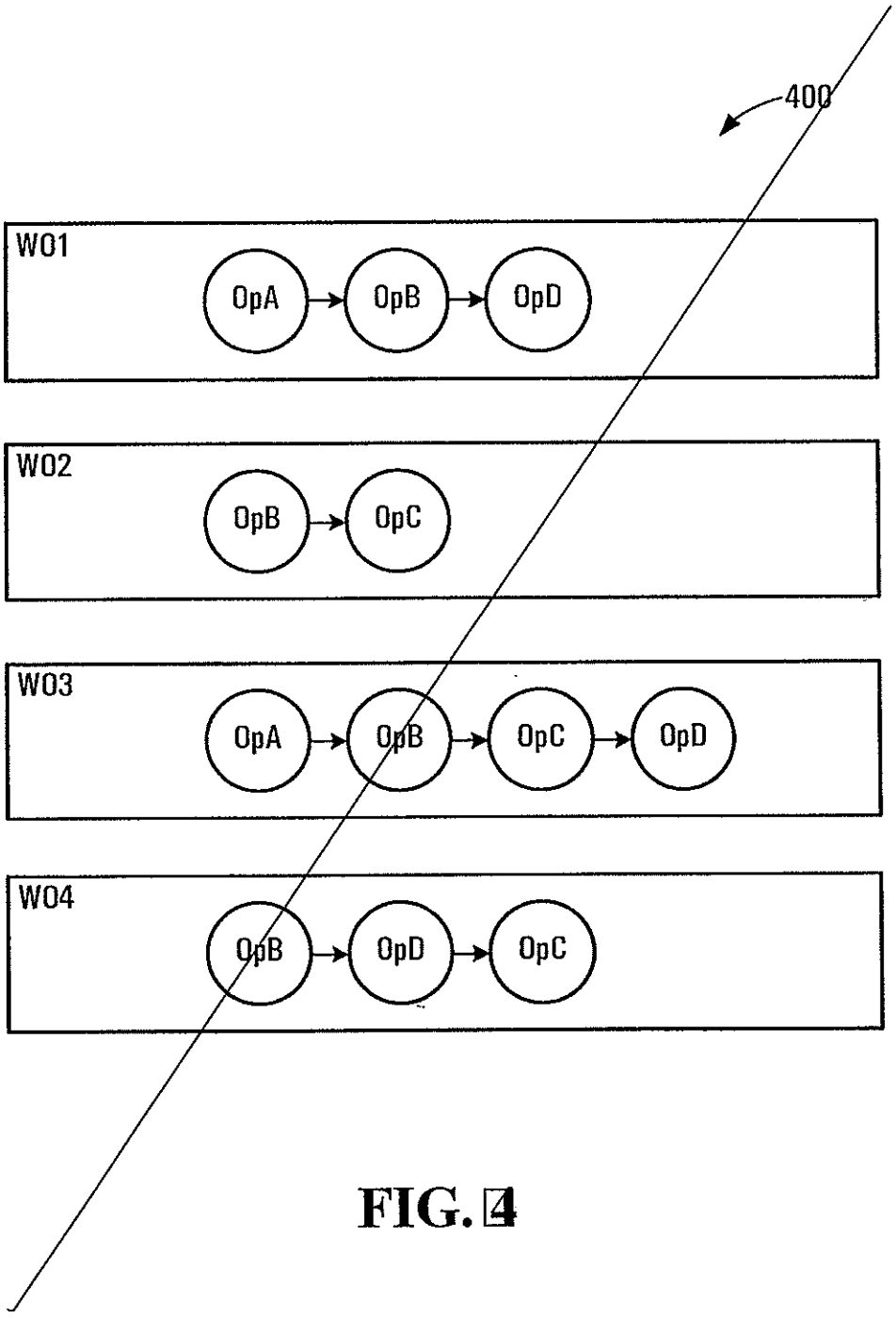

400
WO1
OpA
OpB
OpD
WO2
OpB
OpC
WO3
OpA
OpB
OpC
OpD
WO4
OpB
OpD
OpC

**FIG. 4**

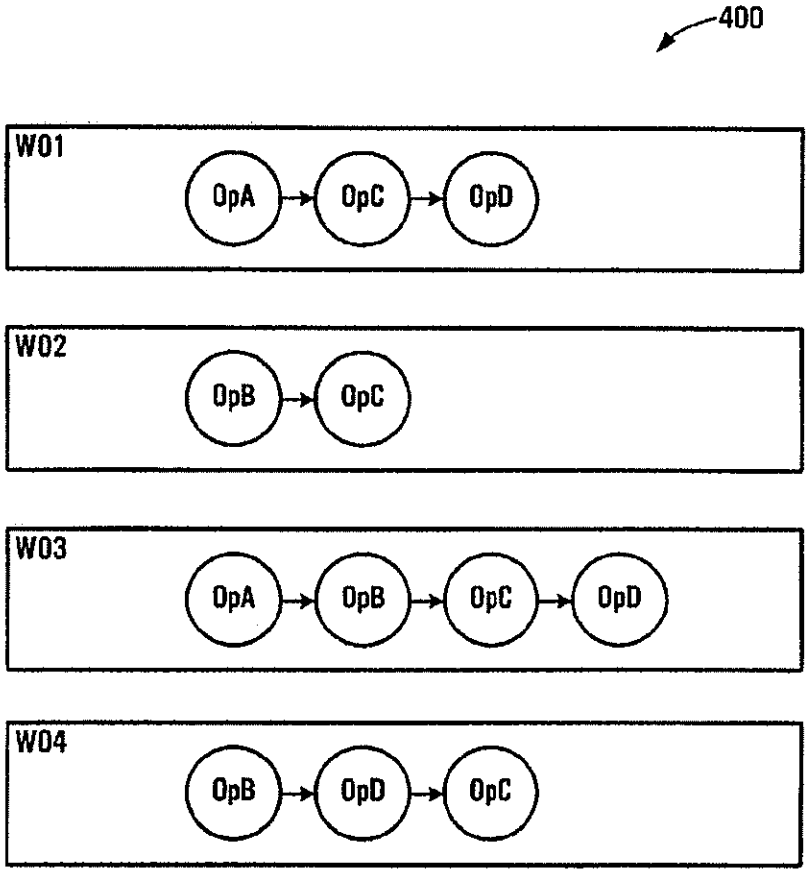

400
W01
OpA
OpC
OpD
W02
OpB
OpC
W03
OpA
OpB
OpC
OpD
W04
OpB
OpD
OpC

**FIG. 4**

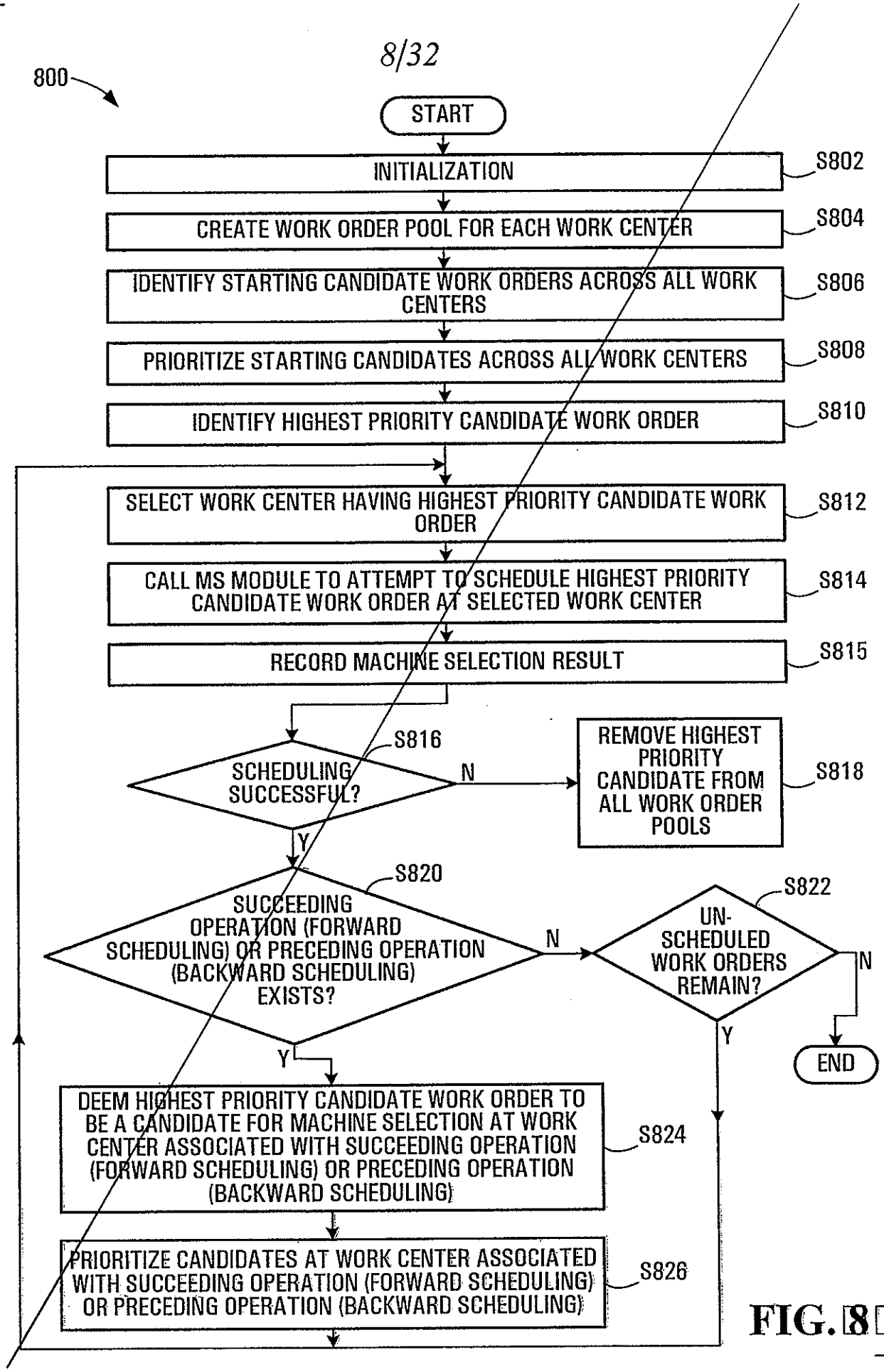

800
START
INITIALIZATION
S802
CREATE WORK ORDER POOL FOR EACH WORK CENTER
S804
IDENTIFY STARTING CANDIDATE WORK ORDERS ACROSS ALL WORK CENTERS
S806
