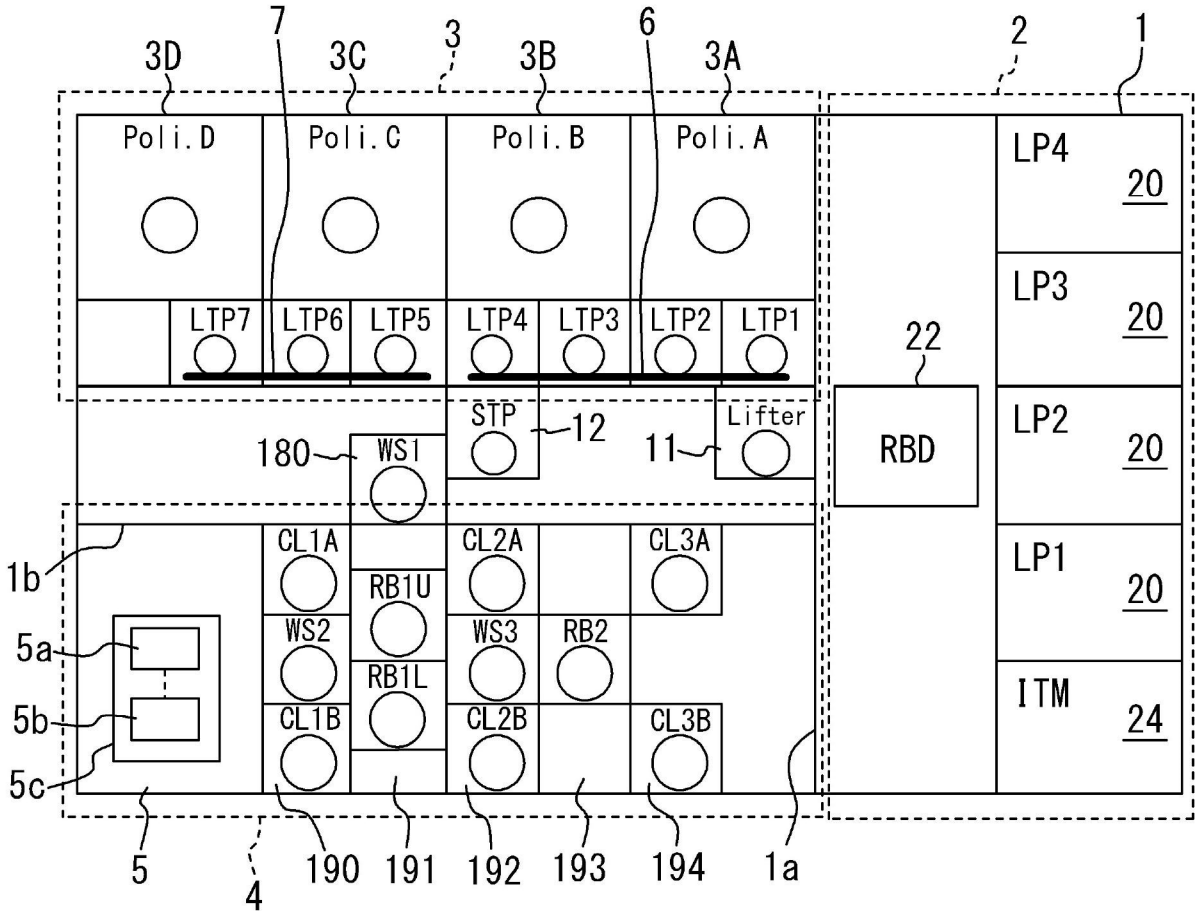

3D
7
3C
3
3B
6
3A
2
1
Poli.D
Poli.C
Poli.B
Poli.A
LP4
20
LP3
20
LP2
20
LP1
20
ITM
24
LTP7
LTP6
LTP5
LTP4
LTP3
LTP2
LTP1
22
RBD
STP
12
Lifter
180
WS1
11
1b
CL1A
CL2A
CL3A
RB1U
5a
WS2
WS3
RB2
RB1L
5b
CL1B
CL2B
CL3B
5c
5
4
190
191
192
193
194
1a

