
Task scheduling of multiple industrial robots through constraint programming

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Abstract

Keywords: key word

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Contents

1	Introduction	7
1.1	Background	7
1.2	Problem specification	8
1.2.1	The setup	8
1.3	Related work	8
1.4	Report structure	8
2	Approach	9
2.1	Constraint Programming	9
2.1.1	Constraints	9
2.1.2	Global constraints	11
2.1.3	Solver	11
2.1.4	Reified	12
2.2	Job-shop scheduling problem	12
2.2.1	Flexible job-shop scheduling problem	12
2.3	MiniZinc	12
2.4	Solvers	12
2.4.1	G12	12
2.4.2	JaCoP	12
2.4.3	Gecode	12
2.4.4	OR-tools	12
2.4.5	Opturion CPX	12
2.4.6	Choco3	12
3	Model	13
3.0.7	Constraints	13
4	Assembly	15
5	Evaluation	17

6 Discussion	21
7 Conclusions	23
7.1 Further work	23
Bibliography	25
Appendix A Model	29
A.0.1 Model variables	29
A.0.2 Variables	29
A.1 Filter	37
A.1.1 Temporal filter	37
A.1.2 Predecessor filter	41
A.2 Constraints	44
A.2.1 Precedences	45
A.2.2 Predecessors	47
Appendix B Tool Manuals	49

Chapter 1

Introduction

1.1 Background

More and more of the production in today's society is getting automated. Manufacturers want to cut cost and make the production more effective by eliminating the human work and replace it with robots. But there are drawbacks; robots are expensive and robots does not have the versatility of a human. This puts pressure on the robot manufacturers to develop robots that are more versatile. Thus eliminating the need for manufacturers to have multiple robots to do multiple tasks and thereby lowering costs. And also by making the robots more versatile the close the gap of what a human and robots are able to do.

Current robot setups usually have one robot performing one task all the time, as oppose to flexible robots which will be performing many different tasks and assemblies. This poses the demand for the scheduling of such robots to be flexible as well. A scheduling of a robot can be a time consuming task. Since manufacturers want as effective assemblies as possible, it can take from days to weeks to perfect an assembly schedule. This is not feasible if you want to use the robot for many different tasks and assemblies. In this thesis we would like to try and automate this scheduling process in order to cut down on the scheduling time. To accomplish this we will be using Constraint programming, as it provides a general interface to solve problems without needing to build a complete framework from scratch. Also, scheduling is a classical constraint problem, thus constraint programming suits this problem well.

One of those robots are ABB's robot YuMi®(formerly known as FRIDA). YuMi®is a dual armed robot made to work along side humans and able to perform the some of the most complex tasks, such as mount a nut or thread a needle.[1] It accomplishes this by using a wide variety of sensors, e.g. force sensor, visual sensors, etc. Usually robot replaces humans to perform dangerous or heavy tasks, YuMi®is mainly designed for small parts assembly, i.e. usually humans roles in todays manufacturing environment.

1.2 Problem specification

1.2.1 The setup

What does our problem look like

1.3 Related work

[brucker 2009] mentions the solving of 15x15 benchmark(15 jobs with 15 operations) being solved without heuristics (although not necessarily in CP).[2]

[Thörnblad] concludes that when a cell is part of an assembly flow, the use of targeting due dates is to prefer. Because makespan can exacerbate an already unreliable flow. The assembly we perform is not a part of a flow, and such we do not concern ourselves with maintaining a stable flow through the cell, but only to optimize the assembly in the cell.[7]

[Garey] shows that job shop problems for size $m \geq 2$ and $n \geq 3$ are NP-complete [4]

[yuan] says pure CP is only effective on small problems of FJSP. To effectively perform larger sizes, methods such as discrepancy search, large neighborhood search(LNS) or iterative flattening search. It also shows LNS together with Hybrid Harmonic Search produces good results.[12]

[ejenstam] [andra test med solvers]

1.4 Report structure

Chapter 2

Approach

2.1 Constraint Programming

Constraint programming is a *declarative* paradigm. This means that in contrast to *imperative* paradigm languages, such as C or Java, the focus of solving problems using constraint programming is on specifying the solution and not the algorithm to solve it. This is done by specifying the solution using *domain variables*, or simply variables, and *constraints*. Variables have a domain of values, meaning they can represent each value in their domain. Variables can often be, depending on language and solver, either integers, floating-points, boolean or symbolic, symbolic being a text or label. For example a symbolic variable representing a week would have the domain $\{Monday, Tuesday, Wednesday, Thursday, Friday, Saturday, Sunday\}$.

2.1.1 Constraints

Constraints are set up as relationships between the variables, and thereby limiting the domains of the variables. Integer domains are often used for variables, so for the rest of this section we will assume variables have integer domains. For this domain the following function symbols can be used: $+$, \times , $-$ and \div . The constraint relation symbols are $=$, $<$, \leq , $>$, \geq . Together with the function symbols and the constraint relation symbols, one can create simple constraint, called *primitive constraints*. An example of a primitive constraint is $X < Y$, i.e. the values in X 's domain has to lower than in Y 's. Primitive constraints can be used to create more complex constraints using the conjunctive connective \wedge . An example of this is $X < Y \wedge Y < 10$, i.e. Y has to be less than 10 and X has to be less than Y . Since all constraints has to hold when the model is evaluated, all constraints are joined in a conjunction.(?) The disjunctive connective \vee is also available and can be used in the same way as \wedge . In some cases the logical implications; reverse implication (\leftarrow), forward implication (\rightarrow) and bi-implication (\leftrightarrow) are also available. Here, for example, the

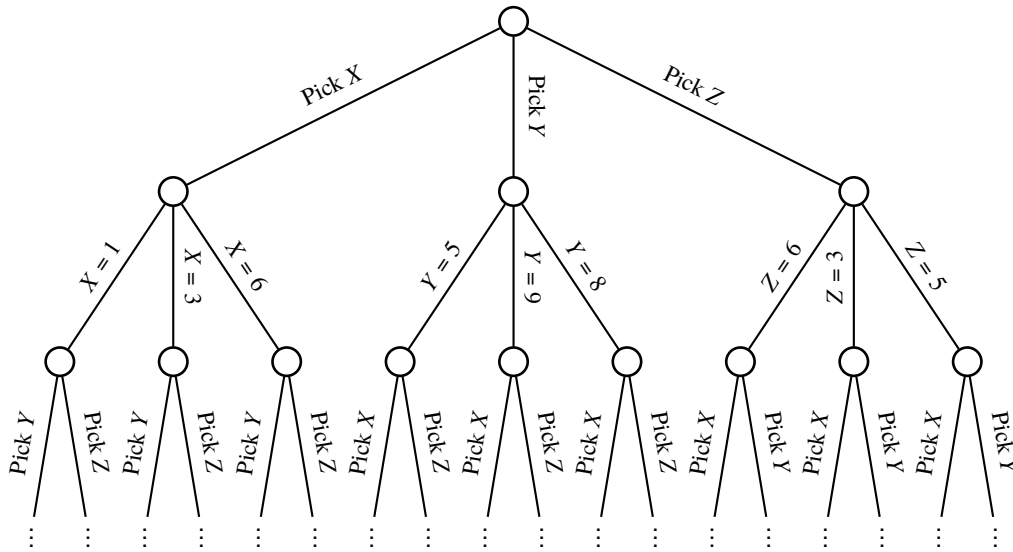


Figure 2.1: The beginning of the search space for the variables X , Y , Z , where $X = \{1, 3, 6\}$ $Y = \{5, 9, 8\}$ $Z = \{6, 3, 5\}$

implication works by taking two logical statement and if the first one evaluates to *true* the other statement should hold as well. For example $X = 0 \rightarrow Y > 5$ says that if $X = 0$ then Y should be larger than 5.

