Software Implementation of Several Production Scheduling Algorithms

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Keywords: Scheduling algorithms, production schedules, manufacturing process.

Abstract: The paper presents several production scheduling algorithms and their software implementation in an experimental program system developed in the program environment of the MATLAB system. The main characteristics and functionality of the individual software modules are described and illustrated by numerical examples.

1 INTRODUCTION

The theory of scheduling deals with problems for optimal allocation of scarce resources for implementation of various activities over time. One broad class of scheduling problems involves the dsign of production scheduling algorithms aimed at the optimization of technological machine and production capacity utilization in a production process. Typically, such a process is characterized by a number of jobs which have to be processed on a number of machines or work places in a given order or sequence. Depending on the specifics, scale and complexity of the particular production process the design of such schedules may represent a difficult and intractable task. It is obvious, however, that the use of optimal production schedules directly affects the production process leading to reduced costs and savings in energy and materials.

In this paper, we present a programme implementation of six production scheduling algorithms which are intended to solve some frequently arising scheduling problems in the production processes of small and medium companies. The algorithms have been developed in the course of a project supported by the National innovation fund as a part of an experimental programme system for production scheduling and inventory control in small and medium enterprises.

2 MODELS OF SCHEDULING PROBLEMS AND RELATED WORK

We shall consider deterministic models of scheduling problems where the number of jobs is denoted by n and the number of machines by m. Usually, the subscript j refers to a job while the subscript i refers to a machine. The following important data are associated with job j, (Pinedo, 2008).

Processing time (p_{ij}) The p_{ij} represents the processing time of job j on machine i. The subscript i is omitted if the processing time of job j does not depend on the machine or if job j is only to be processed on one given machine.

Release date (r_j) The release date r_j of job j may also be referred to as the ready date. It is the time the job arrives at the system, i.e., the earliest time at which job j can start its processing.

Completion time (C_j) This is the moment of time at which the job j comes out of the system. Clearly, the completion time of job j depends on the jobs that have been processed before it.

Due date (d_j) The due date d_j of job j represents the committed shipping or completion date (i.e., the date the job is promised to the customer).

Completion of a job after its due date is allowed, but then a penalty is incurred. When a due date must be met it is referred to as a deadline and denoted by d_j.

Weight (w_j) The weight w_j of job j is basically a priority factor, denoting the importance of job j relative to the other jobs in the system. For example, this weight may represent the actual cost of keeping the job in the system. This cost could be a holding or inventory cost; it also could represent the amount of value already added to the job.

In the current literature it is commonly accepted to describe a scheduling problem by the triplet **< α | β | γ >.** The **α** field describes the machine environment and contains just one entry. The **β** field provides details of processing characteristics and constraints and may contain no entry at all, a single entry, or multiple entries. The **γ** field describes the objective to be minimized and often contains a single entry. Models of many scheduling problems can be described in terms of the triplet **< α | β | γ >,** e.g., see (Brucker, 2007, Pinedo, 2008).

We shall illustrate the usage of the above notation by the following simple models.

- **$1 \mid \mid \Sigma C_j$** denotes the model of a scheduling problem where the jobs are processed on one machine, no preemptions are allowed and the objective is to minimize the sum of completion times of all jobs.
- **$1 \mid r_j \mid \Sigma C_j$** denotes a variant of the above problem where, in addition, release dates of the jobs are specified indicating times at which jobs can start their processing.
- **$1 \mid r_j$, *prmp, prec* | C_{max}** denotes the model of a scheduling problem with one machine where the jobs have release dates, their processing can be interupted, there are precedence restrictions and the objective is to minimize the processing time of all jobs.

