	22
Master Production Schedule	26
Classification	26
Special topics	27
Interface with other functions	29
GT Based MRP System	29
Capacitated Lot Sizing for Multi-Items	30
Evaluation Method of the Heuristic Solution	31
Summary	33
CHAPTER 3. PROBLEM DEFINITION	35
Characteristics and Assumptions	35
Aggregate Production Plan	38
Master Production Schedule	42

CHAPTER 4. THE APPROACHES	47
Preliminary Work	47
Input data	47
Load profile	50
Aggregate Production Plan	52
Heuristics to Develop a TMPS	54
Method A: period-by-period method	56
Method B: shortest path method	61
Method C: tree search method	62
Sampling procedure	65
Tree search method	67
Characteristics of the Methods	68
CHAPTER 5. EXPERIMENTAL TEST	72
Aggregate Production Plan	72
Illustrative example	72
Discussion of the model	74
Master Production Schedule	77
Test problem generation	77
Evaluation measure	86
Discussion of the experimental tests	88
CHAPTER 6. SUMMARY AND CONCLUSION	98
BIBLIOGRAPHY	108
ACKNOWLEDGEMENTS	118
APPENDIX A: AGGREGATE PRODUCTION PLANNING SUBSYSTEM	119
Program List	119
Input of MPSX	120
APPENDIX B: MASTER PRODUCTION SCHEDULING SUBSYSTEM	123
System Flow of Experimental Test	123
Program list	124
Method A	124
Method B	141
Method C	153
Solution standard	165

APPENDIX C: SHORTEST PATH ALGORITHM 178

LIST OF TABLES

	PAGE
TABLE 1. I/O and managerial variables for APP	7
TABLE 2. The method to determine a production requirement	19
TABLE 3. Contrasts of the research with other works .	36
TABLE 4. Input data summary	49
TABLE 5. Demand requirements for APP problem	72
TABLE 6. Weighting factors of each goal	73
TABLE 7. Values of cost parameters	73
TABLE 8. Production plan	74
TABLE 9. Required and planned load	75
TABLE 10. Budgeted and planned expenditure	75
TABLE 11. A pool of all test items	79
TABLE 12. Two cases of average demand for small size problem	80
TABLE 13. Two cases of demand pattern for small size problem	80
TABLE 14. Summary of test data	81
TABLE 15. Cost structure	84
TABLE 16. Setup cost summary	85
TABLE 17. S/H summary	85
TABLE 18. R for constant and seasonal demand patterns	90
TABLE 19. Summary of evaluation measures	91

TABLE 20. Distribution of evaluation measures	92
TABLE 21. Evaluation measures by cost structure	93
TABLE 22. Characteristics of solution standard (Frequency)	94
TABLE 23. Characteristics of solution standard (Ratio)	95
TABLE 24. A Wilcoxon's signed-rank test for cost factors	96

LIST OF FIGURES

	PAGE
FIGURE 1. A formal planning system	4
FIGURE 2. A system flow for load profile	51
FIGURE 3. Flow diagram of Method A	58
FIGURE 4. A shortest path representation of a MPS .	63
FIGURE 5. Flow diagram of Method B	64
FIGURE 6. Tree search method	69
FIGURE 7. Flow diagram of Method C	70
FIGURE 8. Experimental procedure	89

CHAPTER 1. INTRODUCTION

Preface

A production system operates most effectively when the input and the output of the production system flow smoothly. But there are frequently overstocks or shortages in the inventory and unbalanced loads in the shop flow. Therefore, a system plan must consider the variation in the product quantity, place, and time. A planning system should be carefully designed to improve the efficiency of the total production system.

The following points indicate that the importance of the Master Production Schedule (MPS) is increasing.

1. In the hierarchy of production planning processes, the MPS should be the basis of all operational level schedules. Therefore, the impact of the MPS on the efficiency of the total production system is tremendous.
2. Material Requirement Planning (MRP), where the MPS is the primary input, is replacing the traditional ordering point system in the requirement planning of materials.
3. The MPS is frequently used as an essential part to observe an overall effectiveness for the organization in the decision making of strategic

level which is the final phase of development of management information systems.

Group technology (GT) has the promise of meeting the following challenges in modern manufacturing (19).

1. 75% of manufactured parts will be small lot sizes in coming years. This compares with 25% to 35% now.
2. Customized products require special options and are composed of components with high reliability and closer tolerances.
3. The need to integrate the activities of design and manufacturing is increasing.

This research is to propose an aggregate production planning model and methodologies deriving a Tentative Master Production Schedule (TMPS) for a GT cell where MRP is the production planning and control system. Since the MPS interacts with several functions in the planning system, this research deals with planning subsystems including the Aggregate Production Plan (APP) and MPS. A production plan presents a general outline of the manufacturing activity during the planning horizon. This outline should agree with the objective of the work force, the production capacity, and the customer service level in the aggregate level. The APP has been developed for this purpose. The MPS is derived from the production plan or all demand sources while

minimizing the total production cost.

The objective of the research is to find a more formal, responsible method to develop a TMPS which would have the ability to plan the future work load under the available and the authorized capacity limits.

Background

Production planning process

A formal planning system In the hierarchy of the production planning processes, the MPS is the basis for the lower level plans such as the material and the capacity requirement plan. It is constrained by higher level plans such as the marketing plan and the production plan. Robert McCormick (41) described a formal planning system (Figure 1). He pointed out that the MPS is the planning keystone for a manufacturing company utilizing a formal planning and execution system.

The business plan is the long-term objective of the business and the guideline for the marketing plan, the production plan, and the resource allocation plan for the mid-term period. The marketing plan is developed to meet the income level of the business and the existing and potential customer demand. The production capacity works as a constraint for this marketing plan. The production plan is the time phased statement of the production rate, and it

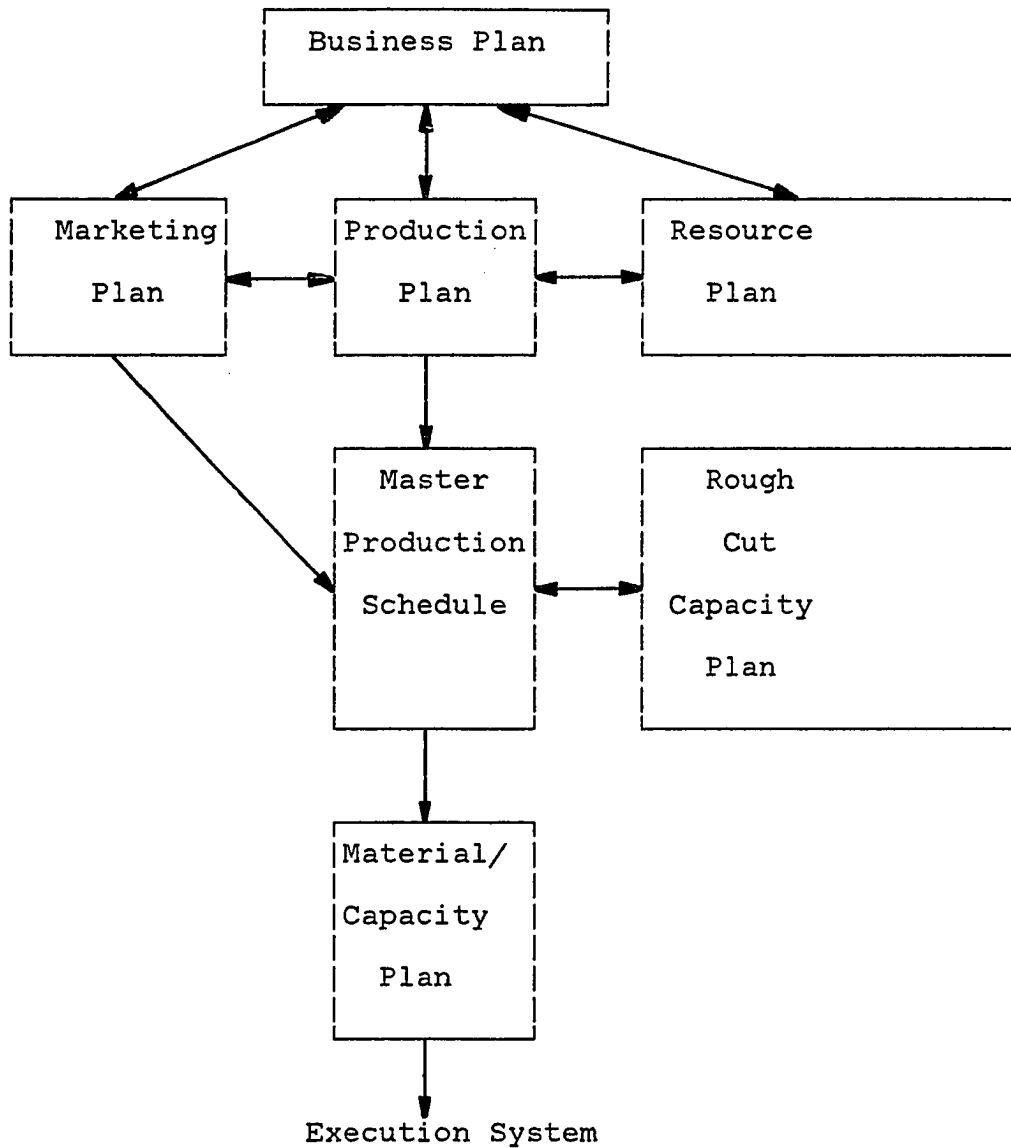


FIGURE 1. A formal planning system

defines the boundary for the future production process. The resource plan functions for all key resources in the company during the production planning horizon. Resources range from drafting-room personnel to cash to capital equipment

and plant square footage (47). The resource plan is prepared to follow up the production plan.

If the MPS is feasible, the material/capacity requirement planning is derived to expedite the MPS. If the material or the capacity cannot be prepared on time, the MPS may be changed. An MRP method can be used for the requirement planning of the material. A load profile which is derived from the Bill of Material (BOM) and the routing file are the bases for the Rough Cut Capacity Plan (RCCP).

This research is concerned with the Production Plan and the MPS, which will be respectively described in the following sections. The MPS is derived from the production plan and is evaluated by the RCCP which calculates the impact of the MPS on the key resources. If there is no production planning function, the MPS is derived from all the demand sources.

Aggregate production plan The production plan may be defined as the time phased statement of the production rate required to meet the customer demand with the minimum total cost. The production plan establishes the manpower requirement, the equipment requirement, and the level of the anticipated inventories. At this point, managers are required to make many decisions such as smoothing the plant production load, adjusting the capacity target and coordinating with production support functions. The

production plan works interactively with the marketing function, the manufacturing function and other supporting functions such as the financing function and the material procurement function.

When there are constraints in the company resources, the production plan is not consistent with the customer demand. Therefore, the company needs the production plan to satisfy the fluctuating customer demand. This suggests that the production plan ought to consider the sales volume, the production volume, and the inventory level in the aggregate level. A production plan is developed to minimize the total production cost constituting the facility, the inventory, the overload and delay penalty cost, etc. The APP has been developed and used for this purpose.

This research considers the APP where the planning horizon is from one month to one year. Buffa and Taubert (5) described the inputs required, the nature of the plans which are the outputs, and the variables which are under managerial control for the aggregate plan (Table 1). This research addresses the aggregate production planning problem where there are conflicting, multiple objectives. The production plan becomes not only the guideline but also the constraint on the MPS.

Master production schedule An MPS, which may be derived from the production plan, is the expected

TABLE 1. I/O and managerial variables for APP

1. Inputs: Forecasts of:
Amount and timing of sales
Costs
Supply
Policies and constraints on:
Overtime
Hiring and firing
Inventories
Capital
Long-range plans
2. Outputs: Aggregate plans and schedules for the use of various sources of capacity
3. Variables under managerial control:
Size of work force
Production rate
Inventory
Subcontracting

manufacturing schedule for the major assemblies or the shippable end items. There are several factors affecting the development of the MPS such as the product level to be

scheduled, the planning horizon, and the time bucket. The master scheduled items are identified by the part number in the BOM. McCormick (41) gives some guidelines for the product level to be scheduled in the BOM. He suggested that the BOM level which minimizes the number of potential master scheduled items should meet two criteria.

1. The master scheduled items must be forecastable by marketing.
2. They must represent the bulk of the capacity resources required to manufacture the shippable end items.

The planning horizon of the MPS is larger than the lead time of the master scheduled items. The lead time is constituted of component manufacturing, subassembly and final assembly, etc. Orlicky (47) stated that one week is the suitable time bucket for a MPS, when MRP is implemented.

There are many variations of the MPS among companies. However, the development procedure for the majority of the MPSs can be stated in the following way.

1. The marketing plan and the production plan which are at a higher level than the MPS are built up. The marketing plan is developed by the customer demand or the forecast. The production plan is coordinated with the marketing plan.
2. A TMPS is derived from the production plan and

the marketing plan.

3. The feasibility of a TMPS is tested by calculating the cumulative load on the key functions of the company.
4. Step 2 and Step 3 are repeated by the "trial and error" method until a feasible TMPS is proposed.
5. A TMPS is finalized by a coordinating function such as a master production scheduling committee.

This research handles the development of a tentative master production schedule from the production plan or all demand sources to minimize the production cost.

Rough Cut Capacity Plan (RCCP) The purpose of the RCCP is to check the feasibility of the MPS. The analysis of the MPS can be performed by calculating the impact on the key functions which may be critical resources in the company. The key manufacturing functions may be any critical resources such as bottleneck machines, or entire work centers, final assembly, or vendors who supply a key raw material (41). When the RCCP shows that the proposed MPS is not feasible, the "trial and error" method is used to find a feasible MPS. The result of using RCCP necessitates one of two changes, i.e., to the MPS or to the capacity. If the infeasibility of the MPS is not resolved by subcontracting or overtime, this fact affects the MPS or the higher level plans such as the production plan, the

marketing plan, and the resource plan.

The cumulative load which is derived by the proposed TMPS is compared with the available capacity limit to evaluate the feasibility of the proposed MPS. The load profile is used instead of the BOM and the routing file to calculate the time-phased cumulative load. The load profile is the planning data representing the time-phased load on each resource to produce one end item. The success of the RCCP depends on the load profile which should be carefully designed and prepared. The logic of the RCCP is just simple calculation to get the cumulative load via the MPS and the load profile. Therefore, the critical factor is the load profile and not the logic of the RCCP.

MRP and GT

MRP The basic principle of MRP is that the quantity and timing of the raw materials/components are determined by the known or forecasted requirements for the end product. Using MRP keeps the inventory balance at the minimum level by supplying the raw materials/components just prior to the date of need, and makes up for the drawbacks of the traditional order point system where shortage and over-stock occur by considering only the past requirements. Wight and Plossl (59) pointed out that "the number of items in inventory that can best be controlled by MRP outnumber those that can be controlled effectively by the order point

by about 100 to 1".

The advantages of MRP are well-known, but successful implementation of an MRP system has not been easy. A great many of MRP systems are still "order launching systems coupled with computer aided dispatching and there have been a number of failures" (56). One U.S. consultant has commented that only about one in a hundred MRP systems might be regarded as "successful" (45).

There may be many factors affecting the successful implementation of an MRP system, but this low rate of success does reflect the inherent problems of the MRP system. Colin New (45) described the drawbacks of MRP:

1. Load input variability is significantly greater than master schedule levels because of the random initiation of orders and their phasing.
2. It is inevitable that component sets will not "match" assembly requirements, because the lot sizes are set in relation to the individual component rather than to a production cycle. This increases inventories and may cause allocation problems when shortages occur.
3. Groups of components with the same setup requirements will rarely be ordered at the same time because of independent component batching. Thus, the scope for setup savings is severely

limited.

All these problems are caused by the complex routings of components and complex interactions among jobs based on the functional layout.

Group technology A GT cell is the production cell which is determined by the component similarity rather than the machine similarity. The production cell is composed of a small group of humans and machines which produce a component set from the raw material. A coding and classification scheme is used to classify similar components and the product families.

A GT cell offers some distinct advantages compared to the functional layout. Reduced throughput time, decreased Work In Process (WIP) and finished goods inventory, increased flexibility to handle forecast errors, and reduced paperwork are some advantages mentioned by actual users (21).

The components must be produced with the right quantity at the right time to meet the final assembly. Correct components should be produced on the scheduled time to get the advantage of GT. This requires a production planning and control system which is suitable for GT cells.

A GT based MRP system Several authors (21, 45, 56) proposed that MRP can be used as a production planning and inventory control system on a group layout producing small

batch large variety products. Throughput time is more rapid and more deterministic in the group layout than in the functional layout, but the quantity and the timing of the raw material or components should be derived from the final end item requirements. MRP can be used for this purpose, but it inherently generates the planned order based on the lot sizing of each component, and each planned order has a different multiple cycle. The MRP with multiple cycle ordering also generates the loading on the GT cell irregularly, which makes it difficult to expedite the operation on the GT cell smoothly and consistently.

To solve this problem, Colin New (45) suggested UPBC (Unique Period Batch Control) of which the essential feature is that all components are ordered on the same cycle. Hyer and Wemmerlöv (21) pointed out that no method for economically determining family lot sizes has been found in the literature dealing with GT cell production. They proposed the NRN rule (Nice Round Numbers rule) for the ordering trigger.

This research hypothesizes that MRP can accommodate the production planning and control system of the GT cell, and handles the production planning subsystem under a GT based MRP system.

Master scheduled items can consist of end items or a classes of similar parts. The load profile which is derived

from the BOM and routing file is used as a tool of master production scheduling. Therefore, the process stages of the master production scheduled items are considered in developing the load profile. This research handles only one level of the production process and does not consider the process stages of the master production scheduled items or interrelationships of the parts. Further, the application of this research is in a GT environment as described by short lead times, small volumes, and requirement of a load profile. While parts classification may be included in developing the load profile, the existence of a classification system is not mandatory to this research. As such the application to a GT cell or a small shop are equally effective.

Need for the Study

The traditional method for master production scheduling is as follows. The master production scheduler develops a TMPS, based on experience, intuition and business sense. It is not known, however, whether a TMPS is reasonable or not until the RCCP of the proposed TMPS is developed. Therefore, the "trial and error" method must be used to get a better TMPS. Even though there is an integrated production planning and inventory control system, the master production scheduling logic usually does not include the

resource constraints. It does include netting logic to derive the production requirement from the gross requirement and on-hand inventory. There are also many designed logic structures to minimize the sum of production and inventory holding cost in order to find the optimal MPS, but the feasibility of the MPS with respect to capacity is also evaluated by the RCCP. A trial and error method is also used to get a better TMPS.

In the traditional "trial and error" method, if multiple items and resources are involved it is almost impossible to balance the work-load on the resources in one iteration. Even several retrials cannot assure the balancing of the work-load. The "trial and error" method has been used because the capacity limit is not considered in developing the TMPS.

There are several reasons why the traditional approach does not include the capacity as a criterion to get the optimal MPS.

1. It is not easy to determine the capacity target/capacity limit because there are so many control variables and elements. The capacity target/capacity limit is derived by compromising available capacity and required capacity. Required capacity is derived from the authorized production plan or the production requirements,

and it is the guideline to determine the available capacity which is the basis for finding the feasible and authorized MPS.

2. There are several analytical approaches to these problems, but either the models are too ideal, or the solution procedures requiring computing time are excessive. Exact methods are computationally limited to the relatively small size of problems.
3. In the simulation approach, it is difficult to generate the realistic test problems because the capacity patterns and the cost functions vary too much. Therefore, it requires excessive computing efforts to simulate all combinations of the system parameters.
4. It is not easy to measure the deviation between the near optimal solution of the proposed approach and the real optimal solution. "Goodness" of the proposed method should be evaluated.

The objective of this research is to find a better methodology than the traditional "trial and error" method. In other words, the research is to develop a TMPS which minimizes the production cost by effectively smoothing the work-load under a GT cell with capacity limits, thus reducing the frequencies of the RCCP application. This is

possible by including a critical capacity limit in the master production scheduling logic as a constraint.

Research Scope and Objectives

This research deals with the case where the business type is make-to-stock under a GT cell. An MRP system accommodates the production planning and control function for this GT cell. The demand pattern of the end items is seasonal, and the capacity limit during the scheduling period is constant. The proposed master production scheduling system is a decision support system, therefore, the TMPS which is the output of the proposed system will be finalized by coordinating functions such as the master production scheduling committee. That is, the process to generate the finalized MPS is not included, but only the process to get the TMPS.

There are several ways to derive the production requirements. They may be derived from the on-hand inventory and all demand sources, which are composed of actual demand (order on the book) and potential order (forecast demand). There may be two categories in deriving a production requirement. First, if there is a production planning function, a TMPS is guided by the production plan. A weekly production requirement is derived from the monthly production plan and the customer order entries.

Second, if there is no production planning function, then a weekly production requirement is determined by all demand sources such as customer order, interplant requirements, warehouse requirements, etc. The methods to derive a production requirement depend on their source and the level of the MPS. The combination of the methods to obtain the production requirements is given in Table 2. In this research, only case B is handled, and the interaction between the production plan and the MPS is excluded. When a heuristic procedure is proposed for the combinatorial problems, the number of test problems may be so large that it is highly impractical to test all the combinations of the system parameters. Therefore, this research will only evaluate the proposed procedure for a family of the specific test problems.

Research objectives The purpose of this research is to develop the following objectives in a GT based MRP System:

1. To develop a master production scheduling procedure deriving a TMPS which minimizes the total production cost when there is a constraint of capacity limit. The total production cost is composed of setup, holding, overload and delay penalty cost.
2. To develop an aggregate production planning model

TABLE 2. The method to determine a production requirement

The Level of the Production Plan and That of the MPS Source of the Production Requirement	Equal	Different
Optimal Production Plan	Case A	Case B
All Demand Sources	Case B	Case B

which will coordinate the objectives of the marketing, financing, production, and management functions in the production planning level.

3. To develop a method balancing the load within a GT cell.
4. To develop a procedure for getting the optimal capacity target for the critical resources.
5. To develop a procedure to evaluate the heuristic method of getting a TMPS.

Uniqueness of the MPS under a GT Based MRP System

When a functional layout is changed into a GT layout, there are several advantages in master production scheduling. Several characteristics of the MPS under a GT based MRP system and the reasons for them are described below (6). These characteristics will justify the approach to develop the optimal TMPS.

1. The lead time of an end item which includes setup time, queuing time, and transporting time can be reduced.
 - a. The total setup time can be reduced because similar parts are ordered together, therefore, changeover is decreased
 - b. The queuing time and WIP can be reduced, because the material flow and the routings of components and the interactions among the jobs are simplified.
 - c. Transportation time can be reduced. Because machines in a group are close together, continuous transfer is possible.
2. The MPS has the capability to accommodate the market changes quickly because of the reduction in the lead time of the production. This also makes it possible to promise quick delivery to the customer, resulting in increasing the customer service level and potential orders. This implies that the MPS is

elastic to the other external variables; then, the firm planned period in the planning horizon is not mandatory.

3. The feasibility of the proposed TMPS can be evaluated interactively. Similar parts are classified by the coding and classification scheme and they are planned in one family. That is, the scheduling approach is based on the tooling and the material families; therefore, the complexity of the master production scheduling is reduced and the implementation of the interactive MPS system is easier than the other MPS systems under a different environment.
4. Expediting the MPS over the GT cell is simple because the workers have common aims and know their contribution to the company. They understand all operations on a part instead of one operation and work together well because of the minimal external control and the reduction in co-ordination with the other functions.
5. The scheme developing a load profile is different from that of the other environments. A coding and classification scheme and the MRP logic with the single cycle and single phase ordering are used to develop the load profile.

CHAPTER 2. LITERATURE REVIEW

Aggregate Production Plan

There are four widely recognized traditional approaches such as the linear decision rule, management coefficient model, parametric production planning approach, and search decision rule in the aggregate production planning problem.

The pioneering research of the aggregate planning methods was made by Modigliani et al. (43). They developed the linear decision rule as a means of making aggregate employment and production rate decisions. The objective function of the linear decision rule model is to minimize a quadratic total cost function. The total cost is composed of the costs caused by regular work force level, hiring/firing, overtime/idle time, and inventory holding.

Bowman (2) developed the management coefficient model on the premise that the managers are aware of and sensitive to the variables which are important in the aggregate planning decisions, but they are inconsistent in using their knowledge. He proposed to establish the form of decision rules for aggregate planning through rigorous analysis. On the contrary, the coefficients for these decision rules were setup through the multiple regression analysis of the management's past decisions.

The parametric production planning approach developed by

Jones (24) is a heuristic approach to discover the decision rules for work force and production. This approach is to evaluate all of the possible combinations of parameters for these rules and to find a parameter set minimizing the cost function. The selected parameters are incorporated with the work force rule and the production rule.

The search decision rule developed by Taubert (57) can cover more realistic problems. The more realistic the model is, the more difficult the analysis is. The search decision rule uses the heuristic optimum-seeking procedures to reach the optimum of an objective function.

Elwood S. Buffa and William H. Taubert (5) classified the decision rule approaches to the aggregate planning problem into mathematically optimal decision rule approach, heuristic decision rule approach and search decision rule approach.

This research is devoted to the mathematically optimal decision rule approach to solve the problem where there are conflicting multiple objectives. The mathematical decision rule approach contains the linear decision rule, linear programming, dynamic programming, goal programming, etc.

Several authors cited below extended the linear decision rule (5). Hanssman and Hess attempted to formulate an approximating linear model to the original non-linear cost terms. Hanssman-Hess linear programming model is equivalent

to the linear decision rule model in terms of general structure. The decision variables and the cost criterion function are the same, but there is a difference that in the Hanssman-Hess linear programming model the cost criterion function is linear, but in the linear decision rule model it is quadratic. Sypkens identifies plant capacity as a decision variable in addition to the work force and production rate. Chang and Jones generalized the linear decision rule methodology to yield both aggregate and disaggregate planning in a multi-product environment. Bergstrom and Smith have developed the basic linear decision rule model to one involving both multi-products and the inclusion of a revenue term.

Some authors described below tried to solve the aggregate production planning problem by applying linear programming (5). Bowman proposed the use of the distribution model of linear programming for aggregate planning. McGarrah developed a basic simplex model of aggregate planning for one period where change and inventory cost functions have the general forms. The specific applications of the simplex model in the industrial aggregate planning situations are reported by Eisemann and Young in the study of a textile mill and by Greene, Chatto, Hicks and Cox in the packing industry.

Several authors tried to solve the problem where there are multiple objectives by applying goal programming. Veikko Jääskeläinen (23) used three separate and incompatible

goals, the levels of production, employment and inventories. He defined the preemptive priority factors associated with goals so that goals in a lower rank are satisfied only after those in a higher rank are satisfied or reach points beyond which no improvements are possible under the given constraints. Lee (30) and Kornbluth (26) suggested that goal programming can provide an improved model for the aggregate scheduling problem. Lee (30) pointed out that one advantage of goal programming is that it can be solved by a modified version of the familiar simplex method. Goodman (18) developed a goal programming approach to the problem of scheduling aggregate production and work force. He demonstrated that the effectiveness of such an approach is highly dependent upon the degree of nonlinearity which the goal programming model must approximate. The results indicate that, for relatively low degree models, goal programming may provide an efficient and effective solution approach, while for higher degree models the approach may be inappropriate. Lawrence and Burbridge (29) presented a multiple goal linear programming model for coordinating production and logistics planning. S. M. Lee, R. L. Morris and L. Franz (31) presented an integer goal programming approach to the problem involving fixed costs and multiple goals. A. G. Lockett and A. P. Muhlemann (34) handled the problem achieving a balance between a smooth work-load on the factory and matching production with promised delivery dates.

