Time (s)	Robot		robot	machine 1	robot	machine 2	robot	machine 3
	0.1	BUSY	5.5s: get part from INPUT conveyor; load part to machine	5.5s: service time		Idle		Idle
	0.2	BUSY				Idle		Idle
	0.4	BUSY				Idle		Idle
	0.5	BUSY				Idle		ldle
	0.7	BUSY				Idle		Idle
	0.8	BUSY				Idle		Idle
	1	BUSY				Idle		Idle
	1.1	BUSY				ldle		Idle
	1.2	BUSY				Idle		Idle
	1.4	BUSY				Idle		Idle
	1.5	BUSY				Idle		Idle
	1.7	BUSY				Idle		Idle
	1.8	BUSY				Idle		Idle
	1.9	BUSY				Idle		Idle
	2.1	BUSY				Idle		Idle
	2.2	BUSY				Idle		ldle
	2.4	BUSY				Idle		Idle
	2.5 2.6	BUSY				Idle Idle		ldle
	2.7	BUSY				Idle		Idle
	2.8 2.9	BUSY				Idle		Idle
	3	BUSY				Idle		Idle
	3.1	BUSY				ldle		Idle
	3.2 3.3	BUSY				Idle		ldle ldle
	3.4	BUSY				Idle		Idle
	3.5 3.6	BUSY				Idle		ldle
	3.7	BUSY				ldle		Idle
	3.8	BUSY				idle		Idle
	3.9 4	BUSY				ldle		Idle
	4.1	BUSY				Idle		Idle
	4.2 4.3	BUSY				Idle		ldle
	4.4	BUSY				idle		Idle
	4.5 4.6	BUSY				idle		Idle
	4.7	BUSY				Idle		Idle
	4.8	BUSY				Idle		Idle
	4.9 5	BUSY				Idle		Idle
	5.1	BUSY				ldle		Idle
	5.2 5.3	BUSY				Idle		ldle
	5.4	BUSY				Idle		Idle
	5.5	BUSY		33s: machine cycle	1.7s: move to pickup pos.	Idle		Idle
	5.6 5.7	BUSY		335. Hacilile Cycle	1.75. Hove to pickup pos.	7.2s: service time		Idle
	5.8	BUSY						Idle
	5.9	BUSY						ldle
	6.1	BUSY						Idle
	6.2 6.3	BUSY BUSY						Idle
	6.4	BUSY						Idle
	6.5	BUSY						Idle
	6.6 6.7	BUSY						Idle
	6.8	BUSY						Idle
	6.9 7	BUSY						ldle
	7.1	BUSY						Idle
	7.2 7.3	BUSY			5.5s: get part from INPUT conveyor; load part			Idle
	7.4	BUSY			to machine			Idle
	7.5	BUSY						Idle
	7.6 7.7	BUSY						Idle
	7.8	BUSY						Idle
	7.9 8	BUSY						Idle
	8.1	BUSY						Idle
	8.2 8.3	BUSY						ldle
	8.4	BUSY						Idle
	8.5 8.6	BUSY						Idle
	8.7	BUSY						Idle
	8.8	BUSY BUSY						ldle
	8.9 9	BUSY						Idle
	9.1	BUSY						Idle
	9.2 9.3	BUSY						Idle
	9.4	BUSY						Idle
	9.5 9.6	BUSY						Idle
	9.7	BUSY						Idle
	9.8 9.9	BUSY						ldle
	10	BUSY						Idle
	10.1 10.2	BUSY BUSY						idle idle
	10.3	BUSY						Idle
	10.4 10.5	BUSY BUSY						ldle
	10.5	BUSY						Idle
	10.7	BUSY						Idle
	10.8 10.9	BUSY						Idle
	11	BUSY						Idle
	11.1 11.2	BUSY						ldle
	11.3	BUSY						Idle
	11.4 11.5	BUSY						ldle
	11.6	BUSY BUSY						Idle
	11.7	BUSY						Idle
	11.8 11.9	BUSY						ldle
	12	BUSY						Idle
	12.1 12.2	BUSY						ldle

12.3 12.4 12.5 12.6 12.7	BUSY BUSY
12.5 12.6 12.7	
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13.3	BUSY
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13.5	BUSY
13.6 13.7	
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13.9	BUSY
14	BUSY
14.1	BUSY
14.2	BUSY
14.3	
14.4 14.5	BUSY BUSY
14.5	
14.7	
14.8	BUSY
14.9	BUSY
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15.1	BUSY
15.2 15.3	
15.3 15.4	
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15.6	
15.7	BUSY
15.8	BUSY
15.9	
16 16.1	BUSY BUSY
16.1 16.2	
16.2	
16.4	BUSY
16.5	BUSY
16.6	BUSY
16.7	
16.8	
16.9 17	BUSY BUSY
17.1	
17.2	
17.3	BUSY
17.4	BUSY
17.5	
17.6	BUSY
17.7	
17.8	
17.9 18	
18.1	
18.2	BUSY
18.3	BUSY
18.4	BUSY
18.5	BUSY
18.6	
18.7	
18.8 18.9	BUSY BUSY
19	BUSY
19.1	BUSY
19.2	BUSY
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19.4 19.5	BUSY BUSY
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19.9	BUSY
19.9 20	BUSY IDLE
19.9 20 20.1	BUSY IDLE IDLE
19.9 20 20.1 20.2	BUSY IDLE IDLE IDLE
19.9 20 20.1 20.2 20.3	BUSY IDLE IDLE IDLE IDLE IDLE IDLE
20.1 20.2 20.3 20.4 20.5	BUSY IDLE IDLE IDLE IDLE IDLE IDLE IDLE
20 20.1 20.2 20.3 20.4 20.5 20.6	BUSY IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
20.1 20.2 20.3 20.4 20.5 20.6 20.7	BUSY IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8	BUSY IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
19.9 20 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9	BUSY IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
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19.9 20 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9	IOLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE ID
19.9 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21.1 21.1 21.2 21.3	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
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19.9 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.4 21.5	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