For example, we have a problem with the variables x and y . $x = 4$ and $y = \{1..10\}$. Here the x has the value 4 and can thereby only assume the value 4. y on the other hand can assume the values 1 to 10. This means a solution to this problem can be $x = 4$ and $y = 1$ or likewise $x = 4$ and $y = 5$, they are equally correct. On this problem we can impose a constraint, for example $y > x$. Now we have set the constraint that y needs to be larger than x . And since x has a fixed known value we can directly see that $y > 4$, since $x = 4$. Now with this constraint, we can get rid of the lower part of y 's domain and now $y = \{5..10\}$ instead. And now a viable solution can be $x = 4$ and $y = 7$, but not $x = 4$ and $y = 3$.

2.1.2 Global constraints

AllDifferent

Circuit

Cumulative

Global_Cardinality

2.1.3 Solver

A constraint programming program is consisting of many of these constraints and variables. When the solution is specified in a model, a *solver* runs the model. The goal of the solver is to satisfy all the constraints, i.e. set the domains of the variables so that they all follow the relationships of the constraints. This is called the *constraint satisfaction problem*, and can be defined as a triple $\langle Z, D, C \rangle$. $Z = \{x_1 \dots x_n\}$ is a finite set of all the variables in the solution, $D(x_i)$, $x_i \in Z$ is a set representing the domain of values the variable x_i can assume, C is the set of constraints imposed on the variables in Z . The solver accomplishes this by doing a *search* on the space of possibilities, i.e. the *search space*. The search space is in the form of a tree, where each branch is a selection of a variable where the variable's domain is reduced into a smaller subset that conforms with the constraints. The solver traverses the tree in search for a solution. When all variables are set to conform with the constraints a solution is found. If the solver reaches a node where a variable's domain becomes empty, it has to *backtrack* to a previous node from which it can choose a new variable to set, i.e. traversing a new branch of that node.

[8] [5] [6]

2.1.4 Reified

2.2 Job-shop scheduling problem

2.2.1 Flexible job-shop scheduling problem

2.3 MiniZinc

2.4 Solvers

2.4.1 G12

2.4.2 JaCoP

2.4.3 Gecode

2.4.4 OR-tools

2.4.5 Opturion CPX

2.4.6 Choco3

Chapter 3

Model

The most important parts of the model

This model is based on/inspired by the model in [ejenstam]. That model is centered around work performed in fixtures. So tasks can easily be labeled *tray* if it uses a tray, *fixture* if it uses a fixture, etc. This is common robot cell assembly procedures; take a component from a tray, put it in a fixture, get another component, mount the component on the the component in the fixture. But YuMi can perform much more complex tasks than that. We want to be able to schedule mounting tasks that does not incorporate a fixture. We have used a similar way of generalizing tasks by labeling them with *tray*, *fixture*, etc. but extended it.

Model

Variables

The solver takes a description of the robot cell in the form of a MiniZink data file. The file describes; the number of arms available, the tools available, the trays available, the fixtures available, etc. Here on after called *Cell Variables*. It also sets up a number of *Decision Variables* which contains a set of values from which each *Decision Variable* can take.

3.0.7 Constraints

In this section some of the most important constraints for the model will be described. For a full list of used constraints see *Appendix A*, for the MiniZink code see *Appendix B*.

Chapter 4

Assembly

Describing our assembly

Chapter 5

Evaluation

The evaluation of the model

G12

Filter	Pred & Dom		Pred		Dom		None	
Version	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1
Time (ms)	-	-	-	-	-	-	-	-
# of integer variables	174	292	174	313	154	269	154	290
# of boolean variables	162	97	162	97	142	106	142	106
# of arrays	32	46	32	46	30	44	30	44
# of constraints	2555	584	1018	584	2248	558	711	558
% refeed	7.16%	15.92%	17.97%	15.92%	7.25%	17.02%	22.92%	17.02%

JaCoP

Filter	Pred & Dom		Pred		Dom		None	
Version	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1
Time (ms)	635	-	1139619	-	-	-	-	-
# of integer variables	129	223	129	244	129	229	129	250
# of boolean variables	42	27	42	27	42	27	42	27
# of arrays	31	46	31	46	29	43	29	43
# of constraints	2318	425	781	425	2046	416	509	416
% refeed	2.71%	6.35%	8.06%	6.35%	3.07%	6.49%	12.37%	6.49%

Gecode

Filter	Pred & Dom		Pred		Dom		None	
Version	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1
Time (ms)	-	21	-	74019	-	65	-	73496
# of integer variables	129	223	129	244	129	250	129	450
# of boolean variables	42	27	42	27	42	27	42	27
# of arrays	31	50	31	50				
# of constraints	2316	421	779	421	1046	416	509	415
% refeed	2.72%	6.14%	8.08%	6.41%	3.07%	6.49%	12.37%	6.5%

or-tools

Filter	Pred & Dom		Pred		Dom		None	
Version	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1
Time (ms)	257	!	672	!	564	!	600	!
# of integer variables	129	223	129	244	129	229	129	250
# of boolean variables	42	27	42	27	42	27	42	27
# of arrays	31	50	31	50	29	43	29	43
# of constraints	2316	421	779	421	2046	416	509	416
% refeed	2.72%	6.41%	8.08%	6.41%	3.07%	6.49%	12.37%	6.49%

Opturion CPX - no warm start

Filter	Pred & Dom		Pred		Dom		None	
Version	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1
Time (ms)	25163591	!	-	!	7332356	!	-	!
# of integer variables	28736	9530	28736	28875	28716	9507	28716	28852
# of boolean variables	57284	18654	57284	57322	57264	18702	57264	57370
# of arrays	32	4694	32	14366	30	28209	30	14382
# of constraints	102519	33021	100982	100675	102212	33024	100675	100678
% refeed	55.91%	56.26%	56.76%	56.86%	56.06%	56.24%	56.92%	56.85%

Opturion CPX - warm start

Filter	Pred & Dom		Pred		Dom		None	
Version	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1
Time (ms)	26318399	!	-	!	7231907	!	-	!
# of integer variables	28736	9530	28736	28875	28716	9507	28716	28852
# of boolean variables	57284	18654	57284	57322	57264	18702	57264	57370
# of arrays	32	4694	32	14366	30	28209	30	14382
# of constraints	102519	33021	100982	100675	102212	33024	100675	100678
% refeed	55.91%	56.26%	56.76%	56.86%	56.06%	56.24%	56.92%	56.85%

Choco3

Filter	Pred & Dom		Pred		Dom		None	
Version	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1	1.6	2.0.1
Time (ms)	-	-	-	-	-	-	-	-
# of integer variables	129	223	129	244	129	229	129	250
# of boolean variables	42	27	42	27	42	27	42	27
# of arrays	31	50	31	50	29	43	29	43
# of constraints	2316	421	779	421	2046	416	509	416
% refeed	2.47%	6.41%	8.08%	6.41%	3.07%	6.49%	12.37%	6.49%

Chapter 6

Discussion

The discussion of the results

Concurrent tasks vs. en task med två maskiner. Två tasks ger mer generella constraints, man kan säga att all tasks tar upp en maskin alltid och att man begränsar det med ett constraint att vissa måste ske samtidigt. Man kan ha constraintet att alla tasks kan ha en predecessor. En task gör att man måste kunna säga att tasks kan ta upp till så många maskiner som finns tillgängliga -> fler constraints. Man måste kunna säga att en task ska kunna ha flera predecessors -> fler constraints.

