

Contents

Preface	v
Acknowledgements	ix
PART 1 Introduction	1
Chapter 1 Introduction to Adaptive Memory Programming and Production Planning and Control	3
1.1. Production Planning Control within Integrated Manufacturing Framework	3
1.1.1. Demand management	5
1.1.2. Production planning	6
1.1.3. Master production scheduling	6
1.1.4. Final assembly scheduling	7
1.1.5. Material requirement planning	7
1.1.6. Resource requirement planning and allocation	7
1.1.7. Rough-cut-capacity planning	8
1.1.8. Capacity requirement planning	8
1.1.9. Production control	8
1.1.10. New developments	9
1.2. Conventional Combinatorial Optimization Techniques	10
1.2.1. Optimization algorithms	12
1.2.2. Approximation algorithms or heuristics	12
1.3. Intelligent Optimization Fundamentals	14
1.3.1. Adaptive memory	16
1.3.2. Strategic exploration	17
1.3.3. Intensification	17
1.3.4. Diversification	17

1.3.5. Neighbourhood	18
1.3.6. Move type	18
1.3.7. Solution from constructive methods	19
1.3.8. Generic scheme of an adaptive memory programming	19
1.4. Adaptive Memory Programming	20
1.4.1. Explicit memory versus implicit memory	21
1.4.2. Neural networks	22
1.4.3. Genetic algorithms	24
1.4.4. Tabu Search	24
1.4.5. Ant systems	25
1.5. Hybrid Systems	26
1.6. Summary	29

PART 2 Production Planning and Control Decisions 33

Chapter 2 Production Planning Systems	35
2.1. Introduction	35
2.2. Demand Forecasting	38
2.2.1. Simple moving average	38
2.2.2. Simple regression	41
2.2.3. Simple exponential smoothing	42
2.2.4. Seasonal exponential smoothing	45
2.3. Production Planning	47
2.3.1. Chase strategy	53
2.3.2. Level-production strategy	55
2.3.3. Flexible working hours strategy	57
2.4. Master Production Schedule	59
2.4.1. Calculating the Master Production Schedule (MPS)	60
2.5. Material Requirement Planning (MRP)	63
2.5.1. Material Resources Planning (MRP II)	72
2.6. Resource Requirement Planning and Allocation	75
2.7. Rough Cut Capacity Planning (RCCP)	82
2.8. Capacity Resources Planning (CRP)	83
2.9. Summary	85

Chapter 3	Production Control Systems	90
3.1.	Introduction	90
3.2.	Scheduling in Job Shop Production	92
3.2.1.	Dispatching rules	94
3.2.2.	Nondelay schedules	97
3.3.	Scheduling in Batch Production	103
3.3.1.	Batch sizing	104
3.3.2.	Batch sequencing	105
3.3.3.	Line of balance for batch production scheduling	106
3.4.	Scheduling in Line Flow Production	111
3.4.1.	Curtailed-enumeration algorithm of NEH	113
3.4.2.	Algorithms	115
3.4.3.	Branch and bound technique	119
3.4.4.	A graphical flow-shop manufacturing scheduling system: FSMS	127
3.5.	Scheduling in Assembly Line Production	133
3.5.1.	Line balancing	133
3.6.	Material Management	140
3.6.1.	Purchasing	140
3.6.2.	Process selection	141
3.6.3.	Inventory control	145
3.6.4.	Material handling and storage	145
3.6.5.	Distribution and logistics	145
3.7.	Inventory Control	147
3.7.1.	Lot sizing for independent demand items	147
3.7.2.	Economic order quantity	148
3.7.3.	Economic Production Quantity (EPQ)	150
3.7.4.	Economic Discounts Quantity (EQD)	152
3.8.	Inventory Control Systems	154
3.8.1.	Order point and stockout	155
3.8.2.	Continuous review system	156
3.8.3.	Periodic review system	157
3.8.4.	Periodic Order Quantity (POQ)	159
3.9.	Quality Control	161
3.9.1.	Taguchi method for quality control	163
3.9.2.	Process analysis and control tools	173
3.9.3.	Statistical Process Control (SPC) tools	175