19.9 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.4 21.5 21.6	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.4 21.5 21.6 21.7	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.4 21.5 21.6 21.7 21.8	IOLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE ID
19.9 20 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21.1 21.2 21.3 21.4 21.5 21.6 21.7 21.8 21.9	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
20.2 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.4 21.5 21.6 21.7 21.8 21.9 22 22.1	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
19.9 20 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.4 21.5 21.6 21.7 21.8 21.9 22 22.1	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
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19.9 20.0 20.1 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.5 20.6 20.7 21.1 21.1 21.1 21.4 21.5 21.6 21.7 21.8 21.9 22 22.1 22.2 22.3 22.4 22.2 22.3 22.4 22.2 22.3 22.4 22.2 22.3 22.4 20.5 20.5 20.5 20.5 20.5 20.5 20.5 20.5	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
1999 20 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21.1 21.2 21.5 21.6 21.7 21.2 22.2 22.3 22.4 22.5 22.4 22.5 22.3 22.4 22.5 22.5 22.5 22.5 22.5 22.5 22.5	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
19.9 200 20.1 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.7 21.1 21.2 21.3 21.4 21.5 21.6 22.2 22.3 22.4 22.5 22.6 22.6 22.6 22.7 22.2 22.3 22.4 22.5 22.6 22.6 22.6 22.6 22.6 22.6 22.6	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
20.1 20.2 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.4 21.5 21.6 21.7 22.2 22.3 22.4 22.5 22.4 22.5 22.6	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE
20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21 21.1 21.2 21.3 21.9 21.9 22.2 22.1 22.2 22.3 22.4 22.2 22.2 22.3 22.4 22.2 22.3 22.4 22.3 22.4 22.5 22.6 22.7 22.8 22.8 22.9 22.8 22.8 22.8 22.9 22.8 22.8	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
201 20.1 20.2 20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 20.1 21.1 21.2 21.3 21.4 21.5 21.6 21.7 21.8 21.2 22.2 22.2 22.2 22.2 22.2 22.2	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
20.1 20.2 20.3 20.4 20.5 20.6 20.7 20.8 20.9 21.1 21.2 21.3 21.4 21.5 21.6 21.7 21.8 22.1 22.2 22.3 22.4 22.5 22.6 22.7 22.8 22.8 22.9 22.8 22.9 22.8 22.9 22.8 22.9 22.8 22.9 22.9	OLE
201 201 202 203 204 205 205 205 205 206 6 207 21 211 211 212 213 214 215 216 22 221 222 223 224 222 223 224 23 23 23 23 23 23 23 23 23 23 23 23 23	DUE
20.1 20.1 20.2 20.3 20.4 20.5 20.6 20.9 21 21.1 21.2 21.3 21.4 21.5 21.6 21.7 22.2 22.3 22.4 22.5 22.6 22.7 22.3 22.4 22.5 22.5 22.6 22.7 22.7 22.8 22.7 22.8 22.9 22.9 22.9 22.9 22.9 22.9 22.9	IOLE IOLE IOLE IOLE IOLE IOLE IOLE IOLE
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344	24.6	IDLE	l	1		
A	24.7	IDLE				
50 001 10 10 10 10 10 10 10 10 10 10 10 10 10 1						
Section 1981  101  101  101  101  101  101  101	24.9	IDLE				
Section   Sect						
150   150						
5-50	25.3	IDLE				
### Company   Co						
100   100	25.5	IDLE				
2-10						
35	25.8	IDLE				
50		IDLE				
10						
100   100	26.2	IDLE				
50	26.3					
No. 00         DOIS           No. 00         DOIS           No. 00         DOIS           10         DOIS           27         DOIS           28         DOIS           29         DOIS           20         DOIS <t< th=""><th>26.4</th><th>IDLE</th><th></th><th></th><th></th><th></th></t<>	26.4	IDLE				
### PACE   PACE						
No. 10						
24	26.8	IDLE				
720		IDLE				
220   Section						
725	27.2	IDLE				
200	27.3	IDLE				
756   SC   SC   SC   SC   SC   SC   SC   S	27.4	IDLE				
777   SICE						
2-26   Color						
100	27.8	IDLE				
24.1						
252		IDLE				
253	28.2	IDLE				
255	28.3	IDLE				
226 OUE						
230   OLD						
285   DEC   290   ORI   290   ORI   291   ORI   292   ORI   293   ORI   295   ORI   296   ORI   296   ORI   297   ORI   298   ORI   299   ORI   299   ORI   290	28.7	IDLE				
20						
25.	29	IDLE				
202						
254	29.2	IDLE				
255   DOL		IDLE				
256 OLG 278 OLG 289 OLG 289 OLG 280 OL						
227   DOLE   28	29.6	IDLE				
299	29.7	IDLE				
30   DEC   31   DEC   32   DEC   33   DEC   34   DEC   35   DEC   36   DEC   37   DEC						
301   00E	30	IDLE				
303   SUG   304   SUG   305   SUG   306   SUG   307   SUG   308   SUG   309   SUG   309   SUG   309   SUG   309   SUG   309   SUG   301   SUG   301   SUG   302   SUG   303   SUG   304   SUG   305   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   319   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   319   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   310   SUG   311   SUG   312   SUG   313   SUG   314   SUG   315   SUG   315   SUG   316   SUG   317   SUG   318   SUG   319   SUG   310   SUG   310   SUG   310   SUG   310						