Chapter 7

Conclusions

The conclusions

7.1 Further work

I [ejenstam] kommer de fram till att local search fungerar dåligt.[3] [yuan 2013] menar de att Large neighborhood Search (LNS) tillsammans med Hybrid Harmony Search (HHS) fungerar mycket väl med flexible job shop problem och löser problemet med begränsningen för CP vid dessa problem.[12] Kan vara värt att titta vidare på

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Appendices

Appendix A

Model

Beskriv grunder i hur modellen fungerar There are moves put inbetween each task Model doesn't deal with coordinates only times for movement between tasks The data used by the model can be generated using tools described in [appendix ??] The move time depends on if there is a change between the tasks, if there is a task, the change will be longer than usual.

Terminology:

The goal for the assembly is to assemble components. This is components fed to the assembly from the outside, for example button components. The final assembly is the complete assembly of components that make the final product. All the smaller assemblies before that are called sub-assemblies. For reasons explained further down, we will in this thesis call components such as buttons for *primitive* components instead of just components.

A.0.1 Model variables

A.0.2 Variables

Static variables

Static variables are variables that have a fixed value, or is a set or list containing fixed values.

$$nbrTasks \in \{1, \dots, 2^{32} - 1\} \quad (A.1)$$

$$tasks = \{1, \dots, nbrTasks\} \quad (A.2)$$

First we define the number of tasks to be scheduled. Each task is identified

As mentioned, this model is based on the technique of using predecessors to determine which task comes directly before another. This creates the need to have source and a sink

node for each machine, we call them start tasks and goal tasks. As they are not provided as parameters, the model creates them and give them identifiers with numbers above the tasks to be scheduled. As seen later, this is a convenient way of numbering these tasks.

$$startTasks = \{nbrTasks + 1, \dots, nbrTasks + nbrMachines\} \quad (A.3)$$

As sources, the start tasks are the predecessors to the first tasks for each machine.

$$goalTasks = \{nbrTasks + nbrMachines + 1, \dots, nbrTasks + nbrMachines \times 2\} \quad (A.4)$$

As sinks, the goal tasks has the last task as predecessor for each arm.

$$allTasks = tasks \cup startTasks \cup goalTasks \quad (A.5)$$

We group together all tasks in one set in order for a more readable notation further down.

$$nbrMachines \in \{1, \dots, 2^{32} - 1\} \quad (A.6)$$

$$machines = \{1, \dots, nbrMachines\} \quad (A.7)$$

Here we define the machines available for the assembly. A machine in this model is an arm.

$$nbrTools \in \{1, \dots, 2^{32} - 1\} \quad (A.8)$$

$$tools = \{1, \dots, nbrTools\} \quad (A.9)$$

$$toolNeeded(t) \in tools, t \in tasks \quad (A.10)$$

These are the tools that can be fitted on an arm. The model assumes that there is a set of $nbrTools$ for each machine. I.e. if $nbrTools = 2$ and $nbrMachines = 2$, there is a set of tool 1 and tool 2 for machine 1, and another set of tools 1 and 2 for machine 2. There cannot be a combination of tools such as, for example, only tool 1 for machine 1 and a set of tools 1 and 2 for machine 2.

$toolNeeded(t)$ defines the tool task t needs.

$$nbrComponents \in \{1, \dots, 2^{32} - 1\} \quad (A.11)$$

$$components = \{1, \dots, nbrComponents\} \quad (A.12)$$

$$componentsUsed(t) \subset components, t \in tasks \quad (A.13)$$

$$componentCreated(t) \in components \cup \{0\}, t \in tasks \quad (A.14)$$

$nbrComponents$ defines the number of components used. All components needs to be uniquely identified in the assembly, so even if we use 4 screws in an assembly, we need to define all 4 screws. As mentioned before we distinguish between components and *primitive* components. The reason for that is that in the model we do not distinguish between a *primitive* component and a sub-assembly, they are the same. And in the model we call them components. The reason for this is because we found it easier to only have one sort of object to deal with when it comes to what will be assembled, instead of two. This means that the final assembly is also a component, i.e. the product produced by the assembly is

a component. In other words, in this thesis *primitive* components and sub-assemblies are sub sets of components.

$componentsUsed(t)$ defines the set of components task t uses. A task usually only uses one component at a time, but uses two in the case of mounting tasks, the mounted component and the component mounted on.

To know when a sub-assembly is created we set is as $componentCreated$ for the task where it is created. This cannot happen anywhere else other than at a mount task, although there is no check in the model for it. If there is not component created at a task, $componentCreated = 0$

Since components also can be sub-assemblies, it means a component can have subcomponents. These have been grouped in different groups to assist the constraints.

$$taskSubComponents(t) \subset components, t \in tasks \quad (A.15)$$

$taskSubComponents(t)$ is the set of components that make up the subcomponents for the components used in task t . One can think of the subcomponents as layers with the component on top, call it origin component, and the layer below are the components that make up that component, and so on. $taskSubComponents(t)$ contains the components one layer down, if the component itself is not a *primitive* component. In that case, $taskSubComponents(t)$ contains that component instead.

$$taskCompleteSubComponents(t) \subset components, t \in tasks \quad (A.16)$$

To use the layer metaphor again, $taskCompleteSubComponents(t)$ contains all the layers below the origin component, for all the components in task t . Not including the origin components themselves. If the origin component is a *primitive* component, the set is empty.

$$subComponents(c) \subset components, c \in components \quad (A.17)$$

$subComponents(c)$ contains only the the *primitive* subcomponents for component c , one layer down. If c is a *primitive* component or is only made of sub-assemblies, the set is empty.

$$nbrTrays \in \{1, \dots, 2^{32} - 1\} \quad (A.18)$$

$$trays = \{1, \dots, nbrTrays\} \quad (A.19)$$

$$tray(t) \in trays \cup \{0\}, t \in tasks \quad (A.20)$$

The trays available in the assembly, $trays$. Trays are used to hold components until we need them in the assembly. This can be that the tray holds the components from the beginning, as with *primitive* components fed to the assembly, or it can be a sub-assembly put there during the assembly to be picked up again later. Each *primitive* component has its own tray, so we can have a button tray, a cover tray, etc.

$tray(t)$ is the tray task t uses. If no tray is used by the task, $tray(t) = 0$.

$$nbrFixtures \in \{1, \dots, 2^{32} - 1\} \quad (A.21)$$

$$fixtures = \{1, \dots, nbrFixtures\} \quad (A.22)$$

$$fixture(t) \in fixtures \cup \{0\}, t \in tasks \quad (A.23)$$

fixtures defines the fixtures available in the assembly. A fixture is primarily used to hold a component in order for another component to be mounted on that component. Although, as will be shown in the assembly example [section?], the fixture can be used for purposes than just holding components.

fixture(t) is the fixture task *t* uses. If no fixture is used by the task, *fixture(t)* = 0

$$nbrOutputs \in \{1, \dots, 2^{32} - 1\} \quad (A.24)$$

$$outputs = \{1, \dots, nbrOutputs\} \quad (A.25)$$

$$output(t) \in outputs \cup \{0\}, t \in tasks \quad (A.26)$$

outputs defines the outputs available. An output is the final stage for a component in an assembly. After it is put here, it will not be removed. Although, there can still be other components mounted on the component put on the output. In that respect an output can be viewed as a fixture, only that the components put there can not be removed.

output(t) is the output used by task *t*. If no output is used by the task, *output(t)* = 0.

$$nbrConcurrentGroups \in \{1, \dots, 2^{32} - 1\} \quad (A.27)$$

$$concurrentGroups = \{1, \dots, nbrConcurrentGroups\} \quad (A.28)$$

$$concurrentTasks(k) \subset tasks, k \in concurrentGroups \quad (A.29)$$

concurrentTasks(k) is the *k*:th concurrent group among the concurrent groups defined. A concurrent group is a group of tasks that has to be performed at the same time. Hence, a concurrent group can not be larger than the amount of machines available, although, there is no check for it in the model.