FIG. 1

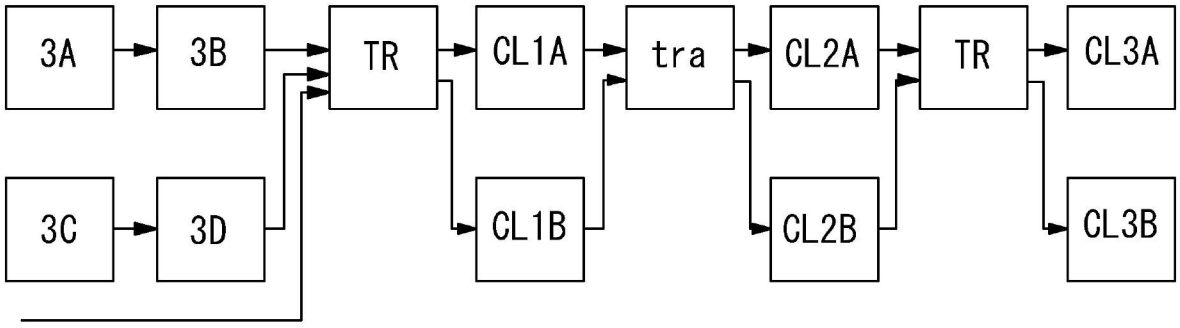

3A
3B
TR
CL1A
tra
CL2A
TR
CL3A
3C
3D
CL1B
CL2B
CL3B

FIG. 2

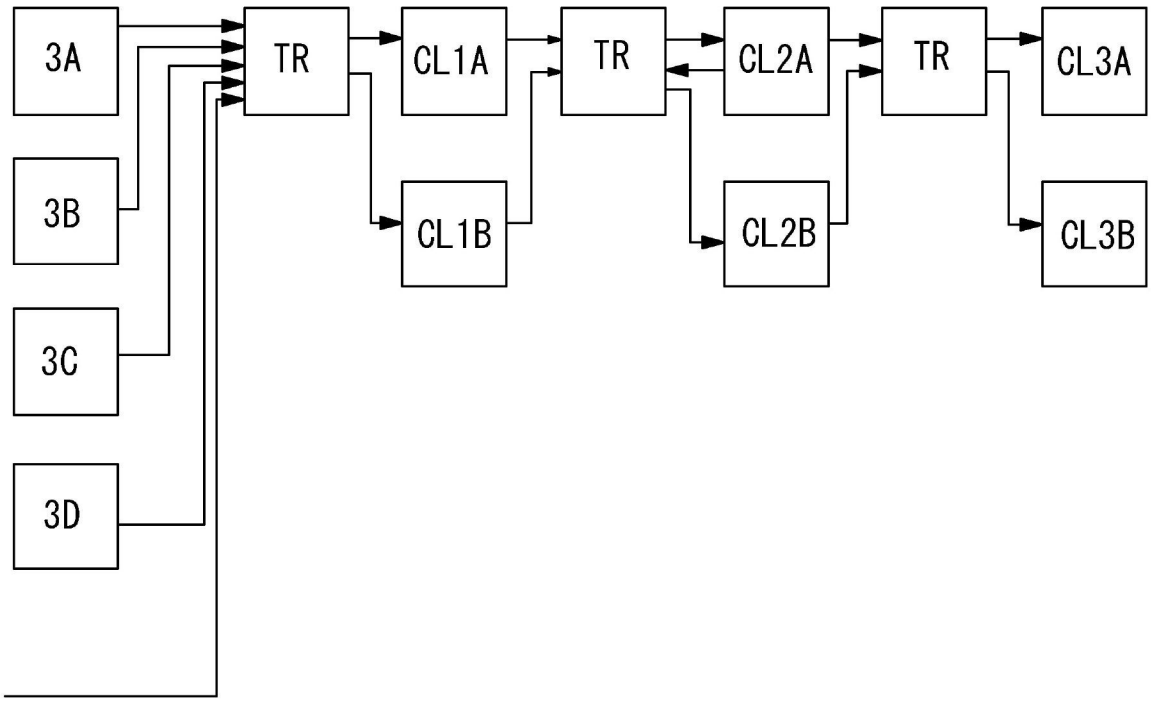


FIG. 3

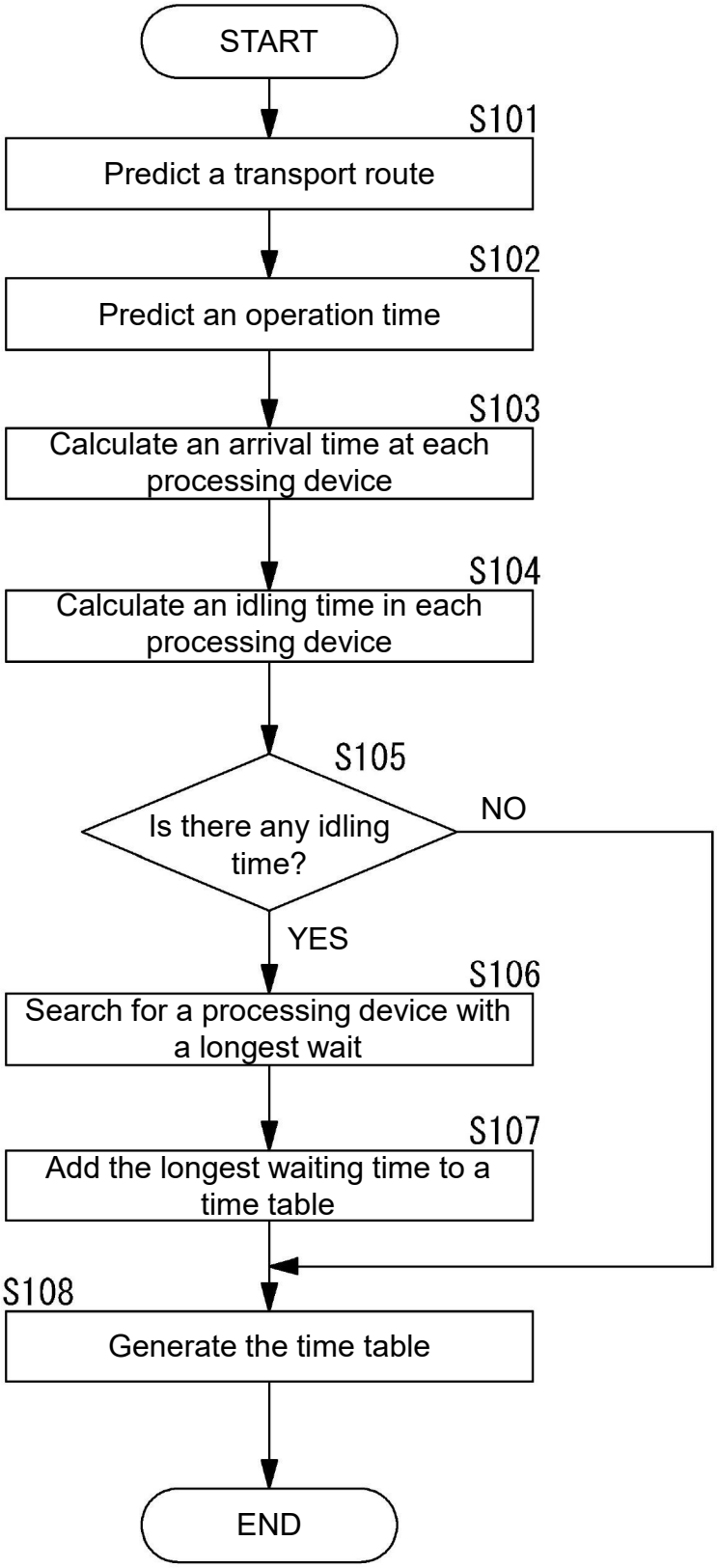

START
S101
Predict a transport route
S102
Predict an operation time
S103
Calculate an arrival time at each processing device
S104
Calculate an idling time in each processing device
S105
Is there any idling time?
NO
YES
S106
Search for a processing device with a longest wait
S107
Add the longest waiting time to a time table
S108
Generate the time table
END