30-5 ONE	30.2	IDLE				
105						
100						
30.5 DUE 30.5 DUE 30.5 DUE 30.5 DUE 30.5 DUE 31.1 DUE 31.2 DUE 31.3 DUE 31.4 DUE 31.5 DUE 31.6 DUE 31.6 DUE 31.6 DUE 31.7 DUE 31.8 DUE 32 DUE 33 DUE 34 DUE 35 DUE 35 DUE 36 DUE 37 DUE 38 DUE		IDLE				
311 DUE 31.1 DUE 31.2 DUE 31.6 DUE 31.7 DUE 31.8 DUE 31.8 DUE 31.9 DUE 32.1 DUE 32.1 DUE 32.1 DUE 32.1 DUE 32.1 DUE 32.1 DUE 32.2 DUE 32.3 DUE 32.3 DUE 33.3 DUE 33.4 DUE 33.5 DUE 33.6 DUE 33.7 DUE 33.8 DUE 33.8 DUE 33.8 DUE 33.9 DUE 34.1 DUE 34.1 DUE 34.2 DUE 34.3 DUE 35.5 DUE 35.5 DUE 35.6 DUE 35.7 DUE 35.7 DUE 35.8 DUE 35.9 DUE 36.9 DUE 36.9 DUE 37.9		IDLE				
31. ODE 31.1 ODE 31.2 ODE 31.2 ODE 31.3 ODE 31.3 ODE 31.4 ODE 31.5 ODE 31.6 ODE 31.7 ODE 31.7 ODE 31.7 ODE 31.8 ODE 31.9 ODE 31.9 ODE 32.0 ODE 32.0 ODE 32.1 ODE 32.1 ODE 32.1 ODE 32.2 ODE 32.3 ODE 32.4 ODE 32.5 ODE 32.6 ODE 32.7 ODE 32.8 ODE 33.8 ODE 33.8 ODE 33.8 ODE 33.8 ODE 33.9 ODE 33.9 ODE 33.9 ODE 33.0 ODE 33.1 ODE 33.1 ODE 33.1 ODE 33.1 ODE 33.2 ODE 33.3 ODE 33.3 ODE 33.3 ODE 33.4 ODE 34.0 ODE 34.0 ODE 34.1 ODE 34.2 ODE 34.3 ODE 35.3	30.8	IDLE				
31.1   DUE 31.2   DUE 31.3   DUE 31.4   DUE 31.5   DUE 31.6   DUE 31.6   DUE 31.7   DUE 31.8   DUE 31.9   DUE 32   DUE 33   DUE 34   DUE 35   DUE 36   DUE 37   DUE 38   DUE 3						
313   OLE   315   OLE   316   OLE   317   OLE   318   OLE   319   OLE   320   OLE   321   OLE   322   OLE   323   OLE   324   OLE   325   OLE   326   OLE   327   OLE   328   OLE   339   OLE   330   OLE   331   OLE   332   OLE   333   OLE   333   OLE   334   OLE   335   OLE   336   OLE   337   OLE   338   OLE   338   OLE   339   OLE   340   OLE   341   OLE   342   OLE   343   OLE   344   OLE   345   OLE   346   OLE   347   OLE   348   OLE   349   OLE   340   OLE   341   OLE   342   OLE   343   OLE   344   OLE   345   OLE   346   OLE   347   OLE   348   OLE   349   OLE   340   OLE   341   OLE   342   OLE   343   OLE   344   OLE   345   OLE   346   OLE   347   OLE   348   OLE   349   OLE   340   OLE   341   OLE   342   OLE   343   OLE   344   OLE   345   OLE   346   OLE   347   OLE   348   OLE   349   OLE   340   OLE   341   OLE   342   OLE   343   OLE   344   OLE   345   OLE   355   OLE   356   OLE   357   OLE   358   OLE   359   OLE   350   OLE   350   OLE   351   OLE   352   OLE   353   OLE   353   OLE   354   OLE   355   OLE   355   OLE   356   OLE   357   OLE   358   OLE   359   OLE   350   OLE   350   OLE   350   OLE   351   OLE   352   OLE   353   OLE   354   OLE   355   OLE   355   OLE   356   OLE   357   OLE   358   OLE   359   OLE   350   OLE   350   OLE   350   OLE   351   OLE   352   OLE   353   OLE   354   OLE   355   OLE   355   OLE   356   OLE   357   OLE   358   OLE   358   OLE   359   OLE   350   OLE   350   OLE   350   OLE   351   OLE   352   OLE   353   OLE   354   OLE   355   OLE   356   OLE   360   OLE   360   OLE   360   OLE   360   OLE   360   OLE   370	31.1	IDLE				
31.4 DE  31.6 DE  31.6 DE  31.7 DE  31.8 DE  31.8 DE  31.9 DE  32.1 DE  32.1 DE  32.1 DE  32.2 DE  32.3 DE  32.3 DE  32.4 DE  32.5 DE  32.5 DE  32.6 DE  32.6 DE  32.7 DE  32.8 DE  33.9 DE  33.0 DE  33.1 DE  33.1 DE  33.1 DE  33.2 DE  33.3 DE  33.4 DE  33.5 DE  33.6 DE  33.6 DE  33.7 DE  33.8 DE  34.8 DE  35.8 DE  35.		IDLE				
31.6 OUE 31.7 OUE 31.7 OUE 31.8 OUE 31.9 OUE 32 OUE 32.0 OUE 32.1 OUE 32.1 OUE 32.2 OUE 32.3 OUE 32.4 OUE 32.5 OUE 32.6 OUE 32.6 OUE 32.7 OUE 32.8 OUE 32.8 OUE 32.9 OUE 32.9 OUE 33.1 OUE 33.3 OUE 33.4 OUE 33.5 OUE 33.6 OUE 33.7 OUE 33.8 OUE 33.8 OUE 33.9 OUE 34.0 OUE 35.0 OUE 35.0 OUE 36.0 OUE 37.0 OUE 38.0						
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38.2	IDLE							
38.3 38.4	IDLE IDLE							
38.5 38.6	IDLE BUSY	4.8s: retrieve part, place on output	4.8s: service time					
38.7 38.8	BUSY BUSY	conveyor						
38.9	BUSY							
39 39.1	BUSY BUSY							
39.2 39.3	BUSY BUSY							
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43.1	BUSY							
43.2 43.3	BUSY BUSY							
43.4 43.5	BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time					
43.6 43.7	BUSY BUSY							
43.8 43.9	BUSY BUSY							
44	BUSY							
44.1 44.2	BUSY BUSY							
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44.5 44.6	BUSY BUSY							
44.7	BUSY							
44.8 44.9	BUSY BUSY							