The *k* set of tasks needing concurrent execution *nbrConcurrentGroups* defines the number of concurrent groups used.

$$nbrOrderedGroups \in \{1, \dots, 2^{32} - 1\} \quad (A.30)$$

$$orderedGroups = \{1, \dots, nbrOrderedGroups\} \quad (A.31)$$

$$orderedGroup(k) \subset tasks, k \in orderedGroups \quad (A.32)$$

$$ordered(k, i) \in tasks, i \in \{1, \dots, |orderedGroup(k)|\}, k \in orderedGroups \quad (A.33)$$

$$orderedSet = \bigcup_{\forall k \in orderedGroups} ordered(k), orderedSet \subset tasks \quad (A.34)$$

orderedGroup(k) is the *k*:th ordered group specified, there are *nbrOrderedGroups* ordered groups. An ordered group is an array of tasks that has to come in a very specific order. An example of this could be if an assembly has many move tasks that needs to be performed one after another in order to make an intricate movement. As will be showed in the constraints[section?], we can reason the relation between tasks if they use a certain component and are a certain kind of action. But we can not reason using two move tasks, there is no way to tell which should come before the other based on the component they use.

$orderedGroup(k)$ is an array and the tasks in it will be scheduled in the order they com in the array. All the tasks in the group will be performed on the same machine, it can not order tasks on different machines.

If one wants to access a certain task in a group, one can use $ordered(k, i)$ to access the i :th element of the k :th group.

$orderedSet$ is the set of all tasks included in an ordered group.

$tray(t)$, $output(t)$ and $fixture(t)$ can not be set at the same time for a task, since that would mean the task is performed at two locations at the same time, although this is not checked by the model. The only restriction for what kind of tasks can be performed using these are that output can not be used by a take task and tray can not be used by a mount task. If ones assembly contains these combinations, the output or tray should be changed to a fixture.

$$mounting \subset tasks \quad (A.35)$$

$$taking \subset tasks \quad (A.36)$$

$$moving \subset tasks \quad (A.37)$$

$$putting \subset tasks \quad (A.38)$$

Each task performed can be classified as either a mount task, a take task, a move task or a put task, but only one of them.

Taking A task that picks up a component is a taking task. The location of the component is specified by either a tray or a fixture, but not an output since there is no reason to pick up something that has been placed on an output.

Mounting A task that mounts a component on another component is a mounting task. This assumes that the component to mount is picked up and in the hand. The location of the component to mount on is defined by either a fixture or an output.

Putting A task that puts a component somewhere is a putting task. Where a component is put is defined by either a fixture, a tray or an output.

Moving A task that moves a components from one place to another is a moving task. The model already puts in moves between tasks and if, for example, the first task is a take task and the second task is a put task, the move in between them is essentially a move that moves a component from one place to the another. Although, sometimes it can be handy to define a task that explicitly moves a component. An example of that can be if one wants to spin a component around. Then one can specify a take task in order to pick up the component, a move task to turn it, and a put task to put the component back. In this case there will be three moves of the component; one to move from the take task to the move task, the move task itself, and a move from the move task to the put task.

$$putting(c) \subset putting, c \in components \quad (A.39)$$

$$mounting(c) \subset mounting, c \in components \quad (A.40)$$

$$taking(c) \subset taking, c \in components \quad (A.41)$$

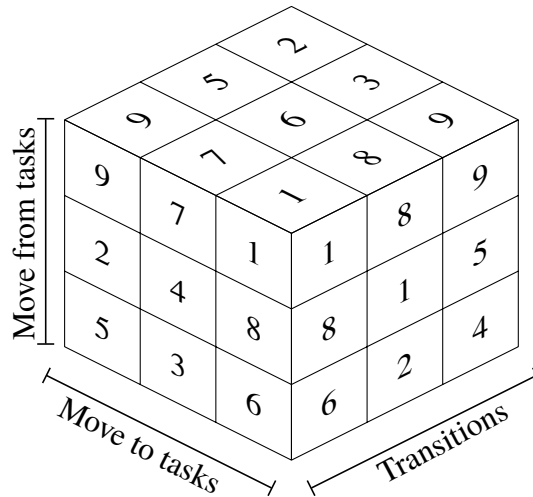


Figure A.1: The timeMatrix3D

$$moving(c) \subset moving, c \in components \quad (A.42)$$

putting(c), *mounting(c)*, *taking(c)* and *moving(c)* are subsets of respective set above based on the component involved.

$$duration(t) \in \{0, \dots, 2^{32} - 1\}, t \in tasks \quad (A.43)$$

duration(t) is simply the duration of task *t*.

For the model to decide how long a move between two tasks should be and if there should be a change of tool in between, a matrix is used, *timeMatrix3D*, see figure A.1. This is a 3-dimensional matrix and contains the times for moving between all the tasks depending on what tool change occurs. On its y-axis it has the tasks to move from, on the x-axis the tasks to move to, and on the z-axis the different transitions between tools that can occur.

$$timeMatrixDepth = \frac{n^2 - n + 2}{2}, n = nbrTools \quad (A.44)$$

$$\begin{aligned} timeMatrix3D(t(from), t(to), k) &\in \{0, \dots, 2^{32} - 1\}, \\ t(from) &\in tasks \cup startTasks, \\ t(to) &\in tasks, k \in \{0, \dots, timeMatrixDepth\} \end{aligned} \quad (A.45)$$

timeMatrixDepth is the length of the z-axis, i.e. the depth of the matrix. It should be said that the reason for using the method described below is to reduce the size of the matrix and avoid too much redundancy.

What we mean with "different transitions" is easiest to show through an example. Lets say we have 3 tools available for each machine. We consider each tool state as a node in a graph, see figure A.2, with the old tool state to the left and the new tool state to the right. Between them we can draw the different ways we can change state. The we start to consider which ones we actually need. We can change from tool 1 to tool 1, which is not changing tool at all. The same can be done for tool 2, but not changing tool here costs just as much time as with tool 1. So the change from tool 1 to itself covers not changing tool for this tool, as well as for all the other tools, thereby we only need to keep track of one of

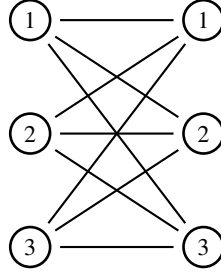


Figure A.2: All the transitions between the tool states

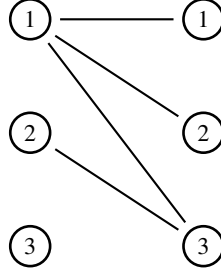


Figure A.3: The reduced number of transitions between the tool states

these changes. We can also change from tool 1 to tool 2. And we can change back from 2 to 1, although here in the model we assume the change from one tool to another takes the same time the other way around as well. Therefore, we consider the change from tool 1 to tool 2 the same as from tool 2 to tool 1, and only keep track of one of them. If we keep consider the rest of the transitions this way, we will end up with a reduced number of transitions, in our case 4, see figure A.3

It has been observed that using the reasoning above, *timeMatrixDepth* follows the function A.44.

$$taskOutOfRange(m) \subset tasks, m \in machines \quad (A.46)$$

Depending on the physical layout of the assembly, sometimes not all tasks can be done with all machines. It could be that the machines would collide or simply that the spatial location is out of reach for the machine. In those cases we can specify tasks are out of hand for a specific machine. This is the only time when we distinguish between the two machines and connect the machine in the model model with the machine in the real world. In all other aspects other than this the machines in the model are identical and has the potential perform the same work.