3.9.4. Process control for variables	176
3.10. Summary	180

PART 3 Emerging Optimization Techniques 187

Chapter 4 Artificial Neural Networks 189

4.1. Background to Neural Networks	189
4.2. Learning in Supervised Neural Networks: Delta Rule	193
4.3. Backpropagation Neural Network (BPN)	197
4.4. Self-Organising Map (SOM) Neural Network	201
4.4.1. Neighbourhood	203
4.4.2. Size of Kohonen layer	204
4.4.3. Training coefficient	204
4.5. Adaptive Resonance Theory	204
4.5.1. Basic features of ART network	206
4.5.2. ART1	208
4.5.3. ART2	219
4.6. Hopfield Neural Network	227
4.7. Application of Neural Networks to Machine Tooling and Production Sequencing in Manufacturing Cell Planning	229
4.7.1. Complete tooling changeover: a TSP approach	230
4.7.2. Partial tooling changeover	237
4.7.3. Assembly cell assignment and sequencing	247
4.7.4. Automated turret punch press location and hit sequencing	252
4.7.5. Flow shop sequencing	255
4.7.6. Job shop sequencing	261
4.8. Summary	268

Chapter 5 Genetic Algorithms 273

5.1. Introduction	273
5.1.1. Genetic algorithms versus traditional optimization and search techniques	274
5.2. Fundamentals of Genetic Algorithms	276
5.2.1. Selection	277
5.2.2. Partial bits exchange	278

- 5.2.3. Random bit alteration 281
- 5.3. Manual Simulation of Genetic Algorithms 282
- 5.4. Aggregate Production Planning 286
 - 5.4.1. Mathematical model for aggregate production planning . . 292
 - 5.4.2. Aggregate production planning fundamentals 294
- 5.5. Genetic Algorithms Design Issues 297
 - 5.5.1. Representation: genetic code 298
 - 5.5.2. Initialization 299
 - 5.5.3. Evaluation or score function values 299
 - 5.5.4. Selection and selection 303
 - 5.5.5. Partial bits exchange: mechanism to obtain new solutions 304
 - 5.5.6. Improving partial bits exchange operation 306
 - 5.5.7. Random bit alteration: mechanism to obtain new solutions 307
 - 5.5.8. Replacement strategy 308
 - 5.5.9. Convergence and divergence policies 308
 - 5.5.10. The entropy measure 309
 - 5.5.11. Diversification 309
 - 5.5.12. Preventing loss of solutions 310
- 5.6. Genetic Algorithm Implementation 310
 - 5.6.1. Data structures 310
 - 5.6.2. The genetic algorithm procedures 311
- 5.7. Qualitative Innovations and Improvements 313
 - 5.7.1. Parameter setting 314
 - 5.7.2. Genetic algorithm operation 315
- 5.8. Computational Tests and Results 318
 - 5.8.1. Comparing genetic algorithms with other methods 319
 - 5.8.2. Comparing genetic algorithms with integer linear programming 322
- 5.9. Summary 325

- Chapter 6 Tabu Search 333**
- 6.1. Background to Tabu Search 333
- 6.2. The Dilemma of Hill Climbing 336
- 6.3. Tabu Search Fundamentals 338
- 6.4. Short Term Memory in Tabu Search 339

6.4.1.	Recency-based memory	341
6.4.2.	Tabu tenure	344
6.4.3.	Aspiration criteria	346
6.4.4.	Basic ideas for implementing recency-based memory	347
6.4.5.	Candidate list strategies	349
6.5.	Long Term Memory in Tabu Search	351
6.5.1.	Frequency-based memory	351
6.5.2.	Logical restructuring	354
6.5.3.	Intensification strategies	358
6.5.4.	Diversification strategies	359
6.5.5.	Strategic oscillation	361
6.5.6.	Basic ideas for implementing long term memory	363
6.6.	The Theory of Constraints Product Mix Problem	364
6.6.1.	Labour-based management accounting	364
6.6.2.	Linear programming for the product mix problem	369
6.6.3.	Theory of constraints heuristic for the product mix problem	371
6.6.4.	More on theory of constraints	374
6.6.5.	Revised theory of constraints algorithm for the product mix problem	381
6.7.	Application of Tabu Search to the Product Mix Problem	388
6.7.1.	Initial solution	388
6.7.2.	Move	389
6.7.3.	Neighbourhood size	390
6.7.4.	Tabu list size	391
6.7.5.	Aspiration criterion	391
6.7.6.	Intensification	391
6.7.7.	Diversification	391
6.7.8.	Stopping criteria	392
6.8.	Summary	396
Chapter 7 Ant Systems		401
7.1.	The Ant System Paradigm	401
7.2.	Ant Systems Fundamentals	404
7.2.1.	Pheromone trail or memory	404
7.2.2.	Solutions manipulation	405
7.2.3.	Intensification and diversification	406