Master Production Schedule

Classification

Each company may have its own master production scheduling procedure. This can be shown from the fact that most literature of the master production scheduling procedure published from the industry has its own uniqueness. Some authors tried to classify the Master Production Schedule types. Mather and Plossl (38) reviewed ten different types of the master schedule. Paul Maranka (36) discussed the classification of Mather and Plossl and pointed out that a number of combinations of the ten master schedule types under one roof can be encountered and this required the master schedule process to be defined general enough so that any of the types or the combination, thereof, could be incorporated into one planning group. He identified the master schedule type with one of three basic business types--continuous process; production lots made-to-stock and/or option-to-order; and make-to-order. David I. Leo (33) made the abstracts of the COPICS (Conversational Oriented Production and Inventory Control System), where the master production schedule planning flow is classified into--make-to-stock, assemble-to-order, and make-to-order. A. L. Steven (55) suggested three criteria: make-to-stock, make-to-order, and the completely engineered product for the MPS classification.

Special topics

Many authors have concentrated on conceptualizing the development of Master Production Schedules within the hierarchy of production plans.

A. L. Steven (55) described the closed loop MRP system where the relationships among production plan, master schedule and RCCP are represented. David O. Nellemann (44) explained the production planning and the master scheduling as the management's game plan. Robert McCormick (40) discussed the interdependence of the master schedule to the other planning functions including production plan, forecasting, rough cut capacity planning, and planning BOM, plus its interface with downstream modules of material requirements planning and the final assembly schedule. Richard W. Malko (35) stressed that the master scheduling System is the key sub-system for the successful manufacturing control systems and needs the help of other sub-systems to generate the final results. He also wrote about how the raw data can be acquired at the beginning and what techniques are used to remain consistent. John F. Proud (48) introduced the twelve principles of good MPS.

Several companies announced the master production scheduling system in specific business types. Robert W. Kohankie II, Waterbury Farrell and Richard R. Morency (25) implemented a system for preparing a master schedule in a

consumer goods company. They developed the master schedule to convert the production forecast into specific product code level demands that can then be used to schedule each production line against current capacities. W. H. Gaw (17) showed the "team approach" can be used to develop and maintain the master scheduling in a "make-to-order" manufacturing firm. In the process industrials, John Burt (7) discussed the appropriate levels of MPS, techniques for integrating multiple levels, use of planning, inverted BOM, and the relationships with forecasting, production planning and scheduling design. Romeyn C. Everdell and Woodrow W. Chamberlain (16) discussed master scheduling in a multi-plant environment.

Several authors discussed one aspect of MPS. Darnton and Garton (11) described the factors that lead to the changes in the company's planning and control systems, and described the means used to monitor effectiveness of the system. James R. Schwendinger (50) stressed that order promising is a by-product of the MPS process which makes it feasible to make significant improvements in dealing with customers. Ernest C. Huges (20) stressed that lead time management is the key to successful master scheduling and proposed a method to establish a successful lead time management program. Scott R. Miller (42) showed that the Master Production Schedule can compromise the objectives of marketing and production and inventory control. John. J. Bruggeman

and Kathleen T. Merkin (4) described how the master scheduling project is responsible for coordinating the efforts of the other organizational specialists to insure the development of a comprehensive, feasible master production plan. Hal Mather (37) pointed out the importance of the BOM for a successful MPS and excessive protectionism within the various organizations that use the BOM prevents the development of its improvements.

Interface with other functions

J. Gaylord May (40) stressed that an accurate forecast of customer demand is, perhaps, the most important ingredient to establish a good master schedule. So, he focused on the concepts which are designed to improve customer demand forecasts in front of manufacturing lead-times. Russel Copeman (9) covered a specific approach used to integrate product line forecasts with actual orders and actual satellite assembly plant requirements into a single master schedule, where it includes the make-to-stock and make-to-order type of customer orders together. Linda M. Smith (51) stressed that order factors have an effect on the success of any MRP-master schedule coordination.

GT Based MRP System

As far as the literature survey is concerned, only four papers have dealt with MRP and GT in combination. Colin New

(45) said that the combination of MRP and GT is the new strategy for the component production. The SCRAGOP (Short Cycle Requirements and Group Organized Production) system works well for the component production if the production order trigger is UPBC (Unique Period Batch Control). Nallan C. Suresh (56) pointed out that the optimal production system in a small batch/large variety situation, where the conditions are appropriate for the GT, consists of the following: A group layout; a "short cycle-flow control" approach for direct materials planning and ordering; and a scheduling approach based on tooling, and material families in addition to the other relevant factors. He explained the short cycle-flow control approach which is required in a GT situation can be met by an MRP system. Hyer and Wemmerlöv (21) explained that MRP and GT are a viable combination in a general framework for production planning and control. They discussed the drawback of the period batch control and proposed NRN (Nice Round Numbers) rule to find the order quantity. Spencer (52) explored the scheduling components for the GT lines producing diesel engines in a company.

Capacitated Lot Sizing for Multi-Items

Lot sizing is used to determine the timing and sizing of production to minimize the setup and the holding cost. The first effort to develop the lot sizing technique for multi

items with the capacity limit was made by Eisenhut (15). He defined a priority index from a modified Silver-Meal heuristic for a single product without capacity constraints. Then the production lots are assigned to the current scheduling period until either the capacity constraint is violated or all marginal cost reductions become negative. But this method may generate an underload in an earlier period; therefore, it will result in an infeasible solution. Lambrecht and Vanderveken (28) proposed a backtrack routine to solve this problem by extending the Eisenhut heuristic. Dixon and Silver (13) presented an alternative modified heuristic which guarantees the generation of a feasible solution (if one exists) to avoid the above situation. Ali Dogramaci et al. (14) developed four-step algorithm which improves the feasible solutions obtained to get a better solution. Reuven Karni and Yaakov Roll (49) also developed a lower bound solution by improving the feasible solution so obtained until no further improvement can be made. The above heuristics can be described as period-by-period methods. Newson (46) developed another technique by using a modified Wagner-Whitin algorithm. Newson's heuristic is based upon a series of the shortest path calculations for a network representing the uncapacitated problem.

Evaluation Method of the Heuristic Solution

When a heuristic solution is developed for the large combinatorial problems, a solution standard is necessary to evaluate the proposed solution or procedure. An optimal solution can be used for the solution standard, but it is almost impractical to find the optimal solution for the combinatorial problems in most cases. Therefore, a near optimal solution can be used for the solution standard. Several researchers developed inference procedures to get an estimation of the minimum using small order statistics of a large sample. Lauren de Hann (12) constructed a procedure to derive a confidence interval for the minimum of a function using asymptotic theory. Weissman (58) constructed a procedure to develop confidence intervals based on the lower extreme values of a large sample for the threshold parameter (unknown minimum-life) of a life distribution.

After getting the solution standard, a question is raised, "How does one use the solution standard to evaluate the heuristic solution and procedure?" Dannenbring (10) classified the measurement of a solution goodness as follows:

1. Comparative measure
2. Achievement measure
3. Distributional measure

Comparative measure determines the magnitude of the difference between the solution standard and the value of the

heuristic solution. Achievement measure determines whether the heuristic solution value is equal to the solution standard or not. Distributional measure is aimed at finding the chances that a solution could have been obtained with a value better than that for the heuristic solution being evaluated. Achievement measure gives a simple yes or no statement for an individual problem; therefore, this measure is useful when it is used together with other measures. Distributional measure requires the generation of the possible solution set to determine the distribution pattern of the solution.

Summary

1. An aggregate production planning problem with multiple objectives has been developed to coordinate the conflicting objectives of each function in an organization. This type of an APP problem is solved by goal programming technique.
2. Considerable research has been devoted to the conceptual aspect of master production scheduling, but there is little research in the methodology of master production scheduling.
3. Several researches have been handled concerning operational level scheduling in a GT cell, but not much concerning managerial level scheduling.

4. Little research has been made in master production scheduling with the time phasing effect of the load and the capacity limit.
5. Little research has been done in multi-item lot sizing rules, and these lot sizing rules may be used for the master production scheduling tool. But, there are more managerial factors to be considered in master production scheduling; therefore, these multi-item lot sizing rules cannot be directly used for master production scheduling.
6. Little research has been done under the environment where MRP is used as the production planning and control system on a GT cell.
7. Comparative measures other than distributional measures and achievement measures have been mostly used to evaluate the heuristics for the combinatorial optimization problems.

CHAPTER 3. PROBLEM DEFINITION

Characteristics and Assumptions

Contrasts between this research and the papers of Eisenhut and Newson are shown in Table 3. The characteristics of this research can be described as follows. The time phasing effect of load, overload cost, and delay penalty cost are considered in the process of scheduling. The methods in the research include the traditional period-by-period method and the shortest path algorithm. A tree search scheme is also included as a heuristic search method for the optimal solution. A left threshold parameter of an unknown distribution is used as a solution standard instead of a solution from the Wagner-Whitin (W-W) algorithm. The need for production smoothing is reduced because available capacity is compromised in the process of master production scheduling. Multi-resource cases are also allowed in this research.

This research deals with two subsystems of the production planning and control system for a GT based MRP system. These subsystems include the aggregate production planning and the master production scheduling systems. The APP, the output of the aggregate production planning system, is the basis for the production plan which may be the primary input to the master production scheduling system. If there is no APP function in the production planning

TABLE 3. Contrasts of the research with other works

	Eisenhut(15)	Newson(46)	Kim
Time Phasing of Load	No	No	Yes
Backlog & Overload	No	No	Yes
Cost Factor	Setup Holding	Setup Holding Overload	Setup Holding Overload Penalty
Approach Method	Period-by- Period	Shortest Path	Period-by-period Shortest Path Tree Search
Solution Standard	W-W Algorithm	W-W Algorithm	Threshold Parameter Estimation
Need for Production Smoothing	More	More	Less
Multi-Resource Problem	No	No	Yes

system, then the production requirements are determined from all demand sources. The following assumptions are made in the development of the aggregate production planning and the master production planning systems.

1. The marketing plan and the APP are represented on a per month basis, and the MPS is on a per week basis.
2. A company has a controllable number of end items made from multiple component parts.
3. A structured BOM exists and end items in the TMPS are identified by part numbers in the BOM. The business type is make-to-stock.
4. The demand pattern is seasonal. All production lead times of end items are known and deterministic.
5. The relative importances among conflicting goals can be quantified.
6. Every end item has a load profile which represents the measurable load on the critical resources.
7. Capacity limitations of critical resources can be defined and constant during the scheduling period.
8. There is a one to one correspondence between a TMPS and a total cost which is composed of set

up, holding, overload, and delay penalty cost.

Aggregate Production Plan

The APP is the plan of production, inventories and work force at an aggregate level to respond to fluctuating demands on a production system (32). The function of the aggregate production planning system is to keep a balance of work-load and to match production with the promised delivery dates and the expenditure plan. For work-load smoothing, load profiles and capacity limitations are used. Therefore, load profiles, capacity limitation of the critical resources, and the marketing and financing plans are prepared in advance.

Load profile refers to the estimated capacity requirements of the item in the MPS on a limited number of the key departments (41). For every manufacturing end item in a TMPS, the standard load on each machine for a GT cell should be defined. In the production planning level, only the capacity limitations of several critical resources are considered, instead of considering all resources. The marketing plan is a guideline for the monthly APP. The marketing department develops the marketing plan on a per month basis. The financing plan is prepared in the same way.

The aggregate production planning system must consider

the balance between external demand and internal supply in a production system. The objective function in the aggregate production planning system is to minimize the weighted deviations from the desired goals. These goals are defined as follows:

1. Satisfy the requirement that the production cost is consistent with the production budget.
2. Satisfy all of the forecast requirements of the marketing department during the planning horizon.
3. Satisfy the sales requirements for each period.
4. Insure that the actual production load is equal to the average capacity limit of the GT cell for each period.
5. Insure that the total amount of inventory during the planning horizon is less than a given value.
6. Insure that the actual workload is equal to the regular workload in the supporting departments for each period.

The production planner uses the output of the aggregate production planning system to build up the monthly production plan which may be translated into a weekly TMPS. The aggregate production planning problem can be represented in the following goal programming model:

1) Variable Definitions

The variables in the model are defined as follows:

- X_{it} : production quantity of end item i in month t
 S_{it} : sales requirement of end item i in month t
 B_t : available budget for the production in month t
 I_{it} : on hand inventory level of end item i at the end of month t
 L_{ijkt} : load of end item i assigned to machine K in the j th group at the period t , $t=1,2,\dots,T$ where T is the total lead time
 L_{i***} : a set which is composed of L_{ijk} , $L_{ij..}$, $L_{i.k}$, $L_{i....}$ where W_k is the weighting factor for machines
 L_{ijk} : total load of end item i assigned to machine K in the j th group = $\sum_t L_{ijkt}$
 $L_{ij..}$: sum of the weighted load of each machine in group j = $\sum_k W_k \cdot L_{ijk}$.
 $L_{i.k}$: total load of end item i on machine K = $\sum_j L_{ijk}$.
 $L_{i....}$: total load of end item i on the shop floor = $\sum_j L_{ij..} = \sum_k W_k \cdot L_{i.k}$.
 A_{**} : a set which is composed of A_{jk} , $A_{j.}$, $A_{.k}$, $A_{..}$
 A_{jk} : average load of machine K in the j th group = $(1/T) \sum_i \sum_t X_{it} \cdot L_{ijk}$.
 $A_{j.}$: average load of the j th group = $(1/T) \sum_i \sum_t X_{it} \cdot L_{ij..}$
 $A_{.k}$: average load of machine K = $(1/T) \sum_i \sum_t X_{it} \cdot L_{i.k}$.
 $A_{..}$: average load of total shop floor = $(1/T) \sum_i \sum_t X_{it} \cdot L_{i....}$

- L_{ij*t} : load of end item i assigned to j th key department at period t , $t=1,2,\dots,T$ where T is the total lead time.
- L_{ij*} : total load of end item i assigned to the j th key department = $\sum_t L_{ij*t}$
- A_{j*t} : regular available capacity of key department in month t
- L : maximum accumulated dollar amount of the inventory item during the planning horizon
- C_i : inventory holding cost per unit per period for the end item i
- CM_i : manufacturing cost per unit for the end item i
- CV_i : dollar amount of the end item i
- \underline{W} : vector of weighting factors for the deviation variables
- \underline{D} : transposed vector of the deviation variable

2) Model Formulation

The objective function and the constraints of the model are defined as follows:

- (1) Objective Function: Minimize the total weighted deviation derived from the gap between the desired goal and the achieved goal. Several goals are developed by financing, marketing, manufacturing, management, and other major supporting functions.

$$\text{Minimize } Z = \underline{W} \underline{D}$$

(2) Constraints: Several goals described above are transformed into the following constraints. All variables and constraints need not be considered simultaneously. Critical variables and constraints are included in the model. The deviation variables with subscript n and p are, respectively, under achieving and over achieving for each goal.

1. Financing:

$$\sum_i (C_i \cdot (I_{it}) + CM_i \cdot X_{it}) + D_{nt} - D_{pt} = B_t,$$

for all t

2. Marketing:

$$\sum_t X_{it} = \sum_t S_{it}, \text{ for all } i$$

3. Shop Floor:

$$\sum_i X_{it} \cdot L_{i***} + D_{n**t} - D_{p**t} = A_{**}, \text{ for all } t$$

4. Management:

$$\sum_i \sum_t CV_i \cdot (I_{it}) + D_n - D_p = L$$

5. Others:

$$\sum_i X_{it} L_{ij*} + D_{nj*t} - D_{pj*t} = A_{j*t}, \text{ for all } t$$

$$I_{i,t-1} + X_{it} - S_{it} = I_{it}, \text{ for all } i,t$$

A small size problem for a GT cell is illustrated in Chapter 5.

Master Production Schedule

The purpose of the master production scheduling system is to derive a TMPS which satisfies the objective function

from the demand requirements. The quantity of end items in a period of the MPS may represent a gross requirement, a production requirement, or a planned order. This research presupposes that the quantity of end items in the MPS implies production requirements or planned order. If the quantity is the gross requirement, it can be changed into the production requirement by considering the on-hand inventory. The demand requirements of end items can be determined from all demand sources or derived from the production plan. If the capacity target can be derived from capacity planning, it can be used, if not, the capacity limit is used instead of the capacity target. The problem is to derive a TMPS from the demand requirements which is derived from the production plan or all demand sources. The objective function to be minimized is the sum of setup, carrying, overload, and shortage penalty cost. There is a per end item setup cost parameter for each product group and a per unit carrying cost parameter for each product group in one week period. There is also machine-hour or man-hour cost for overload for each critical resource. It is not easy to determine the shortage penalty cost, which is determined for each product group in a one week period. In general, the shortage penalty cost includes loss of goodwill and business, loss of revenue, etc. In this research, the shortage penalty cost only includes the shut down cost of the assembly department when an order misses a due date.

There are two constraints, the capacity and the due date. The capacity constraint includes parameters describing the maximum machine-hours or man-hours available during each period. Infinite shortage penalty cost implies that the due date should be kept, and infinite overload cost implies that the capacity limit should be kept. If the shortage penalty cost and the overload cost are finite, small values, then the system will compromise the trade off between the overload cost and the shortage penalty cost to minimize the total cost. The master production scheduling problem can be represented in the following model:

1) Variable Definitions

i : item to be produced ($i=1,2,\dots,I$)

t : production period ($t=1,2,\dots,T$)

S_{it} : demand for the item i in the period t

X_{it} : units of the product i to be produced
in the period t

$E_{it} = \sum_{t'=1}^t (X_{it'} - S_{it'})$
excess or shortage of the production of
item i from period 1 to period t over the
demand of item i from period 1 to period t

$$[E_{it}]^+ = \begin{cases} E_{it} & \text{if } E_{it} \geq 0 \\ 0 & \text{if } E_{it} < 0 \end{cases}$$

$$[E_{it}]^- = \begin{cases} 0 & \text{if } E_{it} \geq 0 \\ -E_{it} & \text{if } E_{it} < 0 \end{cases}$$

$$d(X_{it}) = \begin{cases} 0 & \text{if } X_{it} = 0 \\ 1 & \text{if } X_{it} > 0 \end{cases}$$

RC_t : capacity limit during the period t

S_i : setup cost of the item i

C_i : carrying cost per unit of the item i
per period carried

P_i : penalty cost per unit of the item i
per period delayed

O_t : cost per man-hour or machine-hour of labor or
machine which is overdriven in the period t

L_{ij} : load of the end item i in the period j,
where $j=1,2,\dots,J$ and the total lead time(J)
is less than three in the test problems.

L_{ijk} : load of the end item i in the period k caused
by the production X_{ij}

$$L_{ijk} = L_{i,k-j+1} \cdot X_{ij}$$

OC_t : the total required load minus the available
load in period t

$$[OC_t]^+ = \begin{cases} OC_t & \text{if } OC_t \geq 0 \\ 0 & \text{if } OC_t < 0 \end{cases}$$

2) Model Formulation

(1) Objective Function

$$\begin{aligned} \text{Minimize } Z = & \sum_i \sum_t d(X_{it}) \cdot S_i + \sum_i \sum_t [E_{it}]^+ \cdot C_i \\ & + \sum_i \sum_t [E_{it}]^- \cdot P_i + \sum_t [OC_t]^+ \cdot O_t \end{aligned}$$

(2) Constraints

$$\sum_t X_{it} = \sum_t S_{it}, \text{ for all } i$$

$$\sum_i (L_{it-2,t} + L_{it-1,t} + L_{it,t}) = RC_t + OC_t, \text{ for all } t$$

If the value of subscript is non-positive, the corresponding load is zero.

CHAPTER 4. THE APPROACHES

Preliminary Work

Input data

The time bucket in the aggregate production planning level is one month but at the master production scheduling level is one week. All input variables discussed in Chapter 3 can be summarized as follows. The related function and the necessities of each variable are summarized in Table 4:

(1) Load Profile

L_{ijkt} : load of end item i assigned to machine k in the j th group at period t , $t=1,2,\dots,T$ where T is the total lead time.

L_{ij*t} : load of end item i assigned to the j th key department at period t , $t=1,2,3,\dots,T$ where T is the total lead time.

L_{ij} : load of end item i in the period j , $j=1,2,\dots,J$ where J is the total lead time. In the master production planning level, only one resource is observed. This load profile can be derived from L_{ijkt} and L_{ij*t} .

(2) Policy Variables

S_{it} : sales requirement of end item i at month t .

B_t : available budget for the production at month t .

- L : maximum accumulated dollar amount of the total inventory for all items during the planning horizon.
- A_{j*t} : regular workforce level of the jth key department at month t.
- RC_t : production capacity limit on the shop floor which is defined by each critical resource.

(3) Cost Parameters

- S_i : setup cost of end item i.
- P_i : penalty cost per unit of end item i per period delayed.
- C_i : inventory holding cost per unit per period for the end item i.
- O_t : the cost of overload for the critical resources.

(4) System Output

- PP : production plan determined by the APP which is the output of the aggregate production planning system.
- TMPS : tentative master production schedule which is the output of the master production scheduling system.

(5) Others

- CM_i : manufacturing unit cost for the end item i.
- CV_i : market price of an end item i.
- W : set of weighing factors for the

TABLE 4. Input data summary¹

Input Data	Var	Related Function	APP	MPS
1. Load Profile		Production	M*	M*
2. Policy Var.	S_{it}	Marketing	O	.
	B_t	Financing	O	.
	L	Management	O	.
	A_{j^*t}	Supporting	M*	.
	RC_t	Production	.	M*
3. cost Para.	S_i	Accounting	O	M
	P_i	Accounting	O	M
	C_i	Accounting	O	M
	O_t	Accounting	.	M*
4. System Output	PP	APP	.	O
	TMPS	MPS	.	.
5. Others	CM_i	Accounting	O	.
	CV_i	Accounting	O	.
	W	Planning	M	.

- ¹ M: mandatory input data
O: optional input data
*: system needs only the value of critical resources
.: not necessary.

deviation variables.

Load profile

The most important prerequisite for the analysis is the existence of the load profile for each end item. The element of the load profile of the end item i is defined for the shop floor and the key departments. Key departments include sub-assembly, final assembly, and other critical supporting departments. To get the load profile, an explosion simulator and a detail operation scheduling and loading system are used. The general system flow of these two functions is given in Figure 2.

The BOM (Bill of Material) specifies the composition and the process stages of the end item in the MPS. An MRP system and a coding and classification system are used for the explosion simulator which generates the planned order schedule for all manufactured components by exploding the end item in the BOM through all levels. The Bill of Labor (or Capacity) provides the standard hours of labor (or Capacity) requirements for each operation. The planned order schedule and the Bill of Labor (or Capacity) are the inputs for the operation scheduling system which determines the sequence of the planned order for the made parts. The loading system determines the standard hours representing the estimated labor (or capacity) requirements of an end item on each key resource in a company. These standard data

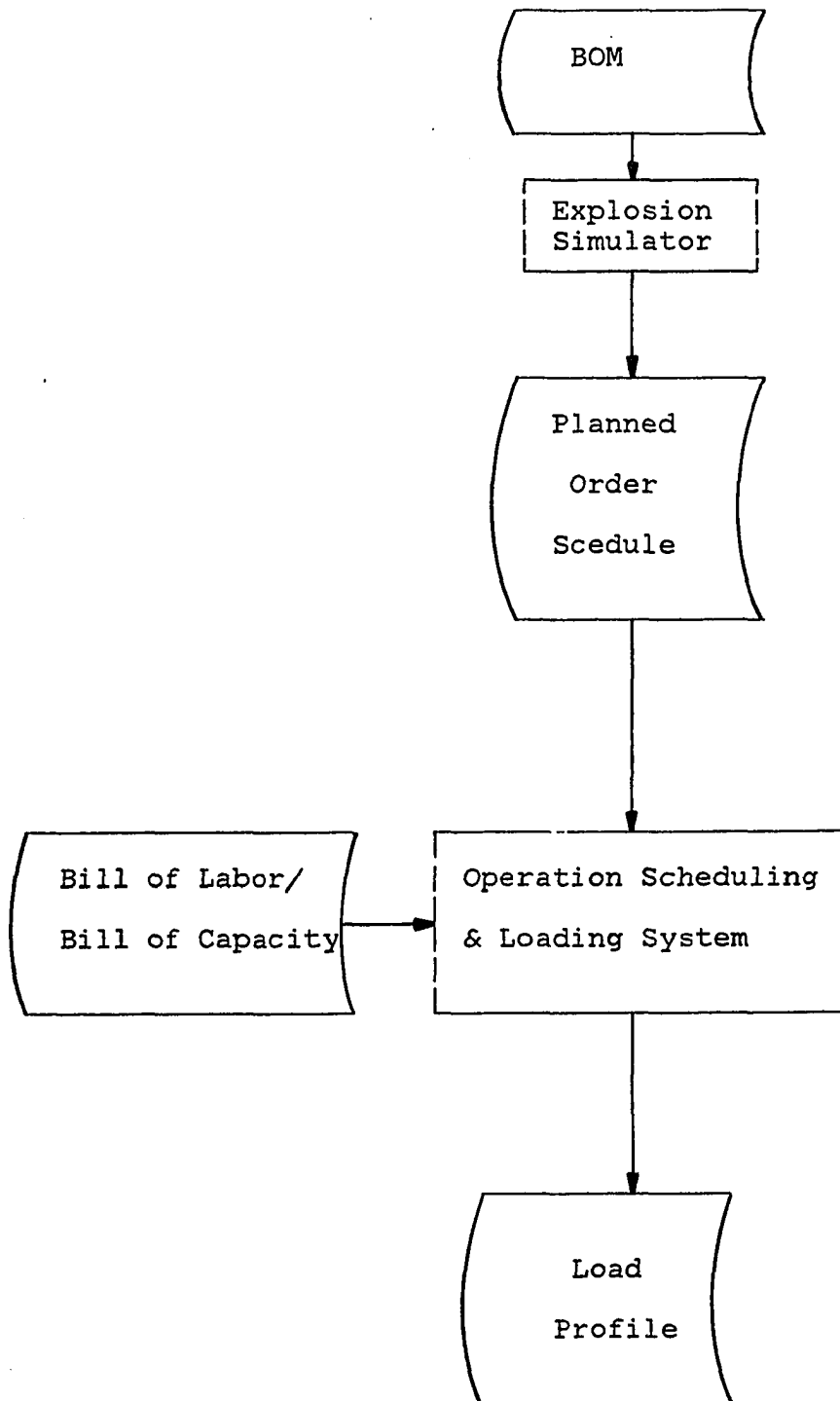


FIGURE 2. A system flow for load profile

are the load profile which represents the time phased load on each key resource to produce one unit of end item.

Aggregate Production Plan

The given aggregate production planning problem is a typical multi-goal optimization problem. All variables and constraints need not be handled simultaneously. The critical resources and the constraints are selected by the user. A matrix generator program creating the input of the aggregate production planning system is necessary to make the system more flexible. In this research, several critical resources and constraints are selected for an illustrative example. The goal programming model is converted into the linear programming model in the following ways. The machine K in the Jth group and Lth supporting department are only critical resources. The other cases can be handled in the same way.

