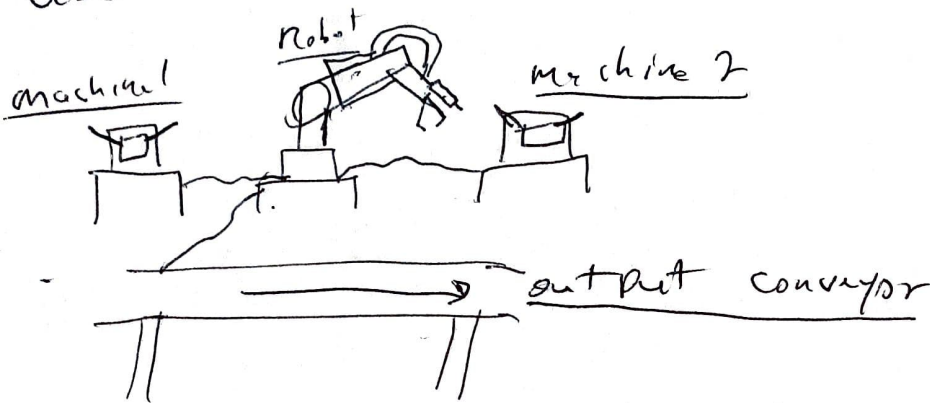
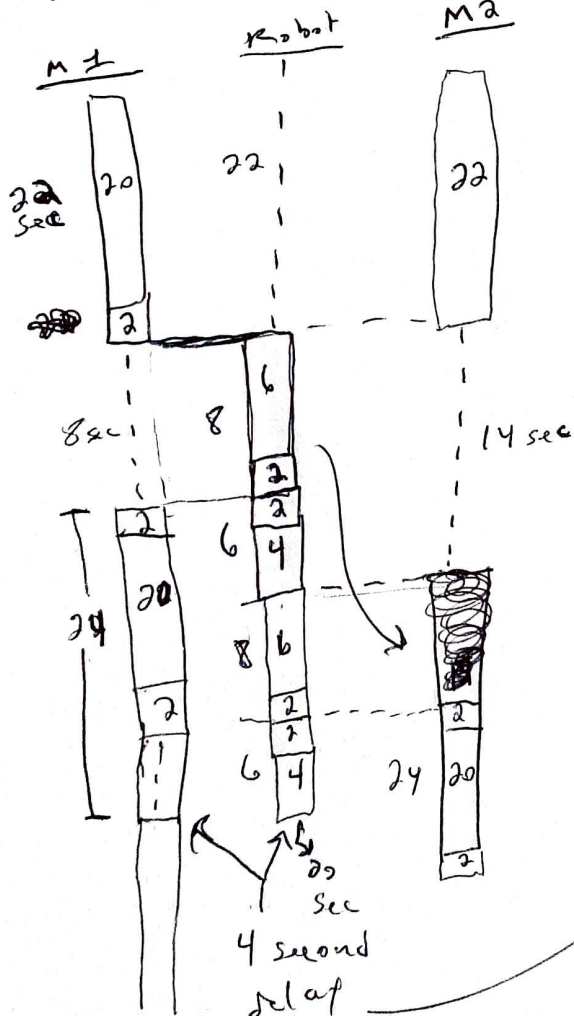


question 29 - Demetrius Johnson

a) use Robot-centered workflow is best.



b) Time chart



c) Robot ~~is~~

cycle for 1 machine
is 20 sec; machine
time is 24 sec

machine interference = $\boxed{45 \text{ sec}}$