Decision variables

Decision variables are variables that can take on many values. It is these values that the solver set out to determine in order to solve the problem.

$$usingMachine(t) \in machines, t \in tasks \quad (A.47)$$

The model has to decide which task uses which machine.

$$pred(t) \in allTasks, t \in allTasks \quad (A.48)$$

Each task has a predecessor that tells the model what other task comes right before the task in question on the same machine.

$$\begin{aligned} maxE = & (max(\{duration(t) : t \in tasks\}) + \\ & max(\{timeMatrix3D(t_1, t_2, k) : \\ & \quad \forall t_1 \in tasks \cup startTasks, \\ & \quad \forall t_2 \in tasks, \\ & \quad \forall k \in \{0, \dots, timeMatrixDepth\}\}) \times nbrTasks \end{aligned} \quad (A.49)$$

In order to create an upper limit for variables dealing with time, we create a rough upper limit of the complete assembly. It simply takes the longest duration for a task and the longest duration for a move between tasks and assert it for all the tasks.

$$start(t) \in \{0, \dots, maxE\}, t \in allTasks \quad (A.50)$$

$$end(t) = start(t) + duration(t), t \in allTasks \quad (A.51)$$

Each task has to start have a start time. We set it to be anywhere between time 0 and the maximum possible end calculated before.

To simplify notation we also introduce one more variable called $end(t)$. It is the time when task t ends and is simply the sum of the start and the duration of the task.

$$moveDuration(t) \in \{0, \dots, maxE\}, t \in allTasks \quad (A.52)$$

$$moveStart(t) \in \{0, \dots, maxE\}, t \in allTasks \quad (A.53)$$

$$moveEnd(t) = moveStart(t) + moveDuration(t), t \in allTasks \quad (A.54)$$

As mentioned before, each task has a move time connected to it since it takes a certain amount of time to move from one task to another. Since this time depends on both what task comes before it and what tools is needed for both of the tasks, the duration for the move is a decision variable as opposed to the duration for the task itself.

$$makespan \in \{0, \dots, maxE\} \quad (A.55)$$

Since the goal of the assembly is to complete the assembly in as little time as possible, we set up a variable for it, $makespan$. It is this variable the solver will try to minimize.

$$toolUsed(t) \in tools, t \in allTasks \quad (A.56)$$

The last variable is for determine what tool should be used for a task. With $toolNeeded$ we specify what tool is needed for the specific task. But we do not need to specify a tool if the task does not need any specific tool. That is why we need to determine what tool should be used for those tasks. Leaving the option open by not specifying any particular tool opens up for optimisations since it could mean we can avoid costly tool changes.

A.1 Filter

In [11] [9] [10] Vilím shows that filtering the domains of variables when, as in our case, using sequence dependent setup times can have a great effect on the runtime. Here we present a set of filters in order to minimize the domains of the variables.

A.1.1 Temporal filter

The largest domains in the model are the domains for the variables dealing with time, i.e. the temporal variables. Reducing those has the potential to cut much of the processing time.

$$\begin{aligned}
 (\forall t \in tasks) \\
 maxMoveDurs(t) = max(\{timeMatrix3D(t, j, k) : \\
 \quad \forall j \in tasks, \\
 \quad \forall k \in \{1, \dots, timeMatrixDepth\}, \\
 \quad j \neq t\})
 \end{aligned} \tag{A.57}$$

$$\begin{aligned}
 (\forall t \in tasks) \\
 minMoveDurs(t) = min(\{timeMatrix3D(t, j, k) : \\
 \quad \forall j \in tasks, \\
 \quad \forall k \in \{1, \dots, timeMatrixDepth\}, \\
 \quad j \neq t\})
 \end{aligned} \tag{A.58}$$

We start with defining two variables, $maxMoveDurs(t)$ and $minMoveDurs(t)$. These contain the maximum duration and the minimum duration respectively for each task taken from the time matrix.

$$maxEnd = \sum_{\forall t \in tasks} duration(t) + maxMoveDurs(t) \tag{A.59}$$

$$minEnd = \frac{\sum_{\forall t \in tasks} duration(t) + minMoveDurs(t)}{nbrMachines} \tag{A.60}$$

By using the newly created variables we can define yet another two. These define a new maximum for the total time of the assembly, $maxEnd$. It is similar to $maxE$ in equation A.49, although much more thorough in the filtering. These variables also define a new minimum for the total time of the assembly, it was earlier just set to 0.

To calculate the maximum end we look at the worst case scenario for the assembly. The worst case would be if all the tasks had to be done one after the other, one at a time, on the same machine and they would take the longest time, according to the time matrix, to move between them. See figure A.4. This can simply be defined by summing the durations and maximum move durations for all the tasks.

To calculate the minimum end we look at the best case scenario. The best case scenario is if all the tasks can be evenly scheduled over all machines, taking the shortest, according to the time matrix, time to move between them. See figure A.5. We can define this by summing up the durations and minimum move durations for all the task end divide the

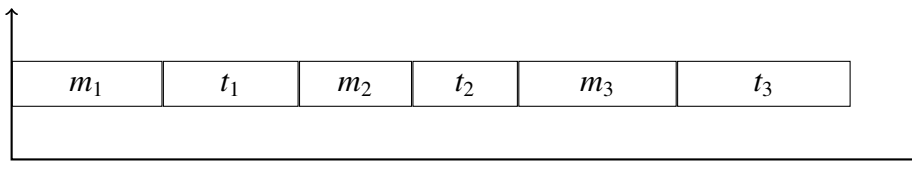


Figure A.4: The worst case assembly

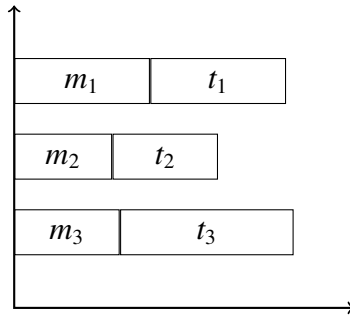


Figure A.5: The best case assembly

sum with the number of machines available. If the tasks can be perfectly evenly scheduled across all the machines, the total assembly time will be equal to *minEnd*, if they cannot *menEnd* will always be smaller than the total assembly time.

We can now start using *maxEnd* and *minEnd* to filter variables

$$\begin{aligned}
 (\forall t \in allTasks) \\
 start(t) \leq maxEnd - duration(t) \wedge \\
 start(t) \geq minMoveDurs(t)
 \end{aligned} \tag{A.61}$$

We set an upper bound for the start of a task by setting it to happen at latest the duration of the task time units before the *maxEnd*, since the task has to have time to execute before the end.