45 45.1	BUSY BUSY	5.5s: get part from INPUT conveyor; load part						
45.2 45.3	BUSY BUSY	to machine						
45.4 45.5	BUSY							
45.6	BUSY							
45.7 45.8	BUSY BUSY				Idle			
45.9 46	BUSY BUSY				idle idle			
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49.2 49.3	BUSY BUSY			Idle
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49.6	BUSY			Idle
49.7 49.8	BUSY BUSY			Idle
49.9	BUSY			Idle
50	BUSY			Idle
50.1 50.2	BUSY BUSY			idle
50.2	BUSY			Idle
50.4	BUSY			Idle
50.5	BUSY			Idle
50.6 50.7	BUSY BUSY	33s: machine cycle	4.8s: retrieve part, place on output conveyor	4.8s: service time
50.8	BUSY		conveyor	
50.9	BUSY			
51 51.1	BUSY BUSY			
51.1	BUSY			
51.3	BUSY			
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52.1	BUSY			
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54.8	BUSY			
54.9	BUSY			
55 55.1	BUSY BUSY			
55.2	BUSY			
55.3	BUSY		4.7	
55.4 55.5	BUSY BUSY		1.7s: move to pickup pos.	7.2s: service time
55.6	BUSY			
55.7	BUSY			
55.8 55.9	BUSY BUSY			
56	BUSY			
56.1	BUSY			
56.2 56.3	BUSY BUSY			
56.4	BUSY			
56.5	BUSY			
56.6 56.7	BUSY BUSY			
56.8	BUSY			
56.9	BUSY			
57 57.1	BUSY BUSY		5.5s: get part from INPUT conveyor; load part	
57.2	BUSY		to machine	
57.3	BUSY			
57.4 57.5	BUSY BUSY			
57.6	BUSY			
57.7	BUSY			
57.8 57.9	BUSY BUSY			
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60.3	BUSY			
60.4 60.5	BUSY BUSY			
60.6	BUSY			
60.7	BUSY			
60.8 60.9	BUSY BUSY			
60.9	BUSY			
61.1	BUSY			
61.2	BUSY BUSY			
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Second					conveyor	
May	62.9					
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30	63.1					
600						
GO	63.4	BUSY				
600   600						
Gall						
Section   Sect	63.8					
140						
60	64.1	BUSY				
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66	64.3	BUSY				
50						
Get 1						
465   Miles 651   Miles 652   Miles 653   Miles 654   Miles 655   Miles 656   Miles 657   Miles 658   Miles 659   Miles 659   Miles 650   Miles 650   Miles 650   Miles 650   Miles 651   Miles 652   Miles 653   Miles 653   Miles 654   Miles 655   Miles 655   Miles 656   Miles 657   Miles 658   Miles 659   Miles 650	64.7	BUSY				
66   Note   Color   Co						
63   300   64   700   64   700   64   700   64   700	65	BUSY				
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65   Mile   65.4						
62 2	65.5	BUSY				
GEA 1 100 1	65.6	BUSY				
65   107   108   1						
66   60	65.9	BUSY				
662   663   664   665	66					
Section   1972						
100   100	66.3					
66.6 1822						
66   600   6	66.5	BUSY				
66   Service   S						
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Column		BUSY				
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3-10	74.2	BUSY				
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March   Marc						
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54	74.7	IDLE				
Section   Sect						
5-20	75	IDLE				
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Column	75.3					
100						
30	75.6	IDLE				
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AC	76	IDLE				
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Paid   Paid	78.9	IDLE				
79.3	79	IDLE				
733   DEE						
7-7-4	79.3	IDLE				
7-56   DEC   7-57   DEC   7-58   DEC   80	79.4	IDLE				
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81.7 IDLE 81.9 IDLE 82.1 IDLE 82.1 IDLE 82.1 IDLE 82.2 IDLE 82.4 IDLE 82.5 IDLE 82.5 IDLE 82.6 IDLE 82.7 IDLE 82.8 IDLE 83.1 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.4 IDLE 83.5 IDLE 83.5 IDLE 83.6 IDLE 83.6 IDLE 83.6 IDLE 83.6 IDLE 83.7 IDLE 83.7 IDLE 83.8 IDLE 83.8 IDLE 83.9 I	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
82 IDLE 82.1 IDLE 82.1 IDLE 82.2 IDLE 82.3 IDLE 22.4 IDLE 82.5 IDLE 82.6 IDLE 82.7 IDLE 82.8 IDLE 82.8 IDLE 83.1 IDLE 83.1 IDLE 83.1 IDLE 83.2 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.4 IDLE 83.4 IDLE 83.5 IDLE 83.6 IDLE 83.6 IDLE 83.7 IDLE 83.7 IDLE 83.8 IDLE 83.8 IDLE 83.9 IDL	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
82	80.6 80.7 80.8 80.9 81.1 81.2 81.3 81.4 81.5 81.6	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
\$2.1 OUE \$2.2 OUE \$2.3 OUE \$2.4 OUE \$2.5 OUE \$2.6 OUE \$2.6 OUE \$2.6 OUE \$2.7 OUE \$2.7 OUE \$2.8 OUE \$2.8 OUE \$3.1 OUE \$3.2 OUE \$3.3 OUE \$3.3 OUE \$3.3 OUE \$3.3 OUE \$3.4 OUE \$3.5 OUE \$3.6 OUE \$3.6 OUE \$3.7 OUE \$3.8 OUE \$3.8 OUE \$3.8 OUE \$3.8 OUE \$3.9 OUE \$3.9 OUE \$3.9 OUE \$3.9 OUE \$3.0 OUE \$3.	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