The objective is to minimize \underline{WD} , i.e.,

$$\begin{aligned} \text{Min } \{ & \sum_t (W_{nt} \cdot D_{nt} + W_{pt} \cdot D_{pt}) + \\ & \sum_j \sum_k \sum_t (W_{njkt} \cdot D_{njkt} + W_{pjkt} \cdot D_{pjkt}) + \\ & (W_n \cdot D_n + W_p \cdot D_p) + \\ & \sum_l \sum_t (W_{nlt} \cdot D_{nlt} + W_{plt} \cdot D_{plt}) \} \end{aligned}$$

All deviation variables with subscript n should have

positive values, therefore constraints are changed in the following way:

$$D_{nt} = B_t + D_{pt} - \sum_i (C_i \cdot I_{it} + CM_i \cdot X_{it}) \geq 0$$

therefore

$$\sum_i (C_i \cdot I_{it} + CM_i \cdot X_{it}) - D_{pt} \leq B_t \text{---(1)}$$

In the similar manner,

$$D_{njkt} = A_{jk} + D_{pjkt} - \sum_i (X_{it} \cdot L_{ijk}) \geq 0$$

$$\sum_i (X_{it} \cdot L_{ijk}) - D_{pjkt} \leq A_{jk} \text{-----(3)}$$

$$D_n = L + D_p - \sum_i \sum_t (CV_i \cdot I_{it}) \geq 0$$

$$\sum_i \sum_t (CV_i \cdot I_{it}) - D_p \leq L \text{-----(4)}$$

$$D_{nlt} = A_{lt} + D_{plt} - \sum_i (X_{it} \cdot L_{il}) \geq 0$$

$$\sum_i (X_{it} \cdot L_{il}) - D_{plt} \leq A_{lt} \text{-----(5)}$$

The number in parentheses is the constraint number in Chapter 3. If we substitute all deviation variables with subscript n into the objective function and drop the constant term, we can get the following objective function:

Objective Function

$$\begin{aligned} \text{MIN} [& \sum_t ((W_{nt} + W_{pt}) \cdot D_{pt} - W_{nt} \cdot \sum_i (C_i \cdot I_{it} + CM_i \cdot X_{it}) \\ & + \sum_j \sum_k (W_{njkt} + W_{pjkt}) \cdot D_{pjkt} - W_{njkt} \cdot (\sum_i X_{it} \cdot L_{ijk})) \\ & + (W_n + W_p) \cdot D_p - W_n \cdot \sum_i \sum_t (CV_i \cdot I_{it}) \\ & + \sum_l \sum_t ((D_{plt}) \cdot (W_{nlt} + W_{plt}) - W_{nlt} \cdot \sum_i (X_{it} \cdot L_{il}))] \end{aligned}$$

A small size illustrative example for a GT cell will be shown in Chapter 5.

Heuristics to Develop a TMPS

The following functions are defined to explain the heuristics developing a TMPS.

- AVA(t) : available capacity in the time period t. When the production quantity $X_{i,t+1-j}$ is scheduled, AVA(t) is updated. If AVA(t) is a negative value, this means that there is overload in the time period t. $AVA(t) = [AVA(t) - \sum_j (L_{ij} \cdot X_{i,t+1-j})]$, $j=1,2,3$
- OC(i,t,q) : the amount by which the cumulative capacity exceeds the capacity limit when the requirement q of the item i is scheduled in the period t. $OC(i,t,q) = \sum_j [(L_{ij} \cdot q) - AVA(t-1+j)]^+$
- A(i,t,q) : overload cost which is caused by scheduling the demand requirement q of the item i in the period t. $A(i,t,q) = O_t \cdot OC(i,t,q)$ where O_t is the overload cost per unit resource.
- B(i,t,q) : penalty cost caused by delaying the requirement q of the item i in the period t by one period.

$$B(i,t,q) = P_i \cdot q + (1-d(S_{i,t+1})) \cdot (S_i)$$

$$\text{where } d(S_{i,t+1}) = \begin{cases} 0 & \text{if } S_{i,t+1} = 0 \\ 1 & \text{if } S_{i,t+1} > 0 \end{cases}$$

$C(i,j,t)$: penalty cost when the requirement $S_{i,t-j+1}$, $S_{i,t-j+2}, \dots, S_{i,t}$ are scheduled in the period $t+1$. The value of J is the difference between the current period t and the earliest period t where S_{it} is not scheduled at period t .

$$C(i,j,t) = \sum_{j=1}^J (S_{i,t-j+1} \cdot j \cdot P_i) + S_i \cdot d(S_{i,t+1})$$

$U1(i,t)$: Eisenhut Formula: Expected cost reduction by including S_{it} in the present lot.

$$\frac{S_i - I(i,t)}{t \cdot t \cdot S_{it}}$$

$U2(i,t)$: Lambrecht and Vanderveken Formula: Expected cost reduction by including S_{it} in the present lot.

$$\frac{S_i + I(i,t-1) - C_i \cdot (t-1) \cdot (t-1) \cdot S_{it}}{t \cdot (t-1) \cdot S_{it}}$$

$I(i,T)$: inventory cost of the item i when the order cycle is length T .

$$I(i,T) = h(i) \sum_t (t-1) \cdot S_{it}$$

$M(i,j,T)$: subtraction of $I(i,T)$ from S_i based on the shortest path from the first period to the period j .

$N(i,j,k)$: total cost composed of setup, holding and overload cost for producing the demand of item i for the period $j+1$ to k at the very end of the period j .

Method A: period-by-period method

The basic principle of this approach is to increase the lot size with the demand requirement where the marginal cost reduction is positive until there is an overload. If there is an overload at the current requirement, backtracking and delaying are also considered together, and a decision with minimum cost is made to minimize the total cost. Scheduling is performed in the following way from the beginning month to the end month of the planning horizon (See Figure 3).

Step 0. Preliminary Analysis: Determine the supply and the demand, i.e., the allowable capacity and the required capacity during the scheduling horizon. If the average overload is not acceptable, the master production scheduler should appeal to the upper production planning level or revise the production requirements. The allowable overload should be determined by the master production scheduler. This analysis is performed in the lump.

- Step 1. Initialize all system parameters: System parameters include cost and resource parameters. There are four cost elements, i.e., setup, holding, overload and shortage penalty cost. Resource parameter implies the capacity limit or the capacity target. The net production requirement and the load profile are also determined. In the net production requirement matrix, the element S_{it} of the matrix represents the requirements for the product i in the period t where $i = 1, 2, \dots, I$ and $t = 1, 2, \dots, T$. Find $T_{i2} = 3 - k$ where $L_{ik} = \text{MAX}(L_{i1}, L_{i2}, L_{i3})$.
- Step 2. If there are waiting requirements in the waiting list, schedule the requirements with the penalty cost $C(i, j, t)$ as a priority. The value of j is recalled by the system. The higher penalty cost will have the higher priority. After calculating positive and finite $U1(i, t)$ for the current period, schedule current requirement with the priority of high $U1(i, t)$. If the waiting and current requirements cannot be scheduled without overloading, go to Step 5. Otherwise, calculate the positive $U2(i, t)$ for all i and t if S_{it} is not zero.
- Step 3. Search the highest $U2(i, t)$ in the coming periods. If the corresponding S_{it} does not generate an overload, add the S_{it} to the production quantity of

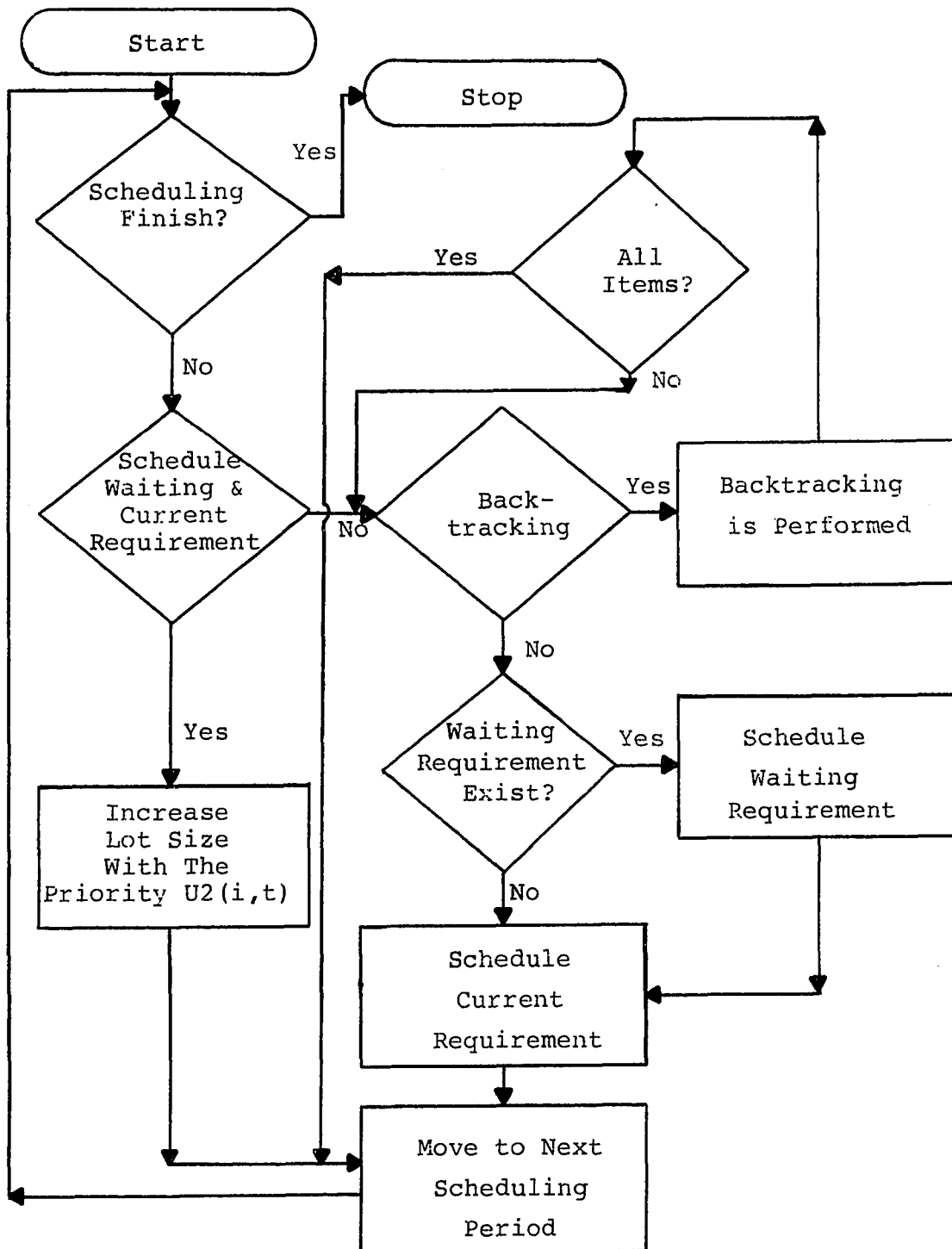


FIGURE 3. Flow diagram of Method A

the current scheduling period. This step is repeated until there is an overload. If there is an overload, get the next item which does not generate an overload.

Step 4. Update the requirements matrix by subtracting the scheduled amount from the corresponding requirements of the matrix, and make the next scheduling period number one. Repeat Step 2, Step 3 and Step 4 until the end of the scheduling horizon.

Step 5. Check to determine whether backtracking is possible.

Calculate $TAVA_i$ and TL_i where

$$TAVA_i = AVA(t-T_i) + AVA(t-T_i+1) + \dots + AVA(t-T_{i2})$$

$$TL_i = (L_{i1} + L_{i2} + L_{i3}) \cdot S_{it}$$

The value of T_i equals $\min(t, AA / ((C_i) \cdot (S_{it})))$ where

$$AA = \min(A(i, t, S_{it}), B(i, t, S_{it})).$$

If the condition of backtracking is satisfied, i.e., $TAVA_i$ is larger than TL_i and there is no waiting requirement at the beginning of scheduling in the current period, go to Step 7. If not, go to Step 6.

Step 6. Calculate overloading and penalty cost, then follow the policy which has the minimum cost.

1) If overloading occurs in the waiting list of schedules in the current period,

Calculate $A(i, t, WA_{it})$ and $C(i, j, t)$ for the

remaining waiting items in the waiting list, then follow the policy which has the minimum cost. WA_{it} is the total waiting quantity of item i and the value of j is recalled by the system. If $A(i,t,WA_{it})$ is larger than $C(i,j,t)$ for an item in the waiting list, the following items in the waiting list and all current demands should wait. If $A(i,t,WA_{it})$ is smaller than $C(i,j,t)$ for all items in the waiting list, then, calculate $A(i,t,S_{it})$ and $B(i,t,S_{it})$ for all current demand requirements. Also follow the policy which has the minimum cost.

2) If overloading occurs at the current requirements, calculate $A(i,t,S_{it})$ and $B(i,t,S_{it})$ for the remaining current requirements, then follow the policy which has the minimum cost and go to Step 4.

Step 7. Find T_{i3} where $T_{i3} = T_{i1} + T_{i2}$ and $AVA(T_{i1}) = \text{MAX}(AVA(t-T_{i1}+1), AVA(t-T_{i1}+2), \dots, AVA(t-T_{i2}))$. If $A(i,t,S_{it})$ which is less than AA , can be found in the period t where t lies between $t = T_{i3}$ and the current period, then shift S_{it} to period t leftwards. If not, calculate $A(i,t,S_{it})$ and $B(i,t,S_{it})$, then follow the policy which has the minimum cost. If all items are scheduled, go to Step 4; otherwise, go to Step 5.

Method B: shortest path method

There is always a one to one correspondence between the path from the node 0 to the node t and a TMPS. For example, in a single product (Figure 4), if the path is composed of two arcs, 0_2 and 2_4 , then this path corresponds to a TMPS which will produce the S_{11}, S_{12} at the beginning of the period 1 and S_{13}, S_{14} at the beginning of the period 3.

The addition of the node 0 is used for the graphical representation of the lot sizing problem (46). If the planning horizon is T , then the total number of possible paths from the period 1 to the period T is 2^{T-1} , and the total number of arcs is $T \cdot (T+1)/2$. In the above example where T equals 4, the total number of paths is $2^3 = 8$, and the total number of arcs is $4 \cdot 5/2 = 10$. The basic principle of Method B is to get the shortest path from the node 0 to the node T while allocating the required capacity for each item. Scheduling is performed in the following way item-by-item (see Figure 5).

Step 0. Same as Method A except that the priorities among all items should be defined.

Step 1. Same as Method A except that backlogging is not allowed. Set $i=1, j=1, k=1$. The value of i is the item number which implies the priority sequence among all items. An arc is made of the node j and the node k , i.e., j is the beginning node number and

k is the ending node number.

- Step 2. If all items are scheduled, stop the process.
Calculate the positive $M(i, j-1, k)$. If the net requirement of the current period is zero, then the product i is disregarded, and if the net requirement of the future period is zero, then $M(i, j-1, k)$ will have a very large value. If $M(i, j-1, k)$ is positive, then go to Step 5, otherwise go to Step 3.
- Step 3. If j equals $T-1$, then go to Step 6. If not, go to Step 4.
- Step 4. Find the shortest path from the node 0 to the node j and update the resource in the work area based on this shortest path. Increase j and k by 1 respectively, then go to Step 2.
- Step 5. Calculate the value of $N(i, j-1, k)$, and put this value into the corresponding position of the matrix $N(i, T-1, T)$. Increase k by 1 and go to Step 2.
- Step 6. Find the shortest path from the node 0 to the node T . The corresponding TMPS is the proposed TMPS of item i . Update the resource and get next item number and set j at 1 and k at 1, then go to Step 2.

Method C: tree search method

Method C is proposed when splitting of the production quantity is allowed. The splitting of the quantity is usually constrained by several restrictions such as batching

Period	1	2	3	4
Demand Requirement	S_{11}	S_{12}	S_{13}	S_{14}
MPS	$X_{11} = S_{11} + S_{12}$	$X_{12} = 0$	$X_{13} = S_{13} + S_{14}$	$X_{14} = 0$

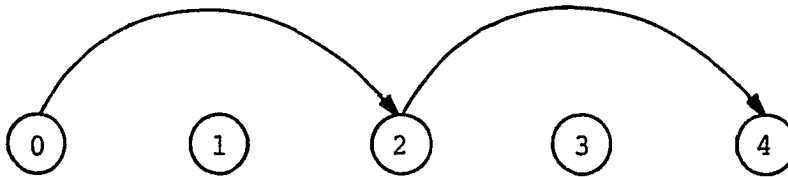


FIGURE 4. A shortest path representation of a MPS

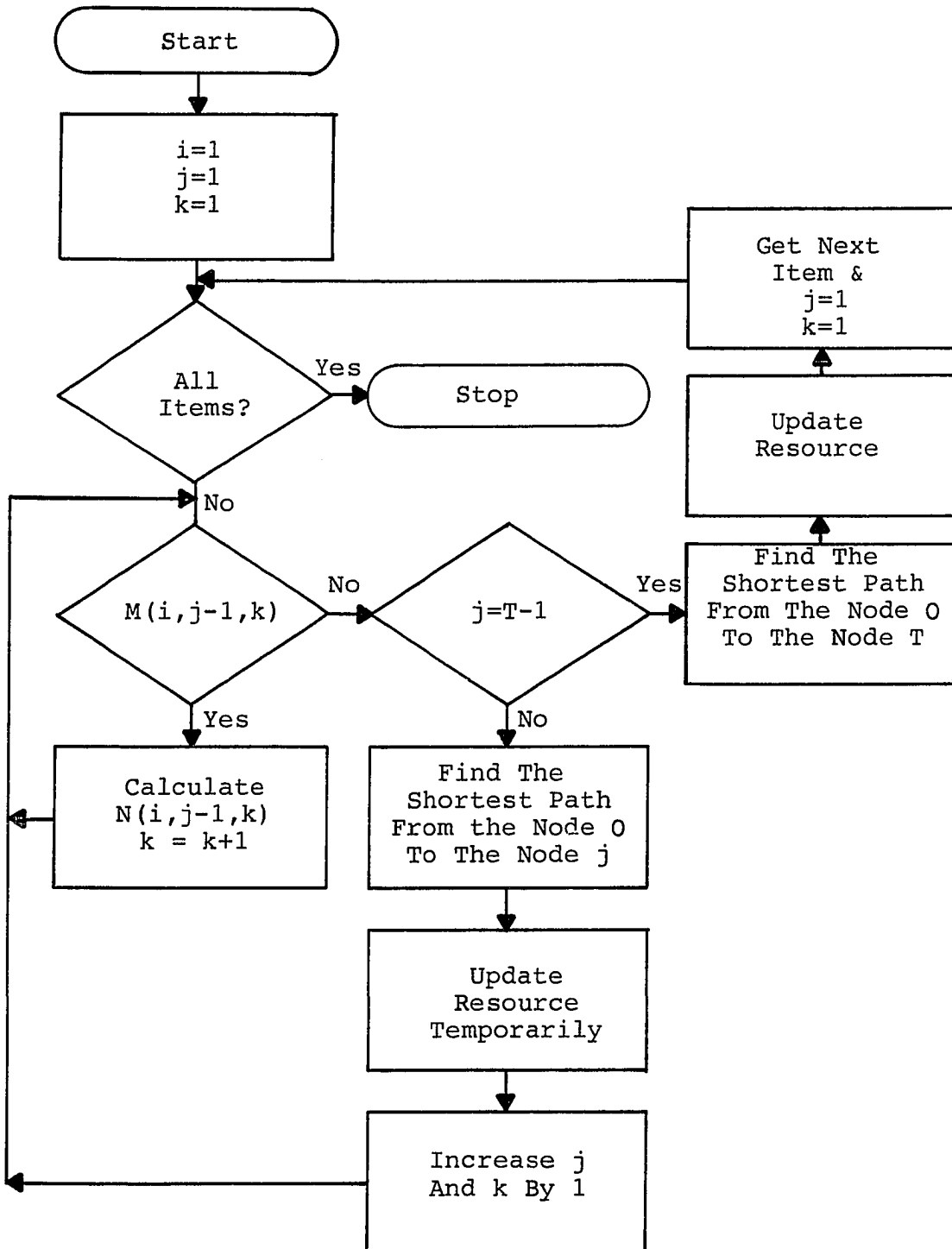


FIGURE 5. Flow diagram of Method B

rules. But there is no restriction for splitting in method C to simplify the problem. Method C is incorporated with the TMPS which is derived from Method A or Method B. A mechanism to derive a random sampling TMPS is defined as follows to describe Method C.

Sampling procedure Available capacity in each period is determined from the capacity limit and the required capacity, which is calculated from the load profile of each end item and the proposed TMPS. The process to generate a TMPS is performed in the following ways:

Case A. When there is overload

The total cost of a TMPS can be primarily decreased by reducing overload cost, but there is a trade-off between overload cost and holding cost. When production quantity shifts leftwards, the overload cost may be reduced, but inventory holding cost is increased. The sampling process is performed as follows.

1. Determine the period spans where there is overload or underload during the scheduling period. If there are several underload and overload spans, the selection of a consecutive underload and overload span is determined randomly.
2. An Origin Period ($t=OP$) during the overload period span is determined randomly.

3. A Destination Period ($t=DP$) during the underload period span which is the previous span of the above overload period span is determined randomly. Item number (i) is also determined randomly. When the corresponding production quantity is zero, all items and periods during the overload period span are scanned to search a positive production quantity. If the search fails, repeat 1, 2, and 3 until the predetermined counter number is reached.
4. A production quantity is determined by dividing the available capacity at period DP by L_{ij} ($j=1,2,3$) where the value j is determined randomly. The Left Shift Quantity (LSQ) is the smaller quantity between this production quantity and corresponding scheduling quantity (X_{it}).
5. Shift the amount of LSQ in the period OP to the period DP leftwards.
6. Modify the previous TMPS and calculate the total cost of the new generated TMPS.

Case B. When there is no overload

The total cost of a TMPS can be decreased by reducing the inventory holding cost and the setup cost. The inventory holding cost only can be decreased by shifting the production quantity rightwards, but right shifting should

not be allowed to generate a penalty cost. The sampling procedure is performed as follows.

1. For every end item and scheduling period, find positive E_{it} .
2. For each above case, find the maximum right shift period which does not generate delay penalty cost.
3. Select the item number (i) and the Origin Period ($t=OP$) randomly. Right Shift Quantity (RSQ) is the smaller quantity between E_{it} and X_{it} .
4. Modify the previous TMPS and calculate the total cost of the new proposed TMPS.

Tree search method Method C is a myopic search method to get a better TMPS from a good W-W type TMPS. An improved TMPS is selected among random TMPSs of size n . Random sampling is performed from the above improved TMPS until predetermined number of levels is reached (See Figure 6). Method C is described as follows (Figure 7).

- Step 1. Start from a good W-W type TMPS. Method A or Method B can be used to determine a good W-W type TMPS.
- Step 2. If the search level is a predetermined number, then stop the process. The best schedule which is found so far, is the proposed TMPS of Method C.
- Step 3. Generate random TMPSs of size n by using the above random sampling procedure.

- Step 4. Choose the best TMPS among random TMPSs of size n .
- Step 5. Update the schedule and all the related statistics, i.e., the available capacity and all cost statistics.
- Step 6. Branch from the best TMPS and increase the search level by 1. Then, go to Step 2.

Four independent random samples of the TMPS are selected and the predetermined number for the search level is also four in the experimental test of this research.

Characteristics of the Methods

Several characteristics of the methods to develop a TMPS can be described as follows:

1. Capacity target/capacity limit is considered in order to develop the best MPS.
2. The total cost function includes setup, holding, overload and shortage penalty cost. The trade off between the capacity and the due date is considered.
3. The load profile is used as a tool for the master production scheduling. This is possible because the lead time of each end item is short. The firm planning period need not be included, because of a quick response to customer orders. Manual intervention is possible where there is a

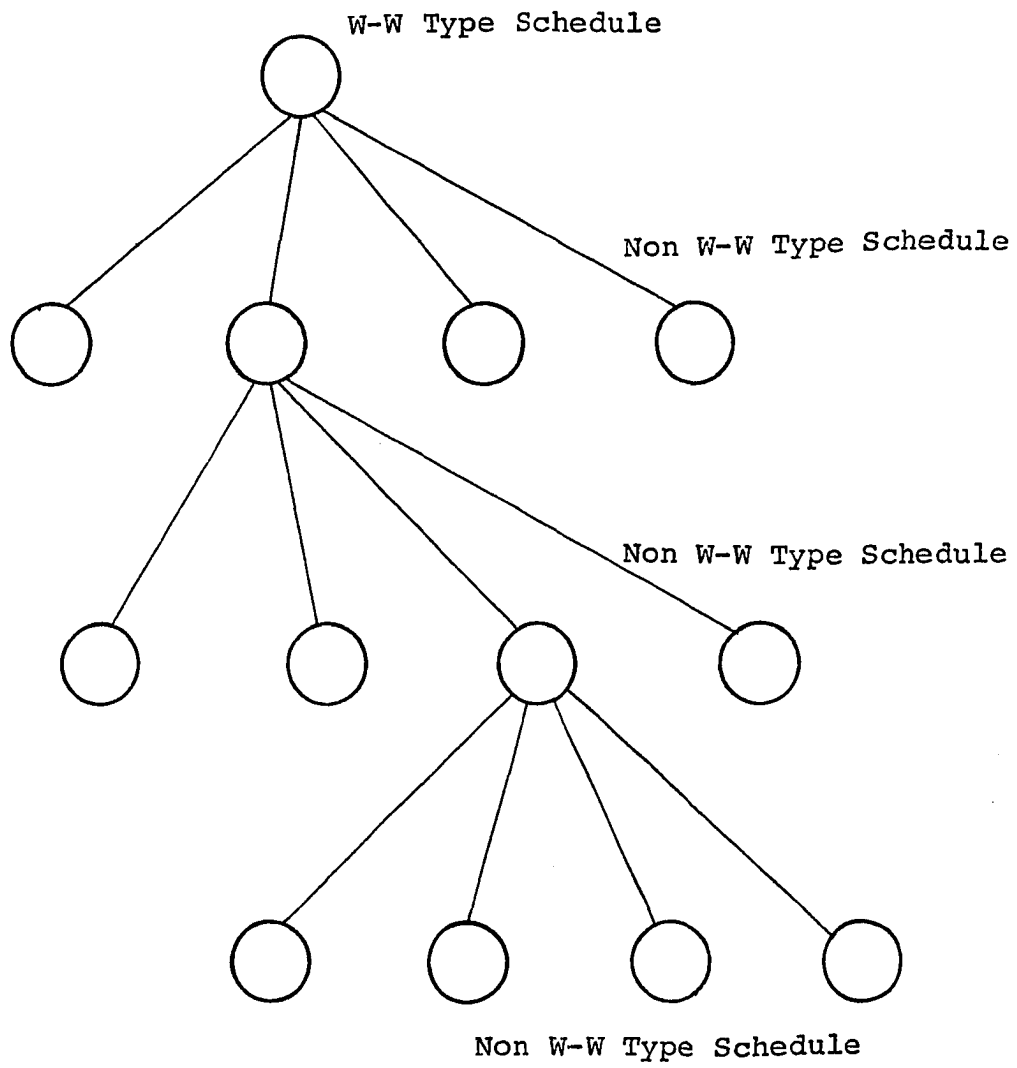


FIGURE 6. Tree search method

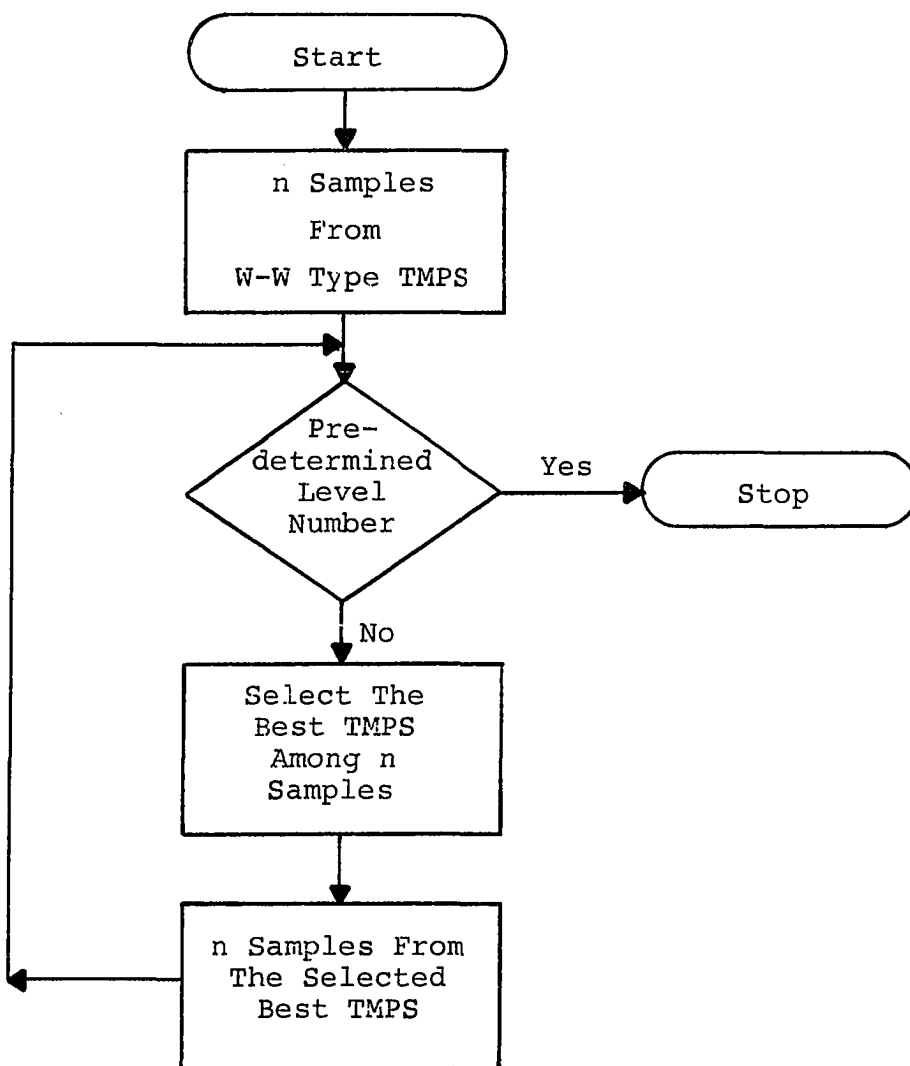


FIGURE 7. Flow diagram of Method C

trade off between the capacity and the due date; therefore interactive programming is favorable to implement this approach. The master production scheduling system under a GT based MRP system can be interactive.

