

The Application of Combined Multiple-Objective and Genetic Algorithm in FMS Scheduling

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ABSTRACT

彈性製造系統 (Flexible Manufacturing System : FMS) 融合了許多自動化的觀念與彈性技術於單一的生產系統中，是一種多種類少量的彈性生產方式[1]，在生產上擁有途程彈性之特性，使得傳統的單一途程規劃轉變為多途程規劃加工背景的排程問題，除需考慮各工件的加工順序外，還需考慮各作業選擇的加工機器問題，增加了排程問題的複雜度。本研究使用具求解最佳解能力的遺傳基因演算法 (Genetic Algorithms) 結合處理多目標 (Multiple-Objective) 的歸屬函數 (Membership Function) 之觀念，發展一套求解彈性製造系統排程的啟發式解法，同時考慮最小化的平均遲延時間、平均流程時間、最大化的平均機器使用率三個排程績效指標，以求得一滿意的妥協解，使得發展之啟發式解法更具效率 (Efficiency) 與績效 (Performance)，相信對實際的應用必有所助益。研究最後，針對遺傳基因演算法執行中系統參數做一實驗設計找出最佳參數組合，以增進解題的品質，使遺傳基因演算法在具多重績效的FMS排程應用更加穩健。關鍵字：彈性製造系統、排程、遺傳基因演算法、多目標

Keywords : Flexible Manufacturing System ; Multiple Objective ; Genetic Algorithm ; Membership Function

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