82.2 IDLE 82.4 IDLE 82.5 IDLE 82.6 IDLE 82.7 IDLE 82.7 IDLE 82.8 IDLE 82.9 IDLE 83.1 IDLE 83.1 IDLE 83.1 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.4 IDLE 83.5 IDLE 83.5 IDLE 83.6 IDLE 83.6 IDLE 83.6 IDLE 83.6 IDLE 83.7 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.9 I	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
82.4 IDLE 82.5 IDLE 82.6 IDLE 82.7 IDLE 82.8 IDLE 82.9 IDLE 83.1 IDLE 83.1 IDLE 83.1 IDLE 83.1 IDLE 83.2 IDLE 83.3 IDLE 83.5 IDLE 83.5 IDLE 83.6 IDLE 83.6 IDLE 83.6 IDLE 83.7 IDLE 83.7 IDLE 83.8 IDLY 83.8 IDLY 83.9 IDLY 84.1 IDLY 84.1 IDLY 84.1 IDLY 84.1 IDLY 84.2 IDLY 84.3 IDLY 84.3 IDLY 84.4 IDLY 84.3 IDLY 84.4 IDLY 84.5 IDLY 84.5 IDLY 84.6 IDLY 84.7 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.9 IDLY 84.9 IDLY 84.1 IDLY 84.1 IDLY 84.2 IDLY 84.3 IDLY 84.4 IDLY 84.5 IDLY 84.5 IDLY 84.6 IDLY 84.6 IDLY 84.7 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.9 IDLY 85.1 IDLY 85.1 IDLY 85.1 IDLY 85.2 IDLY 85.3 IDLY 85.5 I	80.6 80.7 80.8 80.9 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 81.9	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
82.5 IDLE 82.7 IDLE 82.7 IDLE 82.9 IDLE 83.1 IDLE 83.1 IDLE 83.1 IDLE 83.3 IDLE 83.3 IDLE 83.3 IDLE 83.5 IDLE 83.5 IDLE 83.6 IDLY 83.6 IDLY 83.7 IDLY 83.8 IDLY 83.9 IDLY 84.1 IDLY 84.1 IDLY 84.1 IDLY 84.1 IDLY 84.1 IDLY 84.1 IDLY 84.1 IDLY 84.2 IDLY 84.3 IDLY 84.3 IDLY 84.4 IDLY 84.5 IDLY 84.6 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.8 IDLY 84.9 IDLY 84.9 IDLY 85.1 IDLY 85.2 IDLY 85.3 IDLY 85.3 IDLY 85.4 IDLY 85.5 IDLY 85.6 IDLY 85.6 IDLY 85.6 IDLY 85.7 IDLY 85.7 IDLY 85.8 IDLY 85.8 IDLY 85.8 IDLY 85.8 IDLY 85.9 I	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 82.8 82.1	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
82.6 IDLE 82.8 IDLE 83.1 IDLE 83.1 IDLE 83.1 IDLE 83.2 IDLE 83.3 IDLE 83.4 IDLE 83.4 IDLE 83.5 IDLE 83.6 IDLE 83.6 IDLE 83.7 IDLE 83.8 IDLE 83.8 IDLE 83.8 IDLE 83.9 I	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 82.2 82.1	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
82.8 IDLE 83 IDLE 83 IDLE 83.1 IDLE 83.2 IDLE 83.3 IDLE 83.4 IDLE 83.5 Busy 83.6 Busy 83.7 Busy 83.8 Busy 84 Busy 84 Busy 84 Busy 84.1 Busy 84.2 Busy 84.3 Busy 84.4 Busy 84.4 Busy 84.5 Busy 84.6 Busy 84.6 Busy 84.7 Busy 84.8 Busy 84.8 Busy 84.8 Busy 84.8 Busy 84.9 Busy 85.1 Busy 86.1 Busy 87.8 Busy 88.1 Busy 88.2 Busy 88.3 Busy 88.4 Busy 88.5 Busy 88.5 Busy 88.6 Busy 88.7 Busy 88.8 Busy 88.9 B	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 82.1 82.2 82.3 82.4	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
8.2.9 IDLE 8.3.1 IDLE 8.3.1 IDLE 8.3.3 IDLE 8.3.5 IDLE 8.3.6 IDLE 8.3.6 IDLE 8.3.7 IDLE 8.3.7 IDLE 8.3.9 IDLE 8.3.0 IDLE	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 82.2 82.1 82.2 82.3 82.4 82.5 82.5	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
83 IDLE 83.2 IDLE 83.3 IDLE 83.4 IDLE 83.5 IDLE 83.6 IDLE 83.7 IDLE 83.7 IDLE 83.8 IDLS 83.9 IDLS 84.1 IDLS 84.1 IDLS 84.1 IDLS 84.1 IDLS 84.2 IDLS 84.3 IDLS 84.3 IDLS 84.4 IDLS 84.5 IDLS 84.5 IDLS 84.6 IDLS 84.6 IDLS 84.7 IDLS 84.7 IDLS 84.7 IDLS 84.8 IDLS 84.8 IDLS 84.9 IDLS 84.9 IDLS 85.1 IDLS 85.2 IDLS 85.3 IDLS 85.3 IDLS 85.3 IDLS 85.4 IDLS 85.5 IDL	80.6 80.7 80.8 80.9 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.1 82.2 82.3 82.5 82.6 82.7	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
83.1 IDLE 83.3 IDLE 83.6 IDLE 83.6 IDLE 83.7 IDLE 83.8 IDLE 83.8 IDLE 83.9 I	80.6 80.7 80.8 80.9 80.9 81.1 81.2 81.3 81.4 81.5 81.5 81.6 81.7 81.8 82.2 82.1 82.6 82.7 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.6 82.7 82.8 82.8 82.8 82.8 82.8 82.8 82.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
83.3 IDLE 83.5 IDLE 83.6 Lears	80.6 80.7 80.8 80.9 81.1 81.2 81.3 81.4 81.5 81.7 81.8 82.2 82.1 82.2 82.4 82.5 82.6 82.7 82.8 82.9 82.9 82.9 82.9 82.9 82.9 82.9	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
83.4 IDLE  83.5 IDLE  83.6 IDLE  83.7 IDLE  83.7 IDLE  83.8 IDLE  83.9 IDLSY  84.1 IDLSY  84.1 IDLSY  84.1 IDLSY  84.3 IDLSY  84.4 IDLSY  84.5 IDLSY  84.6 IDLSY  84.5 IDLSY  84.6 IDLSY  84.7 IDLSY  84.8 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.1 IDLSY  85.3 IDLSY  85.4 IDLSY  85.5 IDLSY  85.5 IDLSY  85.6 IDLSY  85.7 IDLSY  85.8 IDLSY  85.8 IDLSY  85.8 IDLSY  85.8 IDLSY  85.8 IDLSY  85.8 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY  85.9 IDLSY	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.1 82.2 82.4 82.5 82.6 82.7 82.8 83.8 83.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