4. This approach can be used even though there is no total production planning and inventory control system. That is, an MPS alone system is possible, if the load profile and other auxiliary system parameters are determined manually.
5. The use of a RCCP function is not necessary because the capacity target /capacity limit is already considered in order to develop the MPS.
6. If the lead time and queuing time are short, this approach can be used for the master production scheduling system of the other environments.
7. The scheduling procedure considers the time phasing effect of the production load.
8. This approach is capacity-sensitive in developing the TMPS, therefore it will make up for the capacity-insensitivity of MRP.

CHAPTER 5. EXPERIMENTAL TEST

Aggregate Production Plan

Illustrative example

An illustrative example, where the total number of items is 2 and the planning horizon is 6, is given as follows. The critical resources are a machine in a GT cell and a supporting department. The sales requirements which are given in Table 5 are generated from the equation (5.1) where $\sigma = 67$ and $a = 125$, and the average demand is 300 for item 1 and 400 for item 2.

TABLE 5. Demand requirements for APP problem

PERIOD ITEM	1	2	3	4	5	6
1	111	302	226	393	413	445
2	274	410	405	384	452	532

All weighting factors which are presented in Table 6 are independent of the time period, and the highest weighting is given to the over utilization of a machine. The corresponding deviation variable can be found from the corresponding index of the weighting factors. The choice of

these values can be best determined by the management function based on the relative importance of the goals.

TABLE 6. Weighting factors of each goal

Variable	W_{nt}	W_{pt}	W_{nit}	W_{pit}	W_n	W_p	W_{nlt}	W_{plt}
Weighting Factor	0.3	0.1	0.8	0.1	0.7	0.2	0.5	0.1

TABLE 7. Values of cost parameters

Item Variable	1	2
C_i	1	1
CM_i	2	4
CV_i	5	10

The value of C_i , CM_i , and CV_i for each item are given in Table 7. The maximum inventory amount (L) is 16500 and the regular available capacity of the critical department is

5670. The average load of the critical machine is also 5670 and planned budget is 2700 every month. The required loads on the machine and the supporting department are 5 and 10 for the item 1 and the item 2, respectively. The resulting linear program has 77 variables and 34 constraints which are solved by MPSX, taking 1.7s of CPU time. The production plan is given in Table 8, and the required and the planned load are given in Table 9. Overload and underload of required capacity is 2925 respectively, but these value of planned capacity becomes 820 respectively. Table 10 shows the budgeted and the planned expenditures.

TABLE 8. Production plan

Period Item	1	2	3	4	5	6
1	111	515	128	420	596	120
2	593	310	503	357	269	425

Using a higher weighting factor for over utilization will result in lower overload.

Discussion of the model

The proposed model is related with the work of Krajewski and Bradford (27); Lockett and Muhlemann (34).

TABLE 9. Required and planned load

Load	1	2	3	4	5	6
Required	3295	5610	5180	5805	6585	7545
Planned	6485	5675	5670	5670	5670	4850

TABLE 10. Budgeted and planned expenditure

Cost	1	2	3	4	5	6
Budgeted	2700	2700	2700	2700	2700	2700
Planned	2913	2698	2702	2700	2700	1940

The variables and the system parameters are defined for a GT environment. There are several differences between this research and the other works. Even though the solution method is that of Lockett, the environment of the problem and the flexibility of the model are quite different. The proposed model includes a large number of managerial factors for decision making and can handle many critical resources. Therefore, the proposed model is more practical and realistic than the other models. This model is formulated for a GT environment, but can be easily revised for other environments.

Existing software, MPSX, can be used to solve this model. The above example of the small size problem included 77 variables and 34 constraints. The total number of the variables and the constraints in the proposed model is not small, but the program logic of MPSX provides for a maximum of 16,383 rows (and virtually an unlimited number of columns) on a 1024 K system (22). Therefore, the capacity of MPSX releases the restriction of the problem size under the real environment.

A small problem was given and encoded manually for the example. Yet the encoding task for the input of MPSX for a larger problem would be a tremendous task, and the interpretation of the output of MPSX would require much time if the number of constraints and variables is large. Therefore, a matrix generator and report writing program are desirable to implement this model for a real situation. Critical resources are included in the model instead of all resources. It is shown that MPSX can be used to solve the proposed problem. The model does not allow the backlogging case, but backlogging is possible, if the balance equation of the constraints is changed.

How is it possible to get the input data for the matrix generator or MPSX? The prerequisite of implementation of this model is the existence of the standard performance data such as load profiles and cost parameters. The decision

variables can be determined by a decision maker, but the standard performance data which can be derived from the accumulated historical data are not easy to determine. These standard data should be accumulated systematically or given by another related system.

The relative importances of the conflicting goals are not easy to determine. The most suitable decision maker to determine the weighting factor is the manager who can control and compromise the conflicting objectives in each function. There are many ways to determine these weighting factors. For example, when they are trying to determine the weighting factors for overload and over-expenditure, and if the cost of overload is expensive, then they may give higher weighting for overload. The amount of the weighting factor depends on the overload cost and the expenditure caused by loaning. If this model is incorporated with qualitative managerial factors, this model is a very dynamic approach to the production planning problem where there are conflicting objectives.

Master Production Schedule

Test problem generation

A number of test problems are generated to test the proposed methods. The test problem parameters include the pattern of demand, the pattern of capacities and the setup

and holding costs. The method to determine these parameters is extended from the literature of Kenneth R. Baker et al.

(1). Load profile, overload cost and shortage penalty cost are also determined.

The sales requirement in period t is given by

$$d_t = \mu + \sigma \cdot z_t + a \cdot \sin\left[\frac{2\pi}{b}(t+b/4)\right] \dots\dots\dots(5.1)$$

where μ = weekly mean demand

σ = standard error

a = amplitude of the seasonality component

b = length of seasonal cycle, in periods, and

z_t = independent, identically distributed

standard normal random deviates.

There are four parameters in the above equation. The mean demand has the value of 200, 300, and 400; standard error is 67 or 237 and the amplitude of seasonality is 0 or 125. Twelve items are defined based on the above three parameters (Table 11). The cycle length (b) is equal to the planning horizon if the planning horizon is 6, otherwise the cycle length (b) equals 12. If the demand generated was negative, it was set to zero. In the small size problem, the two cases for average demands are considered (Table 12). Two cases are also considered for the amplitude of seasonality and the standard error (Table 13.)

TABLE 11. A pool of
all test
items

ITEM NO	μ	a	σ
1	200	0	67
2	200	0	237
3	200	125	67
4	200	125	237
5	300	0	67
6	300	0	237
7	300	125	67
8	300	125	237
9	400	0	67
10	400	0	237
11	400	125	67
12	400	125	237

TABLE 12. Two cases of average demand for small size problem

Case	Item	Demand
1	1	200
	2	300
2	1	300
	2	400

TABLE 13. Two cases of demand pattern for small size problem

Case	Item	Amplitude	Standard Error
1	1	0	237
	2	0	67
2	1	125	237
	2	125	67

TABLE 14. Summary of test data

Problem Size(N)	Small	Medium	Large
Group of Items	2,5 4,7 6,9 8,11	1,2,3,4,5,6 4,5,6,7,8,9 7,8,9,10,11,12	1,2,...,12
Scheduling Period(T)	6,12	18	24
Cost Structure	3 Cases	3 Cases	3 Cases
Capacity Limit	3 Cases	3 Cases	3 Cases
Problem Set	72	27	9
Replication	5	5	5
Total Number of Problem Set	360	135	45

In the medium size problem, 6 items are selected. The selection is made to represent the all possible combinations of all demand varieties. The large size problem includes all 12 items. Table 14 shows the summary of the test problem sets.

Five replications were made for each problem by changing the seed of random number generator for the demand pattern and the load profile. Only the case of constant capacity, which represents a stable status of a company, was studied. The required capacity is calculated from the load profile and the demand requirements. The capacity limit is represented in terms of the ratio of allowable capacity to required capacity. The ratio 1.1, 1.2, and 1.3, which are used as the capacity limit, corresponds to a capacity utilization of 90.9%, 83.3%, and 76.9% respectively. There are four cost parameters, that is, setup, holding, overload, and penalty cost. The last three costs are referenced from real data in industry (52, 53, 54)¹, and the setup cost is determined systematically. The holding, overload, and penalty cost are 1.38/item*period, 15/unit*period, and 695/item*period respectively. For testing purposes, it was assumed that the setup cost is independent of time period.

¹ The cost ratios are arbitrarily defined and set by the author following personal communication with a master scheduler in industry.

Instead of the ratio of the setup cost to the holding cost, both setup and holding costs are related with the optimal solution. EOQ time supply of each product has been used to represent the set of setup and holding costs (1). The selected EOQ time supply is one, three, and six periods. Three cases were considered for each problem size to represent the various cases of the problem. Table 15 shows the number of items in the problem size and the EOQ time supply. Setup costs are determined from the selected holding cost and the EOQ time supply (Table 16). Table 17 shows the ratio of the setup cost to the holding cost. The spectrum of the ratios covers the band of the ratios which are used in industry and that used by other author (8).

The load profile is determined from the uniform random number generator which gives an integer between 0 and 9. The selected sample problems will be diverse and a representative problem set to evaluate the proposed methods.

TABLE 15. Cost structure

EOQ Time Prob. Supply	Case			
	1	3	6	
Small Size	1	1	1	
	2		1	1
	3	1		1
Medium Size	1	3	2	1
	2	2	2	2
	3	1	2	3
Large Size	1	6	4	2
	2	4	4	4
	3	2	4	6

TABLE 16. Setup cost summary

EOQ Time Avr. Supply Demand	Small	Medium	Large
200	138	1242	4968
300	207	1863	7452
400	276	2484	9936

TABLE 17. S/H summary

EOQ Time Avr. Supply Demand	Small	Medium	Large
200	1.9	17.3	69.0
300	2.9	29.5	103.5
400	3.8	34.5	138.0

Evaluation measure

The ratio (R) of the total cost which is calculated from the proposed TMPS to the solution standard is used as an evaluation measure. The total cost includes setup, inventory, overload, and penalty cost. Solution standard is the near optimal cost which is derived from the small order statistics by using the method of Weissman (58). When there is a large sample, then small order statistics can be used to derive the left threshold of the population distribution. Suppose a distribution function (df) F has a finite left threshold μ . A confidence interval can be derived by using the order statistics $T_1 < T_2 < \dots < T_k$ from a sample whose df is F. The pivotal ratio

$$W_k = \log \frac{T_k - \mu}{T_1 - \mu} \bigg/ \sum_{i=1}^{k-1} \log \frac{T_k - \mu}{T_i - \mu} \quad (k \geq 3)$$

is the basis for the confidence interval for μ . Given a confidence level r and a lower error-probability

P_1 ($0 < r + P_1 < 1$), determine $W_1 = W_k(P_1)$ and $W_2 = W_k(r + P_1)$.

$W_k(p)$ is the quantiles of $W_k = Y_{k-1} / \sum_{i=1}^{k-1} Y_i$, where the Y_i are the order statistics from an exponential sample of size $k-1$. Put

$$G(\mu) = \sum_{i=2}^{k-1} \log \frac{T_k - \mu}{T_i - \mu}, \quad H(\mu) = \log \frac{T_k - \mu}{T_1 - \mu} \quad (\mu < T_1),$$

and $U_i = W_i / (1 - W_i)$ ($i=1,2$). Then the set $\{\mu: W_1 < W_k < W_2\} = \{\mu: U_1 G(\mu) < H(\mu) < U_2 G(\mu)\}$ is an asymptotically exact (as $n \rightarrow \infty$ and $k/n \rightarrow 0$) confidence set for μ with confidence level r for df F which satisfies

$$\lim_{x \downarrow 0} \frac{F(\mu + CX)}{F(\mu + X)} = C^\alpha \quad (\alpha > 0)$$

for every $C > 0$. Unfortunately, this does not guarantee the solution, i.e., there may be null set for this equation. "Median-unbiased" estimator of μ (i.e., estimators which are too large with 50% probability and too small with 50% probability) when r is .50 is used as a solution standard. The df F near the left threshold is assumed to satisfy the regularity condition. Three hundred random total costs of TMPS is generated from a good W-W type schedule which is derived from Method A or Method B and the smallest 10 total costs among 300 are used as the small order statistics.

A quick estimate of α , suggested by Weiss, was used (58).

$$\hat{\alpha} = \log \frac{k-1}{m-1} \bigg/ \log \frac{T_k - T_1}{T_m - T_1}$$

where $k=10$, $m=4$. As the value of α increases beyond 1, it is known that the approach of Weissman becomes less reliable. When the value of α is larger than 1.1, the

smallest value among all samples is used as the evaluation criteria.

Discussion of the experimental tests

Experimental procedure is shown in Figure 8. Method A and Method B are applied to each test problem and develop TMPS A and TMPS B respectively. Method C uses a good W-W type TMPS which is better between TMPS A and TMPS B and generates TMPS C. Each TMPS is associated with a cost which will be compared with a near optimal cost.

The evaluation measure, when the total number of end item is 2 and the amplitude of seasonality is 0 or 125, is shown in Table 18. The measures in the Tables represent the values of R multiplied by 100. Method B is superior to Method A when there is seasonality in demand. The evaluation measures for all types of the test problem sets are given in Figure 19. The results show that Method B is better than Method A for the small size problem set, but Method A is better than Method B for the medium and large size problem sets. The average cost ratios are 1.25, 1.65, and 1.05 for Method A, Method B, and Method C, respectively. As the number of items is increased, Method B becomes less reliable. The defect of Method B is that scheduling is performed item-by-item. Therefore, all items can not be considered simultaneously in each scheduling period. An MPS which is derived from Method B depends on the priority of

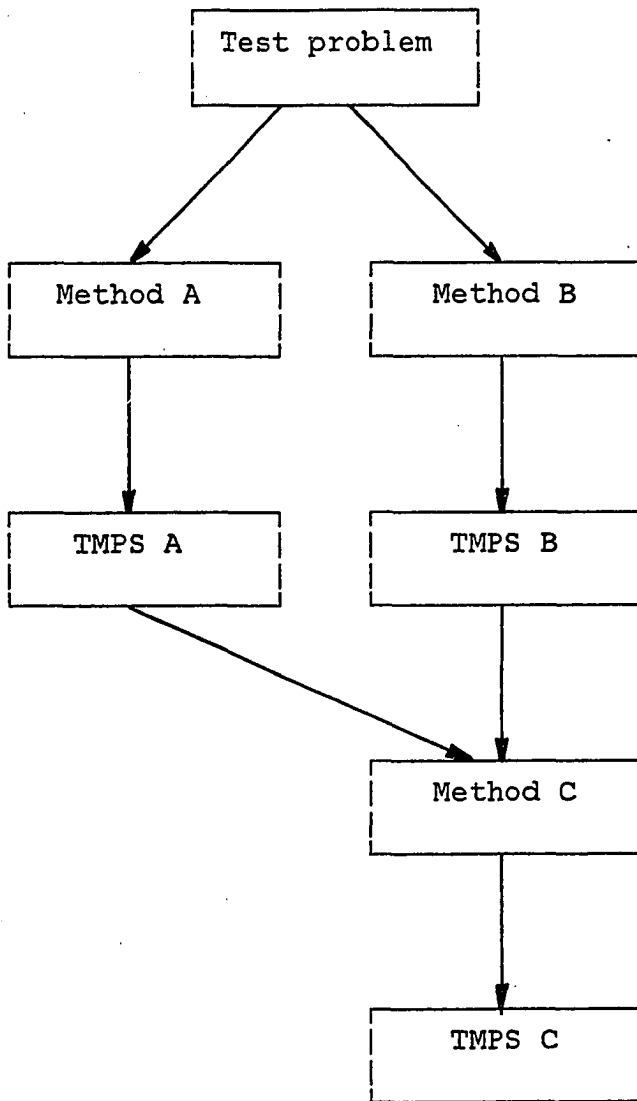


FIGURE 8. Experimental procedure

TABLE 18. R for constant and seasonal demand patterns

N	T	Method	Capacity Ratio							
			1.1		1.2		1.3		Average	
		a	0	125	0	125	0	125	0	125
2	6	A	121	184	129	142	145	116	132	147
		B	127	133	146	118	126	110	134	120
		C	108	108	105	107	108	106	107	107
2	12	A	155	157	118	205	112	154	128	172
		B	171	164	147	141	139	119	153	142
		C	114	120	103	124	103	102	107	115
Average		A	138	170	123	173	128	135	130	159
		B	149	148	146	129	132	114	143	131
		C	109	106	103	109	104	104	106	106

end items. Therefore, Method B becomes less reliable as the total number of end items increases. As the capacity ratio decreases, i.e., the utilization of capacity increases, all methods become less effective. It is interesting that these phenomena are similar to that of other heuristics under different environments (49).

TABLE 19. Summary of evaluation measures

Number of Items	Scheduling Period	Scheduling Method	Capacity Ratio			
			1.1	1.2	1.3	Avr.
2	6	A	152	135	130	139
		B	130	132	118	126
		C	108	106	107	107
2	12	A	156	161	133	150
		B	167	144	129	146
		C	117	113	102	111
6	18	A	110	113	107	110
		B	180	162	146	163
		C	106	102	101	103
12	24	A	104	104	101	103
		B	253	226	201	227
		C	103	103	100	102
Average		A	130	128	117	125
		B	182	166	148	165
		C	108	106	102	105

TABLE 20. Distribution of evaluation measures

N	T	R	1.0	1.1	1.2	1.3	1.4	1.5	1.6	1.7	1.8	1.9	2.0	<	Total
2	6	A	72	28	16	7	6	6	5	5	2	3	4	26	180
		B	74	34	15	11	11	6	6	3	5	3	1	11	180
		C	140	19	11	3	1								
2	12	A	38	46	19	7	9	7	6	10	7	3	2	26	180
		B	26	28	29	20	17	12	5	9	9	3	4	18	180
		C	71	65	20	6	7	3							
6	18	A	42	53	20	7	4	5		1	1	1		1	135
		B	11	19	16	19	14	8	11	4	2	4	1	26	135
		C	63	58	12	2									
12	24	A	20	22	3										45
		B				1	6	1	6	3	5		2	21	45
		C	25	18	2										

The distributions of R for each category are given in Table 20. When the number of items is 2 and scheduling period is 6, frequencies between 1.1 and 1.2 are 16 for Method A. Table 21 classified evaluation measures by cost structure. It is difficult to conclude in the lump which cost structure

TABLE 21. Evaluation measures by cost structure

Number of Items	Scheduling Period	Scheduling Method	Cost Structure		
			Case		
			1	2	3
2	6	A	155	138	125
		B	116	147	116
		C	100	121	100
2	12	A	183	129	138
		B	190	123	128
		C	118	107	107
6	18	A	117	110	103
		B	165	132	192
		C	103	104	102
12	24	A	105	101	102
		B	235	216	230
		C	104	101	101

TABLE 22. Characteristics of solution standard (Frequency)

Number of Items	Scheduling Period	Improved			Unimproved			Total
		X	$\alpha > 1.1$	$\alpha \leq 1.1$	X	$\alpha > 1.1$	$\alpha \leq 1.1$	
2	6	0	12	44	49	75	0	180
2	12	13	58	78	10	18	3	180
6	18	4	46	71	6	5	3	135
12	24	0	22	23	0	0	0	45
Total		17	138	216	65	98	6	540

gives a good or bad solution. When the total number of items is 12 and scheduling period is 24, it can be said that, if the portion of small EOQ time supplies is large, then the result is poor. Table 22 and Table 23 show the frequencies of the lower bound and the ratios of each case. "Improved" implies that the lower bound is improved from a good W-W type MPS. "Unimproved" implies that the lower bound is the smaller value between the total costs of Method A and that of Method B. To find the lower bound, 40% of all problems used Weissman's approach and 28.8% of all problems used the smallest value among all samples. Among the test

TABLE 23. Characteristics of solution standard (Ratio)

Number of Items	Scheduling Period	Improved			Unimproved			Total
		X	$\alpha > 1.1$	$\alpha \leq 1.1$	X	$\alpha > 1.1$	$\alpha \leq 1.1$	
2	6	0	6.7	24.4	27.2	41.7	0	100
2	12	7.2	32.2	43.4	5.6	10.0	1.7	100
6	18	3.0	34.0	52.6	4.4	3.7	2.2	100
12	24	0	48.9	51.1	0	0	0	100
Total		3.2	25.6	40.0	12.0	18.1	1.1	100

problems, 31.2% have not improved the lower bound from a good W-W type TMPS. This portion may be caused by poor estimation procedure of the lower bound or good heuristics of master production scheduling. X implies that α can not be calculated because of insufficient number of sample data. When the lower bound is not improved and α is less than 1.1, this implies that there is a null set of solutions in the interval estimation of Weissman. These figures show that the frequencies of application of Weissman's approach for large size problem is more than that for the small and medium size problems.

TABLE 24. A Wilcoxon's signed-rank test for cost factors

Number of Items	Scheduling Period	Setup Cost	Holding Cost	Overload Cost
		A : B	A : B	A : B
2	6	<	>	>
2	12	<	>	=
6	18	<	>	=
12	24	<	>	<
Total		<	>	=

Setup cost, holding cost, and overload cost are observed separately. Method A and Method B give a paired data of setup, holding, and overload cost for each test problem. The Wilcoxon's signed-rank test is performed for the paired data of three costs to test the different effect of Method A and Method B. The null hypothesis H_0 is $M_a = M_b$ and the alternate hypothesis H_a is $M_a \neq M_b$ where M_a is the median of the cost distribution from Method A and M_b is the median of the cost distribution from Method B. Equality in Figure 24 shows that the null hypothesis H is accepted and

inequality means that the alternate hypothesis H_1 is accepted at 0.05 level of significance respectively. Average setup cost from Method A is less than that from Method B and holding cost from Method A is larger than that of Method B in any case. When the total number of items is 2 and the scheduling period is 6, the average overload cost from Method A is larger than that from Method B, but when the problem size is the largest, the results are reversed. The other problem sets show that there is no significant difference between the overload cost from Method A and that from Method B. In the overall sense, there is strong evidence that the setup cost from Method A is less than that from Method B and holding cost from Method A is larger than that from Method B. There is no significant difference between Method A and Method B for overload cost.

CHAPTER 6. SUMMARY AND CONCLUSION

There are several evidences that the importance of master production scheduling is increasing and GT is the future oriented manufacturing concept. A master production scheduling system is discussed under a GT cell where MRP can be used as a production planning and inventory control system. An aggregate production planning problem where there are multiple conflicting objectives is considered, and a practical model is proposed. Traditional lot sizing problems do not consider the capacity limit or can not violate capacity limit. Three heuristics for master production scheduling are discussed when the capacity limit can be violated, i.e., overloading and subcontracting are allowed.

In Chapter 2, it was shown that goal programming can be used to coordinate the conflicting objectives in the aggregate production planning problem under a GT cell. The master production scheduling problem is important, but little attention is given to this area for following reasons.

1. Master production scheduling problems are diverse in industry.
2. Master production scheduling system is complex because of interrelation with other systems.
3. It is difficult to verify the proposed heuristics

for combinatorial optimization problems.

In Chapter 3, the aggregate production problem is characterized by the goal programming model. The master production scheduling problem is formulated, but linear programming or mixed integer programming are both inefficient methods when there are many end items and the scheduling period is long. This will justify the necessity of heuristics for master production scheduling.

In Chapter 4, the goal programming model for the APP problem is converted into a linear programming model and three heuristics for master production scheduling are discussed. Method A and Method B consider only a W-W type schedule, i.e., demand requirement can not be split for the production requirement. Method C allows splitting the demand requirement in the production scheduling requirement. Method A is the traditional period-by-period method and Eisenhut's marginal cost reduction is used as a priority for scheduling. Method B uses the shortest path algorithm and tries to find a TMPS item-by-item. Method C uses a good W-W type schedule which may be derived from Method A or Method B and searches a TMPS by shifting the production quantity leftwards or rightwards. The search pattern is similar to a tree search scheme.

In Chapter 5, an APP problem where the total number of end items is 2 and the planning horizon is 6 is selected as

an illustrative example. All input data are encoded manually and the output of MPSX is discussed. Diverse sets of the test problems are generated to verify the three proposed heuristics for master production scheduling. There are several system parameters of the test problem sets: the demand pattern, the type of load profile, the capacity limit, and cost parameters. These parameters are determined systematically or referenced from the data of the industry. Five hundred and forty test problems are generated and Method A, Method B, and Method C are applied to each problem respectively. The evaluation measure is the ratio of the total cost from the proposed method to the near optimal total cost which is derived from small order statistics. The left threshold parameter of the distribution of the population is determined by the method of Weissman. When the Weissman's method can not be applied, the smallest value among 300 random costs from sampled TMPSSs is used as the near optimal cost.

In Chapter 6, it is shown that Method B dominates Method A where the problem size is small and the pattern of demand requirement is seasonal. Method A is better than Method B for the other cases. Method C can be only applied for a hypothetical situation, i.e., there is no restriction in splitting of the demand requirement for the production quantity. There should be many variations for Method C but

a typical splitting scheme is shown in this research. All heuristics become less reliable as the capacity utilization is increasing. The average cost ratios of Method A, Method B, and Method C are 1.25, 1.65, and 1.05 respectively. A Wilcoxon's signed-rank test is performed to check the effect of Method A and Method B for setup, holding, and overload cost respectively.

