

SIMULATION OF MANUFACTURING SYSTEMS

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ABSTRACT

This paper discusses how simulation is used to design new manufacturing systems and to improve the performance of existing ones. Topics to be discussed include: manufacturing issues addressed by simulation, simulation software for manufacturing applications, techniques for building valid and credible models, and statistical considerations. A comprehensive example will be given in the conference presentation.

1 INTRODUCTION

One of the largest application areas for simulation modeling is that of manufacturing systems, with the first uses dating back to at least the early 1960's. In this paper we present an overview of the use of simulation in the design and analysis of manufacturing systems. Detailed discussions of simulation, in general, may be found in Banks, Carson, and Nelson (1996) and Law and Kelton (1999). A practical discussion of the steps in a sound simulation study is given in Law and McComas (1990). This paper is a synopsis of a three-day short course with the same title as this paper, which the first author has given more than fifty times since 1985.

2 MANUFACTURING ISSUES ADDRESSED BY SIMULATION

The following are some of the specific issues that simulation is used to address in manufacturing:

The need for and the quantity of equipment and personnel

- Number, type, and layout of machines for a particular objective
- Requirements for transporters, conveyors, and other support equipment (e.g., pallets and fixtures)

- Location and size of inventory buffers
- Evaluation of a change in product volume or mix
- Evaluation of the effect of a new piece of equipment on an existing manufacturing system
- Evaluation of capital investments
- Labor requirements planning
- Number of shifts

Performance evaluation

- Throughput analysis
- Time-in-system analysis
- Bottleneck analysis

Evaluation of operational procedures

- Production scheduling
- Inventory policies
- Control strategies [e.g., for an automated guided vehicle system (AGVS)]
- Reliability analysis (e.g., effect of preventive maintenance)
- Quality-control policies

The following are some of performance measures commonly estimated by simulation:

- Throughput
- Time in system for parts
- Times parts spend in queues
- Queue sizes
- Timeliness of deliveries
- Utilization of equipment or personnel

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