83.5 INUS* 83.7 INUS* 83.8 INUS* 83.9 INUS* 84.1 INUS* 84.2 INUS* 84.3 INUS* 84.4 INUS* 84.5 INUS* 84.6 INUS* 84.6 INUS* 84.7 INUS* 84.8 INUS* 84.8 INUS* 84.6 INUS* 84.7 INUS* 84.8 INUS* 84.6 INUS* 84.7 INUS* 84.8 INUS* 84.8 INUS* 84.9 INUS* 85.1 INUS* 85.1 INUS* 85.1 INUS* 85.1 INUS* 85.2 INUS* 85.3 INUS* 85.4 INUS* 85.5 INUS* 85.5 INUS* 85.5 INUS* 85.5 INUS* 85.5 INUS* 85.5 INUS* 85.6 INUS* 85.7 INUS* 85.8 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS* 85.9 INUS*	80.6 80.7 80.8 80.9 80.9 81.1 81.1 81.2 81.3 81.4 81.5 81.5 81.6 82.2 82.1 82.2 82.3 82.4 82.5 82.9 83.3 83.1 83.2 83.1 83.2 83.1	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
83.7 ausy 83.8 ausy 84 ausy 84.1 ausy 84.2 ausy 84.3 ausy 84.4 ausy 84.4 ausy 84.5 ausy 84.6 ausy 84.7 ausy 84.8 ausy 85.1 ausy 85.1 ausy 85.1 ausy 85.1 ausy 85.2 ausy 85.3 ausy 85.3 ausy 85.4 ausy 85.5 ausy	80.6 80.7 80.8 80.8 80.8 80.8 80.8 80.8 80.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
83.8	80.6 80.7 80.8 80.9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.1 82.2 82.3 82.4 82.5 82.7 82.8 83.3 83.3 83.3 83.4	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE				
84	80.6 80.7 80.8 80.8 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.1 82.2 82.3 82.4 82.5 82.6 83.3 83.3 83.3 83.3 83.3 83.3 83.3 83	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.1 BUSY 84.3 BUSY 84.4 BUSY 84.4 BUSY 84.6 BUSY 84.6 BUSY 84.8 BUSY 84.9 BUSY 85 BUSY 85.1 BUSY 85.1 BUSY 85.2 BUSY 85.3 BUSY 85.3 BUSY 85.4 BUSY 85.5 BUSY	80.6 80.7 80.8 80.9 81.1 81.1 81.2 81.4 81.5 81.6 81.7 82.2 82.1 82.2 82.3 82.4 82.5 82.6 83.3 83.3 83.4 83.3 83.3 83.4 83.3 83.3	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.2	80.6 80.7 80.8 80.9 81 81.1 81.1 81.2 81.5 81.6 81.7 82.2 82.1 82.2 82.3 82.4 82.5 82.6 82.7 83.3 83.3 83.4 83.5 83.8 83.9 83.8 83.8 83.8 83.8 83.8 83.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.3 BUSY 84.5 BUSY 84.6 BUSY 84.7 BUSY 84.8 BUSY 84.9 BUSY 85.1 BUSY 85.1 BUSY 85.2 BUSY 85.4 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.6 BUSY 85.7 BUSY 85.8 BUSY 85.8 BUSY	80.6 80.7 80.8 80.9 81.1 81.1 81.2 81.5 81.6 81.7 81.8 82.2 82.1 82.4 82.5 82.6 82.7 82.8 83.3 83.3 83.3 83.3 83.3 83.3 83.3	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.4 BUSY 84.6 BUSY 84.7 BUSY 84.8 BUSY 84.9 BUSY 85.1 BUSY 85.1 BUSY 85.1 BUSY 85.2 BUSY 85.3 BUSY 85.3 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY 85.5 BUSY	80.6 80.7 80.8 80.9 81 81.1 81.1 81.2 81.5 81.6 81.7 82.2 82.1 82.2 82.3 82.4 82.5 82.6 82.7 83.3 83.3 83.4 83.5 83.8 83.9 83.8 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.9 83.8 83.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.5	80.6 80.7 80.8 80.9 81 81.1 81.1 81.2 81.3 81.4 81.5 81.7 82.2 82.1 82.2 82.3 82.4 82.5 82.6 82.7 82.8 83.8 83.8 83.8 83.8 83.8 83.8 83.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.7 BUSY 84.9 BUSY 85.1 BUSY 85.1 BUSY 85.2 BUSY 85.3 BUSY 85.4 BUSY 85.5 BUSY 85.6 BUSY 85.7 BUSY 85.8 BUSY 85.8 BUSY	80.6 80.7 80.8 80.9 9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.1 82.2 82.5 82.6 82.7 82.8 83.3 83.4 83.5 83.6 83.7 83.8 83.1 83.2 83.3 83.4 84.4 84.3 84.3 84.4	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.8	80.6 80.7 80.8 80.8 80.9 80.9 80.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.3 82.4 82.5 82.6 82.7 82.8 83.3 83.4 83.5 83.9 84.1 84.2 84.3 84.4 84.5 84.5 85.8 86.8 86.8 86.8 86.8 86.8 86.8 86	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
84.9	80.6 80.7 80.8 80.9 9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.8 82.9 83 83.4 83.5 83.8 83.9 84.4 84.5 84.4 84.5 86.6 80.7 80.8 80.6 80.7 80.8 80.6 80.7 80.8 80.6 80.7 80.8 80.6 80.8 80.8 80.8 80.8 80.8 80.