The following areas are categorized as areas for further research:

1. It is not surprising that Method B becomes less reliable as the total number of items increases. The defect of Method B is that scheduling is performed item-by-item, therefore, all end items can not be observed simultaneously in every scheduling period. Therefore, TMPS from Method B depends on the priority of end items and investigation of the effect of the priority of end items will compensate for the defects of Method B. This research determines the priority among end items randomly. The priority can be determined based on average load of each end item or lead time, etc.
2. The quality of the solution depends on the quality of the lower bound, therefore, the solution standard is important in the evaluation

process for a proposed heuristic. An optimal solution is characterized by solution space which depends on the restriction of production size in the real situation. This research assumes that there should be corresponding MPS for the near optimal total cost which is derived from the approach of Weissman. The analytical approach for the optimal solution is ineffective when the problem size is large, but it may be effective when the problem size is small. When the lower bound is determined based on small order statistics, the quality of the lower bound depends on the quality of sampling and estimation procedure. Test results show that sampling procedure and Weissman's approach are useful when the problem size is large, but poor when the problem size is small. The investigation of the procedure to develop the lower bound is valuable for the evaluation of heuristics for general combinatorial problems. Among the total test problems, 31.2% show no improvement of the total cost of the W-W type MPS in this research. This research does not verify whether the lack of improvement comes from the lower quality of the evaluation procedure or from the higher quality

of the proposed heuristics. There should be many variations in the splitting scheme of production requirement, but the research to derive W-W type optimal MPS is required for the case where the production requirement can not be split. The analytical approach to get the optimal schedule is possible for small problems, but the analytical approach is ineffective for medium and large size problem, therefore, this research only used small order statistics to estimate the lower bound to keep consistency for all size problem sets.

3. The ratio of the calculated total cost to the near optimal cost is used as an evaluation measure. A "50%-unbiased median" estimator is used as a lower bound. When the inference of the lower bound is interval estimation instead of point estimation, new evaluation measure should be defined, and the evaluation scheme should be different.
4. Even though the proposed heuristics allow for cases of multi-resource problems, test problems only handled the cases of single resource problems. Therefore, it would be interesting to test the proposed heuristics for the multi-

resource problems. The quality of the heuristics for the master production scheduling system depends on the input data structure of the system, therefore, it is necessary to test the proposed heuristics for other input data structures to verify the proposed heuristics for general cases.

5. There are several factors affecting the value of R. Factors include demand pattern and cost structures, capacity ratio, type of load profile, etc. The contribution of these factors to the value of R is not investigated, because it is not easy to quantify the several factors.

Finally, several conclusions reached are as follows;

1. The aggregate production planning problem where there are multiple objectives can be formulated as a goal programming model. The proposed aggregate production planning model can be used effectively with a matrix generating and report writing program for input and output of MPSX. If the model is incorporated with the qualitative managerial factors, the proposed model is dynamic in the sense that any critical factors varying with time can be included in the model.
2. Method B dominates the traditional period-by-

period Method A in the small size problem where there is seasonality. But, Method A is better than Method B in the other cases. Method C dominates both Method A and Method B in all cases, but there should be many variations and restrictions in Method C. The average cost ratios are 1.25, 1.65, and 1.05 for Method A, Method B, and Method C, respectively. There are defects in Method B which can be solved by considering the effect of priorities among end items. Method A allows delay penalty, but there are no cases of delay for the selected test data. Method A and Method B are used to find a global optima, but Method C is used to search local optima from a good W-W type schedule.

3. The aggregate production planning model and the heuristics for master production scheduling are proposed for a GT cell, but the APP model can be easily revised for other environments, and the heuristics for master production scheduling can be used if the production lead time is short under other environments.
4. The efficiency of the evaluation procedure depends on the quality of the sampling procedure and the estimation procedure. The solution

standard is determined from the Weissman's approach or the smallest sample value among all observations. The portion of Weissman's approach is 40.0% and that of the other case is 28.8%. Among the test problems, 31.2% show no improvement from a good W-W type TMPS.

The expected value and the contributions of this research are as follows;

1. Many decision factors and critical resources can be included in the APP model for a GT cell.
2. A better methodology is presented to develop a TMPS than the traditional "trial and error" method; therefore, reduces the turn around time for a master production scheduler to find the best TMPS.
3. The possibility of eliminating the traditional RCCP evaluation method is raised because the available capacity can be negotiable during the process of master production scheduling.
4. The frequency of running the MRP explosion logic is decreased by providing a practical MPS. Therefore, MRP can be well incorporated in the production planning and inventory control system.
5. A communication tool for finalizing MPS is proposed and the effectiveness of the total

production system is increased by improving the procedure to develop a MPS which is the trigger for the planning of the production support function.

6. An optimization procedure for combinatorial problems is shown and an evaluation procedure for heuristics of combinatorial problems is proposed.

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ACKNOWLEDGEMENTS

I would like to express my gratitude to those people who were instrumental in the completion of this dissertation.

I wish to thank the members of my dissertation committee, professors Eric M. Malstrom, John C. Even, and Vincent A. Sposito for their thoughtful criticisms and suggestions. I am indebted to professor Herbert T. David for his valuable discussions in the estimation of unknown shape parameters. I am extremely thankful to professor Keith L. McRoberts, my committee chairman, for his guidance and assistance in the research and his support throughout my graduate study.

I am also indebted to many others who have helped in this study. The brief discussions with professor William Q. Meeker and Dorea C. Y. Chang were valuable in accomplishing this dissertation. Several letters answering my questions from Michael S. Spencer, William L. Berry, and Colin New were also helpful for this research.

I am grateful to my parents and parents-in-law who have faith in me. Finally, I am grateful for the patience and continuous support of my wife, and to two beautiful daughters who understood my absence when they wanted my attention.

APPENDIX A: AGGREGATE PRODUCTION PLANNING SUBSYSTEM

Program List

```
PROGRAM  
INITIALZ  
MOVE(XDATA, 'APP2')  
MOVE(XPBNAME, 'GTMRP')  
CONVERT  
BCDOUT  
SETUP  
MOVE(XOBJ, 'COST')  
MOVE(XRHS, 'ZZ2')  
PRIMAL  
SOLUTION  
EXIT  
PEND
```

Input of MPSX

NAME
ROWS

N COST
L R1
L R2
L R3
L R4
L R5
L R6
E R7
E R8
L R9
L R10
L R11
L R12
L R13
L R14
L R15
L R16
L R17
L R18
L R19
L R20
L R21
E R22
E R23
E R24
E R25
E R26
E R27
E R28
E R29
E R30
E R31
E R32
E R33

COLUMNS

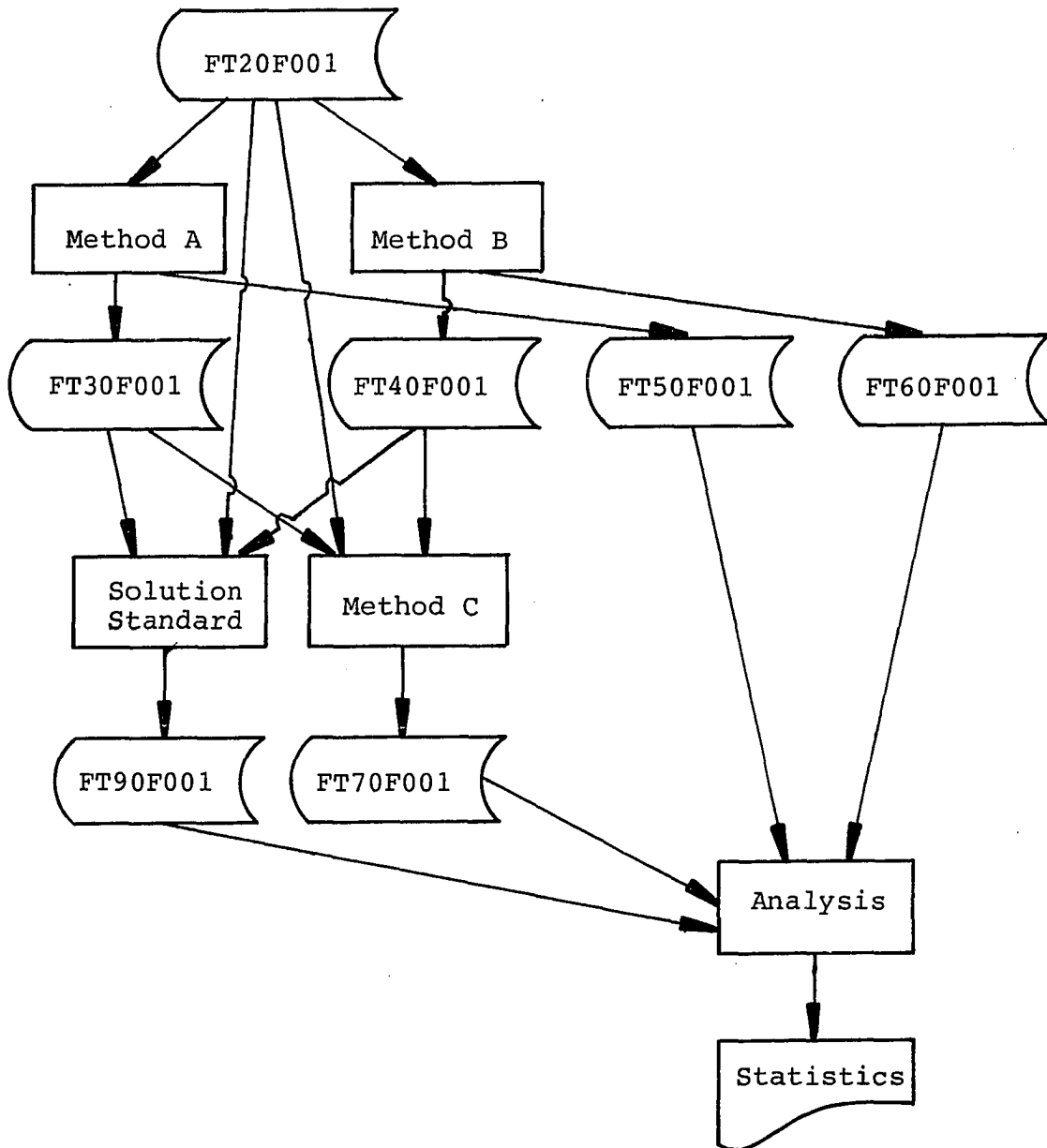
DP1	COST	.40000	R1	-	1.00000
DP2	COST	.40000	R2	-	1.00000
DP3	COST	.40000	R3	-	1.00000
DP4	COST	.40000	R4	-	1.00000
DP5	COST	.40000	R5	-	1.00000
DP6	COST	.40000	R6	-	1.00000
DP11	COST	.90000	R9	-	1.00000
DP12	COST	.90000	R10	-	1.00000
DP13	COST	.90000	R11	-	1.00000
DP14	COST	.90000	R12	-	1.00000

DP15	COST		.90000	R13	-	1.00000
DP16	COST		.90000	R14	-	1.00000
DP	COST		.90000	R15	-	1.00000
DP1N1	COST		.60000	R16	-	1.00000
DP1N2	COST		.60000	R17	-	1.00000
DP1N3	COST		.60000	R18	-	1.00000
DP1N4	COST		.60000	R19	-	1.00000
DP1N5	COST		.60000	R20	-	1.00000
DP1N6	COST		.60000	R21	-	1.00000
I11	COST	-	3.80000	R1		1.00000
I11	R15		5.00000	R22	-	1.00000
I11	R23		1.00000			
I12	COST	-	3.80000	R2		1.00000
I12	R15		5.00000	R23	-	1.00000
I12	R24		1.00000			
I13	COST	-	3.80000	R3		1.00000
I13	R15		5.00000	R24	-	1.00000
I13	R25		1.00000			
I14	COST	-	3.80000	R4		1.00000
I14	R15		5.00000	R25	-	1.00000
I14	R26		1.00000			
I15	COST	-	3.80000	R5		1.00000
I15	R15		5.00000	R26	-	1.00000
I15	R27		1.00000			
I16	COST	-	3.80000	R6		1.00000
I16	R15		5.00000	R27	-	1.00000
I21	COST	-	7.30000	R1		1.00000
I21	R15		10.00000	R28	-	1.00000
I21	R29		1.00000			
I22	COST	-	7.30000	R2		1.00000
I22	R15		10.00000	R29	-	1.00000
I22	R30		1.00000			
I23	COST	-	7.30000	R3		1.00000
I23	R15		10.00000	R30	-	1.00000
I23	R31		1.00000			
I24	COST	-	7.30000	R4		1.00000
I24	R15		10.00000	R31	-	1.00000
I24	R32		1.00000			
I25	COST	-	7.30000	R5		1.00000
I25	R15		10.00000	R32	-	1.00000
I25	R33		1.00000			
I26	COST	-	7.30000	R6		1.00000
I26	R15		10.00000	R33	-	1.00000
X11	COST	-	5.10000	R1		2.00000
X11	R7		1.00000	R9		5.00000
X11	R16		5.00000	R22		1.00000
X12	COST	-	5.10000	R2		2.00000
X12	R7		1.00000	R10		5.00000
X12	R17		5.00000	R23		1.00000
X13	COST	-	5.10000	R3		2.00000

X13	R7	1.00000	R11	5.00000
X13	R18	5.00000	R24	1.00000
X14	COST	- 5.10000	R4	2.00000
X14	R7	1.00000	R12	5.00000
X14	R19	5.00000	R25	1.00000
X15	COST	- 5.10000	R5	2.00000
X15	R7	1.00000	R13	5.00000
X15	R20	5.00000	R26	1.00000
X16	COST	- 5.10000	R6	2.00000
X16	R7	1.00000	R14	5.00000
X16	R21	5.00000	R27	1.00000
X21	COST	- 10.20000	R1	4.00000
X21	R8	1.00000	R9	10.00000
X21	R16	10.00000	R28	1.00000
X22	COST	- 10.20000	R2	4.00000
X22	R8	1.00000	R10	10.00000
X22	R17	10.00000	R29	1.00000
X23	COST	- 10.20000	R3	4.00000
X23	R8	1.00000	R11	10.00000
X23	R18	10.00000	R30	1.00000
X24	COST	- 10.20000	R4	4.00000
X24	R8	1.00000	R12	10.00000
X24	R19	10.00000	R31	1.00000
X25	COST	- 10.20000	R5	4.00000
X25	R8	1.00000	R13	10.00000
X25	R20	10.00000	R32	1.00000
X26	COST	- 10.20000	R6	4.00000
X26	R8	1.00000	R14	10.00000
X26	R21	10.00000	R33	1.00000
RHS				
ZZ2	R1	2700.00000	R2	2700.00000
ZZ2	R3	2700.00000	R4	2700.00000
ZZ2	R5	2700.00000	R6	2700.00000
ZZ2	R7	1890.00000	R8	2457.00000
ZZ2	R9	5670.00000	R10	5670.00000
ZZ2	R11	5670.00000	R12	5670.00000
ZZ2	R13	5670.00000	R14	5670.00000
ZZ2	R15	16500.00000	R16	5670.00000
ZZ2	R17	5670.00000	R18	5670.00000
ZZ2	R19	5670.00000	R20	5670.00000
ZZ2	R21	5670.00000	R22	111.00000
ZZ2	R23	302.00000	R24	226.00000
ZZ2	R25	393.00000	R26	413.00000
ZZ2	R27	445.00000	R28	274.00000
ZZ2	R29	410.00000	R30	405.00000
ZZ2	R31	384.00000	R32	452.00000
ZZ2	R33	532.00000		
ENDATA				

APPENDIX B: MASTER PRODUCTION SCHEDULING SUBSYSTEM

System Flow of Experimental Test



Program list

Method A

```

$JOB          'KIM',TIME=(2,03),PAGES=200
C
C234567890
C
C * I/O FILE SUMMARY *****
C
C          DD NAME          DSN
C
C 1. INPUT  FT20FO01        K.I6467.DATA
C
C 2. OUTPUT FT30FO01        K.I6467.RESA
C
C          FT50FO01        K.I6467.MINA
C
C ***** FILE DESCRIPTION *****
C
C 1. K.I6467.DATA
C
C     1) INO: TOTAL NUMBER OF END-ITEM
C
C        TNO: TOTAL NUMBER OF PERIOD
C
C        DSEED: SEED FOR LOAD PROFILE
C
C        OCOST: OVERLOAD COST PER UNIT RESOURCE
C
C     2) IX: SEED FOR DEMAND REQUIREMENT
C
C     3) MEAN: AVERAGE DEMAND
C
C        MVAR: STANDARD ERROR
C
C        MAMP: SEASONAL AMPLITUDE
C
C     4) RATIO: CAPACITY RATIO (START)
C
C        NCT:  NUMBER OF CASES OF CAPACITY RATIO
C              (INCREMENT IS 0.1)
C
C     5) P(I), S(I), H(I)
C
C 2. K.I6467.RESA
C
C     1) SUMTC: TOTAL COST FROM METHOD A
C

```

```

C      2) WDT(I,T):
C
C      3) SKD(I,T):
C
C      4) AVARES(J,T):
C
C 3. K.I6467.MINA
C
C      1) SUMTC: SUMS+SUMH+SUMP+SUMOC
C
C          SUMS: TOTAL SETUP COST
C
C          SUMH: TOTAL HOLDING COST
C
C          SUMP: TOTAL PENALTY COST
C
C          SUMOC: TOTAL OVERLOAD COST
C
C ***** ARRAY DESCRIPTION *****
C
C      ITEM(T): PRODUCTION REQUIREMENT AT TIME T, T=1, 2,..., TNO
C
C      DT(I,T): WDT(I,T): PRODUCTION REQUIREMENT OF END ITEM I
C                AT TIME T
C                I=1, 2,..., INO    T=1, 2,..., TNO
C
C      RESLIM(J,T): CAPACITY LIMIT, J=1    T=1, 2,..., TNO
C
C      LP(I,1,K): LOAD PROFILE, I=1,2,...,INO  J=1  K=1,2,3
C
C      P(I): PENALTY COST PER UNIT OF THE ITEM I
C            PER PERIOD CARRIED.
C
C      S(I): SET UP COST OF THE ITEM I
C
C      H(I): CARRYING COST PER UNIT OF THE ITEM I
C            PER PERIOD CARRIED.
C
C      WAIT(I,T): WAITING AREA FOR SCHEDULING,
C                I=1, 2,..., INO;  T=1, 2,..., TNO
C
C      RQRES(J,T): REQUIRED RESOURCE, J=1    T=1,2,3
C
C      AVARES(J,T): AVAILABLE RESOURCE, J=1  T=1,2,...,26
C
C      WORK(I,1): WAITING COST
C
C      WORK(I,2): WAITING AMOUNT
C
C      WORK(I,3): MAX WAITING PERIOD FROM CURRENT PERIOD.
C

```

```

C   SWDT(I,2): SORTED ARRAY OF WAITING COST.
C
C           SWDT(I,1): WAITING COST/COST INDEX
C
C           SWDT(I,2): CORRESPONDING ITEM NUMBER.
C
C   SKD(I,T): SCHEDULE OF END ITEM I AT PERIOD T,
C             I=1,2,...,INO   T=1,2,...,TNO
C
CCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCC
C
C   VARIABLE DECLARATION
C
C           INTEGER SW,CT,T,TNO,TO,TT,T1,T2(12),T3,TA,CTMT2,SI,SIM1
C           INTEGER WORK,TEMP1,CHECK,TNO2
C           REAL GGNQF,Y,LP
C           REAL ITEM(24),OCOST,MTAVA,MTLI,MAB
C           REAL RQRES(1,3),TEMP(12,1,3),E(12,26)
C           DOUBLEPRECISION DSEED,NDSEED
C           COMMON /ONE/ P(12),S(12)
C           COMMON /TWO/ DT(12,24),H(12),U(12,24),SWDT(12,3)
C           COMMON /THREE/ LP(12,1,3),SKD(12,24),AVARES(1,26)
C           COMMON/FOUR/WORK(12,3),WAIT(12,24)
C           COMMON/FIVE/CHECK(12)
C           COMMON/SIX/WDT(12,24),DSEED,NDSEED,SUMD
C           COMMON/SEVEN/OCOST
C   DO 12345 IJKL=1,5
C   C   INITIALIZATION
C           CALL CLOCK(IC)
C           J=1
C           JNO=1
C           KNO=3
C           READ(20,10) INO,TNO,DSEED,OCOST
10  FORMAT(2I2,F20.7,F7.2)
C           IF (TNO.GE.12) THEN
C               NTNO=12
C           ELSE
C               NTNO=TNO
C           ENDIF
C           TNO2=TNO+2
C           NDSEED=DSEED
C           WRITE(6,30) INO,TNO,DSEED,OCOST
30  FORMAT(' INO,TNO,DSEED,OCOST',2I3,F20.7,F7.2)
C   C   GENERATE LOAD PROFILE
C           READ(20,50) IX
50  FORMAT(I12)
C           WRITE(6,70) IX
70  FORMAT(' OLD SEED FOR LP',I13)
C           DO 90 III=1,INO
C               CALL RANDU(IX,IY,R)

```

```

IX=IY
R=R*1000
IR=INT(R)
WRITE(6,110) IR
110 FORMAT(2X,'RANDOM NUMBER',I6)
DO 90 IB=1,3
RA=IR/((10)**(3-IB))
LP(III,1,IB)=INT(RA)
IR=IR-INT(RA)*((10)**(3-IB))
90 CONTINUE
WRITE(6,130) IX
130 FORMAT(' NEW SEED FOR LOAD PROFILE',I18)
STRES=0
C
C GENERATE DEMAND REQUIREMENTS
C
DO 150 I=1,INO
STLP=0
DO 170 IT=1,3
170 STLP=STLP+LP(I,1,IT)
READ(20,190) MEAN,MVAR,MAMP
190 FORMAT(3I3)
CALL DEMAND(I,MEAN,MVAR,MAMP,NTNO,DT,TNO)
STRES=STRES+STLP*SUMD
WRITE(6,210) MEAN,MVAR,MAMP
210 FORMAT(' MEAN,MVAR,MAMP',3I5)
WRITE(6,230) (DT(I,T),T=1,TNO)
230 FORMAT(2X,12F10.2/)
150 CONTINUE
DO 250 I=1,INO
SLP=-9E10
DO 270 K=1,KNO
IF (LP(I,1,K).GT.SLP) THEN
SLP=LP(I,1,K)
ISLP=K
ENDIF
270 CONTINUE
T2(I)=ISLP-1
250 CONTINUE
UNIRES=STRES/TNO
READ(20,290) RATIO,NCT
290 FORMAT(F7.2,I2)
SRATIO=RATIO
C
C SIMULATE FOR DIFFERENT COST STRUCTURES
C
DO 10000 IIII=1,3
RATIO=SRATIO
DO 310 I=1,INO
READ(20,330) P(I),S(I),H(I)

```

```

330 FORMAT(3F7.2)
      WRITE(6,350) I,P(I),S(I),H(I)
350  FORMAT(' I,P(I),S(I),H(I)',I3,3F7.2)
310  CONTINUE
C
C   SIMULATE FOR DIFFERENT CAPACITY LIMITS
C
      DO 9999 IJK=1,NCT
      J=1
        CALL CLOCK(IH)
        WRITE(6,370) RATIO,IJK
370  FORMAT('1RATIO,NCT',F7.2,I2)
        DO 390 I=1,INO
        DO 390 T=1,TNO
390  DT(I,T)=WDT(I,T)
        TAVA=0
        SWAIT=0
        PHI=3.14159
        DO 410 I=1,INO
        DO 410 T=1,TNO
        WAIT(I,T)=0
410  SKD(I,T)=0
        DO 430 K=1,3
430  RQRES(1,K)=0
        DO 450 I=1,INO
        DO 450 IJ=1,3
450  WORK(I,IJ)=0
        RC=UNIRES*RATIO
        WRITE(6,470) RC,UNIRES
470  FORMAT(' RC,UNIRES',2F16.2)
C   DETERMINE CAPACITY LIMIT
      DO 490 I=1,TNO2
      AVARES(1,I)=RC
490  CONTINUE
      RATIO=RATIO+0.1
C *****
      DO 1000 T=1,TNO
      DO 510 I=1,INO
      IF (DT(I,T).EQ.0) THEN
        CHECK(I)=0
      ELSE
        CHECK(I)=1
      ENDIF
510  CONTINUE
C   WRITE(6,20) ((DT(I,N),N=1,TNO),I=1,INO)
C   WRITE(6,20) ((SKD(I,N),N=1,TNO),I=1,INO)
C   WRITE(6,20) ((WAIT(I,N),N=1,TNO),I=1,INO)
      CT=T
      CT2=CT+2
      SW=0

```

```

C SORT WORK(I,1) IN SWDT(I,2)
C PRIORITY OF SCHEDULING IS DETERMINED
  IF (SWAIT.EQ.1) THEN
    DO 550 I=1,INO
      SWDT(I,1)=WORK(I,1)
      SWDT(I,2)=I
550    CONTINUE
C
      CALL SRT(SWDT,INO,1)
    ENDIF
C
    IF (SWAIT.EQ.1) THEN
      DO 570 II=1,INO
        I=SWDT(II,2)
        IF (WORK(I,1).EQ.0) GO TO 570
        DO 590 K=1,KNO
          RQRES(J,K)=LP(I,1,K)*WORK(I,2)
          T1=T+K-1
          TEMP1=AVARES(J,T1)-RQRES(J,K)
          IF (TEMP1.LT.0) THEN
            SW=1
            SI=II
            GO TO 600
          ENDIF
590        CONTINUE
          DO 610 K=1,KNO
            T1=T+K-1
            AVARES(J,T1)=AVARES(J,T1)-RQRES(J,K)
610        CONTINUE
C THE REQUIREMENTS IN WAITING AREA IS SCHEDULED
        SKD(I,T)=SKD(I,T)+WORK(I,2)
        CALL CLEARW(I,CT)
        WRITE(6,901)
570      CONTINUE
        SWAIT=0
      ENDIF
630    CONTINUE
      DO 650 II=1,INO
        IF (DT(II,T).NE.0) THEN
          GO TO 670
        ENDIF
650    CONTINUE
      GO TO 1000
670    CONTINUE
      DO 690 I=1,INO
        IF ((DT(I,CT).EQ.0)) THEN
          SWDT(I,1)=9E10
        ELSE
          SWDT(I,1)=S(I)/DT(I,CT)
        ENDIF

```

```

        SWDT(I,2)=I
690 CONTINUE
C
    CALL SRT(SWDT,INO,1)
    DO 710 II=1,INO
        I=SWDT(II,2)
        IF (CHECK(I).EQ.0) GO TO 710
            DO 730 K=1,KNO
                RQRES(J,K)=LP(I,1,K)*DT(I,T)
                T1=T+K-1
                TEMP1=AVARES(J,T1)-RQRES(J,K)
                IF (TEMP1.LT.0) THEN
                    SW=2
                    SI=II
                    GO TO 600
                ENDIF
            CONTINUE
730    DO 770 K=1,KNO
                T1=T+K-1
                AVARES(J,T1)=AVARES(J,T1)-RQRES(J,K)
770 CONTINUE
        SKD(I,T)=SKD(I,T)+DT(I,T)
        WRITE(6,902)
        DT(I,T)=0
710 CONTINUE
C SW=1,2 IMPLIES SKD IS NOT POSSIBLE WITHOUT OVERLOADING
    IF (CT.LT.TNO) THEN
        CALL UNI(CT,INO,TNO)
        ENDIF
        GO TO 1000
600 CONTINUE
        IF ((SWAIT.EQ.1).OR.(SW.EQ.1).OR.(T.EQ.1)) GO TO 870
C CHECK WHETHER THE BACKTRACKING IS POSSIBLE OR NOT
C ***** BACK TRACKING ROUTINE START *****
        DO 790 II=SI,INO
            I=SWDT(II,2)
            SAVA=-9E10
            IF (CT.GT.3) THEN
                DO 810 TO=3,CT
                    IF (AVARES(1,TO).GT.SAVA) THEN
                        SAVA=AVARES(1,TO)
                        T1=TO
                    ENDIF
                CONTINUE
810 CONTINUE
C T IMPLIES THE TIME OF MAXIMUM AVA(T)
        T3=T1-T2(I)
                                ELSE
            T3=1
        ENDIF
        TAVA=0

