

Contents

1. Introduction	1
1.1. The multi-line steel hot rolling mill of BÖHLER	1
1.2. Scheduling problem	3
1.2.1. Start time planning	3
1.2.2. Job selection and sequencing	3
1.2.3. Problem description	4
1.3. State of the art	5
1.3.1. Start time planning	5
1.3.2. Scheduling and sequencing	6
1.4. Contribution	9
1.5. Content	9
2. Model of the production process and the plant	11
2.1. Model of the production process	12
2.1.1. Processing of a single product	12
2.1.2. Processing of multiple products	13
2.2. Topological model of the plant	16
2.3. Main sections of the plant	19
2.3.1. Walking beam furnace	19
2.3.2. Induction furnace	19
2.3.3. Reversing rolling stand	20
2.3.4. Flat rolling line	21
2.3.5. Cross conveyor	21
2.3.6. Heating box	21
2.3.7. Profile rolling line	22
3. Start time planning	23
3.1. Introduction	23
3.2. Problem statement	25
3.2.1. System description	25
3.2.2. Optimization problem	26
3.3. Computational methods	27
3.3.1. Deterministic process times	27

Contents

3.3.2.	Stochastic process times, analytical solution	29
3.3.3.	Stochastic process times, Monte-Carlo-based solution	32
3.4.	Case studies	33
3.4.1.	Example with 3 machines	33
3.4.2.	Example with 7 machines	35
3.5.	Start time planning in the steel hot rolling mill	38
3.5.1.	Calculation of earliest possible start times	38
3.5.2.	Evaluation of planning results	40
4.	Schedule optimization	43
4.1.	Introduction	43
4.2.	Production process	43
4.2.1.	Production process of jobs	43
4.2.2.	Production process of multiple groups	46
4.3.	Optimization problem	48
4.3.1.	Cost function	51
4.3.2.	Optimization problem	52
4.4.	Exact optimization of individual groups	53
4.4.1.	Integer optimization of a P-Group	54
4.4.2.	Integer optimization of an F-Group	57
4.4.3.	Conclusions	59
4.5.	Heuristic optimization of multiple groups	60
4.5.1.	Permutation moves	61
4.5.2.	Neighborhood functions	62
4.5.3.	Optimization algorithm	63
4.6.	Use case	65
4.6.1.	Problem definition	65
4.6.2.	Optimization	65
4.6.3.	Simulation results	66
4.6.4.	Repeatability	70
4.6.5.	Conclusions	71
5.	Conclusions and outlook	73
5.1.	Model of the production process and the plant	73
5.2.	Start time planning	74
5.3.	Job selection and sequence optimization	75
5.4.	Outlook	77

A. Process time models	79
A.1. Walking beam furnace	79
A.1.1. Checkpoints 1-2	79
A.1.2. Checkpoints 2-12	79
A.2. Induction furnace	80
A.2.1. Checkpoints 3-4	80
A.2.2. Checkpoints 4-5, 4-7, 4-9	80
A.2.3. Checkpoints 5-6, 7-8, 9-10	80
A.2.4. Checkpoints 6-11, 8-11, 10-11	81
A.2.5. Checkpoints 11-12	81
A.3. Reversing rolling stand	81
A.3.1. Checkpoints 12-13	81
A.3.2. Checkpoints 13-14	83
A.3.3. Checkpoints 14-15	83
A.3.4. Checkpoints 14-20	84
A.3.5. Checkpoints 20-21	84
A.4. Flat rolling line	85
A.4.1. Checkpoints 15-16	85
A.4.2. Checkpoints 16-17	85
A.4.3. Checkpoints 17-18	88
A.4.4. Checkpoints 18-19	89
A.4.5. Checkpoint 19 → Exit 1	89
A.5. Cross conveyor	89
A.5.1. Checkpoints 12-22	89
A.5.2. Checkpoints 21-22	89
A.6. Heating box	90
A.6.1. Checkpoints 22-23	90
A.6.2. Checkpoints 23-24	90
A.6.3. Checkpoints 24-25	91
A.7. Profile rolling line	91
A.7.1. Checkpoints 25-26	91
A.7.2. Checkpoints 26-27, ..., 30-31, 29 → Exit 2	92
A.7.3. Checkpoints 31-32	92
A.7.4. Checkpoints 32-33, 32 → Exit 3	93
A.7.5. Checkpoints 33-34	93
A.7.6. Checkpoint 34 → Exit 4	93
A.8. Evaluation	94