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2013 12 tasks to

4 workers (a)

Worker Task(s)

Activity Time

(sec) Capacity

(units per hour)

1 1,2,3 70 51.43

2 4,5,6 55 65.45

3 7,8,9 85 42.35

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4 10, 11, 12 60 60

(a) Capacity = $1 / 85 \text{ sec} = 42.35$
units per hour

(b) Direct labor
content =

$(70+55+85+60)$

sec = 270

sec/unit or 4.5

min/unit (c)

Labor

utilization =

labor content /

(labor content +

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total idle time)
 $= 270 \text{ sec} / (270$
 $+ 15 + 30 + 0 + 25$
 $\text{sec}) = 79.41\%$

(d) Note that we
are facing a ...

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following mixed-
integer linear
program: $\max 2x_1 + 3x_2$ st $4x_1 + 9x_2 \leq 36$ $7x_1 +$

$x_2 \leq 7$ $x_1, x_2 \geq 0$ and integer

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of stations to
meet $D = 400$ is.

$$N = \frac{D}{S} = \frac{400}{115} = 3.4 \rightarrow 4$$

tations. $T = 60$
seconds $\times 480$
minutes) 72.400
units. c. Use
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