FIG. 4

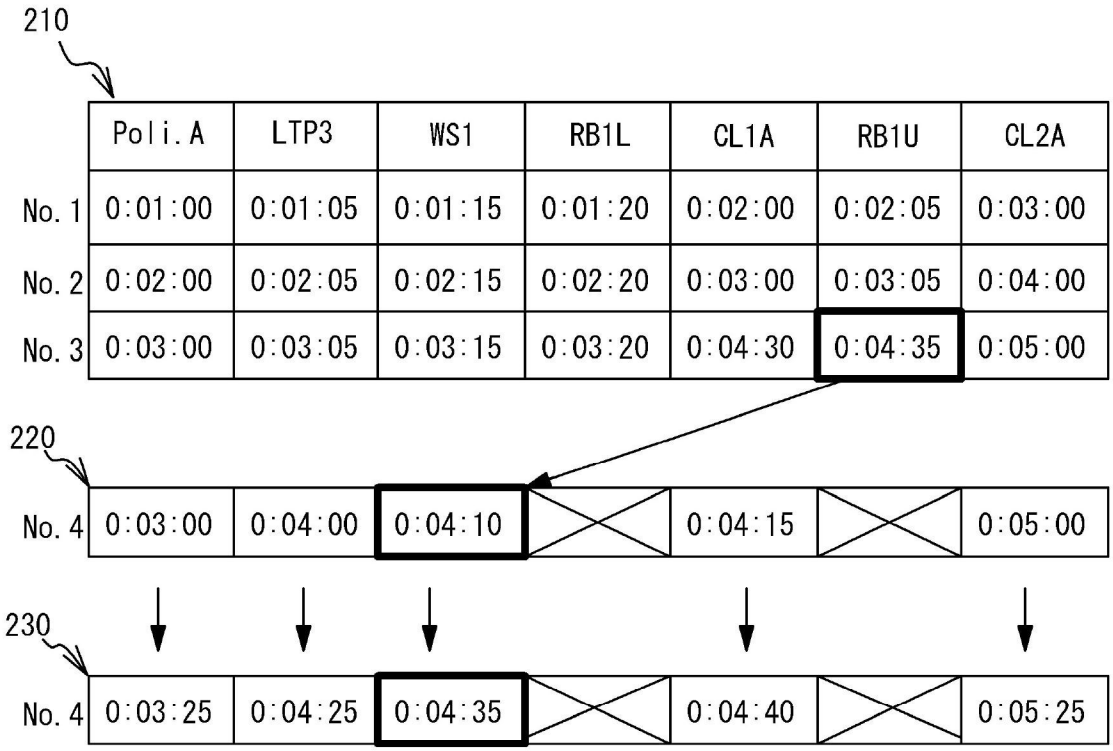


FIG. 5

240

No.	Start	Pos	Poli.A	Poli.B	Poli.C	Poli.D	STP	CL1A	CL1B	CL2A	CL2B	CL3A	CL3B
1	5:13:51 PM	CL3A	——	5:15:44 PM	——	——	5:16:00 PM	5:16:36 PM	——	5:16:44 PM	——	5:17:22 PM	——
2	5:14:32 PM	CL1A	5:16:25 PM	——	——	——	5:16:39 PM	5:17:17 PM	——	5:17:25 PM	——	5:18:04 PM	——
3	5:15:42 PM	Poli.B	——	5:17:37 PM	——	——	5:17:53 PM	5:18:30 PM	——	5:18:38 PM	——	5:19:17 PM	——
4	5:16:25 PM	Poli.A	5:18:20 PM	——	——	——	5:18:35 PM	5:19:12 PM	——	5:19:20 PM	——	5:19:59 PM	——
5	5:14:48 PM	CL1B	——	——	——	5:16:42 PM	5:16:55 PM	——	5:17:32 PM	——	5:17:40 PM	——	5:18:18 PM
6	5:15:29 PM	LTP6	——	——	5:17:22 PM	——	5:17:36 PM	——	5:18:13 PM	——	5:18:21 PM	——	5:18:59 PM
7	5:16:39 PM	Poli.D	——	——	——	5:18:35 PM	5:18:49 PM	——	5:19:26 PM	——	5:19:34 PM	——	5:20:13 PM