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85 ausy 85.1 ausy 85.2 ausy 85.3 ausy 85.4 ausy 85.5 ausy 85.5 ausy 85.5 ausy 85.6 ausy 85.7 ausy 85.9 ausy 85.9 ausy	80.6 80.7 80.8 80.9 9 81 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.8 82.9 83 83.4 83.5 83.8 83.9 84.1 84.2 84.5 84.6 84.7 84.8 84.8	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85.2 BUSY 85.3 BUSY 85.4 BUSY 85.5 BUSY 85.6 BUSY 85.7 BUSY 85.8 BUSY 85.9 BUSY	80.6 80.7 80.8 80.8 80.9 80.1 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.1 82.3 82.4 82.5 82.6 83.3 83.1 83.1 83.2 82.4 83.3 83.4 83.4 84.4 84.5 84.6 84.7 84.8 84.9	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85.3 BUSY 85.4 BUSY 85.5 BUSY 85.6 BUSY 85.7 BUSY 85.8 BUSY 85.9 BUSY	80.6 80.7 80.8 80.9 9 81 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 81.9 82.1 82.2 82.1 82.2 82.3 83.3 83.4 83.5 83.9 84 84.1 84.2 84.3 84.4 84.5 84.6 84.7 84.8 84.9 85.5	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85.4 BUSY 85.5 BUSY 85.6 BUSY 85.7 BUSY 85.8 BUSY 85.9 BUSY	80.6 80.7 80.8 80.9 80.9 80.9 80.9 80.9 80.8 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 81.9 82.4 82.5 82.6 82.7 82.8 83.3 83.4 83.5 83.6 83.7 84.6 84.7 84.8 84.9 84.5 84.8 84.9 84.8 84.9 84.8 84.9 84.8 84.9 84.8 84.9 85.5 81.1	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85.5 BUSY 85.6 BUSY 85.7 BUSY 85.8 BUSY 85.9 BUSY	80.6 80.7 80.8 80.9 99 81 81.1 81.1 81.2 81.3 81.4 81.5 81.5 81.6 81.7 82.8 82.9 82.9 83 83.4 83.5 83.9 84 84.1 84.2 84.3 84.4 84.5 84.6 84.7 84.8 84.9 84.9 85.1 86.8 85.1	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85.7 BUSY 85.8 BUSY 85.9 BUSY	80.6 80.7 80.8 80.9 81 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 81.9 82.2 82.1 82.2 82.3 83.4 83.5 83.6 83.7 83.8 84.4 84.1 84.2 84.3 84.4 84.3 84.4 84.5 85.3 85.4	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85.8 85.9 BUSY	80.6 80.7 80.8 80.9 80.9 80.9 80.8 80.9 80.9 80.8 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 82.2 82.1 82.4 82.5 82.6 82.7 82.8 83.3 83.1 83.2 82.4 82.5 82.6 83.7 83.8 83.9 84.4 84.5 84.5 84.5 85.5 85.4 85.5 85.4 85.5 85.4	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
85.9 BUSY	80.6 80.7 80.8 80.9 99 81 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 81.9 82.1 82.2 82.1 82.3 83.4 83.5 83.4 83.5 83.4 84.4 84.5 84.6 84.7 84.8 84.9 84.9 85.5 85.5 85.5 85.5 85.5 85.5 85.5 85	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
86 BUSY	80.6 80.7 80.8 80.9 80.9 80.9 80.8 80.9 80.9 80.8 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 81.9 82.1 82.2 82.3 82.4 82.5 82.6 82.7 82.8 83.3 83.4 83.5 83.6 83.7 83.8 83.9 84.4 84.5 84.5 84.6 84.7 84.8 84.9 84.9 85.5 85.6 85.7 85.5 85.6 85.6 85.7	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			
	80.6 80.7 80.8 80.9 81 81.1 81.1 81.2 81.3 81.4 81.5 81.6 81.7 81.8 82.2 82.1 82.2 82.3 83.3 83.4 83.5 83.6 83.7 83.8 84.4 84.1 84.5 84.6 85.5 85.6 85.7	IDLE IDLE IDLE IDLE IDLE IDLE IDLE IDLE	4.8s: service time			

86.1	BUSY					
86.2 86.3	BUSY BUSY					
86.4	BUSY					
86.5	BUSY					
86.6	BUSY					
86.7 86.8	BUSY BUSY					
86.8	BUSY					
87	BUSY					
87.1	BUSY					
87.2 87.3	BUSY					
87.4	BUSY BUSY					
87.5	BUSY					
87.6	BUSY					
87.7 87.8	BUSY BUSY					
87.8	BUSY					
88	BUSY					
88.1	BUSY					
88.2	BUSY					
88.3 88.4	BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
88.5	BUSY		7.23. Service time			
88.6	BUSY					
88.7	BUSY					
88.8 88.9	BUSY BUSY					
89	BUSY					
89.1	BUSY					
89.2	BUSY					
89.3 89.4	BUSY BUSY					
89.5	BUSY					
89.6	BUSY					
89.7	BUSY					
89.8 89.9	BUSY BUSY					
90	BUSY					
90.1	BUSY	5.5s: get part from INPUT conveyor; load part				
90.2	BUSY	to machine				
90.3 90.4	BUSY BUSY					
90.4	BUSY					
90.6	BUSY					
90.7	BUSY					
90.8 90.9	BUSY BUSY					
90.9	BUSY					
91.1	BUSY					
91.2	BUSY					
91.3	BUSY					
91.4 91.5	BUSY BUSY					
91.6	BUSY					
91.7	BUSY					
91.8	BUSY					
91.9 92	BUSY BUSY					
92.1	BUSY					
92.2	BUSY					
92.3	BUSY					
92.4 92.5	BUSY BUSY					
92.5	BUSY					
92.7	BUSY					
92.8	BUSY					
92.9	BUSY					
93 93.1	BUSY BUSY					
93.2	BUSY					
93.3	BUSY					
93.4	BUSY					
93.5 93.6	BUSY BUSY					
93.7	BUSY					
93.8	BUSY					
93.9	BUSY					
94 94.1	BUSY BUSY					
94.1	BUSY					
94.3	BUSY					
94.4	BUSY					
94.5 94.6	BUSY BUSY					
94.7	BUSY					
94.8	BUSY					
94.9	BUSY					
95 95.1	BUSY BUSY					
95.2	BUSY					
95.3	BUSY					
95.4 95.5	BUSY BUSY					
95.6	BUSY		33s: machine cycle	4.8s: retrieve part, place on output	4.8s: service time	
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129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.2 132.3 132.4 132.5 132.6 132.5 132.6 132.5	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY					
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129.1 129.2 129.3 129.4 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.1 132.2 132.3 132.4 132.5 132.6 132.6 132.7 132.8 132.8 132.8 132.8 132.8 132.8 132.8 132.8	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY					