- 7.3. FANT: Fast Ant System 406
 - 7.3.1. Memory implementation 407
 - 7.3.2. Provisory solution generation 408
 - 7.3.3. Improvement procedure 411
 - 7.3.4. Memory updates 414
 - 7.3.5. Intensification strategies 417
 - 7.3.6. Diversification strategies 417
- 7.4. HAS: Hybrid Ant System 418
 - 7.4.1. Memory implementation 420
 - 7.4.2. Provisory solution generation 420
 - 7.4.3. Improvement procedure 421
 - 7.4.4. Memory update 421
 - 7.4.5. Intensification 422
 - 7.4.6. Diversification 422
- 7.5. The FANT Simulator 422
 - 7.5.1. FANT data structures 423
 - 7.5.2. FANT algorithms 424
- 7.6. HAS Simulator 428
- 7.7. Application of FANT to Flow Shop Scheduling: 1-Criterion 429
 - 7.7.1. Flow shop scheduling 429
 - 7.7.1.1. Graphical method for flow shop scheduling 433
 - 7.7.1.2. Heuristic methods for flow shop scheduling 441
 - 7.7.1.3. Performance measures for flow shop scheduling 445
 - 7.7.1.4. FANT simulator output for flow shop scheduling 446
- 7.8. Application of FANT to Flow Shop Scheduling: Bi-Criteria 464
 - 7.8.1. Mathematical formulation of the bi-criterion flow shop problem 466
 - 7.8.2. Daniels and Chambers heuristic for the bi-criteria problem 467
 - 7.8.3. Ant System-based Heuristic (ASH) for the bi-criteria problem 468
- 7.9. Summary 475

Chapter 8 Simulated Annealing	487
8.1. Simulated Annealing Paradigm	487
8.2. Monte Carlo Model for Simulating Physical Annealing	490
8.3. Analogy Between Physical and Simulated Annealing	492
8.4. Cooling Schedule Classifications for Simulated Annealing Schemes	495
8.4.1. Step-wise temperature reduction scheme	496
8.4.2. Continuous temperature reduction scheme	498
8.4.3. Non-monotonic temperature reduction scheme	499
8.5. Neighbourhood Search Techniques	500
8.5.1. Random search	500
8.5.2. Systematic search	501
8.6. Production Layout Strategies	501
8.6.1. Fixed-position layout	505
8.6.2. Process-based layout	506
8.6.3. Product-based layout	507
8.6.4. Group technology layout	507
8.7. Production Layout Planning	513
8.7.1. Determining part families	513
8.7.2. Cell formation	514
8.7.3. Rationalization of part families and workloads	533
8.7.4. Selecting the type of cell layout	533
8.7.5. Layout machines and auxiliary facilities in cell	536
8.8. Application of Simulated Annealing to Cell Formation	537
8.8.1. Problem representation	537
8.8.2. Transition mechanism	537
8.8.3. Cooling schedule	538
8.8.4. The simulated annealing algorithm	539
8.9. Summary	547
Chapter 9 Programming Techniques	553
9.1. Data Structure	554
9.2. Modular Design	557
9.3. Simple Tabu Search Run	573
9.4. Summary	584

Appendix	587
A. Pascal Fundamentals	587
A.1. Putting Pascal fundamentals to use	602
A.2. Getting something from Pascal fundamentals	606
A.3. Summary	608
B. A Simple Tabu Search in Pascal	608
Author Index	625
Subject Index	629