```

```

DO 830 TO=T3,CT
TAVA=TAVA+AVARES(J,TO)
830 CONTINUE
MTAVA=TAVA/(CT-T3+1)
TLI=(LP(I,1,1)+LP(I,1,2)+LP(I,1,3))*DT(I,CT)
MTLI=TLI/3
IF ((MTAVA.GT.MTLI).AND.(SWAIT.EQ.O)) THEN
    GO TO 850
    ELSE
    I=I+1
    GO TO 870
ENDIF
C FIND MAX AVA
850 Q=DT(I,T)
A1=A(I,T,Q,LP,AVARES)
B1=B(I,T,DT,TNO)
IF (A1.LT.B1) THEN
    MAB=A1
    ELSE
    MAB=B1
ENDIF
C
DO 890 TA=T3,CT
HCCOST=(CT-TA)*H(I)*Q
AWORK=A(I,TA,Q,LP,AVARES)+HCCOST
C
IF (SKD(I,TA).EQ.O) THEN
    DEL=1
    ELSE
    DEL=0
ENDIF
AWORK=AWORK+DEL*S(I)
C
IF (AWORK.LT.MAB) THEN
    QTY=DT(I,T)
    CALL SKDING(SKD,I,TA,DT,QTY,AVARES,RQRES,LP,1)
    DT(I,T)=0
    WRITE(6,903)
    GO TO 910
ENDIF
890 CONTINUE
C
C
IF (A1.LT.B1) THEN
    QTY=DT(I,T)
    CALL SKDING(SKD,I,T,DT,QTY,AVARES,RQRES,LP,0)
    WRITE(6,904)
    ELSE
    WAIT(I,T)=DT(I,T)
    WORK(I,2)=WORK(I,2)+DT(I,T)

```



```

C
930    CONTINUE
      ENDIF
        IF (SW.EQ.1) THEN
          SI=1
DO 990 I=1,INO
      IF ((DT(I,CT).EQ.0)) THEN
        SWDT(I,1)=9E10
          ELSE
        SWDT(I,1)=S(I)/DT(I,CT)
      ENDIF
      SWDT(I,2)=I
990    CONTINUE
C
      CALL SRT(SWDT,INO,1)
      ENDIF
        DO 1010 II=SI,INO
          I=SWDT(II,2)
          IF (CHECK(I).EQ.0) GO TO 1010
          AWORK=A(I,CT,DT(I,T),LP,AVARES)
          BWORK=B(I,CT,DT,TNO)
C
      IF (AWORK.LT.BWORK) THEN
        QTY=DT(I,T)
        CALL SKDING(SKD,I,CT,DT,QTY,AVARES,RQRES,LP,0)
        WRITE(6,906)
          ELSE
C
        WAIT(I,CT)=DT(I,CT)
        TEMP1=WORK(I,3)+1
        WORK(I,3)=TEMP1
        WORK(I,2)=WORK(I,2)+DT(I,CT)
        WORK(I,1)=C(I,TEMP1,CT,WAIT,DT)
        DT(I,CT)=0
C
        WRITE(6,1030) (WORK(I,JJ),JJ=1,3),I,CT,WAIT(I,CT)
1030   FORMAT(2X,'WORK123,I,CT,WAIT(I,CT)',5I5,F16.2)
        SWAIT=1
C
      ENDIF
C
1010   CONTINUE
1000   CONTINUE
      WRITE(6,20) ((SKD(I,T),T=1,TNO),I=1,INO)
C
      WRITE(6,20) ((WAIT(I,N),N=1,TNO),I=1,INO)
20    FORMAT(2(4X,6F10.2/))
C TOTAL SETUP COST
C
      SETN=0
      SUMS=0
      DO 4020 I=1,INO

```

```

NSETUP=0
DO 4010 T=1, TNO
  IF (SKD(I, T).GT.0) THEN
    NSETUP=NSETUP+1
  ENDIF
4010  CONTINUE
      SETN=SETN+NSETUP
4020  SUMS=SUMS+NSETUP*S(I)
C
C  CALCULATE HOLDING/PENALTY COST
C
      SUMH=0
      SUMP=0
      TSUMH=0
      TSUMP=0
      DO 4035 I=1, INO
      DO 4030 CT=1, TNO
      SDT=0
      SX=0
      DO 4050 T=1, CT
      SX=SX+SKD(I, T)
4050  SDT=SDT+WDT(I, T)
      E(I, CT)=SX-SDT
      IF (E(I, CT).GT.0) THEN
        SUMH=SUMH+E(I, CT)*H(I)
        TSUMH=TSUMH+E(I, CT)
      ELSE
        SUMP=SUMP-E(I, CT)*P(I)
        TSUMP=TSUMP-E(I, CT)
      ENDIF
4030  CONTINUE
      WRITE(6, 4036) SUMH, SUMP
4036  FORMAT(' SUMH, SUMP', 2F16.2)
4035  CONTINUE
C
C  CALCULATE OVERLOAD COST
C
      SUMOC=0
      DO 4070 T=1, TNO
      IF (AVARES(1, T).LT.0) THEN
        SUMOC=SUMOC-AVARES(1, T)
      ENDIF
4070  CONTINUE
      TSUMOC=SUMOC
      WRITE(6, 4071) SUMOC
4071  FORMAT(' OVARES', F16.2)
      SUMOC=SUMOC*OCOST
C
C  CALCLATE TOTAL COST
C

```

```

SUMTC=SUMS+SUMH+SUMP+SUMOC
C
WRITE(50,4077) SUMTC,SUMS,SUMH,SUMP,SUMOC
C
4077 FORMAT(5F16.2)
WRITE(6,4093) SUMTC,SUMS,SUMH,SUMP,SUMOC
4093 FORMAT(2X,'SUMTC,SUMS,SUMH,SUMP,SUMOC',5F16.2)
WRITE(30,4097) SUMTC
4097 FORMAT(F16.2)
WRITE(30,4098) ((WDT(I,T),T=1,TNO),I=1,INO)
WRITE(30,4098) ((SKD(I,T),T=1,TNO),I=1,INO)
4098 FORMAT(F10.2)
WRITE(30,4099) (AVARES(1,LT),LT=1,TNO2)
4099 FORMAT(F16.2)
WRITE(6,4100) (AVARES(1,LT),LT=1,TNO2)
4100 FORMAT(2(2X,7F16.2/))
CALL CLOCK(IG)
IHPU=IH-IG
WRITE(6,4092) IH,IG,IHPU
4092 FORMAT(' IH,IG,IHPU',3I5)
9999 CONTINUE
10000 CONTINUE
CALL CLOCK(ID)
ICPU=IC-ID
WRITE(6,4091) IC,ID,ICPU
4091 FORMAT(' IC,ID,ICPU',3I5)
C2345 CONTINUE
STOP
END
C *****
REAL FUNCTION A(I,T,Q,LP,AVARES)
REAL TEMP(12,1,3),LP(12,1,3),AVARES(1,26)
INTEGER T
COMMON/SEVEN/OCOST
SUM=0
J=1
DO 5000 K=1,3
TEMP(I,J,K)=LP(I,1,K)*Q
T1=T+K-1
IF (AVARES(J,T1).LT.0) THEN
SUM=SUM+TEMP(I,J,K)
ELSE
WK=TEMP(I,J,K)-AVARES(J,T1)
IF (WK.GT.0) THEN
SUM=SUM+WK
ENDIF
ENDIF
5000 CONTINUE
A=SUM*OCOST
RETURN

```

```

      END
C
C *****
C
      REAL FUNCTION B(I,T,DT,TNO)
      REAL DT(12,24)
      COMMON /ONE/ P(12),S(12)
      INTEGER T,TNO
      IF (T.EQ.TNO) THEN
          DEL=0
          GO TO 5100
      ENDIF
      IF (DT(I,T+1).EQ.0) THEN
          DEL=1
      ELSE
          DEL=0
      ENDIF
5100 B=P(I)*DT(I,T)+DEL*S(I)
      RETURN
      END
C
C *****
C
      REAL FUNCTION C(I,JD,T,WAIT,DT)
      COMMON /ONE/ P(12),S(12)
      REAL WAIT(12,24),DT(12,24)
      INTEGER T, TMIA1
      SUM=0
      DO 5200 IA=1,JD
          TMIA1=T-IA+1
C      WRITE(6,5300) T,IA,JD
5300  FORMAT(2X,'T,IA,JD',3I5)
          SUM=SUM+WAIT(I, TMIA1)*IA*P(I)
5200  CONTINUE
      IF (DT(I,T).GT.0) THEN
          ELSE SUM=SUM+S(I)
      END IF
      C=SUM
      RETURN
      END
C
C *****
      SUBROUTINE DEMAND (IC,MIYOU,SIGMA,AA,BB,DT,TNO)
      INTEGER TNO,SIGMA,AA,BB
      DOUBLEPRECISION DSEED,NDSEED
      COMMON/SIX/WDT(12,24),DSEED,NDSEED,SUMD
      REAL DT(12,24),ITEM(24)
      DSEED = NDSEED
      SUMD=0
      PHI=3.14159

```

```

DO 5400 I=1,TNO
Y=GGNQF(DSEED)
W1=SIGMA*Y
W2=(2*PHI/BB)*(I+BB/4.)
ITEM(I)=MIYOU + W1 +AA*SIN(W2)
IF (ITEM(I).LT.0) THEN
ITEM(I)=0
ENDIF
C   CALCULATE THE RATIO OF ZERO
DT(IC,I)=ITEM(I)
WDT(IC,I)=ITEM(I)
SUMD=SUMD+DT(IC,I)
5400 CONTINUE
NDSEED=DSEED
WRITE(6,5500) NDSEED
5500 FORMAT(' NEW SEED FOR DEMAND',F20.7)
RETURN
END
C *****
SUBROUTINE UNI(CT,INO,TNO)
REAL LP,RQRES(1,3)
INTEGER T,T1,CT,CT1,TNO,TT,TM1
COMMON /ONE/ P(12),S(12)
COMMON /TWO/ DT(12,24),H(12),U(12,24),SWDT(12,3)
COMMON /THREE/ LP(12,1,3),SKD(12,24),AVARES(1,26)
COMMON/FIVE/CHECK(12)
CALL CLOCK(IE)
KNO=3
J=1
DO 6010 LL=CT,TNO
DO 6010 II=1,INO
6010 U(II,LL)=-9E10
C   WRITE(6,6030) CT,INO,TNO
6030 FORMAT(2X,'CT,INO,TNO',3I5)
C   WRITE(6,20) ((DT(I,T),T=1,TNO),I=1,INO)
20 FORMAT(2(4X,6F10.2/))
C   WRITE(6,20) ((SKD(I,T),T=1,TNO),I=1,INO)
DO 6070 I=1,INO
C   WRITE(6,6090) DT(I,CT)
6090 FORMAT(2X,'DT(I,CT)',F16.2)
IF (CHECK(I).EQ.0) GO TO 6070
CT1=CT+1
DO 6110 T1=CT1,TNO
SUM=0
TM1=T1-CT
DO 6130 TT=1,TM1
ITT1=CT+TT-1
SUM=SUM+(TT-1)*DT(I,ITT1)*H(I)
WRITE(6,6150) SUM,DT(I,ITT1),H(I)
6150 FORMAT(2X,3F16.2)

```

```

6130      CONTINUE
          A1=S(I)+SUM -H(I)*((TM1+1-1)**2)*DT(I,T1)
          WRITE(6,6170) A1,SUM,DT(I,T1),I,T1,T1
6170      FORMAT(2X,3F16.2,3I6)
          IF (A1.LE.0) GO TO 6070
          B1=(TM1+1)*(TM1+1-1)*DT(I,T1)
          IF (B1.EQ.0) THEN
              U(I,T1)=9E10
          ELSE
              U(I,T1)=A1/B1
          ENDIF
          WRITE(6,6210) CT,I,T1,U(I,T1)
6210      FORMAT(2X,'CT,I,T1,U(I,T1)',3I5,F16.8)
6110      CONTINUE
6070      CONTINUE
          DO 6230 I=1,INO
              SWDT(I,1)=U(I,CT1)
              SWDT(I,2)=I
              SWDT(I,3)=CT1
6230      CONTINUE
6270      CALL SRT(SWDT,INO,2)
          DO 6250 II=1,INO
              I=SWDT(II,2)
              JO=SWDT(II,3)
              IF (CHECK(I).EQ.0) GO TO 6250
              IF ((U(I,JO)+9E10).LT.0.00001) GO TO 6250
              DST=DT(I,JO)
              DO 6280 K=1,KNO
                  RQRES(J,K)=LP(I,1,K)*DST
                  T1=CT+K-1
                  TEMP1=AVARES(J,T1)-RQRES(J,K)
                  IF (TEMP1.LT.0) THEN
                      RETURN
                  ENDIF
6280      CONTINUE
              SKD(I,CT)=SKD(I,CT)+DST
              DT(I,JO)=0
          DO 6290 K=1,KNO
              T1=CT+K-1
              AVARES(J,T1)=AVARES(J,T1)-RQRES(J,K)
6290      CONTINUE
          IF (JO.EQ.TNO) THEN
              GO TO 6250
          ENDIF
          SWDT(II,1)=U(I,JO+1)
          SWDT(II,3)=SWDT(II,3)+1
          IF (SWDT(II,1).GT.0) THEN
              GO TO 6270
          ELSE
              GO TO 6250

```

```

        ENDIF
6250   CONTINUE
        RETURN
        END
C *****
      SUBROUTINE CLEARW(I,CT)
      INTEGER TT,CT,CTT
      INTEGER WORK
      COMMON/FOUR/WORK(12,3),WAIT(12,24)
      CTT=CT-WORK(I,3)
      DO 7010 TT=CTT,CT
      WAIT(I,TT)=0
      SWAIT=0
7010   CONTINUE
C
      WORK(I,1)=0
      WORK(I,2)=0
      WORK(I,3)=0
      SWAIT=0
      RETURN
      END
C
C
C *****
C
      SUBROUTINE SRT(SWDT,INO,CHK)
C
      INTEGER CHK
      REAL SWDT(12,3)
      INOM1=INO-1
      DO 7030 NPASS=1,INOM1
      INOMN=INO-NPASS
      DO 7050 I=1,INOMN
      IF (SWDT(I,1).LT.SWDT(I+1,1)) THEN
      TEMPO=SWDT(I,1)
      SWDT(I,1)=SWDT(I+1,1)
      SWDT(I+1,1)=TEMPO
C
C
      TEMPO=SWDT(I,2)
      SWDT(I,2)=SWDT(I+1,2)
      SWDT(I+1,2)=TEMPO
C
      IF (CHK.EQ.2) THEN
      TEMPO=SWDT(I,3)
      SWDT(I,3)=SWDT(I+1,3)
      SWDT(I+1,3)=TEMPO
      ENDIF
      ENDIF
7050   CONTINUE

```



```

7030 CONTINUE
      RETURN
      END

```

```

C *****
C

```

```

      SUBROUTINE SKDING(SKD, I, T, DT, QTY, AVARES, RQRES, LP, CHK)
      INTEGER T, CHK
      REAL SKD(12, 24), DT(12, 24), RQRES(1, 3), AVARES(1, 26)
      REAL LP(12, 1, 3)
      J=1
      KNO=3
      SKD(I, T)=SKD(I, T)+QTY
      IF (CHK.EQ.0) THEN
        DT(I, T)=0
      ENDIF
      DO 7070 K=1, KNO
        T1=T+K-1
        RQRES(J, K)=LP(I, 1, K)*QTY
        AVARES(J, T1)=AVARES(J, T1)-RQRES(J, K)
7070 CONTINUE

```

```


```

```

      RETURN
      END

```

```

C$ENTRY

```

Method B

```

$JOB          'KIM',TIME=(2,00),PAGES=100
C
C234567890
C
C * I/O FILE SUMMARY *****
C
C          DD NAME          DSN
C
C 1. INPUT   FT20FO01       K.I6467.DATA
C
C 2. OUTPUT  FT40FO01       K.I6467.RESB
C
C           FT60FO01       K.I6467.MINB
C
C ***** FILE DESCRIPTION *****
C
C 1. K.I6467.DATA
C
C    REFER TO METHOD A
C
C 2. K.I6467.RESB
C
C    SAME AS K.I6467.RESA
C
C 3. K.I6467.MINB
C
C    SAME AS K.I6467.MINA
C
C ** ARRAY DESCRIPTION *****
C
C ITEM(T); PRODUCTION REQUIREMENT AT TIME T, T=1,2,...,TNO
C
C DT(I,T): PRODUCTION REQUIREMENT OF END ITEM I AT TIME T,
C           I=1,2,...,INO    T=1,2,...,TNO
C
C RESLIM(J,T): CAPACITY LIMIT, J=1    T=1,2,...,TNO+2
C
C LP(I,J,K): LOAD PROFILE, I=1,2,...,INO  J=1  K=1,2,3
C
C P(I): PENALTY COST PER UNIT OF THE ITEM I
C       PER PERIOD CARRIED.
C
C S(I): SET UP COST OF THE ITEM I
C
C H(I): CARRYING COST PER UNIT OF THE ITEM I
C       PER PERIOD CARRIED.
C

```

```

C   OCOST: COST PER MAN PERIOD OR MACHINE PERIOD
C           OF OVER TIME LABOR OR MACHINE.
C
C   RQRES(J,T): REQUIRED RESOURCE, J=1   T=1,2,3
C
C   AVARES(J,T): AVAILABLE RESOURCE, J=1   T=1,2,...,TNO+2
C
C   SKD(I,T): SCHEDULE OF END ITEM I, I=1,2,...,INO
C           T=1,2,...,TNO
CCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCCC
C
C   VARIABLE DECLARATION
C
C       INTEGER INO, CT, T, TNO, TNO1, TT, T1, T2, T3, TA, CTMT2
C       INTEGER TEMP1, TEMP2, TEROM, TFROM1, TTO, TNO2
C       INTEGER SIGMA, A, B, IPRD(12), MEAN(12)
C       INTEGER ST, TNOM1
C       INTEGER SWA, STFROM, STTO, COUNT
C       REAL IRA(5), E(12,26), VAL(12), H, MINVAL, MAXVAL
C       REAL GGNQF, Y, LP, LSQ, LSQ1, LSQ2, MAABB
C       REAL ITEM(24), RESLIM(1,26), SKD(12,24), EOQ(12)
C       REAL P(12), COST(24,24), OCOST, HCOST, AVADMD(12), TALP(12)
C       REAL RQRES(1,3), AVARES(1,26), SWDT(12,2), TEMP(12,1,3)
C       DOUBLEPRECISION DSEED, NDSEED
C       COMMON /ONE/ H(12), DT(12,24), LP(12,1,3), S(12)
C       COMMON /TWO/ TARES(1,26), ELSN(25), PRED(25)
C       COMMON /THREE/ DSEED, NDSEED, SUMD
C       COMMON /FOUR/ TNO, TNO2
C   DO 12345 IJKL=1,5
C   INITIALIZATION
C       CALL CLOCK(IC)
C       STRES=0
C       I=1
C       J=1
C       K=1
C       READ(20,10) INO, TNO, DSEED, OCOST
10  FORMAT(2I2, F20.7, F7.2)
C       IF (TNO.GE.12) THEN
C           NTNO=12
C           ELSE
C           NTNO=TNO
C       ENDIF
C   GENERATE LOAD PROFILE
C       READ(20,30) IX
30  FORMAT(I12)
C       WRITE(6,50) IX
50  FORMAT(' OLD SEED FOR LP', I12)
C       DO 70 III=1, INO
C       CALL RANDU(IX, IY, R)
C       IX=IY

```

```

R=R*1000
IR=INT(R)
WRITE(6,90) IR
90  FORMAT(2X, 'RANDOM NUMBER', I6)
    DO 70 IB=1,3
      RA=IR/((10)**(3-IB))
      LP(III,1,IB)=INT(RA)
      IR=IR-INT(RA)*((10)**(3-IB))
70  CONTINUE
    WRITE(6,110) IX
110  FORMAT(' NEW SEED FOR LOAD PROFILE', I12)
    DO 130 I1=1, INO
      SUM=0
    DO 150 I2=1,3
      SUM=SUM+LP(I1,1,I2)
150  CONTINUE
    TALP(I1)=SUM
130  CONTINUE
    NDSEED=DSEED
    WRITE(6,170) INO, TNO, DSEED, OCOST
170  FORMAT(' INO, TNO, DSEED, OCOST', 2I2, F20.7, F7.2)
    KNO=3
C    WRITE(6,190) NF, NTEMP1, NTEMP2, TEMPO
190  FORMAT(2X, 'NF, NTEMP1, 2, TEMPO', 3I5, F16.2)
    TNO1=TNO+1
    TNO2=TNO+2
    JP1=J+1
    DO 210 I=1, INO
      STLP=0
    DO 230 IT=1,3
230  STLP=STLP+LP(I,1,IT)
      READ(20,250) MEAN(I), MVAR, MAMP
250  FORMAT(3I3)
      CALL DEMAND(I, MEAN(I), MVAR, MAMP, NTNO, DT, TNO)
      AVADMD(I)=SUMD/TNO
      WRITE(6,270) SUMD, AVADMD(I)
270  FORMAT(' TOTAL SUM& AVA DMD', 2F16.2)
      STRES=STRES+STLP*SUMD
      WRITE(6,290) MEAN(I), MVAR, MAMP
290  FORMAT(' MEAN(I), MVAR, MAMP', 3I5)
      WRITE(6,310) (DT(I,T), T=1, TNO)
310  FORMAT(2X, 12F10.2/)
210  CONTINUE
      UNIRES=STRES/TNO
      READ(20,330) RATIO, NCT
330  FORMAT(F7.2, I2)
      SRATIO=RATIO
      DO 10000 IIII=1,3
        RATIO=SRATIO
      DO 350 I=1, INO

```

```

      READ(20,370) P(I),S(I),H(I)
370  FORMAT(3F7.2)
      EQQ(I)=SQRT(2*MEAN(I)*S(I)/H(I))
      TMP=EQQ(I)/MEAN(I)
      IPRD(I)=INT(TMP)
      WRITE(6,390) I,P(I),S(I),H(I)
390  FORMAT(' I,P(I),S(I),H(I)',I3,3F10.2)
350  CONTINUE
      DO 9999 IJK=1,NCT
      I=1
      J=1
      K=1
          DO 410 I=1,INO
          DO 410 T=1,TNO
410      SKD(I,T)=0
          PHI=3.14159
C      WRITE(6,430) INO
430      FORMAT(1X,I5)
          DO 450 I=1,INO
          DO 450 T=1,TNO
450      SKD(I,T)=0
          DO 470 K=1,3
470      RQRES(1,K)=0
          DO 490 J=1,TNO
          DO 490 K=J,TNO
          COST(J,K)=9E10
490      CONTINUE
          WRITE(6,510) RATIO,IJK
510      FORMAT(' 1RATIO,NCT',F7.2,I2)
          RC=UNIRES*RATIO
          WRITE(6,530) RC,UNIRES
530      FORMAT(' RC,UNIRES',2F16.2)
C      CAPACITY LIMIT
          DO 550 I=1,TNO2
          AVARES(1,I)=RC
550      CONTINUE
          RATIO=RATIO+0.1
          DO 1000 I=1,INO
          IF (I.LT.INO) THEN
              RCC=AVADMD(I)*TALP(I)
              DO 570 T=1,TNO2
570          TARES(1,T)=RCC
              ELSE
                  DO 590 T=1,TNO2
590          TARES(1,T)=AVARES(1,T)
          ENDDIF
          DO 610 J=1,TNO
          JP1=J+1
          DO 630 K=JP1,TNO1
          SUM=0

```

```

DO 650 T=JP1,K
SUM=SUM+H(I)*(T-JP1)*DT(I,T-1)
650 CONTINUE
TEMP1=S(I)-SUM
IF (TEMP1.GT.0) THEN
KMI=K-1
COST(J,KMI)=CALC(I,J,KMI,AVARES,TARES,OCOST)
ELSE
GO TO 670
ENDIF
630 CONTINUE
670 CONTINUE
IF (J.EQ.TNO) THEN
GO TO 690
ELSE
GO TO 710
ENDIF
710 CONTINUE
IF (J.GE.2) THEN
CALL SPATH(JP1,ELSN,COST)
ENDIF
CALL UPRES(I,JP1,1,DT,LP,AVARES,SKD,COST)
WRITE(6,370) (TARES(1,LT),LT=1,TNO2)
100 CONTINUE
690 CALL SPATH(TNO1,ELSN,COST)
CALL UPRES(I,TNO1,2,DT,LP,AVARES,SKD,COST)
1000 CONTINUE
CALL CLOCK(ID)
ICPU=IC-ID
WRITE(6,730) IC, ID, ICPU
730 FORMAT(' IC, ID, ICPU', 3I5)
C
WRITE(6,310) ((SKD(I,T),T=1,TNO),I=1,INO)
WRITE(6,750) (AVARES(1,LT),LT=1,TNO2)
750 FORMAT(2X,8F16.2)
CALL CCOST(INO,TNO,SKD,AVARES,OCOST,RC,1)
WRITE(40,770) ((DT(I,T),T=1,TNO),I=1,INO)
WRITE(40,770) ((SKD(I,T),T=1,TNO),I=1,INO)
770 FORMAT(F10.2)
WRITE(40,790) (AVARES(1,LT),LT=1,TNO2)
790 FORMAT(F16.2)
9999 CONTINUE
10000 CONTINUE
C2345 CONTINUE
STOP
END
C *****
SUBROUTINE DEMAND (IC,MIYOU,SIGMA,A,B,DT,TNO)
INTEGER TNO,SIGMA,A,B
REAL DT(12,24),ITEM(24),PHI

```

```

DOUBLEPRECISION DSEED,NDSEED
COMMON /THREE/ DSEED,NDSEED,SUMD
SUMD=0
PHI=3.14159
DSEED = NDSEED
DO 1500 I=1,TNO
Y=GGNQF(DSEED)
W1=SIGMA*Y
W2=(2*PHI/B)*(I+B/4.)
ITEM(I)=MIYOU + W1 + A*SIN(W2)
IF (ITEM(I).LT.0) THEN
    ITEM(I)=0
ENDIF
C   CALCULATE THE RATIO OF ZERO
    DT(IC,I)=ITEM(I)
    SUMD=SUMD+DT(IC,I)
1500 CONTINUE
    NDSEED=DSEED
    WRITE(6,1510) DSEED
1510 FORMAT(2X,'NEW DSEED',F20.7)
    RETURN
    END
C *****
SUBROUTINE SPATH(J,ELSN,COST)
REAL COST(24,24),TCOST(25),TEST(25)
REAL ELSN(25)
WRITE(6,1530) ((COST(JJ,KK),KK=1,6),JJ=1,6)
1530 FORMAT(6(2X,6F16.1/))
    DO 1550 I=1,J
        TCOST(I)=9E10
        TEST(I)=0
        ELSN(I)=0
1550 CONTINUE
        TCOST(1)=0
        TEST(1)=1
1590 CONTINUE
    DO 1600 I=1,J
        IF (TEST(I).EQ.1) THEN
            JM1=J-1
            NUM=0
            DO 1610 JJ=1,JM1
                DO 1620 KK=JJ,JM1
                    NUM=NUM+1
                    SERN=NUM
                    KKP1=KK+1
                    IF (JJ.EQ.I) THEN
                        IF ((TCOST(I)+COST(JJ,KK)).LT.TCOST(KKP1))
                            THEN
                                TCOST(KKP1)=TCOST(I)+COST(JJ,KK)
                                ELSN(KKP1)=SERN
                                TEST(KKP1)=1