To set a lower bound for the start of a task, we simply reason that the move to the task can start at its earliest at time 0. Therefore, we limit the task to start earliest direct after the minimum move duration to it.

$$(\forall t \in tasks) moveStart(t) \leq maxEnd - (duration(t) + minMoveDurs(t)) \tag{A.62}$$

In order to limit the move start to a task we use the same reasoning as with start. But now we have to account for that there comes a task after the move and a duration of the move itself. So we have to subtract the duration of the task and the duration of the move. Since we do not know the exact length of the move, we have to use the value we know the duration can not be lower than, which is *minMoveDuration*.

$$\begin{aligned}
 makeSpan \leq maxEnd \wedge \\
 makespan \geq minEnd
 \end{aligned} \tag{A.63}$$

We have already calculated the limits for the whole assembly, *maxEnd* and *minEnd*. Now we just enforce them on the makespan.

$$\begin{aligned}
 (\forall t \in tasks) \\
 (\forall i \in \{0, \dots, maxMoveDurs(t)\} / \{timeMatrix3D(task, j, k) : \\
 \quad \forall j \in tasks, \\
 \quad \forall k \in \{1, \dots, timeMatrixDepth\} \\
 \quad t \neq j\}) \\
 moveDuration(t) \neq i
 \end{aligned} \tag{A.64}$$

We know that the value for move duration will be one of the values in the time matrix, hence we can restrict the duration to only those values. We do that by coming up with the values that the duration cannot assume, and limits the duration to not have those values in its domain.

$$\begin{aligned}
 (\forall t \in tasks/taking) \\
 moveStart(t) \geq min(\{duration(tt) + minMoveDurs(tt) : \forall tt \in taking\})
 \end{aligned} \tag{A.65}$$

The first thing that has to happen to a component in the assembly is that it has to be picked up. So since the assembly starts out with empty machines the first thing that has to happen, with the exception of a tool change, is a take task. Therefore, we can limit that start of the

tasks not being take tasks to happen at earliest after the take task with the smallest sum of duration and minimum move duration.

$$\begin{aligned}
& (\forall t \in tasks) \\
& prevTasks = \{task : \forall task \in tasks, \\
& \quad componentCreated(task) \in componentsUsed(t)\}, \\
& nbrMachines \geq |prevTasks|, \\
& \quad 0 < |prevTasks|, \\
& start(t) \geq \max(\{duration(pt) + minMoveDurs(pt) : \forall pt \in prevTasks\})
\end{aligned} \tag{A.66}$$

The start of a task can be even further limited by analysing the components used by the task and how that relates to what components are created by other tasks.

Lets take task t as an example. We start by getting all tasks that creates the components that is used in task t , $prevTasks$. These tasks has to come before task t since the component that they create cannot be used before they are created. If the number of machines are greater than or equal to the number of task preceding task t , then the best scheduling that can be done is to do all tasks in parallel. That means that task t can start at earliest after the one of the proceeding tasks taking the longest to complete.

$$\begin{aligned}
& (\forall t \in tasks) \\
& prevTasks = \{task : \forall task \in tasks, \\
& \quad componentCreated(task) \in componentsUsed(t)\}, \\
& nbrMachines < |prevTasks|, \\
& start(t) \geq \frac{(\sum_{pt \in prevTasks} duration(pt) + minMoveDurs(pt))}{nbrMachines}
\end{aligned} \tag{A.67}$$

But if the number of machines is fewer than the number of preceding tasks, the best we can do is divide them as equally as possible over the machines. This is the same reasoning as when we calculated $minEnd$ in equation A.60.

$$\begin{aligned}
& (\forall t \in tasks) \\
& succTasks = \{task : \forall task \in tasks, \\
& \quad componentsUsed(t) \subset taskCompleteSubComponent(task), \\
& \quad componentsUsed(t) \cup taskCompleteSubComponents(task) \neq \emptyset\}, \\
& nbrMachines \geq |succTasks|, \\
& \quad 0 < |succTasks|, \\
& start(t) \leq maxEnd - \max(\{duration(st) + minMoveDurs(st) : \\
& \quad \forall st \in succTasks\}) - duration(t)
\end{aligned} \tag{A.68}$$

$succTasks$ are the tasks that has the components used in task t as subcomponents, hence the tasks in $succTasks$ succeeds task t . If the number of machines are greater than or equal to the number of task preceding task t , then the best scheduling is to do all tasks in

parallel. If so the latest task t can end is less than or equal to the maximum end of the schedule minus the longest of the succeeding tasks

$$\begin{aligned}
& (\forall t \in tasks) \\
& succTasks = \{task : \forall task \in tasks, \\
& componentsUsed(t) \subset taskCompleteSubComponent(task), \\
& componentsUsed(t) \cup taskCompleteSubComponents(task) \neq \emptyset\}, \\
& nbrMachines \leq |succTasks|, \\
& start(t) \leq maxEnd - \frac{(\sum_{st \in succTasks} duration(st) + minMoveDurs(st))}{nbrMachines} \\
& \quad - duration(t)
\end{aligned} \tag{A.69}$$

$succTasks$ are the tasks that has the components used in task t as subcomponents, hence the tasks in $succTasks$ succeeds task t . If the number of machines are less than the number of tasks preceding task t , then the best we can do is to divide the task times equally on all machines. If the tasks can be divided onto the machines so that the total length of the times on all machines are the same, that time will be equal to the $sum/nbrMachines$. If they don't match up the maximum of these times will be larger than the $sum/nbrMachines$.

A.1.2 Predecessor filter

$$alldifferent(\{pred(t) : \forall t \in tasks\}) \tag{A.70}$$

Helps ensure that no two tasks can have the same predecessor

$$(\forall t1, \forall t2 \in taking) pred(t1) \neq t2 \tag{A.71}$$

No two taking tasks can be the predecessor of each other

$$(\forall t1, \forall t2 \in taking) pred(t1) \neq t2 \tag{A.72}$$

No two putting tasks can be the predecessor of each other

$$(\forall t1, \forall t2 \in mounting) pred(t1) \neq t2 \tag{A.73}$$

No two mounting tasks can be the predecessor of each other

$$\begin{aligned}
& (\forall t \in tasks) \\
& nonPredecessors = \{t_2 : \forall t_2 \in tasks, \\
& componentsUsed(t) \subset taskCompleteSubComponents(t_2) \vee \\
& componentsUsed(t) \subset subComponents(componentCreated(t_2))\} \\
& (\forall nonPred \in nonPredecessors) \\
& pred(t) \neq nonPred,
\end{aligned} \tag{A.74}$$

A task t cannot have task t_2 as predecessor if task t_2 uses a component, or creates a component, that the component task t uses has as a subcomponent

$$\begin{aligned}
& (\forall startTask \in startTasks) \\
& (\forall putTask \in putting) \\
& pred(putTask) \neq startTask
\end{aligned} \tag{A.75}$$

Since a component has to be taken before it can be put anywhere, put tasks cannot be first in the schedule

$$\begin{aligned}
& (\forall startTask \in startTasks) \\
& (\forall mountTask \in mounting) \\
& pred(putTask) \neq startTask
\end{aligned} \tag{A.76}$$

Since a component has to be taken before it can be mounted anywhere, mount tasks cannot be first in the schedule

$$\begin{aligned}
& (\forall goalTask \in goalTasks) \\
& (\forall takeTask \in taking) \\
& pred(goalTask) \neq takeTask
\end{aligned} \tag{A.77}$$