FIG. 6

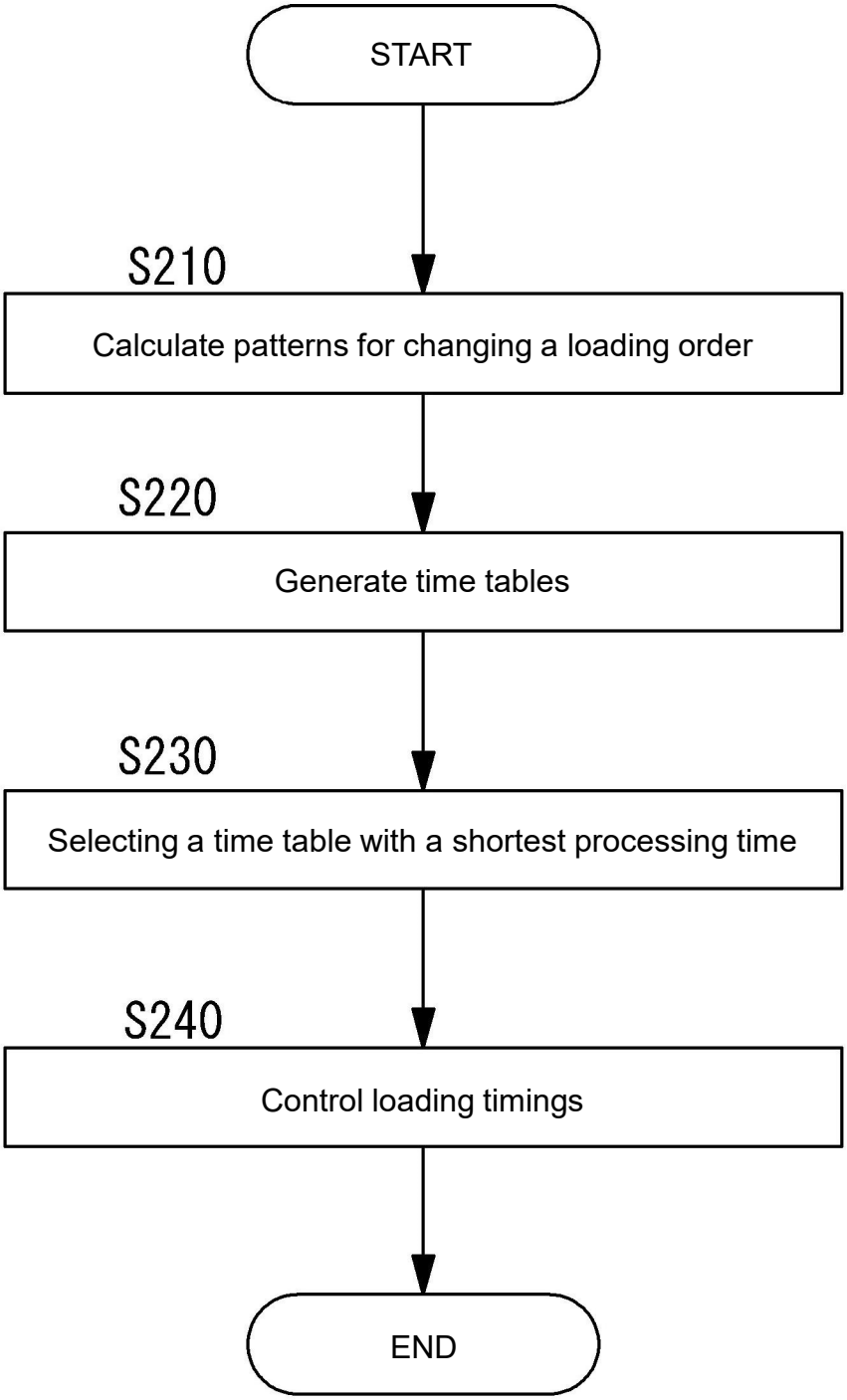

START
S210
Calculate patterns for changing a loading order
S220
Generate time tables
S230
Selecting a time table with a shortest processing time
S240
Control loading timings
END

FIG. 7

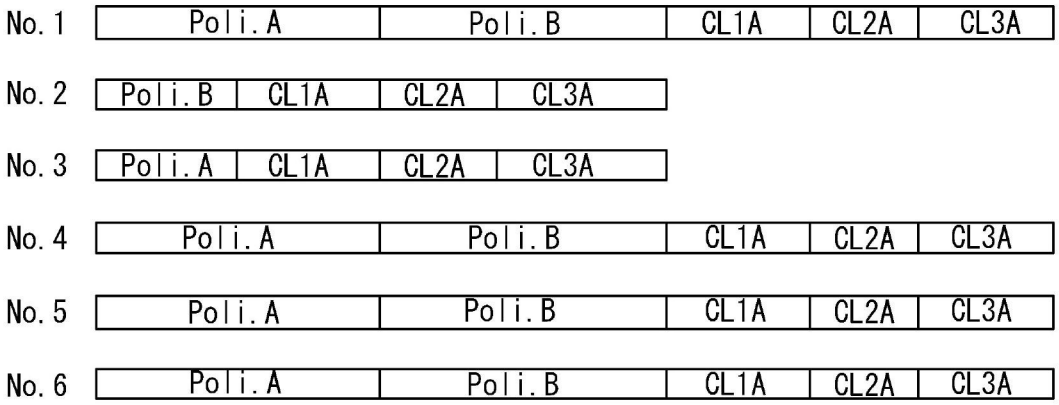

No. 1
Poli. A
Poli. B
CL1A
CL2A
CL3A
No. 2
Poli. B
CL1A
CL2A
CL3A
No. 3
Poli. A
CL1A
CL2A
CL3A
No. 4
Poli. A
Poli. B
CL1A
CL2A
CL3A
No. 5
Poli. A
Poli. B
CL1A
CL2A
CL3A
No. 6
Poli. A
Poli. B
CL1A
CL2A
CL3A