```

```

                                ENDIF
                                ENDIF
1620                            CONTINUE
1610                            CONTINUE
                                TEST(I)=0
                                ENDIF
1600                            CONTINUE
                                DO 1650 I=1,J
                                    IF (TEST(I).EQ.1) GO TO 1590
1650                            CONTINUE
                                IF (J.EQ.5) THEN
                                    DO 1660 M=1,J
                                        WRITE(6,1661) M,TCOST(M),ELSN(M),TEST(M)
1661                            FORMAT(2X,I4,3F15.2)
1660                            CONTINUE
                                ENDIF
                                RETURN
END
C *****
SUBROUTINE UPRES(I,JNO,CHK,DT,LP,AVARES,SKD,COST)
COMMON /TWO/ TARES(1,26),ELSN(25),PRED(25)
COMMON /FOUR/ TNO,TNO2
REAL RQRES(1,3),AVARES(1,26),LP(12,1,3),DT(12,24)
REAL COST(24,24),SKD(12,24)
INTEGER S,S1,F,T,TNO,TNO2,CHK
IF (JNO.EQ.2) THEN
    TDMD=DT(I,1)
    DO 1670 K=1,3
C    WRITE(6,1665) TDMD,LP(I,1,K)
1665    FORMAT(2X,2F10.3)
        RQRES(1,K)=TDMD*LP(I,1,K)
        TARES(1,K)=TARES(1,K)-RQRES(1,K)
1670    CONTINUE
    RETURN
ENDIF
PRED(1)=JNO
J=1
N=1
WHILE(PRED(N).NE.1)
    WRITE(6,1690) N,PRED(N)
1690    FORMAT(5X,'PRED',I5,'=',F10.3)
    N=N+1
    SERN=ELSN(PRED(N-1))
    JTEMP=JNO-1
    JNOM1=JNO-1
    DO 1750 L=1,JTEMP
        T=SERN-JNOM1
        IF (T.LE.0) THEN
            PRED(N)=L
            GO TO 1770

```



```

                                ELSE
                                SERN=SERN-JNOM1
                                JNOM1=JNOM1-1
                                ENDIF
1750      CONTINUE
1770      CONTINUE
          WRITE(6,1690) N,PRED(N)
        END WHILE
      IF (CHK.EQ.2) GO TO 2000
        JNO1=JNO
        NM1=N-1
        DO 1800 KA=1,NM1
          TDMD=0
          F=JNO1
C PRED(1) IS THE DESTINATION
          KA1=KA+1
          S=PRED(KA1)+1
          S1=S-1
          DO 1850 K1=S,F
            TDMD=TDMD+DT(I,K1-1)
1850      CONTINUE
          DO 1900 K=1,3
            RQRES(J,K)=TDMD*LP(I,J,K)
            T1=S1-1+K
            TARES(J,T1)=TARES(J,T1)-RQRES(J,K)
1900      CONTINUE
          JNO1=PRED(KA1)
          WRITE(6,1950) JNO1,KA
1950      FORMAT(2X,2I5/)
1800      CONTINUE
          RETURN
2000 CONTINUE
        JNO1=JNO
        WRITE(6,2040) N
2040      FORMAT(2X,I5/)
        NM1=N-1
        DO 2050 KA=1,NM1
          TDMD=0
          F=JNO1
          KA1=KA+1
          S=PRED(KA1)+1
          S1=S-1
          DO 2100 K1=S,F
            TDMD=TDMD+DT(I,K1-1)
2100      CONTINUE
          SKD(I,S1)=TDMD
          WRITE(6,1950) S,F
          DO 2200 K=1,3
            T1=S1-1+K
            RQRES(J,K)=TDMD*LP(I,J,K)

```

```

                AVARES(J,T1)=AVARES(J,T1)-RQRES(J,K)
2200          CONTINUE
                JNO1=PRED(KA1)
2050          CONTINUE
                WRITE(6,370) (TARES(1,LT),LT=1,TNO2)
370          FORMAT(2X,8F16.2)
                DO 2270 KKK=1,TNO
                DO 2270 JJJ=KKK,TNO
                COST(JJJ,KKK)=9E10
2270          CONTINUE
                RETURN
                END
C *****
SUBROUTINE CCOST(INO,TNO,SKD,AVARES,OCOST,RC,III)
REAL LP
COMMON /ONE/ H(12),DT(12,24),LP(12,1,3),S(12)
REAL E(12,26),AVARES(1,26),SKD(12,24),P(12)
REAL RQRES(1,3)
INTEGER TNO,T,T1,CT,TNO2
WRITE(6,4000) ((SKD(I,T),T=1,TNO),I=1,INO)
4000          FORMAT(2X,12F10.2/)
C
C TOTAL SETUP COST
C
                TNO2=TNO+2
                DO 4005 II=1,12
4005          P(II)=0
                SETN=0
                SUMS=0
                DO 4020 I=1,INO
                NSETUP=0
                DO 4010 T=1,TNO
                IF (SKD(I,T).GT.0) THEN
                NSETUP=NSETUP+1
                ENDIF
4010          CONTINUE
                SETN=SETN+NSETUP
4020          SUMS=SUMS+NSETUP*S(I)
C
C CALCULATE HOLDING/PENALTY COST
C
                SUMH=0
                SUMP=0
                TSUMH=0
                TSUMP=0
                DO 4035 I=1,INO
                DO 4030 CT=1,TNO
                SDT=0
                SX=0
                DO 4050 T=1,CT

```

```

      SX=SX+SKD(I,T)
4050  SDT=SDT+DT(I,T)
      E(I,CT)=SX-SDT
      IF (E(I,CT).GT.0) THEN
          SUMH=SUMH+E(I,CT)*H(I)
          TSUMH=TSUMH+E(I,CT)
          ELSE
          SUMP=SUMP-E(I,CT)*P(I)
          TSUMP=TSUMP-E(I,CT)
      ENDIF
4030  CONTINUE
      WRITE(6,4036) SUMH,SUMP
4036  FORMAT(' SUMH,SHMP',2F16.2)
4035  CONTINUE
C
C  CALCULATE OVERLOAD COST
C
      SUMOC=0
      DO 5000 II=1,TNO2
5000  AVARES(1,II)=RC
      DO 5010 I=1,INO
      DO 5010 IT=1,TNO
      DO 5010 K=1,3
          T1=IT+K-1
          RQRES(1,K)=LP(I,1,K)*SKD(I,IT)
          AVARES(1,T1)=AVARES(1,T1)-RQRES(1,K)
5010  CONTINUE
      WRITE(6,5020) (AVARES(1,LT),LT=1,TNO2)
5020  FORMAT(2X,2(7F16.2/))
      DO 4070 T=1,TNO
          IF (AVARES(1,T).LT.0) THEN
              SUMOC=SUMOC-AVARES(1,T)
          ENDIF
4070  CONTINUE
      TSUMOC=SUMOC
      WRITE(6,4071) SUMOC
4071  FORMAT(' OVARES',F16.2)
      SUMOC=SUMOC*OCOST
C
C  CALCLATE TOTAL COST
C
      SUMTC=SUMS+SUMH+SUMP+SUMOC
C
      WRITE(60,4077) SUMTC,SUMS,SUMH,SUMP,SUMOC
C
      WRITE(60,4077) SUMTC,SETN,TSUMH,TSUMP,TSUMOC
40570  FORMAT(5F16.2)
      WRITE(6,5090) SUMTC,SUMS,SUMH,SUMP,SUMOC
5090  FORMAT(2X,'SUMTC,SUMS,SUMH,SUMP,SUMOC',5F16.2)
      IF (III.EQ.1) THEN
          WRITE(40,5093) SUMTC

```

```

5093  FORMAT(F16.2)
      ENDIF
      RETURN
      END
C *****
      REAL FUNCTION AMIN(AM,BM)
        REAL AM,BM
        IF (AM.LT.BM) THEN
          AMIN=AM
        ELSE
          AMIN=BM
        ENDIF
      RETURN
      END
C *****
      REAL FUNCTION CALC(I,JN,KN,AVARES,TARES,OC)
      REAL AVARES(1,26),TARES(1,26),TEMP(12,1,3),LP
      INTEGER T,TNO
      J=1
      COMMON /ONE/ H(12),DT(12,24),LP(12,1,3),S(12)
      COMMON /FOUR/ TNO,TNO2
C SET UP COST
      A=S(I)
C HOLDING COST/PRODUCTION QUANTITY
      B=0
      PQ=0
      DO 6000 T=JN,KN
        B=B+H(I)*(T-JN)*DT(I,T)
        PQ=PQ+DT(I,T)
      6000  CONTINUE
C OVERLOAD COST
      SUM=0
      DO 6010 K=1,3
        TEMP(I,J,K)=LP(I,J,K)*PQ
        T1=JN+K-1
        IF (T1.GT.TNO) GO TO 6010
        IF (TARES(J,T1).LT.0) THEN
          SUM=SUM+TEMP(I,J,K)
        ELSE
          WK=TEMP(I,J,K)-TARES(J,T1)
          IF (WK.GT.0) THEN
            SUM=SUM+WK
          ENDIF
        WRITE(6,6030) K,TARES(1,T1),PQ,TEMP(I,1,K)
      6030  FORMAT(2X,'K,TARES,PQ,TEMP',I3,3F16.2)
      ENDIF
      6010  CONTINUE
        WRITE(6,6050) SUM
      6050  FORMAT(2X,'SUM=',F16.2)
      C=SUM*OC

```

```
      IF (JN.EQ.3) THEN  
      WRITE(6,6070) A,B,C  
6070  FORMAT(2X,'A,B,C=',3F12.2)  
      ENDIF  
      CALC=A+B+C  
      RETURN  
      END  
C$ENTRY
```

Method C

```

$JOB          'KIM', TIME=(2,30), PAGES=100, NOWARN
C
C * I/O FILE SUMMARY *****
C
C          DD NAME          DSN
C  1. INPUT  FT2OF001      K.I6467.DATA
C
C          FT3OF001      K.I6467.RESA
C
C          FT4OF001      K.I6467.RESB
C  2. OUTPUT  FT7OF001      K.I6467.MINC
C
C ***** FILE DESCRIPTION *****
C
C  1.  K.I6467.DATA
C
C      REFER TO METHODDA
C
C  2.  K.I6467.RESA
C
C      REFER TO METHODDA
C
C  3.  K.I6467.RESB
C
C      REFER TO METHODDB
C
C  4.  K.I6467.MINC
C
C      1) BOUNDL: COST C FROM METHOD C (TREE SEARCH METHOD)
C
C VARIABLE DEFINITION *****
C
C      INTEGER  INO, CT, T, TNO, TNO1, TT, T1, T2, T3, TA, CTMT2
C      INTEGER  TEMP1, TEMP2, TFROM, TFROM1, TTO, TNO2
C      INTEGER  ST, TNOM1, CT1, KSAVE(12), TABLE(20, 4)
C      INTEGER  SWA, STFROM, STTO, COUNT, ITBL(300, 4)
C      REAL    TEMP(12, 1, 3), LP(12, 1, 3), E(12, 24)
C      REAL    SIGN(20, 3), IRA(5), TARES(1, 26)
C      REAL    S(12), P(12), H(12), VAL(10)
C      REAL    LSQ, LSQ1, LSQ2, MAABB
C      REAL    MINVAL, MAXVAL
C      DOUBLEPRECISION  DENOM, DNUMBER
C      COMMON/ONE/DT(12, 24), SKD(12, 24), AVARES(1, 26)
C      COMMON/TWO/VAL10(10), UVAL
C
C      DO 12345 IJKL=1,5

```

```

KNO=3
READ(20,50) INO,TNO,DSEED,OCOST
50 FORMAT(2I2,F20.7,F7.2)
   WRITE(6,100) INO,TNO,DSEED,OCOST
100  FORMAT(' INO,TNO,DSEED,OCOST',2I2,F20.7,F7.2)
      TNO2=TNO+2
C   GENERATE LOAD PROFILE
      READ(20,150) IX,ICT
150  FORMAT(I12,I4)
      WRITE(6,200) IX,ICT
200  FORMAT(' OLD SEED FOR LP & TOTAL COUNT',I12,I4)
      DO 250 III=1,INO
      CALL RANDU(IX,IY,R)
      IX=IY
      R=R*1000
      IR=INT(R)
      WRITE(6,300) IR
300  FORMAT(2X,'RANDOM NUMBER',I6)
      DO 250 IB=1,3
      RA=IR/((10)**(3-IB))
      LP(III,1,IB)=INT(RA)
      IR=IR-INT(RA)*((10)**(3-IB))
250  CONTINUE
      WRITE(6,350) IX
350  FORMAT(' NEW SEED FOR LOAD PROFILE',I12)
      DO 400 II=1,INO
      READ(20,450) MEAN,MVAR,MAMP
450  FORMAT(3I3)
400  CONTINUE
      READ(20,500) RATIO,NCT
500  FORMAT(F7.2,I2)
      SRATIO=RATIO
      DO 550 INUM=1,INO
      SLP=0
      DO 600 K=1,3
         IF (LP(INUM,1,K).GT.SLP) THEN
            SLP=LP(INUM,1,K)
            KSAVE(INUM)=K
         ENDIF
600  CONTINUE
550  CONTINUE
      DO 1000 IIII=1,3
      RATIO=SRATIO
      DO 650 I=1,INO
      READ(20,700) P(I),S(I),H(I)
700  FORMAT(3F7.2)
      WRITE(6,750) P(I),S(I),H(I)
750  FORMAT(' P(I),S(I),H(I)',3F7.2)
650  CONTINUE
      DO 9999 IJK=1,NCT

```

```

IBRCH=0
COUNT=0
BOUNDL=9E11
ILEVEL=1
CALL CLOCK(IC)
SWA=0
STFROM=0
STTO=0
WRITE(6,800) RATIO,IJK
800  FORMAT('IRATIO,IJK',F16.2,I3)
      RATIO=RATIO+0.1
      READ(30,850) STCA
850  FORMAT(F16.2)
      WRITE(6,900) STCA
900  FORMAT(' ORIGINAL TOTAL COST OF RESA',F16.2)
      READ(40,850) STCB
      WRITE(6,900) STCB
900  FORMAT(' ORIGINAL TOTAL COST OF RESB',F16.2)
      IF (STCA.LE.STCB) THEN
          IUNIT=30
          SUMTC=STCA
                                ELSE
          IUNIT=40
          SUMTC=STCB
      ENDIF
      VAL(1)=SUMTC
      SMALLV=SUMTC
      NCOL=2
      CALL READ(IUNIT,INO,TNO)
950  CONTINUE
      DO 1050 LT=1,TNO2
1050  TARES(1,LT)=AVARES(1,LT)
      IF (SMALLV.LT.BOUNDL) THEN
          BOUNDL=SMALLV
      ENDIF
      IF (ILEVEL.GT.4) THEN
          GO TO 1100
      ENDIF
      DO 3010 T=1,TNO
          IF (AVARES(1,T).GT.0) THEN
              ST=T
              GO TO 3030
          ENDIF
3010  CONTINUE
          WRITE(6,3015)
3015  FORMAT(2X,'ALL AVARES IS NEGA')
          GO TO 3950
C *****
3030  TNOM1=TNO-1
      N=1

```



```

SIGN(N,1)=ST
TAVA=0
DO 3050 T=ST, TNOM1
IF (((AVARES(1,T).LT.0).AND.(AVARES(1,T+1).GT.0)).OR.
1 ((AVARES(1,T).GT.0).AND.(AVARES(1,T+1).LT.0))) THEN
SIGN(N,2)=T
SIGN(N,3)=TAVA+AVARES(1,T)
TAVA=0
N=N+1
SIGN(N,1)=T+1
C
IF (T.EQ.TNOM1) THEN
SIGN(N,2)=T+1
SIGN(N,3)=TAVA+AVARES(1,T+1)
ENDIF
ELSE
TAVA=TAVA+AVARES(1,T)
IF (T.EQ.TNOM1) THEN
SIGN(N,2)=TNO
SIGN(N,3)=TAVA+AVARES(1,T+1)
ENDIF
ENDIF
3050 CONTINUE
NT=MOD(N,2)
IF (NT.EQ.0) THEN
NT=N
ELSE
NT=N-1
ENDIF
C WRITE(6,3070) NT
3070 FORMAT(2X, I5)
IF (NT.LT.2) THEN
3075 WRITE(6,3075) NT
FORMAT(2X, I5, 'NT IS LESS THAN 2')
GO TO 3950
ENDIF
C NT IS THE TOTAL NUMBER OF ROWS
C *****
IX=12357
3800 CONTINUE
COUNT=COUNT+1
IF (COUNT.GT. ICT) THEN
WRITE(6,3701)
3701 FORMAT(2X, 'INCREASE COUNT')
GO TO 1100
ENDIF
CALL RANDU(IX, IY, R)
IX=IY
R=R*100000
IR=INT(R)

```

```

C      WRITE(6,3090) IR
3090  FORMAT(2X, 'RANDOM NUMBER', I6)
      DO 3110 IB=1,5
      RA=IR/((10)**(5-IB))
      IRA(IB)=INT(RA)/10.
      IR=IR-INT(RA)*((10)**(5-IB))
3110  CONTINUE
C      WRITE(6,3000) (IRA(IB), IB=1,5)
3000  FORMAT(2X, 5F10.2)
      TEMPO=NT*IRA(1)
      NTEMP1=INT(TEMPO+01.000)
      NTEMP2=MOD(NTEMP1,2)
      IF (NTEMP2.EQ.0) THEN
          NF=NTEMP1
      ELSE
          NF=NTEMP1+1
      ENDIF
C FIND ITEM NUMBER
      TEMPO=INO*IRA(2)
      INUM=INT(TEMPO+01.000)
C FIND THE ORIGIN PERIOD
      TEMP1=SIGN(NF,1)
      TEMP2=SIGN(NF,2)
      TEMPO=(TEMP2-TEMP1)*IRA(3)
      IF (TEMPO.EQ.0) THEN
          TEMPO=-0.001
      ENDIF
      TFROM=INT(TEMPO+01.000)+TEMP1
C      WRITE(6,3145) NF,TEMP1,TEMP2,TFROM,TEMPO
3145  FORMAT(2X, 'NF,TEMP1,2,TFROM,TEMPO', 4I5, F16.2)
      IF (SKD(INUM,TFROM).EQ.0) THEN
          DO 3150 II=TEMP1,TEMP2
              IF (SKD(INUM,II).GT.0) THEN
                  TFROM=II
                  GO TO 3156
              ENDIF
3150  CONTINUE
C ORIGIN PERIOD IS EMPTY
      DO 3175 III=TEMP1,TEMP2
      DO 3175 JJJ=1,INO
          IF (SKD(JJJ,III).GT.0) THEN
              TFROM=III
              INUM=JJJ
              LSQ=IRA(5)*SKD(JJJ,III)
C FIND THE TO PERIOD
      NFM1=NF-1
      TMP1=SIGN(NFM1,1)
      TMP2=SIGN(NFM1,2)
      TMPO=(TMP2-TMP1)*IRA(4)
      IF (TMPO.EQ.0) THEN

```

```

        TMPO=-0.001
        ENDIF
        TTO=INT(TMPO+01.000)+TMP1
            GO TO 3180
        ENDIF
3175  CONTINUE
        GO TO 3800
                                           ELSE
            GO TO 3156
        ENDIF
C
C
C FIND THE DESTINATION PERIOD
C
3156  NEM1=NF-1
        TEMP1=SIGN(NEM1,1)
        TEMP2=SIGN(NEM1,2)
        TEMPO=(TEMP2-TEMP1)*IRA(4)
        IF (TEMPO.EQ.0) THEN
            TEMPO=-0.001
        ENDIF
        TTO=INT(TEMPO+01.000)+TEMP1
C FIND LSQ
        TEMPO=3*IRA(5)
        JJJ=INT(TEMPO+1.000)
        TLP=LP(INUM,1,JJJ)
        IF (TLP.EQ.0) THEN
            TLP=1.
        ENDIF
        LSQ1=AVARES(1,TTO)/TLP
        LSQ2=SKD(INUM,TFROM)
        LSQ=AMIN(LSQ1,LSQ2)
        WRITE(6,3157) AVARES(1,TTO),LSQ1,LSQ2,TTO
3157  FORMAT(2X,'AVA,LSQ1,2,TTO',3F16.2,I5)
3180  CONTINUE
C
C MINUS OCOST
C
        SUM=0
        DO 3200 K=1,3
            TEMP(INUM,1,K)=LSQ*LP(INUM,1,K)
            T1=TFROM+K-1
            IF (TARES(1,T1).LT.0) THEN
                AAA=(-1)*TARES(1,T1)
                BBB=TEMP(INUM,1,K)
                WRITE(6,3205) AAA,BBB,TARES(1,T1),T1
3205  FORMAT(2X,'AAA,BBB,AVA,T1',3F16.2,I5)
                IF (AAA.LT.BBB) THEN
                    MAABB=AAA
                ELSE

```

```

        MAABB=BBB
        ENDIF
        SUM=SUM+MAABB
    ENDIF
    TARES(1,T1)=TARES(1,T1)-TEMP(INUM,1,K)
3200 CONTINUE
    OTCOST=SUM*OCOST
C     WRITE(6,3210) OTCOST,SUM,OCOST
3210  FORMAT(2X,'OTCOST,SUM,OCOST',3F16.2)
C
C
C     PLUS OCOST
C
C OVERLOAD COST
    J=1
    SUM1=0
    DO 3300 K=1,3
        TEMP(INUM,J,K)=LP(INUM,J,K)*LSQ
        T1=TTO+K-1
        IF (TARES(J,T1).LT.0) THEN
            SUM1=SUM1+TEMP(INUM,J,K)
            ELSE
                WK=TEMP(INUM,J,K)-TARES(J,T1)
                IF (WK.GT.0) THEN
                    SUM1=SUM1+WK
                ENDIF
        ENDIF
C     WRITE(6,3350) K,TARES(1,T1),PQ,TEMP(INUM,1,K)
3350  FORMAT(2X,'K,TARES,PQ,TEMP',I3,3F16.2)
    ENDIF
3300 CONTINUE
C     WRITE(6,3400) SUM1
3400  FORMAT(2X,'SUM1=',F16.2)
    OMCOST=SUM1*OCOST
    DO 3450 LT=1,TNO2
3450  TARES(1,LT)=AVARES(1,LT)
C     ADD SETUP COST
C
        TEMPO=SKD(INUM,TTO)
        IF (TEMPO.EQ.0.) THEN
            SCOST=S(INUM)
            ELSE
                SCOST=0
        ENDIF
C
C     ADD HOLDING COST
        HOCOST=(TFROM-TTO)*H(INUM)*LSQ
C
C     WRITE(6,3500) HOCOST,H(INUM),TFROM TTO
3500  FORMAT(2X,2F16.2,2I6)
C     WRITE(6,3550) HOCOST

```

```

3550 FORMAT(2X,'HCOST',F16.2)
C ADD ALL ADDITIONAL COST
C
      TOTCOST=-OTCOST+OMCOST+SCOST+HCOST
C
3600 CONTINUE
      IF (NCOL.LT.10) THEN
      ENDIF
      VAL(NCOL)=TOTCOST+BOUNDL
      TABLE(NCOL,1)=TTO
      TABLE(NCOL,2)=TFROM
      TABLE(NCOL,3)=INUM
      IF (IBRCH.EQ.0) THEN
      TABLE(NCOL,4)=INT(LSQ)
      ELSE
      TABLE(NCOL,4)=INT(RSQ)
      ENDIF
      NCOL=NCOL+1
C
      IF (NCOL.GE.5) THEN
      SMALLV=9E10
      DO 3650 I=1,4
      IF (SMALLV.GT.VAL(I)) THEN
      ISAVE=I
      SMALLV=VAL(I)
      ENDIF
3650 CONTINUE
      IF (IBRCH.EQ.1) THEN
      WRITE(6,3700) (VAL(II),II=1,4)
3700 FORMAT(' **VAL10**',9F10.2/)
      ENDIF
      VAL(1)=VAL(ISAVE)
      IF (ISAVE.EQ.1) THEN
      NCOL=2
      ILEVEL=ILEVEL+1
      GO TO 950
      ENDIF
      INUM=TABLE(ISAVE,3)
      TTO=TABLE(ISAVE,1)
      TFROM=TABLE(ISAVE,2)
      LSQT=TABLE(ISAVE,4)
      RLSQ=FLOAT(LSQT)
      DO 3750 K=1,3
      TEMP(INUM,1,K)=RLSQ*LP(INUM,1,K)
      K1=TFROM+K-1
      K2=TTO+K-1
      AVARES(1,K1)=AVARES(1,K1)+TEMP(INUM,1,K)
      AVARES(1,K2)=AVARES(1,K2)-TEMP(INUM,1,K)
3750 CONTINUE
C UPDATE SCHEDULE

```

```

SKD(INUM,TFROM)=SKD(INUM,TFROM)-RLSQ
SKD(INUM,TTO)=SKD(INUM,TTO)+RLSQ
ILEVEL=ILEVEL+1
NCOL=2
GO TO 950
ELSE
IF (IBRCH.EQ.0) THEN
GO TO 3800
ELSE
GO TO 3900
ENDIF
ENDIF
3950 CONTINUE
IBRCH=1
ISER=1
DO 4035 I=1,INO
DO 4030 CT=1,TNO
SDT=0
SX=0
DO 4050 T=1,CT
SX=SX+SKD(I,T)
4050 SDT=SDT+DT(I,T)
E(I,CT)=SX-SDT
IF (E(I,CT).GT.0) THEN
ITBL(ISER,1)=I
ITBL(ISER,2)=CT
ITBL(ISER,3)=INT(E(I,CT))
SUME=E(I,CT)
IF (CT.EQ.TNO) THEN
ITBL(ISER,4)=0
ELSE
CT1=CT+1
DO 4055 T=CT,TNO
SUME=SUME-DT(I,T)
IF (SUME.LE.0) THEN
ITBL(ISER,4)=T-CT-1
GO TO 4056
ENDIF
4055 CONTINUE
ITBL(ISER,4)=0
4056 CONTINUE
ENDIF
ISER=ISER+1
ENDIF
4030 CONTINUE
4035 CONTINUE
3900 CONTINUE
C GENERATE RANDOM VARIABLE AND INUM AND TFROM
CALL RANDU(IX,IY,R)
IX=IY

```

```

R=R*100
IR=INT(R)
C WRITE(6,3090) IR
DO 4100 IB=1,2
RA=IR/((10)**(2-IB))
IRA(IB)=INT(RA)/10.
IR=IR-INT(RA)*((10)**(2-IB))
4100 CONTINUE
TEMPO=(ISER-1)*IRA(1)
ISERC=INT(TEMPO+1.0)
TEMPO=ITBL(ISERC,4)*IRA(2)
IRSP=INT(TEMPO+1.0)
INUM=ITBL(ISERC,1)
TFROM=ITBL(ISERC,2)
TTO=ITBL(ISERC,2)+IRSP
IF (TTO.GT.TNO) THEN
TTO=TNO
ENDIF
ITEMP=ITBL(ISERC,3)
TEMP11=FLOAT(ITEMP)
RSQ1=AMIN(SKD(INUM,TFROM),TEMP11)
TTOS=TTO+KSAVE(INUM)-1
TLP=LP(INUM,1,KSAVE(INUM))
IF (TLP.EQ.0) THEN
TLP=1.
ENDIF
RSQ2=AVARES(1,TTOS)/TLP
RSQ=AMIN(RSQ1,RSQ2)
C DECREASE THE HOLDING COST
DHCOST=H(INUM)*(TTO-TFROM)*RSQ
C ADD THE SET UP COST
IF (SKD(INUM,TTO).EQ.0) THEN
ASCOST=S(INUM)
ELSE
ASCOST=0
ENDIF
TOTCOST=-DHCOST+ASCOST
GO TO 3600
1100 CONTINUE
WRITE(70,4250) BOUNDL
4250 FORMAT(F16.2)
WRITE(6,4300) NCOL,ILEVEL,BOUNDL
4300 FORMAT('NCOL,ILEVEL, * BOUNDL *',2I5,F16.2)
CALL CLOCK(ID)
ICPU=IC-ID
WRITE(6,4350) IC,ID,ICPU
4350 FORMAT(' IC, ID,ICPU',3I5)
WRITE(6,4400) ((SKD(II,IT),IT=1,TNO),II=1,INO)
4400 FORMAT(6(2X,6F10.2/))
WRITE(6,4450) (AVARES(1,IT),IT=1,TNO2)