There are different types of schedules and one of the first classification of various scheduling problems can be found in the seminal work of Conway et al., (1967). A comprehensive study of scheduling algorithms and their complexity is presented in Lawler et al., (1993). Deterministic scheduling problems are considered in Graham et al., (1979) and a survey of scheduling problems subject to various constraints is given by Lee, (2004). Special classes of scheduling problems with penalties and non-regular objective functions are considered by Baker and Scudder, (1990) and Raghavachari, (1988). A survey of scheduling problems with job families and problems with batch processing, can be found in the work of Potts and Kovalyov (2000). In the more recent literature, production scheduling is also attracting a considerable amount of research. A classification, models and complexity results on problems for parallel machine scheduling are given by Edis et al., (2013) and Prot et al., (2013). References (Allahverdi et al., 2008), (Janiak et al., 2015) and (Kovalyov et al., 2007) represent surveys on scheduling problems with setup times, due windows and jobs with fixed intervals, respectively. Tools for multicriteria scheduling are desribed in (Hoogeveen, 2005) and architectures of manufacturing scheduling systems are discussed in (Framinan and Ruiz, 2010). Finaly, it should be noted that the monographs (Brucker, 2007) and (Pinedo, 2008) give a systematic view of the research work and advancement in the area of scheduling theory and its applications.

3 GENERAL DESCRIPTION OF THE PROGRAM SYSTEM

Our experimental software system is designed to solve a number of problems arising in the technological management of small and medium-size enterprises. Two main groups of problems are under consideration. The system architecture is shown in Figure 1.

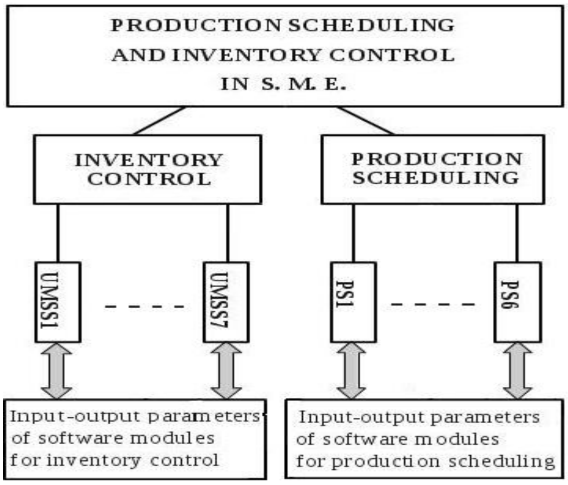

PRODUCTION SCHEDULING AND INVENTORY CONTROL IN S. M. E.
INVENTORY CONTROL
PRODUCTION SCHEDULING
UMSS1
UMSS7
PS1
PS6
Input-output parameters of software modules for inventory control
Input-output parameters of software modules for production scheduling

Figure 1. System architecture

It is seen that it includes two main branches, corresponding to the two groups of problems related with inventory control and production scheduling, respectively. Each branch in turn includes algorithmic software modules to solve specific tasks in the group. The programme system provides an interactive mode of operation in which the user can choose one of the two main branches and then starts a specific algorithmic module depending on the particular problem to be solved. In the process of system operation, input-output parameters of the system turn out to be input-output parameters of the currently active module.

The description of program modules of UMSS1 to UMSS7 in Figure 1, as well as the specific tasks to be solved by means of these modules were presented in (Monov and Tashev, 2011). Program modules from PS1 to PS6 will be described in the next section.

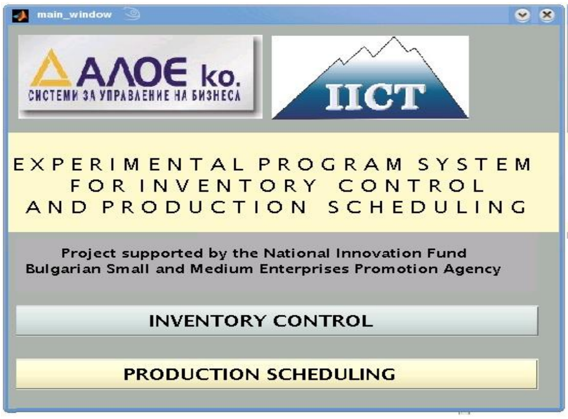
The graphical user interface of the system is simplified and it includes three main modules:

main_window - interface module, bringing up the main menu of the system;

start1_interface - interface module, displaying the inventory control menu;

start2_interface - interface module displaying the production scheduling menu.

