

1

1

```
1 t1 = 9:00 q:2 w周转 = 1h w加权周转 = 1/1 = 1
2 t2 = 9:30 q:3,4 w周转 = 40min = 0.6h w加权周转 = 0.6/0.5=1.2
3 t3 = 9:42 q:4 w周转 = 42m = 42/60h w加权周转 = 42/12 = 7/2 = 3.5
4 t4 = 9:48 w4 = 32m w周转 = 38m = 38/60h w加权周转 = 38/6 = 19/3
5 T = 1.2h/4=0.3h/process
6 w = 3.008333
```

2

```
1 t1 = 9:00 q:2 w周转1 = 1h w加权1 = 1/1 = 1
2 t2 = 9:30 q:3,4 w周转2 = 40min w加权2 = 2/3/0.2 = 4/3
3 t3 = 9.6 q:3 w周转4 = 26min w加权4 = 26/60/0.1 = 13/3
4 t4 = 9.8 w周转3 = 0.8h w加权3 = 0.8/0.2 = 4
5 T = (1.8+66/60)/4 = 0.725
6 w = 1.778
```

3

```
1 t1 = 9:00 q:2
2 t2 = 9:30 q:3,4
3 RR3 = (0.5+0.2)/0.2 =3.5 RR4 = (1/3+0.1)/0.1 = 4
4 t3 = 9.6
5 t4 = 9.8
6 T = 0.725
7 w = 1.778
```

2

1

```
1 t1_1 = 10 q:2,3,4,5 w周转1 = 10
2 t2_2 = 16 q:3,4,5 w周转2 = 16
3 t3_3 = 18 q:4,5 w周转3 = 18
4 t4_4 = 22 q:5 w周转4 = 22
5 t5_5 = 30 w周转5 = 30
6 T = 56/5 = 11.2
```

2

1	$P1 = 30$
2	$P2 = 22$
3	$P3 = 6$
4	$P4 = 16$
5	$P5 = 28$
6	$T = 20.4$

3

1	$P4 = 4$
2	$P3 = 6$
3	$P1 = 16$
4	$P5 = 24$
5	$P2 = 30$
6	$T = 80/5 = 16$