PRIORITIZE STARTING CANDIDATES ACROSS ALL WORK CENTERS
S808
IDENTIFY HIGHEST PRIORITY CANDIDATE WORK ORDER
S810
SELECT WORK CENTER HAVING HIGHEST PRIORITY CANDIDATE WORK ORDER
S812
CALL MS MODULE TO ATTEMPT TO SCHEDULE HIGHEST PRIORITY CANDIDATE WORK ORDER AT SELECTED WORK CENTER
S814
RECORD MACHINE SELECTION RESULT
S815
SCHEDULING SUCCESSFUL?
S816
N
REMOVE HIGHEST PRIORITY CANDIDATE FROM ALL WORK ORDER POOLS
S818
Y
SUCCEEDING OPERATION (FORWARD SCHEDULING) OR PRECEDING OPERATION (BACKWARD SCHEDULING) EXISTS?
S820
N
UN-SCHEDULED WORK ORDERS REMAIN?
S822
N
END
Y
Y
DEEM HIGHEST PRIORITY CANDIDATE WORK ORDER TO BE A CANDIDATE FOR MACHINE SELECTION AT WORK CENTER ASSOCIATED WITH SUCCEEDING OPERATION (FORWARD SCHEDULING) OR PRECEDING OPERATION (BACKWARD SCHEDULING)
S824
PRIORITIZE CANDIDATES AT WORK CENTER ASSOCIATED WITH SUCCEEDING OPERATION (FORWARD SCHEDULING) OR PRECEDING OPERATION (BACKWARD SCHEDULING)
S826