The computer screen with the interface module **main_window** is shown in Figure 2 and the launch of this module in fact starts the system.



EXPERIMENTAL PROGRAM SYSTEM
FOR INVENTORY CONTROL
AND PRODUCTION SCHEDULING

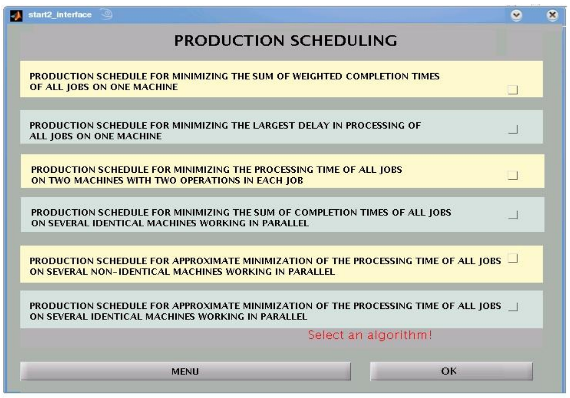
Project supported by the National Innovation Fund
Bulgarian Small and Medium Enterprises Promotion Agency

Figure 2. System main window

By choosing one of the two groups of tasks, the user can start the corresponding interface module which displays the menu for choosing a particular task to be solved. The computer screen of the interface module displaying the production scheduling menu is shown in Figure 3.

Each of the algorithmic software modules can work within the program system and as an independent module as well. In the second case it is necessary the name of the module to be typed in the command window of MATLAB. Then the introduction of input data and the output of results is accomplished by means of the system facilities of the MATLAB programming environment. Each module includes the following capabilities:

- Data input is performed in an interactive mode from a standard keyboard, and the results are displayed automatically after completing the work of the algorithm.
- In each module, a check for correctness of the input data is performed, an opportunity to reintroduce incorrectly entered data is foreseen, and also an opportunity is provided to exit the module during data entry before the start of the computational algorithm.
- Depending on the specifics of the particular algorithm, the software module displays the necessary messages concerning the problem being solved.
- After completion of the work and upon a request of the operator, input data and results can be stored in a specified user file outside of the system for further processing and analysis. The name of this file is defined by the user.



PRODUCTION SCHEDULING

PRODUCTION SCHEDULE FOR MINIMIZING THE SUM OF WEIGHTED COMPLETION TIMES OF ALL JOBS ON ONE MACHINE □

PRODUCTION SCHEDULE FOR MINIMIZING THE LARGEST DELAY IN PROCESSING OF ALL JOBS ON ONE MACHINE □

PRODUCTION SCHEDULE FOR MINIMIZING THE PROCESSING TIME OF ALL JOBS ON TWO MACHINES WITH TWO OPERATIONS IN EACH JOB □

PRODUCTION SCHEDULE FOR MINIMIZING THE SUM OF COMPLETION TIMES OF ALL JOBS ON SEVERAL IDENTICAL MACHINES WORKING IN PARALLEL □

PRODUCTION SCHEDULE FOR APPROXIMATE MINIMIZATION OF THE PROCESSING TIME OF ALL JOBS ON SEVERAL NON-IDENTICAL MACHINES WORKING IN PARALLEL □

PRODUCTION SCHEDULE FOR APPROXIMATE MINIMIZATION OF THE PROCESSING TIME OF ALL JOBS ON SEVERAL IDENTICAL MACHINES WORKING IN PARALLEL □

Select an algorithm!

Figure 3. Interface module **start2_interface**

4 SOFTWARE MODULES FOR PRODUCTION SCHEDULING

In this section, we briefly describe the scheduling problems under consideration and illustrate the work of the corresponding software modules intended to solve these problems.