Since a schedule has to end with an assembly on the output, a take task cannot be at the end of the assembly

$$\begin{aligned}
& counts = \{i : \forall task \in outputTasks, i \in \{0, \dots, 1\}\}, \\
& outputTasks = \{task : \forall task \in tasks, output(task) > 0\}, \\
& goalPreds = \{pred(task) : \forall task \in goalTasks\}, \\
& global_cardinality(goalPreds, outputTasks, counts) \wedge \\
& \sum counts > 0
\end{aligned} \tag{A.78}$$

At least one of the output tasks has to be last on one of the circuits

$$\begin{aligned}
& counts = \{i : \forall task \in startTasks, i \in \{0, \dots, 1\}\}, \\
& takePreds = \{pred(task) : \forall task \in taking, output(task) = 0\}, \\
& global_cardinality(takePreds, startTasks, counts) \wedge \\
& \sum counts > 0
\end{aligned} \tag{A.79}$$

At least one of the take tasks, that's not on an output, has to be first on one of the circuits

$$\begin{aligned}
& (\forall comp \in components) \\
& (\forall mountTask \in mounting(comp)) \\
& (\forall putTask \in putting(comp)) \\
& pred(putTask) \neq mountTask
\end{aligned} \tag{A.80}$$

If a set of tasks on a component involves a mount task and a put task, the predecessor of the put task cannot be the mount task

$$\begin{aligned}
& (\forall comp \in components) \\
& (\forall mountTask \in mounting(comp)) \\
& (\forall takeTask \in taking(comp)) \\
& pred(takeTask) \neq mountTask
\end{aligned} \tag{A.81}$$

If a set of tasks on a component involves a mount task and a take task, the predecessor of the take task cannot be the mount task.

$$\begin{aligned}
& (\forall comp \in components) \\
& (\forall putTask \in puttingcomp, tray(putTask) > 0) \\
& (\forall takeTask \in taking(comp), tray(putTask) = tray(takeTask)) \\
& pred(putTask) \leq takeTask
\end{aligned} \tag{A.82}$$

If a component has a put and take performed on it in a tray, the predecessor of the put task cannot be the take task.

$$\begin{aligned}
& (\forall f \in fixtures) \\
& (\forall putTask \in puttingcomp, fixture(putTask) = f) \\
& (\forall takeTask \in taking(comp), fixture(takeTask) = f, \\
& \quad componentsUsed(putTask) \subset taskSubComponents(takeTask)) \\
& pred(putTask) \leq takeTask
\end{aligned} \tag{A.83}$$

For every put action on a fixture, there is a take action. The predecessor of the put task cannot be the take task.

$$\begin{aligned}
& (\forall group \in \{1, \dots, nbrConcurrentGroups\}) \\
& (\forall t_1 \in concurrentTasks(group)) \\
& (\forall t_2 \in concurrentTasks(group) / \{t_1\}) \\
& pred(t_1) \neq t_2 \wedge pred(t_2) \neq t_1
\end{aligned} \tag{A.84}$$

Concurrent tasks cannot be predecessor to each other.

$$\begin{aligned}
& (\forall t_1 \in tasks, componentCreated(t_1) > 0) \\
& (\forall t_2 \in tasks, componentCreated(t_1) \in compinentUsed(t_2)) \\
& pred(t_1) \neq t_2
\end{aligned} \tag{A.85}$$

Components cannot be used before they are created.

$$\begin{aligned}
& (\forall precTask \in tasks) \\
& (\forall t \in tasks, precTask \neq t, \\
& \quad componentUsed(precTask) \cup taskCompleteSubComponent(t) \subset \\
& \quad \quad \quad taskCompleteSubComponents(t), \\
& \quad componentsUsed(precTask) \cup taskCompleteSubComponents(t) \neq \emptyset \\
& \quad pred(precTask) \neq t
\end{aligned} \tag{A.86}$$

Task using a component cannot execute before all the tasks having it as subcomponent.

$$\begin{aligned}
& (\forall \text{concGroup} \in \text{concurrentTasks}, |\text{concGroup}| = \text{nbrMachines}) \\
& \text{concComps} = \bigcup_{\forall i \in \text{concGroup}} \text{componentsUsed}(i), \\
& \text{concSubComps} = \bigcup_{\forall i \in \text{concGroup}} \text{taskCompleteSubComponents}(i), \\
& \text{preTasks} = \{ \text{preTask} : \forall \text{preTask} \in \text{tasks}, \\
& \quad \text{componentsUsed}(\text{preTask}) \cap \text{concSubComps} \neq \emptyset, \\
& \quad (\forall \text{postTask} \in \text{postTasks}) \\
& \quad (\forall \text{predTask} \in \text{preTasks}) \\
& \quad \text{pred}(\text{postTask}) \neq \text{preTask} \}
\end{aligned} \tag{A.87}$$

If there is a set of concurrent tasks on a subset of tasks using as many machines as available, the tasks after the concurrent tasks cannot have the tasks before the concurrent tasks as predecessors.

A.2 Constraints

$$(\forall t \in \text{tasks}) \text{end}(t) \leq \text{makespan} \tag{A.88}$$

All ends has to be lesser than the total end

$$(\forall t \in \text{startTasks} \cup \text{goalTasks}) \text{start}(t) = 0 \tag{A.89}$$

Start and goal tasks are not temporal tasks, i.e. they are timeless. Therefore, their start time is set to 0

$$\begin{aligned}
& (\forall m \in \text{machines}) \\
& \text{usingMachine}(\text{nbrTasks} + m) = m \wedge \\
& \text{usingMachine}(\text{nbrTasks} + \text{nbrMachines} + m) = m
\end{aligned} \tag{A.90}$$

The start tasks and goal tasks are assigned to machines, thereby there are start and goal tasks assigned to every machine. Because of the way start and goal tasks are created, the start tasks starts with number $\text{nbrTasks} + 1$, and the corresponding goal task for a start task can be accessed by $\text{startTask} + \text{nbrMachines}$.

$$\begin{aligned}
& (\forall m \in \text{machines}) \\
& (\forall t \in \text{tasksOutOfRange}(m)) \\
& \text{usingMachine}(t) \neq m
\end{aligned} \tag{A.91}$$

Setting the tasks that are out of range for each machine

A.2.1 Precedences

$$\begin{aligned}
& (\forall comp \in components) \\
& (\forall mountTask \in mounting(comp)) \\
& (\forall putTask \in putting(comp)) \\
& end(putTask) \leq moveStart(mountTask)
\end{aligned} \tag{A.92}$$

If a set of tasks on a component involves a mount task and a put task, the put task has to come before the mount task

$$\begin{aligned}
& \forall comp \in components \\
& \forall mountTask \in mounting(comp), \\
& \forall takeTask \in taking(comp), \\
& end(takeTask) \leq moveStart(mountTask)
\end{aligned} \tag{A.93}$$

If a set of tasks on a component involves a mount task and a take task, the take task has to come before the mount task

$$\begin{aligned}
& \forall comp \in components \\
& (\forall putTask \in putting(comp), tray(putTask) > 0) \\
& (\forall takeTask \in taking(comp), tray(putTask) = tray(takeTask)) \\
& end(putTask) \leq moveStart(takeTask)
\end{aligned} \tag{A.94}$$

If a component has a put and take performed on it in a tray, the put has to come before the take.

$$\begin{aligned}
& (\forall f \in fixtures) \\
& (\forall putTask \in putting(comp), fixture(putTask) = f) \\
& (\forall takeTask \in taking(comp), fixture(takeTask) = f \wedge \\
& \quad componentsUsed(putTask) \subset taskSubComponents(takeTask)) \\
& end(putTask) \leq moveStart(takeTask),
\end{aligned} \tag{A.95}$$