FIG. 8

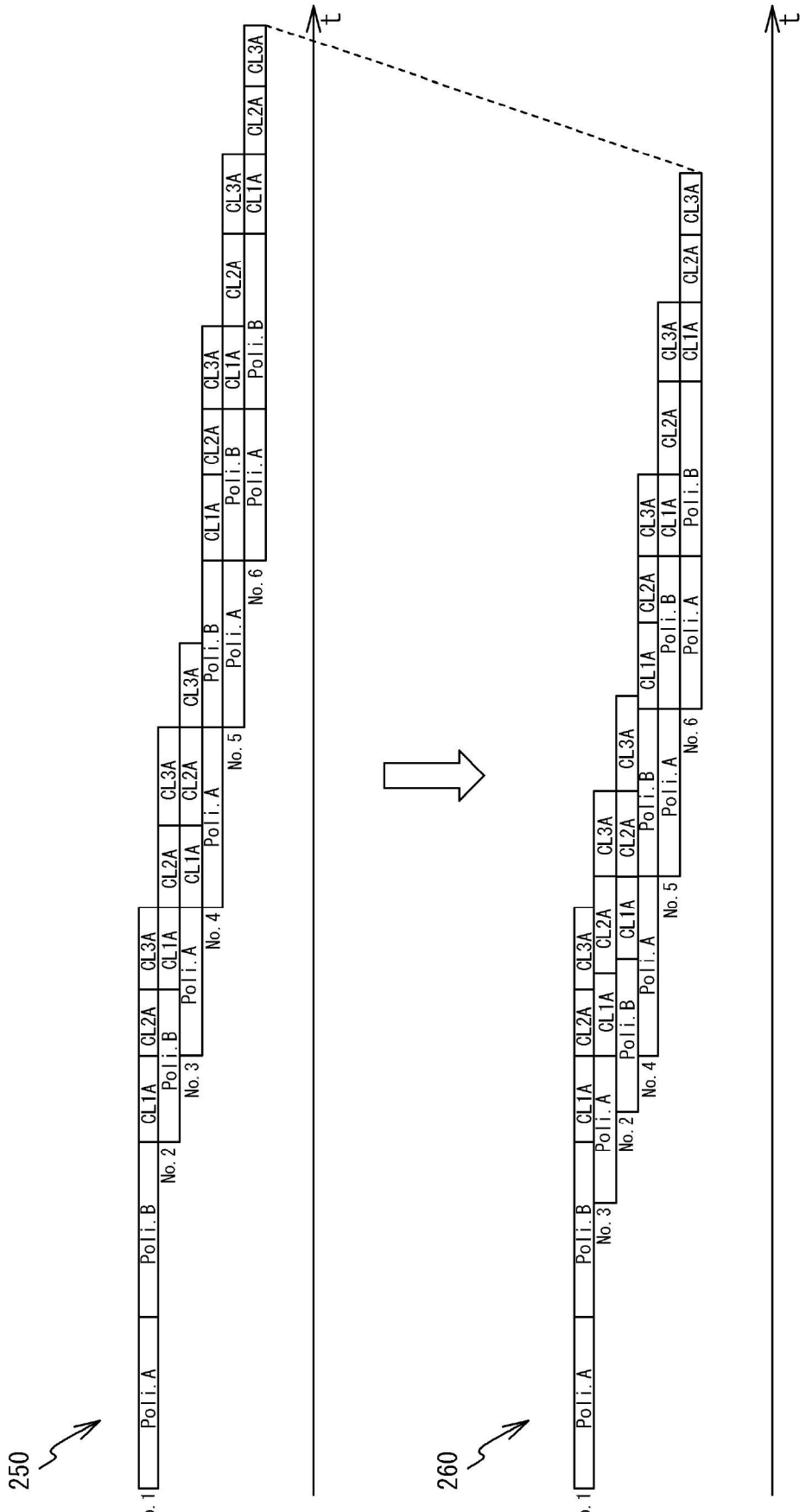


FIG. 9

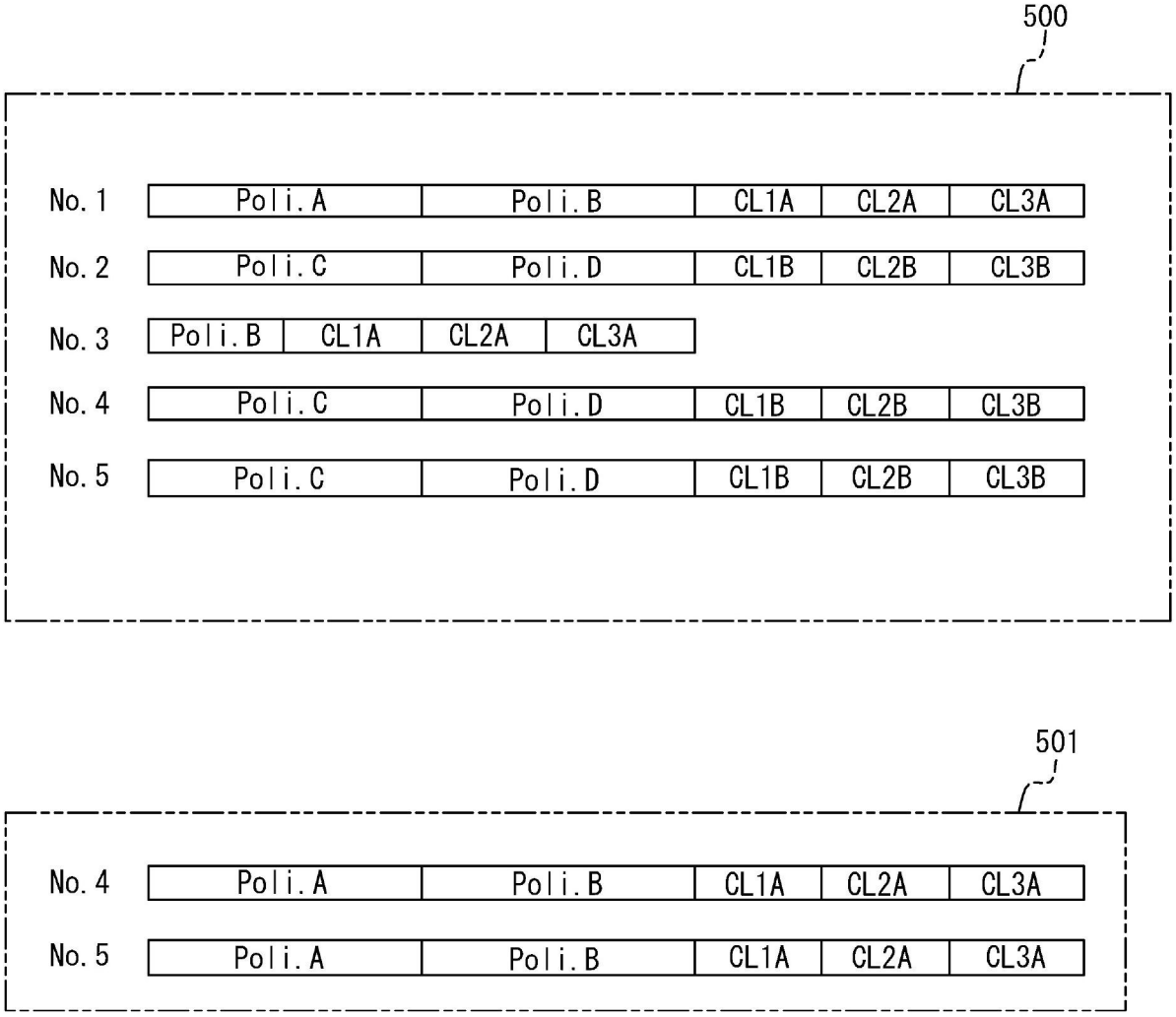

500
No. 1
Poli. A
Poli. B
CL1A
CL2A
CL3A
No. 2
Poli. C
Poli. D
CL1B
CL2B
CL3B
No. 3
Poli. B
CL1A
CL2A
CL3A
No. 4
Poli. C
Poli. D
CL1B
CL2B
CL3B
No. 5
Poli. C
Poli. D
CL1B
CL2B
CL3B
501
No. 4
Poli. A
Poli. B