4.1 Production schedule for minimizing the sum of weighted completion times of all jobs on one machine - $\Sigma w_i C_i$

<u>Problem formulation.</u> The scheduling problem is characterized by one machine environment, i.e. n=1 and m jobs. Each of these jobs has one operation (consisting of a single operation), with processing time p_j. Clearly, in any random order of

implementation of the jobs, they will all be fulfilled in time $\Sigma\ p_j$. The completion times and weights of the jobs are C_j and w_j, respectively. The problem consists in finding such a sequence of jobs processing which will minimize the weighted sum of completion times of all jobs. Thus, the implemented algorithm minimizes the quantity $\Sigma\ w_i\ C_i$.

Input data. These are: the number m of jobs, the numbers $p_j > 0$ and numbers $w_j > 0$.

Output data. This is the optimal schedule indicating the sequence of processing of jobs that will minimize the quantity $\Sigma\ w_j\ C_j$. The optimal value of $\Sigma\ w_j\ C_j$ is also computed.

The above problem is solved by means of the software module **PS1.** The work of the module is illustrated by the following numerical example.

Example 1. Consider the scheduling problem with three jobs which have to be processed on one machine with numerical data given in Table 1.

Table 1. Numerical data for Example 1.

Jobs, J_j	Processing times, p_i	Weights, w_j
J_1	4	3
J_2	2	1
J_3	5	4

The software module **PS1** computes the quantities $q_j = p_j / w_j$, finds the optimal schedule and the minimal value of $\Sigma\ w_i C_i$. The output results are written in a user file which is given below.

PRODUCTION SCHEDULE FOR MINIMIZING THE SUM OF WEIGHTED COMPLETION TIMES OF ALL JOBS ON ONE MACHINE - 1 | | $\Sigma\ w_i C_i$

Optimal schedule

Job: 3
- Processing time (P_3): 5
- Weight (W_3): 4
- Value q = P_3 / W_3: 1.25
- Completion time (C_3): 5
- Value (W_3C_3): 20

Job: 1
- Processing time (P_1): 4
- Weight (W_1): 3
- Value q = P_1 / W_1: 1.3333
- Completion time (C_1): 9
- Value (W_1C_1): 27

Job: 2
- Processing time (P_2): 2
- Weight (W_2): 1
- Value q = P_2 / W_2: 2
- Completion time (C_2): 11
- Value (W_2C_2): 11

Minimal value: Sum (WjCj) = 58

4.2 Production schedule for minimizing the largest delay in processing of all jobs on one machine - 1 | | Lmax

Problem formulation. In this case, the objective is to find an optimal schedule for the operation of one machine under the following conditions. The number of jobs to be processed is m and for each job j two variables are given: the processing time p_j and the due date d_j. All jobs are available at the initial time and this allows them to be processed in any order. If you choose such an order, then the job j will be completed at the time C_j and thus the delay of the job is C_j - d_j. For any chosen order (sequence) of processing, the delays of the jobs can be calculated. Each particular order of jobs processing is characterized by the maximum value among these delays. The aim in this production scheduling problem is to find this sequence of jobs processing for which this maximum delay is as small as possible.

Input data. These are: the number m of jobs, the numbers $p_j > 0$ and numbers $d_i > 0$.

Output data. This is the optimal schedule indicating the sequence of processing of jobs that will minimize the maximal delay L_{max} of jobs. The minimal value of L_{max} is also computed.

The above problem is solved by means of the software module **PS2.** The work of the module is illustrated by the following numerical example.

Example 2. Consider the scheduling problem with three jobs which have to be processed on one machine with numerical data given in Table 2.

Table 2. Numerical data for Example 2.