For every put action on a fixture, there is a take action. The put action has to come before the take action.

$$\begin{aligned}
& (\forall f \in fixtures) \\
& puts = [put : \forall put \in putting, fixture(put) = f], \\
& takesForEachPut = [\{take : \forall take \in taking, fixture(take) = f, \\
& componentsUsed(put) \subset taskCompleteSubComponent(take)\} : \forall put \in puts], \\
& takes = [\arg \min_{\forall take \in takesForEachPut(p)} taskCompleteSubComponent(take) : \\
& \quad \forall p \in \{1, \dots, |puts|\}], \\
& cumulative([moveStart(task) : \forall task \in puts], \\
& \quad [abs(end(takes(i)) - moveStart(puts(i))) : \forall i \in \{1, \dots, |puts|\}], \\
& \quad [1 : \forall i \in \{1, \dots, |puts|\}], \\
& \quad 1)
\end{aligned} \tag{A.96}$$

The intervals between when components are put and then taken again cannot overlap on the same fixture.

$$\begin{aligned}
& (\forall group \in \{1, \dots, nbrConcurrentGroups\}) \\
& \quad (\forall t_1 \in concurrentTasks(group)) \\
& \quad (\forall t_2 \in concurrentTasks(group) / \{t_1\}) \\
& \quad \quad start(t_1) = start(t_2) \wedge \\
& \quad \quad usingMachine(t_1) \neq usingMachine(t_2),
\end{aligned} \tag{A.97}$$

Concurrent tasks has to happen at the same time.

$$\begin{aligned}
& (\forall t_1 \in tasks, componentCreated(t_1) > 0) \\
& (\forall t_2 \in tasks, componentCreated(t_1) \in compinentUsed(t_2)) \\
& moveStart(t_2) \geq end(t_1)
\end{aligned} \tag{A.98}$$

Components cannot be used before they are created.

$$\begin{aligned}
& (\forall precTask \in tasks) \\
& \quad (\forall t \in tasks, precTask \neq t, \\
& \quad \quad componentUsed(precTask) \cup taskCompleteSubComponent(t) \subset \\
& \quad \quad taskCompleteSubComponents(t), \\
& \quad \quad componentsUsed(precTask) \cup taskCompleteSubComponents(t) \neq \emptyset) \\
& end(precTask) \leq moveStart(t),
\end{aligned} \tag{A.99}$$

Task using a component cannot execute before all the tasks having it as subcomponent.

$$\begin{aligned}
& (\forall f \in \text{fixtures}) \\
& \text{fixtureTasks} = [t : \forall t \in \text{tasks}, \text{fixture}(t) = f], \\
& \text{cumulative}([\text{start}(t) : \forall t \in \text{fixtureTasks}], \\
& \quad [\text{duration}(t) : \forall t \in \text{fixtureTasks}], \\
& \quad [1 : t \in \text{fixtureTasks}], \\
& \quad 1)
\end{aligned} \tag{A.100}$$

Tasks on the same fixture cannot overlap.

$$\begin{aligned}
& (\forall tr \in \text{trays}) \\
& \text{trayTasks} = [t : \forall t \in \text{tasks}, \text{tray}(t) = tr], \\
& \text{cumulative}([\text{start}(t) : \forall t \in \text{trayTasks}], \\
& \quad [\text{duration}(t) : \forall t \in \text{trayTasks}], \\
& \quad [1 : t \in \text{trayTasks}], \\
& \quad 1)
\end{aligned} \tag{A.101}$$

Tasks on the same tray cannot overlap.

$$\begin{aligned}
& (\forall o \in \text{outputs}) \\
& \text{outputTasks} = [t : \forall t \in \text{tasks}, \text{output}(t) = o], \\
& \text{cumulative}([\text{start}(t) : \forall t \in \text{outputTasks}], \\
& \quad [\text{duration}(t) : \forall t \in \text{outputTasks}], \\
& \quad [1 : t \in \text{outputTasks}], \\
& \quad 1)
\end{aligned} \tag{A.102}$$

Tasks on the same output cannot overlap.

$$(\forall t \in \text{tasks}) \text{Start}(t) \geq \text{moveEnd}(t) \tag{A.103}$$

A task can only start after the move to it.

A.2.2 Predecessors

$$(\forall t \in \text{tasks}) \text{moveStart}(t) \geq \text{end}(\text{pred}(t)) \tag{A.104}$$

A task has to start after its predecessor.

$$\begin{aligned}
& (\forall \text{startTask} \in \text{startTasks} / \{\text{nbrTasks} + 1\}) \\
& \text{pred}(\text{startTask}) = \text{startTask} + \text{nbrMachines} - 1
\end{aligned} \tag{A.105}$$

In order to create a circuit containing the sub circuits, for all start tasks, except the first one, the start tasks predecessor is the previous goal task.

$$\text{pred}(\text{nbrTasks} + 1) = \text{nbrTasks} + \text{nbrMachines} \times 2 \tag{A.106}$$

To complete the circuit, the first start tasks predecessor is the last goal task.

$$circuit(\{pred(t) : \forall t \in tasks\}) \quad (A.107)$$

The predecessors has to form a circuit.

$$\begin{aligned} & (\forall c \in components) \\ & (\forall mountTask \in mounting(c)) \\ & \quad puts = \{p : \forall p \in putting(c), \\ & \quad \quad (fixture(p) > 0 \wedge fixture(p) = fixture(mountTask)) \vee \\ & \quad \quad (output(p) > 0 \wedge output(p) = output(mountTask)) \vee \\ & \quad \quad (tray(p) > 0 \wedge tray(p) = tray(mountTask))\}, \\ & \quad (\forall takeTask \in taking(c), takeTask \notin orderedSet, puts = \emptyset) \\ & \quad pred(mountTask) = takeTask \end{aligned} \quad (A.108)$$

If a set of tasks on a component involves a mount and a take task, but no move tasks or put task on the same fixture, tray or output as the mount, the take task is the predecessor of the mount task.

$$\begin{aligned} & (\forall c \in components, moving(c) = \emptyset) \\ & (\forall putTask \in putting(c), tray(putTask) = 0) \\ & (\forall takeTask \in taking(c)) \\ & \quad pred(putTask) = takeTask \end{aligned} \quad (A.109)$$

If a set of tasks on a component involves a put task not in a tray and a take task, and there is no moves involved, the take task has to be the predecessor of the put task.

$$\begin{aligned} & (\forall k \in orderedGroups) \\ & (\forall i \in \{1, \dots, |orderedGroup(k)|-1\}) \\ & \quad pred(ordered(k, i+1)) = ordered(k, i) \end{aligned} \quad (A.110)$$

Sets up the predecessors in accordance with the ordered groups.

$$\begin{aligned} & (\forall t \in tasks \cup goalTasks) \\ & \quad usingMachine(t) = usingMachine(pred(t)) \end{aligned} \quad (A.111)$$

A task has to use the same machine as its predecessor.

$$\begin{aligned} & (\forall t \in tasks) \\ & \quad k = abs(toolUsed(t) - toolUsed(pred(t))) + 1, \\ & \quad moveDuration(t) = timeMatrix3D(pred(t), t, k) \end{aligned} \quad (A.112)$$

Take tasks has to use the same tool as its predecessor or do a change first.

$$(\forall t \in tasks, toolNeeded(t) \neq 0) toolUsed(t) = toolNeeded(t) \quad (A.113)$$

Set the tool used for each task in accordance with *toolNeeded*.

Appendix B

Tool Manuals