```

```

4450 FORMAT(2(2X,7F16.2/))
9999 CONTINUE
10000 CONTINUE
C2345 CONTINUE
      STOP
      END
C *****
      SUBROUTINE READ(IUNIT,INO,TNO)
          INTEGER TNO,T,TNO2
          COMMON/ONE/DT(12,24),SKD(12,24),AVARES(1,26)
          TNO2=TNO+2
          DO 6000 I=1,INO
          DO 6000 T=1,TNO
          READ(IUNIT,70) DT(I,T)
6000 CONTINUE
          WRITE(6,6050) ((DT(II,IT),IT=1,TNO),II=1,INO)
6050 FORMAT(6(2X,6F10.2/))
          DO 6100 I=1,INO
          DO 6100 T=1,TNO
          READ(IUNIT,6125) SKD(I,T)
6125 FORMAT(F10.2)
6100 CONTINUE
          WRITE(6,6150) ((SKD(II,IT),IT=1,TNO),II=1,INO)
6150 FORMAT(6(2X,6F10.2/))
          DO 6200 T=1,TNO2
          READ(IUNIT,6250) AVARES(1,T)
6250 FORMAT(F16.2)
6200 CONTINUE
          WRITE(6,6300) (AVARES(1,IT),IT=1,TNO2)
6300 FORMAT(2(2X,7F16.2/))
              IF (IUNIT.EQ.30) THEN
                  IDUM=40
                      ELSE
                          IDUM=30
                              ENDIF
                  IT=2*INO*TNO+TNO+2
                  DO 6350 II=1,IT
                      READ(IDUM,6400) DUMMY
6400 FORMAT(F16.2)
6350 CONTINUE
          RETURN
          END
C *****
      REAL FUNCTION AMIN(AM,BM)
          REAL AM,BM
          IF (AM.LT.BM) THEN
              AMIN=AM
                      ELSE
                          AMIN=BM
                              ENDIF

```



```
      RETURN
      END
C *****
      SUBROUTINE SORT(VAL,INO)
C
      REAL VAL(100)
      INOM1=INO-1
      DO 6450 NPASS=1,INOM1
          INOMN=INO-NPASS
          DO 6500 I=1,INOMN
              IF (VAL(I).GT.VAL(I+1)) THEN
                  TEMPO=VAL(I)
                  VAL(I)=VAL(I+1)
                  VAL(I+1)=TEMPO
C
C
              ENDIF
          6500 CONTINUE
      6450 CONTINUE
      RETURN
      END
C$ENTRY
```

Solution standard

```

$JOB          'KIM' , TIME=(2,00) , PAGES=100
C
C * I/O FILE SUMMARY *****
C
C          DD NAME          DSN
C
C 1. INPUT  FT20F001        K.I6467.DATA
C
C          FT30F001        K.I6467.RESA
C
C          FT40F001        K.I6467.RESB
C
C 2. OUTPUT FT90F001        K.I6467.EXT
C
C ***** FILE DESCRIPTION *****
C
C 1.  K.I6467.DATA
C
C    REFER TO METHOD0A
C
C 2.  K.I6467.RESA
C
C    REFER TO METHOD0A
C
C 3.  K.I6467.RESB
C
C    REFER TO METHOD0B
C
C 4.  K.I6467.EXT
C
C    1) VAL(1): VAL10(1): BOUNDL: SOLUTION STANDARD
C
C *** VARIABLE DEFINITION *****
C
C    INTEGER INO,CT,T,TNO,TNO1,TT,T1,T2,T3,TA,CTMT2
C    INTEGER TEMP1,TEMP2,TEROM,TEROM1,TTO,TNO2
C    INTEGER ST,TNOM1,CT1,KSAVE(12)
C    INTEGER SWA,STFROM,STTO,COUNT,ITBL(300,4)
C    REAL TEMP(12,1,3),LP(12,1,3),E(12,24)
C    REAL SIGN(20,3),IRA(5),TARES(1,26)
C    REAL S(12),P(12),H(12),VAL(300)
C    REAL LSQ,LSQ1,LSQ2,MAABB
C    REAL MINVAL,MAXVAL
C    DOUBLEPRECISION DENOM,DNUMER,DB,ALPHA
C    COMMON/ONE/DT(12,24),SKD(12,24),AVARES(1,26)
C    COMMON/TWO/VAL10(10),UVAL
C
C    DO 12345 IJKL=1,5

```

```

KNO=3
READ(20,50) INO,TNO,DSEED,OCOST
50 FORMAT(2I2,F20.7,F7.2)
WRITE(6,100) INO,TNO,DSEED,OCOST
100 FORMAT(' INO,TNO,DSEED,OCOST',2I2,F20.7,F7.2)
TNO2=TNO+2
C GENERATE LOAD PROFILE
READ(20,150) IX,ICT
150 FORMAT(I12,I4)
WRITE(6,200) IX,ICT
200 FORMAT(' OLD SEED FOR LP & TOTAL COUNT',I12,I4)
DO 250 III=1,INO
CALL RANDU(IX,IY,R)
IX=IY
R=R*1000
IR=INT(R)
WRITE(6,300) IR
300 FORMAT(2X,'RANDOM NUMBER',I6)
DO 250 IB=1,3
RA=IR/((10)**(3-IB))
LP(III,1,IB)=INT(RA)
IR=IR-INT(RA)*((10)**(3-IB))
250 CONTINUE
WRITE(6,400) IX
400 FORMAT(' NEW SEED FOR LOAD PROFILE',I12)
DO 450 II=1,INO
READ(20,500) MEAN,MVAR,MAMP
500 FORMAT(3I3)
450 CONTINUE
READ(20,550) RATIO,NCT
550 FORMAT(F7.2,I2)
SRATIO=RATIO
DO 600 INUM=1,INO
SLP=0
DO 650 K=1,3
IF (LP(INUM,1,K).GT.SLP) THEN
SLP=LP(INUM,1,K)
KSAVE(INUM)=K
ENDIF
650 CONTINUE
600 CONTINUE
DO 10000 IIII=1,3
RATIO=SRATIO
DO 700 I=1,INO
READ(20,750) P(I),S(I),H(I)
750 FORMAT(3F7.2)
WRITE(6,800) P(I),S(I),H(I)
800 FORMAT(' P(I),S(I),H(I)',3F7.2)
700 CONTINUE
DO 9999 IJK=1,NCT

```

```

IBRCH=0
COUNT=0
  CALL CLOCK(IC)
SWA=0
STFROM=0
STTO=0
  WRITE(6,850) RATIO,IJK
850  FORMAT('1RATIO,IJK',F16.2,I3)
  RATIO=RATIO+0.1
  READ(30,900) STCA
900  FORMAT(F16.2)
  WRITE(6,950) STCA
950  FORMAT(' ORIGINAL TOTAL COST OF RESA',F16.2)
  READ(40,900) STCB
  WRITE(6,1050) STCB
1050 FORMAT(' ORIGINAL TOTAL COST OF RESB',F16.2)
  IF (STCA.LE.STCB) THEN
    IUNIT=30
    SUMTC=STCA
  ELSE
    IUNIT=40
    SUMTC=STCB
  ENDIF
  VAL(1)=SUMTC
  NCOL=2
  CALL READ(IUNIT,INO,TNO)
  DO 1100 LT=1,TNO2
1100 TARES(1,LT)=AVARES(1,LT)
  DO 1150 T=1,TNO
    IF (AVARES(1,T).GT.0) THEN
      ST=T
      GO TO 3030
    ENDIF
1150 CONTINUE
  WRITE(6,1200)
1200  FORMAT(2X,'ALL AVARES IS NEGA')
  GO TO 9997
C *****
3030 TNOM1=TNO-1
  N=1
  SIGN(N,1)=ST
  TAVA=0
  DO 3050 T=ST,TNOM1
    IF (((AVARES(1,T).LT.0).AND.(AVARES(1,T+1).GT.0)).OR.
1 ((AVARES(1,T).GT.0).AND.(AVARES(1,T+1).LT.0))) THEN
      SIGN(N,2)=T
      SIGN(N,3)=TAVA+AVARES(1,T)
      TAVA=0
      N=N+1
      SIGN(N,1)=T+1

```

```

C
      IF (T.EQ.TNOM1) THEN
          SIGN(N,2)=T+1
          SIGN(N,3)=TAVA+AVARES(1,T+1)
      ENDIF

                                          ELSE

          TAVA=TAVA+AVARES(1,T)
          IF (T.EQ.TNOM1) THEN
              SIGN(N,2)=TNO
              SIGN(N,3)=TAVA+AVARES(1,T+1)
          ENDIF
      ENDIF
3050  CONTINUE
C      WRITE(6,3020) T,N,((SIGN(N,JJ),JJ=1,3),N=1,4)
3020  FORMAT(2X,'T,N,SIGN123',2I5,4(3F16.2/))
      NT=MOD(N,2)
      IF (NT.EQ.0) THEN
          NT=N
      ELSE
          NT=N-1
      ENDIF
C      WRITE(6,3070) NT
3070  FORMAT(2X,I5)
      IF (NT.LT.2) THEN
          WRITE(6,3075) NT
3075  FORMAT(2X,I5,'NT IS LESS THAN 2')
          GO TO 9997
      ENDIF
C  NT IS THE TOTAL NUMBER OF ROWS
C *****
      IX=12357
3700  CONTINUE
      COUNT=COUNT+1
      IF (COUNT.GT.ICT) THEN
          WRITE(6,3701)
3701  FORMAT(2X,' INCREASE COUNT')
          NCOLM1=NCOL-1
          IF (NCOLM1.GT.1) THEN
              CALL SORT(VAL,NCOLM1)
          ENDIF
C      WRITE(80,4450) VAL(1)
      WRITE(90,4450) VAL(1)
      WRITE(6,3778) VAL(1)
3778  FORMAT(' VAL(1)',F16.2)
          GO TO 9999
      ENDIF
      CALL RANDU(IX,IY,R)
      IX=IY
      R=R*100000
      IR=INT(R)

```

```

C      WRITE(6,3090) IR
3090  FORMAT(2X, 'RANDOM NUMBER', I6)
      DO 3110 IB=1,5
      RA=IR/((10)**(5-IB))
      IRA(IB)=INT(RA)/10.
      IR=IR-INT(RA)*((10)**(5-IB))
3110  CONTINUE
C      WRITE(6,3000) (IRA(IB), IB=1,5)
3000  FORMAT(2X, 5F10.2)
      TEMPO=NT*IRA(1)
      NTEMP1=INT(TEMPO+01.000)
      NTEMP2=MOD(NTEMP1,2)
      IF (NTEMP2.EQ.0) THEN
          NF=NTEMP1
          ELSE
          NF=NTEMP1+1
      ENDIF
C FIND ITEM NUMBER
      TEMPO=INO*IRA(2)
      INUM=INT(TEMPO+01.000)
C FIND THE FROM PERIOD
      TEMP1=SIGN(NF,1)
      TEMP2=SIGN(NF,2)
      TEMPO=(TEMP2-TEMP1)*IRA(3)
      IF (TEMPO.EQ.0) THEN
          TEMPO=-0.001
      ENDIF
      TFROM=INT(TEMPO+01.000)+TEMP1
C      WRITE(6,3145) NF,TEMP1,TEMP2,TFROM,TEMPO
3145  FORMAT(2X, 'NF,TEMP1,2,TFROM,TEMPO',4I5,F16.2)
      IF (SKD(INUM,TFROM).EQ.0) THEN
          DO 3150 II=TEMP1,TEMP2
          IF (SKD(INUM,II).GT.0) THEN
              TFROM=II
              GO TO 3156
          ENDIF
3150  CONTINUE
C FROM PERIOD IS EMPTY
      DO 3175 III=TEMP1,TEMP2
      DO 3175 JJJ=1,INO
          IF (SKD(JJJ,III).GT.0) THEN
              TFROM=III
              INUM=JJJ
              LSQ=IRA(5)*SKD(JJJ,III)
C FIND THE TO PERIOD
          NEM1=NF-1
          TMP1=SIGN(NEM1,1)
          TMP2=SIGN(NEM1,2)
          TMPO=(TMP2-TMP1)*IRA(4)
          IF (TMPO.EQ.0) THEN

```

```

        TMPO=-0.001
        ENDIF
        TTO=INT(TMPO+01.000)+TMP1
        GO TO 3180
        ENDIF
3175 CONTINUE
        GO TO 3700
                                           ELSE
        GO TO 3156
        ENDIF
C
C
C FIND THE DESTINATION PERIOD
C
3156 NFM1=NF-1
        TEMP1=SIGN(NFM1,1)
        TEMP2=SIGN(NFM1,2)
        TEMPO=(TEMP2-TEMP1)*IRA(4)
        IF (TEMPO.EQ.0) THEN
            TEMPO=-0.001
        ENDIF
        TTO=INT(TEMPO+01.000)+TEMP1
C FIND LSQ
        TEMPO=3*IRA(5)
        JJJ=INT(TEMPO+1.000)
        TLP=LP(INUM,1,JJJ)
        IF (TLP.EQ.0) THEN
            TLP=1
        ENDIF
        LSQ1=AVARES(1,TTO)/TLP
        LSQ2=SKD(INUM,TFROM)
        LSQ=AMIN(LSQ1,LSQ2)
C        WRITE(6,3157) AVARES(1,TTO),LSQ1,LSQ2,TTO
3157 FORMAT(2X,'AVA,LSQ1,2,TTO',3F16.2,I5)
3180 CONTINUE
C
C MINUS OCOST
C
        SUM=0
        DO 3200 K=1,3
            TEMP(INUM,1,K)=LSQ*LP(INUM,1,K)
            T1=TFROM+K-1
            IF (TARES(1,T1).LT.0) THEN
                AAA=(-1)*TARES(1,T1)
                BBB=TEMP(INUM,1,K)
C        WRITE(6,3205) AAA,BBB,TARES(1,T1),T1
3205 FORMAT(2X,'AAA,BBB,AVA,T1',3F16.2,I5)
                IF (AAA.LT.BBB) THEN
                    MAABB=AAA
                ELSE

```

```

        MAABB=BBB
        ENDIF
        SUM=SUM+MAABB
    ENDIF
    TARES(1, T1)=TARES(1, T1)-TEMP(INUM, 1, K)
3200 CONTINUE
    OTCOST=SUM*OCOST
C     WRITE(6, 3210) OTCOST, SUM, OTCOST
3210 FORMAT(2X, 'OTCOST, SUM, OTCOST', 3F16.2)
C
C
C PLUS OTCOST
C
C OVERLOAD COST
    J=1
    SUM1=0
    DO 3300 K=1, 3
    TEMP(INUM, J, K)=LP(INUM, J, K)*LSQ
    T1=TTO+K-1
    IF (TARES(J, T1).LT.0) THEN
        SUM1=SUM1+TEMP(INUM, J, K)
    ELSE
        WK=TEMP(INUM, J, K)-TARES(J, T1)
        IF (WK.GT.0) THEN
            SUM1=SUM1+WK
        ENDIF
    ENDIF
C     WRITE(6, 3350) K, TARES(1, T1), PQ, TEMP(INUM, 1, K)
3350 FORMAT(2X, 'K, TARES, PQ, TEMP', I3, 3F16.2)
    ENDIF
3300 CONTINUE
C     WRITE(6, 3400) SUM1
3400 FORMAT(2X, 'SUM1=', F16.2)
    OMCOST=SUM1*OCOST
    DO 3450 LT=1, TNO2
3450 TARES(1, LT)=AVARES(1, LT)
C ADD SETUP COST
C
    TEMPO=SKD(INUM, TTO)
    IF (TEMPO.EQ.0.) THEN
        SCOST=S(INUM)
    ELSE
        SCOST=0
    ENDIF
C
C ADD HOLDING COST
    HOCOST=(TFROM-TTO)*H(INUM)*LSQ
C
C     WRITE(6, 3500) HOCOST, H(INUM), TFROM TTO
3500 FORMAT(2X, 2F16.2, 2I6)
C     WRITE(6, 3550) HOCOST

```



```

3550 FORMAT(2X,'HCOST',F16.2)
C ADD ALL ADDITIONAL COST
C
      TOTCOST=-OTCOST+OMCOST+SCOST+HCOST
C
      IF (NCOL.LT.10) THEN
      ENDIF
3600 VAL(NCOL)=TOTCOST+SUMTC
      NCOL=NCOL+1
C
      IF (NCOL.GT.300) THEN
        CALL SORT(VAL,100)
      II=1
      SVAL=0.00
        DO 3650 I=1,100
          IF (SVAL.NE.VAL(I)) THEN
            IF (II.LE.10) THEN
              VAL10(II)=VAL(I)
              II=II+1
            ELSE
              GO TO 124
            ENDIF
          ENDIF
          SVAL=VAL(I)
3650 CONTINUE
          IF (II.LT.10) THEN
            IIM1=II-1
            DO 3800 III=II,10
3800 VAL10(III)=VAL10(IIM1)
            ENDIF
          124 WRITE(6,3850) (VAL10(II),II=1,10)
3850 FORMAT(' VAL10',10F10.1/)
          DBN=VAL10(4)-VAL10(1)
          IF (DBN.NE.0) THEN
            DB=(VAL10(10)-VAL10(1))/DBN
          ELSE
            WRITE(6,3900)
            GO TO 3960
          ENDIF
          IF (DLOG(DABS(DB)).NE.0) THEN
            ALPHA=DLOG(DFLOAT(3))/DLOG(DABS(DB))
            WRITE(6,3950) ALPHA
3950 FORMAT(' ALPHA',D16.7/)
          ELSE
            WRITE(6,3900)
3900 FORMAT(' ALPHA CAN NOT BE CALCULATED')
            GO TO 3960
          ENDIF
        ELSE
          IF (IBRCH.EQ.0) THEN

```

```

                                GO TO 3700
                                ELSE
                                GO TO 3970
                                ENDIF
ENDIF
IF (ALPHA.GT.(DFLOAT(11)/DFLOAT(10))) THEN
  WRITE(6,4150)
4150  FORMAT(' ALPHA IS LARGER THAN 1.1')
      GO TO 3960
ENDIF
UVAL=0.4266
B=VAL10(1)-1
IF (VAL10(1).GT.3000) THEN
  DICRT=1000
                                ELSE
  DICRT=100
ENDIF
A=B-1000.
DO 4200 I=1,40
IF (A.LT.0) THEN
  GO TO 4250
ENDIF
  CALC=F(A)*F(B)
  IF (CALC.LE.0) THEN
    GO TO 4560
                                ELSE
    A=B-1000.*(I+1)
  ENDIF
4200 CONTINUE
4250 WRITE(6,4300)
4300 FORMAT(' F(A)*F(B) IS POSITIVE')
      WRITE(6,4350)
4350  FORMAT(' BOUNDL::::::::::NULL')
C3960 WRITE(80,4450) VAL10(1)
      WRITE(90,4450) VAL10(1)
      WRITE(6,4500) VAL10(1)
4500  FORMAT(' SMALLEST VALUE AMONG SAMPLE',F16.2)
      GO TO 9999
4560 CONTINUE
      ICOUNT=50
      CALL ZBRENT(F,0.0,3,A,B,ICOUNT,IER)
      BOUNDL=(A+B)/2
      IBRCH=0
      GO TO 4570
9997 CONTINUE
      IBRCH=1
      ISER=1
      DO 4035 I=1,INO
      DO 4030 CT=1,TNO
          SDT=0

```

```

        SX=0
    DO 4050 T=1,CT
        SX=SX+SKD(I,T)
4050    SDT=SDT+DT(I,T)
        E(I,CT)=SX-SDT
        IF (E(I,CT).GT.0) THEN
            ITBL(ISER,1)=I
            ITBL(ISER,2)=CT
            ITBL(ISER,3)=INT(E(I,CT))
            SUME=E(I,CT)
            IF (CT.EQ.TNO) THEN
                ITBL(ISER,4)=0
            ELSE
                CT1=CT+1
                DO 4055 T=CT1,TNO
                    SUME=SUME-DT(I,T)
                    IF (SUME.LE.0) THEN
                        ITBL(ISER,4)=T-CT-1
                        GO TO 4056
                    ENDIF
2055    CONTINUE
                ITBL(ISER,4)=0
4056    CONTINUE
            ENDIF
            ISER=ISER+1
        ENDIF
4030    CONTINUE
4035    CONTINUE
3970    CONTINUE
C GENERATE RANDOM VARIABLE AND INUM AND TFROM
    CALL RANDU(IX,IY,R)
    IX=IY
    R=R*100
    IR=INT(R)
C    WRITE(6,3090) IR
    DO 4600 IB=1,2
        RA=IR/((10)**(2-IB))
        IRA(IB)=INT(RA)/10.
        IR=IR-INT(RA)*((10)**(2-IB))
4600    CONTINUE
        TEMPO=(ISER-1)*IRA(1)
        ISERC=INT(TEMPO+1.0)
        TEMPO=ITBL(ISERC,4)*IRA(2)
        IRSP=INT(TEMPO+1.0)
        INUM=ITBL(ISERC,1)
        TFROM=ITBL(ISERC,2)
        TTO=ITBL(ISERC,2)+IRSP
        IF (TTO.GT.TNO) THEN
            TTO=TNO
        ENDIF

```

```

ITEMP=ITBL(ISERC,3)
TEMP11=FLOAT(ITEMP)
RSQ1=AMIN(SKD(INUM,TFROM),TEMP11)
TTOS=TTO+KSAVE(INUM)-1
TLP=LP(INUM,1,KSAVE(INUM))
IF (TLP.EQ.0) THEN
  TLP=1
ENDIF
RSQ2=AVARES(1,TTOS)/TLP
RSQ=AMIN(RSQ1,RSQ2)
C DECREASE THE HOLDING COST
  DHCOST=H(INUM)*(TTO-TFROM)*RSQ
C ADD THE SET UP COST
  IF (SKD(INUM,TTO).EQ.0) THEN
    ASCOST=S(INUM)
  ELSE
    ASCOST=0
  ENDIF
  TOTCOST=-DHCOST+ASCOST
  GO TO 3600
4570 CONTINUE
  WRITE(90,4450) BOUNDL
4450  FORMAT(F16.2)
  WRITE(6,4750) BOUNDL
4750  FORMAT(' * BOUNDL *',F16.2)
  CALL CLOCK(ID)
  ICPU=IC-ID
  WRITE(6,4800) IC, ID, ICPU
4800  FORMAT(' IC, ID, ICPU',3I5)
C WRITE(80,4450) VAL10(1)
9999 CONTINUE
10000 CONTINUE
C2345 CONTINUE
STOP
END
C *****
  SUBROUTINE READ(IUNIT,INO,TNO)
    INTEGER TNO,T,TNO2
    COMMON/ONE/DT(12,24),SKD(12,24),AVARES(1,26)
    TNO2=TNO+2
    DO 6000 I=1,INO
      DO 6000 T=1,TNO
        READ(IUNIT,6150) DT(I,T)
6000 CONTINUE
C WRITE(6,6050) ((DT(II,IT),IT=1,TNO),II=1,INO)
6050 FORMAT(6(2X,6F10.2/))
      DO 6160 I=1,INO
        DO 6160 T=1,TNO
          READ(IUNIT,6150) SKD(I,T)
6150 FORMAT(F10.2)

```

```

6160 CONTINUE
      WRITE(6,6200) ((SKD(II,IT),IT=1,TNO),II=1,INO)
6200 FORMAT(6(2X,6F10.2/))
      DO 6250 T=1,TNO2
      READ(IUNIT,6300) AVARES(1,T)
6300 FORMAT(F16.2)
6250 CONTINUE
C     WRITE(6,6350) (AVARES(1,IT),IT=1,TNO2)
6350 FORMAT(2(2X,7F16.2/))
      IF (IUNIT.EQ.30) THEN
          IDUM=40
      ELSE
          IDUM=30
      ENDIF
      IT=2*INO*TNO+TNO+2
      DO 6500 II=1,IT
          READ(IDUM,6400) DUMMY
6400 FORMAT(F16.2)
6500 CONTINUE
      RETURN
      END
C *****
      REAL FUNCTION AMIN(AM,BM)
      REAL AM,BM
      IF (AM.LT.BM) THEN
          AMIN=AM
      ELSE
          AMIN=BM
      ENDIF
      RETURN
      END
C *****
      SUBROUTINE SORT(VAL,INO)
C
      REAL VAL(300)
      INOM1=INO-1
      DO 6600 NPASS=1,INOM1
          INOMN=INO-NPASS
          DO 6700 I=1,INOMN
              IF (VAL(I).GT.VAL(I+1)) THEN
                  TEMPO=VAL(I)
                  VAL(I)=VAL(I+1)
                  VAL(I+1)=TEMPO
          C
          C
              ENDIF
          C
          C
6700      CONTINUE
6600 CONTINUE
      RETURN
      END

```

```
C *****  
  REAL FUNCTION F(U)  
  COMMON/TWO/VAL10(10),UVAL  
  DOUBLEPRECISION DENOM,DNUMER  
    DENOM=(VAL10(2)-U)*(VAL10(3)-U)*(VAL10(4)-U)*  
  1      (VAL10(5)-U)*(VAL10(6)-U)*(VAL10(7)-U)*  
  2      (VAL10(8)-U)*(VAL10(9)-U)  
    DNUMER=(VAL10(10)-U)**8  
    F=(DNUMER/DENOM)**UVAL-(VAL10(10)-U)/(VAL10(1)-U)  
  RETURN  
  END  
C$ENTRY
```

APPENDIX C: SHORTEST PATH ALGORITHM

The shortest path algorithm (39) which is applied to the Method B can be described as follows:

Definition 1(Data structure); A data structure B is a pair $B=(K,R)$, where K is a finite set of nodes and R is a finite set of relations on K. The value of a node $k \in K$ is denoted by W_k .

Definition 2(Linear List); A linear list (of length n) is a data structure $B=(K,R)$, where K consists of n nodes and R consists of exactly one relation N and where the nodes of K can be ordered so that $N = \{(K_{i-1}, K_i) \mid 2 \leq i \leq n\}$.

Definition 3(Queue); A queue is a linear list in which nodes can be removed only at the beginning and nodes can be inserted only at the end of the list.

The problem is to find the shortest connection from node g to node j. There is a linear array E of length n with nodes e_1, e_2, \dots, e_n , a queue S, and a number U much larger than any possible distance occurring in the problem. The shortest path algorithm is processed as follows:

1. The value We_i assigns at each point in time the shortest connection from g to i yet found. Thus, $We_i = u$ means that so far no connection from g to i has been found and $We_i = 0$ indicates that i is the

given city, i.e., that $i=g$. So at the beginning $We_i = u$ for $i=g$ and $We_g \neq 0$.

2. If a value i occurs in the queue S , then i can be reached from g by way of a connection of length We_i ; it is then to be determined whether there are possibly shorter connections than any yet found, from g via node i to other nodes j . The queue S initially consists of exactly one node with value g .
3. If a connection of length h , where $0 < h < We_j$, from g to j is found, then We_j is replaced by this value h and j is added to the queue S , as long as j does not already appear in S .
4. For finding new or shorter connections to nodes from g , the value i of the first node of the queue S is always used: since i appears in S , there is a connection from g to i ; each j that can be reached directly from i is considered. Let $h = We_i + \text{direct distance from } i \text{ to } j$; if $h < We_j$, then proceed according to Step 3. After considering all direct connections from i , i is removed from S .
5. The process terminated as soon as the queue S is empty. Each ei with $0 < We_i < u$ means that at this

point in time the shortest distance from g to
 i is We_i .