Jobs, J_i	Processing times, p_i	Due dates, d_i
J_1	3	4
J_2	5	6
J_3	2	5

The software module **PS2** computes the optimal sequence of jobs processing which is $<J_{1,}\ J_{3,}\ J_2>$ and the minimal value of L_{max} which is L_{max} = 4. For comparison, if the jobs are processed in the order $<J_{2,}\ J_{3,}\ J_1>$ then the corresponding delay is 6. The output results are written in a user file which is given below.

```
PRODUCTION SCHEDULE FOR MINIMIZING THE
LARGEST DELAY IN PROCESSING OF ALL JOBS
ON ONE MACHINE  -  1 | |  LMAX

                    Optimal schedule

Job: 1
- Processing time ($P_1$): 3
- Due date ($D_1$): 4
- Completion time ($C_1$): 3
- Delay $C_1$-$D_1$: -1

Job: 3
- Processing time ($P_3$): 2
- Due date ($D_3$): 5
- Completion time ($C_3$): 5
- Delay $C_3$-$D_3$: 0

Job: 2
- Processing time ($P_2$): 5
- Due date ($D_2$): 6
- Completion time ($C_2$): 10
- Delay $C_2$-$D_2$: 4

The largest delay in the processing of jobs: $C_2$-$d_2$ = 4
for job 2
```

4.3. Production schedule for minimizing the processing time of all jobs on two machines with two operations in each job F2 | | Cmax

Problem formulation. In this production scheduling problem we have two machines which, in general, are different. The number of jobs to be processed is m and each of these jobs has two operations. For each job the first operation is performed on machine 1 and lasts a_j time units and the second operation is performed on machine 2 and has a length b_j. The essential question in this problem is that for each job the second operation can be run on a machine 2 only after the complete implementation of the first operation on the machine 1. It is necessary to find such a sequence of jobs processing, in other words to find such a schedule, at which the execution of all the jobs is completed in the shortest time.

Input data. These are: the number m of jobs, the processing times a_j of the first operations and the processing times b_j of the second operations.

Output data. This is the optimal schedule indicating the sequence of processing of jobs on the two machines that will minimize the overall processing time. The value of this time is also indicated.

Remark. It should be noted that the optimal sequence for the first machine is performed by consecutively processing the first operations of the jobs running on the machine immediately one after another. The second operations of the jobs, however, are executed on the second machine only after the first operations has been completed on the first machine.

The above problem is solved by means of the software module **PS3.** The work of the module is illustrated by the following numerical example.

Example 3. Consider the scheduling problem with three jobs which have to be processed on two machines with numerical data given in Table 3.

Table 3. Numerical data for Example 3.

Jobs, J_j	Processing times a_j of the first operations on Machine 1	Processing times b_j of the second operations on Machine 2
J_1	4	1
J_2	2	5
J_3	6	3

The software module **PS3** computes the optimal sequence of jobs processing which is <$J_{2,}$ $J_{3,}$ J_1 > and the minimal processing time of all jobs is 13. For comparison, if the jobs are processed in the order <$J_{1,}$ $J_{2,}$ J_3 > then the corresponding processing time is 15. The output results are written in a user file which is given below.

```
PRODUCTION SCHEDULE FOR MINIMIZING THE
PROCESSING TIME OF ALL JOBS ON TWO MACHINES
WITH TWO OPERATIONS IN EACH JOB:   F2 || CMAX

                    Optimal schedule

Job: 2
- Processing time of operation 1 for this job: 2
- Processing time of operation 2 for this job: 5

Job: 3
- Processing time of operation 1 for this job: 6
- Processing time of operation 2 for this job: 3

Job: 1
- Processing time of operation 1 for this job: 4
- Processing time of operation 2 for this job: 1
```

```
_______________________________________________
Minimum total execution time of all jobs : 13
_______________________________________________
```

4.4. Production schedule for minimizing the sum of completion times of all jobs on several identical machines working in parallel - P || Σ Cj

Problem formulation. The following production scheduling problem is considered. There are n identical machines working in parallel. The number of jobs to be processed is m and each of these jobs has one operation. The jobs processing times are p_j . For each job the processing time is the same for all machines (identical machines). It is necessary to find the optimal schedule which minimizes the sum of completion times of all jobs.

Input data. These are: the number m of jobs, the number n of machines, processing times p_j .