FIG. 8

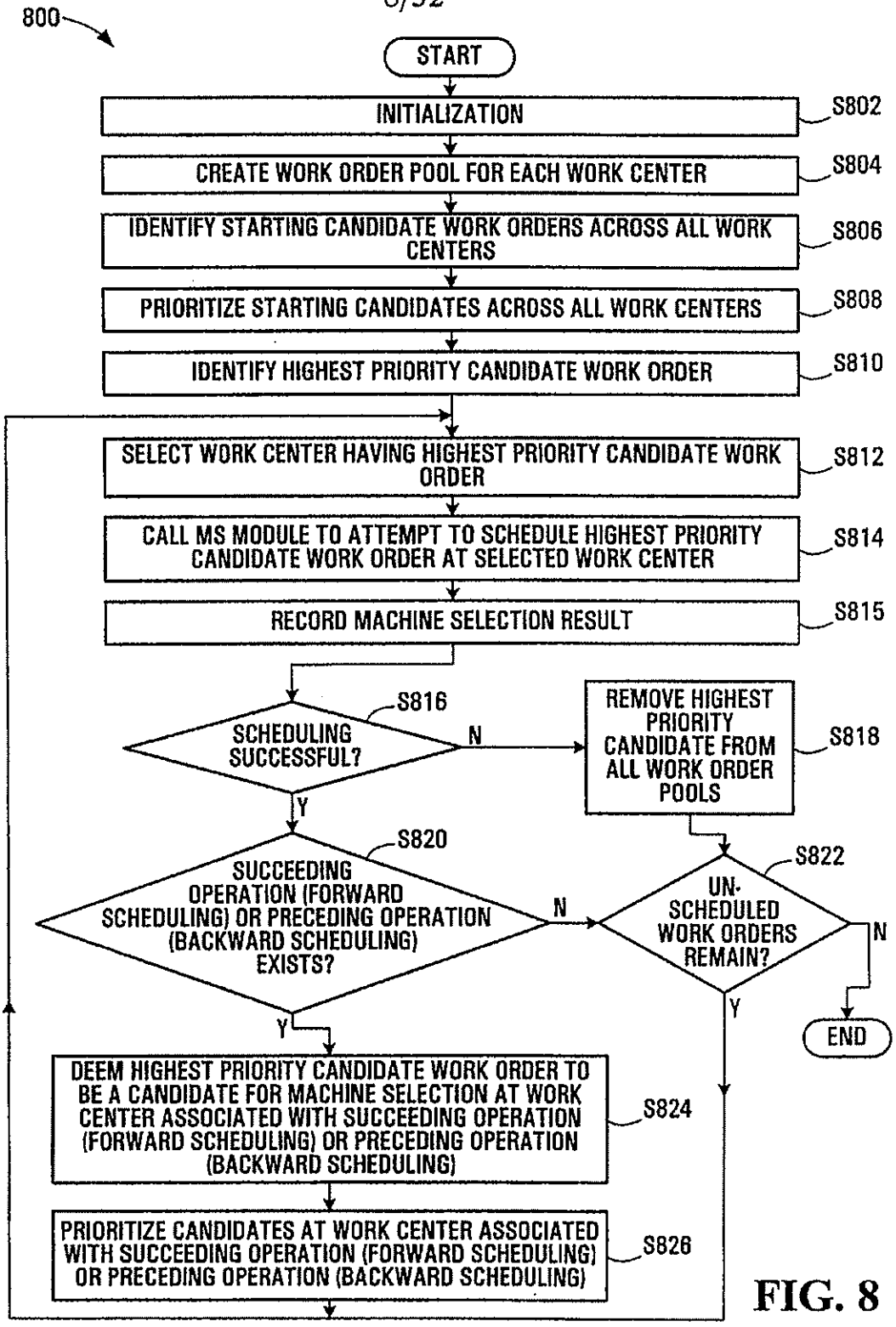

800
START
INITIALIZATION
S802
CREATE WORK ORDER POOL FOR EACH WORK CENTER
S804
IDENTIFY STARTING CANDIDATE WORK ORDERS ACROSS ALL WORK CENTERS
S806
PRIORITIZE STARTING CANDIDATES ACROSS ALL WORK CENTERS
S808
IDENTIFY HIGHEST PRIORITY CANDIDATE WORK ORDER
S810
SELECT WORK CENTER HAVING HIGHEST PRIORITY CANDIDATE WORK ORDER
S812
CALL MS MODULE TO ATTEMPT TO SCHEDULE HIGHEST PRIORITY CANDIDATE WORK ORDER AT SELECTED WORK CENTER
S814
RECORD MACHINE SELECTION RESULT
S815
S816
SCHEDULING SUCCESSFUL?
N
Y
REMOVE HIGHEST PRIORITY CANDIDATE FROM ALL WORK ORDER POOLS
S818
S820
SUCCEEDING OPERATION (FORWARD SCHEDULING) OR PRECEDING OPERATION (BACKWARD SCHEDULING) EXISTS?
N
Y
S822
UN-SCHEDULED WORK ORDERS REMAIN?
N
Y
END
DEEM HIGHEST PRIORITY CANDIDATE WORK ORDER TO BE A CANDIDATE FOR MACHINE SELECTION AT WORK CENTER ASSOCIATED WITH SUCCEEDING OPERATION (FORWARD SCHEDULING) OR PRECEDING OPERATION (BACKWARD SCHEDULING)
S824
PRIORITIZE CANDIDATES AT WORK CENTER ASSOCIATED WITH SUCCEEDING OPERATION (FORWARD SCHEDULING) OR PRECEDING OPERATION (BACKWARD SCHEDULING)
S826

FIG. 8