

Contents

Contents

xiii

I	Simulation Concepts	1
1	Introduction to Simulation	3
1.1	About the Book	4
1.2	Systems and Models	6
1.3	When to Simulate (and When Not To)	8
1.4	Simulation Success Skills	10
1.4.1	Project Objectives	10
1.4.2	Functional Specification	12
1.4.3	Project Iterations	15
1.4.4	Project Management and Agility	16
1.4.5	Stakeholder and Simulationist Bills of Rights	18
2	Basics of Queueing Theory	21
2.1	Queueing-System Structure and Terminology	23
2.2	Little's Law and Other Relations	27
2.3	Specific Results for Some Multiserver Queueing Stations	28
2.3.1	$M/M/1$	28
2.3.2	$M/M/c$	28
2.3.3	$M/G/1$	30
2.3.4	$G/M/1$	30
2.4	Queueing Networks	32
2.5	Queueing Theory vs. Simulation	34
2.6	Problems	35
3	Approaches to Simulation	39
3.1	Kinds of Simulation	39
3.1.1	Static vs. Dynamic Models	40
3.1.2	Continuous-Change vs. Discrete-Change Dynamic Models	41
3.1.3	Deterministic vs. Stochastic Models	42
3.2	Model 3-1: Manual Simulation	43
3.3	General-Purpose Programming Languages	51

3.4	Spreadsheet Simulation Models	52
3.4.1	Model 3-2: Single-Period Inventory Profits	52
3.4.2	Model 3-3: Single-Server Queueing Delays	58
3.5	Special-Purpose Simulation Software	62
3.6	Problems	63
4	Input Analysis	67
4.1	Specifying Univariate Input Probability Distributions	68
4.1.1	General Approach	69
4.1.2	Options for Using Observed Real-World Data	69
4.1.3	Choosing Probability Distributions	70
4.1.4	Fitting Distributions to Observed Real-World Data	73
4.1.5	Distribution-Fitting Issues	81
4.2	Types of Inputs	83
4.2.1	Deterministic vs. Stochastic	83
4.2.2	Scalar vs. Multivariate vs. Stochastic Processes	84
4.2.3	Time-Varying Arrival Rate	86
4.3	Random-Number Generators	87
4.4	Generating Random Variates and Processes	90
4.5	Problems	95
II	Simulation Modeling With Simio	97
5	First Simio Models	99
5.1	The Basic Simio User Interface	100
5.2	Model 5-1: First Project Using the Standard Library Objects	104
5.2.1	Building the Model	105
5.2.2	Initial Experimentation and Analysis	113
5.2.3	Replications and Statistical Analysis of Output	115
5.2.4	Warm-up Period and Steady-State vs. Terminating Simulations	120
5.2.5	Model Verification	122
5.3	Model 5-2: First Model Using Processes	123
5.4	Model 5-3: Automated Teller Machine (ATM)	129
5.5	Beyond Means: Simio MORE (SMORE) Plots	134
5.6	Exporting Simulation Output Data for Further Statistical Analysis	142
5.7	Basic Model Animation	143
5.8	Summary	147
5.9	Problems	148
6	Intermediate Modeling With Simio	151
6.1	Simio Framework	151
6.1.1	Introduction to Objects	151
6.1.2	Properties and States	155
6.1.3	Tokens and Entities	161

6.1.4	Processes	162
6.1.5	Objects as Resources	164
6.1.6	Data Scope	167
6.1.7	Expression Builder	167
6.2	Model 6-1: PCB Assembly	169
6.3	Model 6-2: Enhanced PCB Assembly	173
6.3.1	Adding a Rework Station	174
6.3.2	Resource Schedules	179
6.3.3	Machine Failures	186
6.3.4	Verification of Model 6-2	187
6.4	Model 6-3: PCB Model With Process Selection	189
6.5	Model 6-4: Comparing Multiple Alternative Scenarios	195
6.6	Summary	200
6.7	Problems	200
7	Working With Model Data	203
7.1	Data Tables	203
7.1.1	Basics of Tables	204
7.1.2	Model 7-1: An Emergency Department Using a Data Table	205
7.1.3	Sequence Tables	210
7.1.4	Model 7-2: Enhanced ED Using Sequence Tables	212
7.1.5	Arrival Tables and Model 7-3	216
7.1.6	Relational Tables	219
7.1.7	Table Import/Export	221
7.2	Schedules	221
7.2.1	Calendar Work Schedules	221
7.2.2	Manual Schedules	223
7.3	Rate Tables and Model 7-4	224
7.4	Function Tables and Model 7-5	227
7.5	Lists	228
7.6	Changeovers	229
7.7	State Arrays	230
7.8	Summary	232
7.9	Problems	232
8	Animation and Entity Movement	235
8.1	Animation	235
8.1.1	Why Animate?	235
8.1.2	Navigation and Viewing Options	237
8.1.3	Background Animation With the Drawing Ribbon	239
8.1.4	Status Animation With the Animation Ribbon	241
8.1.5	Editing Symbols with the Symbols Ribbon	242
8.1.6	Model 8-1: Animating the PCB Assembly	245
8.2	Entity Movement	250
8.2.1	Entity Movement Through Free Space	250
8.2.2	Using Connectors, TimePaths, and Paths	252

8.2.3	Using Conveyors	254
8.2.4	Model 8-2: PCB Assembly with Conveyors	255
8.2.5	Using Workers	258
8.2.6	Using Vehicles	261
8.2.7	Model 8-3: ED Enhanced with Hospital Staff	262
8.3	Summary	270
9	Advanced Modeling With Simio	271
9.1	Model 9-1: ED Model Revisited	271
9.1.1	Resource-Level Optimization With Model 9-1	281
9.2	Model 9-2: Pizza Take-out Model	289
9.2.1	Experimentation With Model 9-2	297
9.3	Model 9-3: Fixed-Capacity Buffers	301
9.4	Summary	307
9.5	Problems	307
10	Customizing and Extending Simio	311
10.1	Basic Concepts of Defining Objects	312
10.1.1	Model Logic	313
10.1.2	External View	314
10.1.3	Sub-classing an Object Definition	315
10.1.4	Properties, States, and Events	317
10.2	Model 10-1: Building a Hierarchical Object	318
10.2.1	Model Logic	318
10.2.2	External View	320
10.3	Model 10-2: Building a Base Object	321
10.3.1	Model Logic	322
10.3.2	External View	325
10.4	Model 10-3: Sub-Classing an Object	327
10.4.1	Model Logic	327
10.4.2	External View	330
10.5	Working With User Extensions	330
10.5.1	General Steps to Create and Deploy a User Extension	332
10.6	Summary	333
10.7	Problems	333
III	Case Studies Using Simio	335
11	Introductory Cases	337
11.1	Machining-Inspection Operation	337
11.1.1	Problem Description	337
11.1.2	Sample Model and Results	340
11.2	Amusement Park	349
11.2.1	Problem Description	349
11.2.2	Sample Model and Results	352

CONTENTS

xvii

11.3 Simple Restaurant	354
11.3.1 Problem Description	354
11.4 Small Branch Bank	357
12 Advanced Cases	363
12.1 Vacation City Airport	363
12.2 Simply The Best Hospital	367
Bibliography	371
Index	375