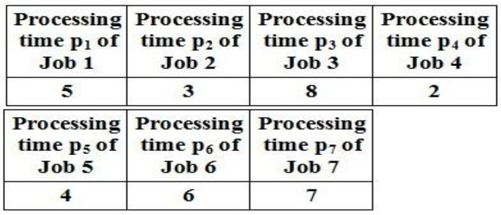
Output data. This is the optimal schedule indicating the particular jobs processing on each machine and the sequence at which these jobs are executed. The optimal value of the sum of completion times ΣC j is also computed.

Remark. The implemented algorithm is based on priorities and it uses the rule SPT (shortest processing time first). The point is that all jobs are ranked in order of monotonically increasing times p_j . The first few jobs are distributed on the machines and later, when a machine completes its work, the next job is placed on this machine.

The above problem is solved by means of the software module **PS4.** The work of the module is illustrated by the following numerical example.

Example 4. Consider the scheduling problem with seven jobs which have to be processed on three machines with numerical data given in Table 4.

Table 4. Numerical data for Examples 4 and 6.



Processing time p_1 of Job 1	Processing time p_2 of Job 2	Processing time p_3 of Job 3	Processing time p_4 of Job 4	Processing time p_5 of Job 5	Processing time p_6 of Job 6	Processing time p_7 of Job 7
5	3	8	2	4	6	7

The software module **PS4** computes the optimal sequence of jobs processing on each machine and the minimal value of the sum of completion times of all jobs. This value is found to be 51. For comparison, if the jobs are processed in the order <J_1, J_2, J_3, J_4, J_5, J_6, J_7> then the corresponding value of the sum is 58. The output results are written in a user file which is given below.

```
_______________________________________________
PRODUCTION SCHEDULE FOR MINIMIZING THE SUM OF
COMLETION  TIMES  OF  ALL  JOBS  ON  SEVERAL
IDENTICAL MACHINES WORKING IN PARALLEL
–  P || Σ  Cj
_______________________________________________
_______________________________________________
                Optimal Schedule
_______________________________________________
Machine:1
_______________________________________________
- Job:4
- Processing time of this job:2
_______________________________________________
- Job:1
- Processing time of this job :5
_______________________________________________
- Job:3
- Processing time of this job:8
_______________________________________________
_______________________________________________
Machine:2
_______________________________________________
- Job:2
- Processing time of this job:3
_______________________________________________
- Job:6
- Processing time of this job:6
_______________________________________________
_______________________________________________
Machine:3
_______________________________________________
- Job:5
- Processing time of this job:4
_______________________________________________
- Job:7
- Processing time of this job:7
_______________________________________________
_______________________________________________
Sum of completion times of all jobs:  Σ  Cj :51
_______________________________________________
```

4.5. Production schedule for approximate minimization of the processing time of all jobs on several non-identical machines working in parallel - Q || C_{max}

Problem formulation. There are several machines which are not identical. This means that they have different speeds of operation, but in all other aspects of their capabilities are the same. A number of jobs are to be processed, each of which consists of a single operation. Any job can be executed on any machine. The absolute speeds of operation of machines are known in advance. The algorithm calculates their relative speeds. The jobs processing times on *the slowest* machine are known. All machines and jobs are available at the initial time of operation. The aim is to allocate jobs for execution on machines in such a way as to obtain as little as possible processing time of all jobs. The algorithm gives *approximate* (suboptimal) solution of this problem.

Input data. These are: the number of machines and their absolute speeds of operation, the number of jobs and their processing times on the slowest machine.

Output data. The obtained schedule and the processing time of all jobs.

Remark. The algorithm finds the relative speeds of the machines and arranges them in order of decreasing of these speeds. Then it arranges jobs in order of decreasing of their individual processing times on the slowest machine. The algorithm allocates jobs on machines by putting the first of waiting jobs on the fastest free (released) machine.

The above problem is solved by means of the software module **PS5.** The work of the module is illustrated by the following numerical example.

