

Fig. 1. A 3-stage flow line with 2 operators in each stage.

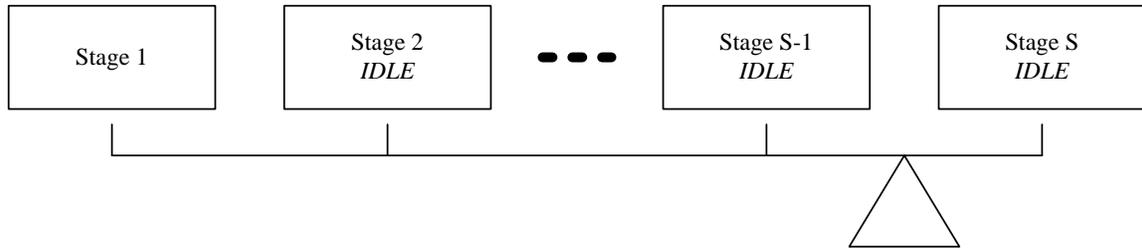


Fig. 2. A lever concept for IDLE in SS.

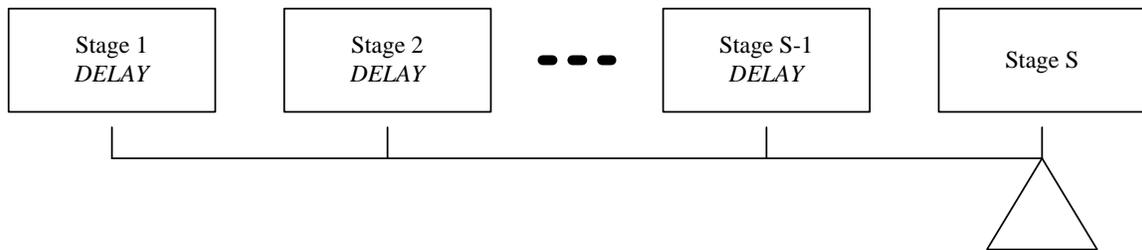


Fig. 3. A lever concept for DELAY in SS.

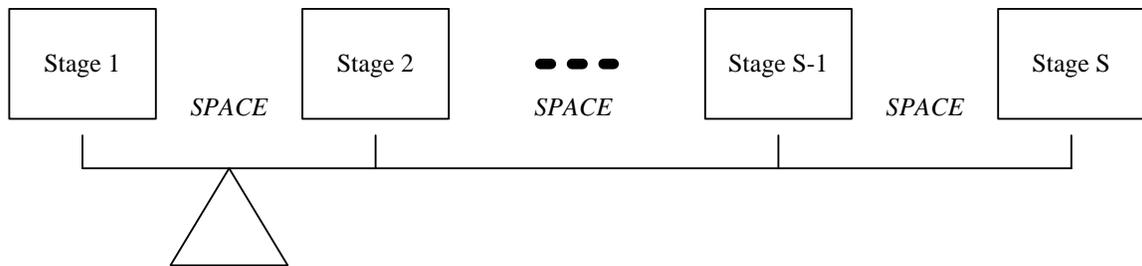


Fig. 4. A lever concept for SPACE in SS.