CL1A
CL2A
CL3A
No. 5
Poli. A
Poli. B
CL1A
CL2A
CL3A

FIG. 10

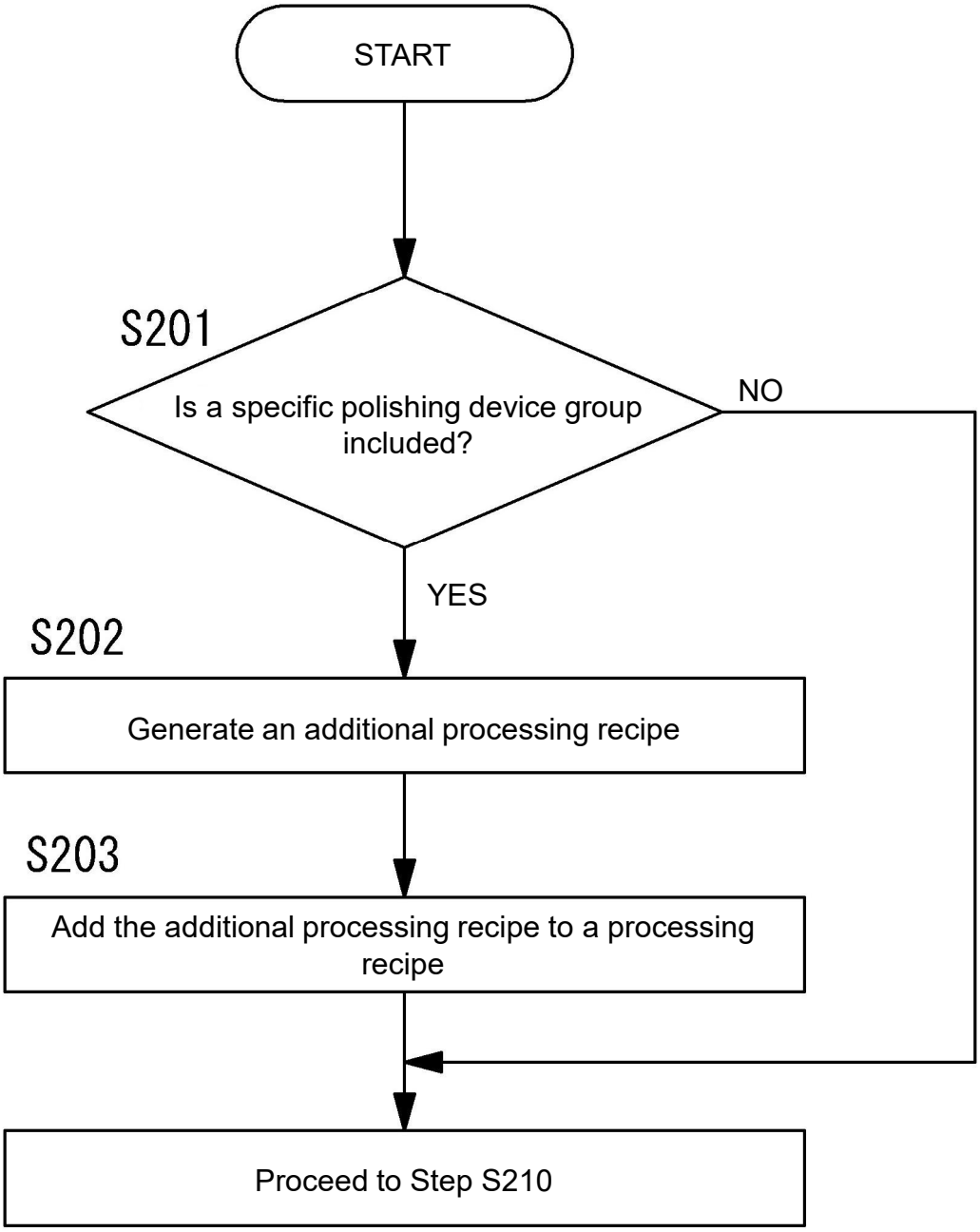

START
S201
Is a specific polishing device group included?
NO
YES
S202
Generate an additional processing recipe
S203
Add the additional processing recipe to a processing recipe
Proceed to Step S210