Example 5. Consider the scheduling problem with five jobs which have to be processed on three machines. The absolute speeds of operation are given in Table 5 and the processing times of the jobs on the slowest machine are given in Table 6.

Table 5. Absolute speeds of operation.

Machine 1	Machine 2	Machine 3
2	4	6

Table 6. Processing times.

Job 1	Job 2	Job 3	Job 4	Job 5
3	4	5	6	7

The software module **PS5** computes a schedule which approximately minimizes the processing time of all jobs on the three machines. The output results are written in a user file which is given below.

```
PRODUCTION SCHEDULE FOR APPROXIMATE
MINIMIZATION OF THE PROCESSING TIME OF
ALL JOBS ON SEVERAL NON-IDENTICAL MACHINES
WORKING IN PARALLEL - Q || Cmax
________________________________________________
________________________________________________
                Computed schedule
________________________________________________
________________________________________________
Machine:3
-Relative speed of operation:3
-Total processing time of this machine:3.6667
________________________________________________
No1
Job:5
-Processing time of this job:2.3333
________________________________________________
No2
Job:2
-Processing time of this job:1.3333
________________________________________________
________________________________________________
Machine:2
-Relative speed of operation:2
-Total processing time of this machine:4.5
________________________________________________
No1
Job:4
-Processing time of this job :3
________________________________________________
No2
Job:1
-Processing time of this job:1.5
________________________________________________
________________________________________________
Machine:1
-Relative speed of operation:1
-Total processing time of this machine:5
________________________________________________
No1
Job:3
-Processing time of this job:5
________________________________________________
Maximal processing time Cmax=5 obtained on machine:1
________________________________________________
```

4.6. Production schedule for approximate minimization of the processing time of all jobs on several identical machines working in parallel - P || C max

Problem formulation. In this production scheduling problem there are m identical machines working in parallel. The number of jobs is n and each of them consists of one operation. The processing times of jobs p_j are known and for each job the processing time is the same for all machines. The aim is to allocate jobs for execution on machines in such a way as to obtain as little as possible processing time of all jobs. The algorithm gives *approximate* (suboptimal) solution of this problem.

Input data. These are: the number of machines, the number of jobs and their processing times.

Output data. The obtained schedule and the processing time of all jobs.

Remark. The software module implements an approximate algorithm using the LPT rule (longest processing time first). At first all jobs are ranked in order of monotonically decreasing times p_j. Observing the LPT rule, the first ordered jobs are placed on the available machines. Next, as a machine becomes free the next job is executed on it. The algorithm enables us to estimate the deviation from the optimal value of the problem. If we denote by C max_opt the minimal processing time of all jobs, then the implemented algorithm ensures execution time, which is less than or equal to 4/3 C max_opt. The above problem is solved by means of the software module **PS6.** The work of the module is illustrated by the following numerical example.

Example 6. Consider the scheduling problem with seven jobs which have to be processed on three machines. The jobs processing times are the same as in Example 4 and are given in Table 4.

The software module **PS6** computes a suboptimal schedule including the following sequence of jobs processing.

- Job3, Job2, Job4 are processed on Machine 1,
- Job7 and Job5 are processed on Machine 2,
- Job6 and Job1 are processed on Machine 3.

In this case the maximal processing time is C_{max}=13 which is obtained on Machine 1.

4 CONCLUSIONS

The paper presents a software implementation of six algorithms intended to provide solutions to some basic production scheduling problems and to facilitate the production management in small and medium enterprises. Our experimental program system is open for adding new modules and in a future work, a library of scheduling algorithms and software modules can be developed and incorporated in the system. In particular, the system capabilities can be extended by using more elaborate mathematical models of manufacturing processes taking into account various processing characteristics and constraints and different machine environments.

ACKNOWLEDGEMENTS

The research work reported in the paper is supported by the project AComIn "Advanced Computing for Innovation", grant 316087, funded by the FP7 Capacity Programme (Research Potential of Convergence Regions).

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