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129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131.1 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.1 132.2 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.1 133.1 133.1 133.1	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.3 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.1 131.1 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.2 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.3 133.1 133.1 133.1 133.1 133.3 133.3 133.3 133.3	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.2 132.3 133.4 133.5 133.6 133.7 133.8	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.2 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.3 133.4 133.5 133.6 133.7 133.8 133.9	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.2 132.3 133.1 134.4 135.5 136.6 139.7 139.8 139.9 139.9 139.1 139.1 139.2 139.3	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131.1 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.2 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.3 133.4 133.1 133.1 133.2 133.3 133.4 133.5 133.6 133.7 133.8 133.9 133.8 133.9 133.1 133.1 133.1 133.1 133.2 133.3 133.4 133.5 133.6 133.7 133.8 133.8 133.9 133.8 133.9 133.8 133.9 133.8 133.9 133.8 133.8 133.9 134.1 134.1	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.4 129.5 129.6 129.7 129.8 129.9 130.0 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.2 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.3 133.4 133.5 133.6 133.7 133.8 133.9 133.1 133.1 133.1 133.1 133.2	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.6 129.7 129.8 129.9 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.1 132.1 132.1 132.1 132.3 133.1 134.4 134.1 134.2 133.3 133.4 134.4 134.2	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 132.1 132.2 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.3 133.1 133.1 133.2 133.3 133.4 133.5 133.6 133.7 133.8 133.9 133.7 133.8 133.9 133.7 133.8 133.9 134.1 134.2 134.1 134.2 134.3 134.4 134.5 134.6	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.4 129.5 129.6 129.7 129.8 129.9 130.0 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.1 132.1 132.1 132.3 132.4 132.5 132.6 132.7 132.8 133.3 133.4 134.1 134.2 134.3 134.4 134.5	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 132.1 132.2 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.3 133.1 133.1 133.2 133.3 133.4 133.5 133.6 133.7 133.8 133.9 133.7 133.8 133.9 133.7 133.8 133.9 134.1 134.2 134.1 134.2 134.3 134.4 134.5 134.6	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	1.7s: move to pickup pos.	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.1 130.2 130.6 130.6 130.7 130.8 130.9 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.2 132.3 133.1 133.1 133.1 134.4 135.5 136.6 137.7 138.8 139.9 139.3 131.3 131.4 132.1 132.2 132.3 133.3 133.4 133.5 133.6 133.7 133.8 133.9 133.1 133.2 133.3 133.1 133.2 133.3 133.3 133.4 133.5 133.6 133.7 133.8 133.9 134.4 134.1 134.1 134.1 134.1 134.2 134.3 134.4 134.5 134.6 134.7 134.8 134.9 135.1	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY	5.5s; get gart from BIPUT conveyor, load part	7.2s: service time			
129.1 129.2 129.3 129.4 129.5 129.6 129.7 129.8 129.9 130.1 130.1 130.1 130.2 130.3 130.4 130.5 130.6 130.7 130.8 130.9 131 131.1 131.2 131.3 131.4 131.5 131.6 131.7 131.8 131.9 132.1 132.1 132.1 132.1 132.1 132.1 132.3 132.4 132.5 132.6 132.7 132.8 132.9 133.1 134.1	BUSY BUSY BUSY BUSY BUSY BUSY BUSY BUSY		7.2s: service time			

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140.6	BUSY	33s: machine cycle	4.8s: retrieve part, place on output	4.8s: service time
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145.5	BUSY		and the state of t	7.23. Service time
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146.7 146.8 146.9 147 147.1	BUSY BUSY BUSY		5.5s: get part from INPUT conveyor; load part to machine	
146.7 146.8 146.9 147 147.1 147.2	BUSY BUSY		5.5s: get part from INPUT conveyor; load part to machine	
146.7 146.8 146.9 147 147.1	BUSY BUSY BUSY BUSY		5.5s: get part from INPUT conveyor; load part to machine	

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152.6	BUSY		33s: machine cycle	4.8s: retrieve part, place on output	4.8s: service time
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157.4	BUSY			2.72 move to pickup pos.	7.25. SerVICE TIME
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