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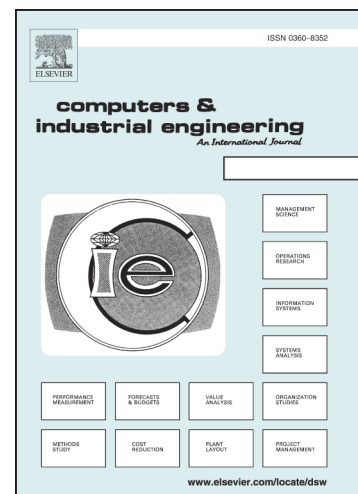
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**SINGLE MACHINE COMMON FLOW ALLOWANCE GROUP
SCHEDULING WITH LEARNING EFFECT AND RESOURCE
ALLOCATION**

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