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Author: Honglin Qu Sujing Wang Qiang Xu

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A New Method of Cyclic Hoist Scheduling for Multi-recipe and Multi-stage Material Handling Processes †

Honglin Qu¹, Sujing Wang²,*, Qiang Xu¹,*

¹Dan F. Smith Department of Chemical Engineering ²Department of Computer Science Lamar University, Beaumont, TX 77710, USA

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