FIG. 11

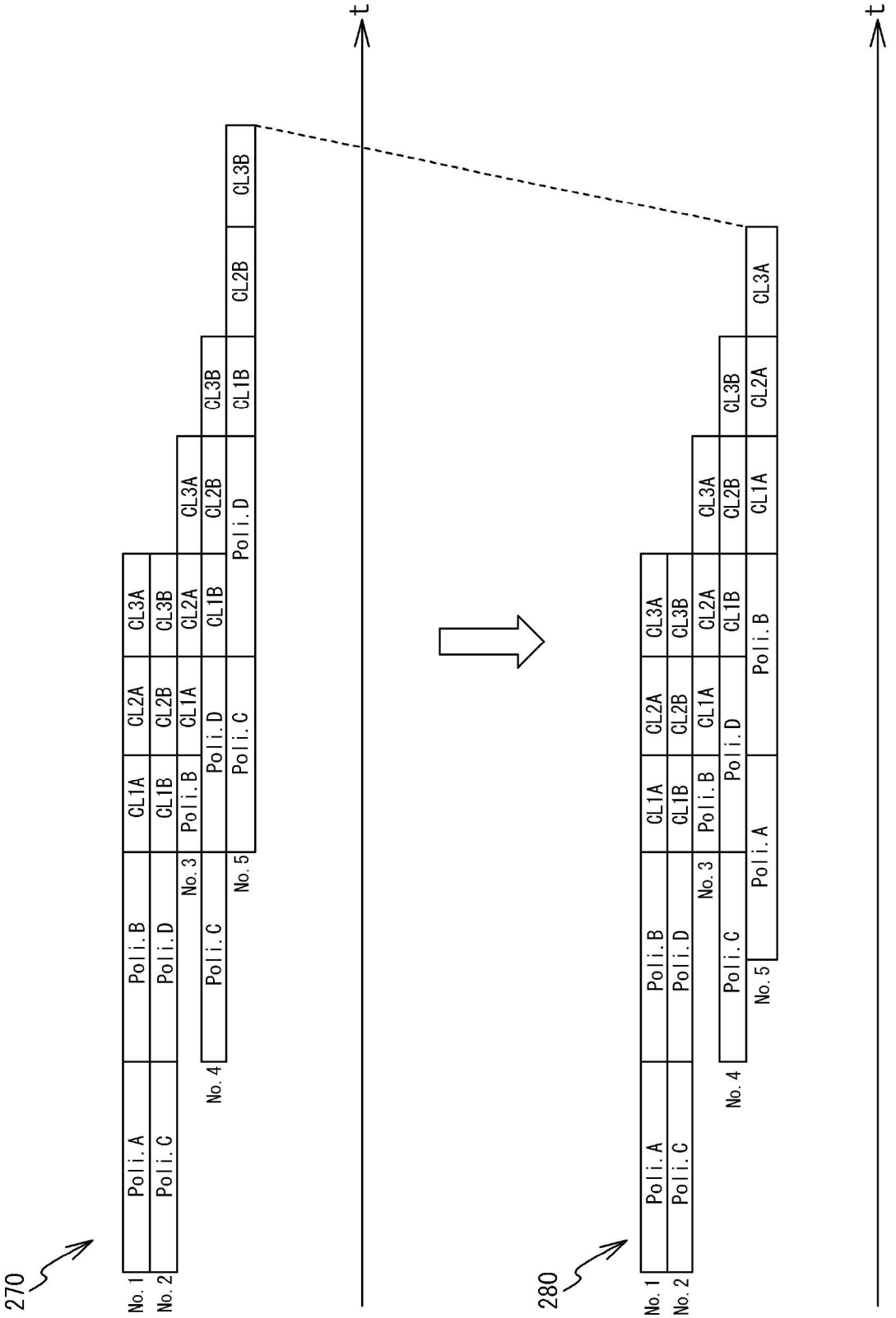

270
No. 1
No. 2
No. 3
No. 4
No. 5
Poli. A
Poli. C
Poli. B
Poli. D
Poli. C
Poli. D
CL1A
CL1B
CL2A
CL2B
CL3A
CL3B
t
280
No. 1
No. 2
No. 3
No. 4
No. 5
Poli. A
Poli. C
Poli. B
Poli. D
Poli. A
Poli. B
CL1A
CL1B
CL2A
CL2B
CL3A
CL3B
t

FIG. 12