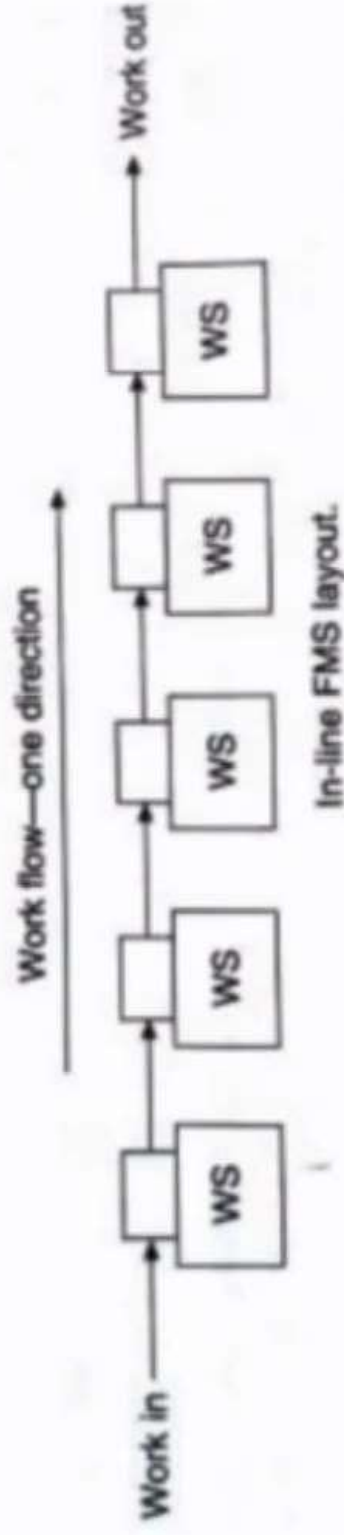
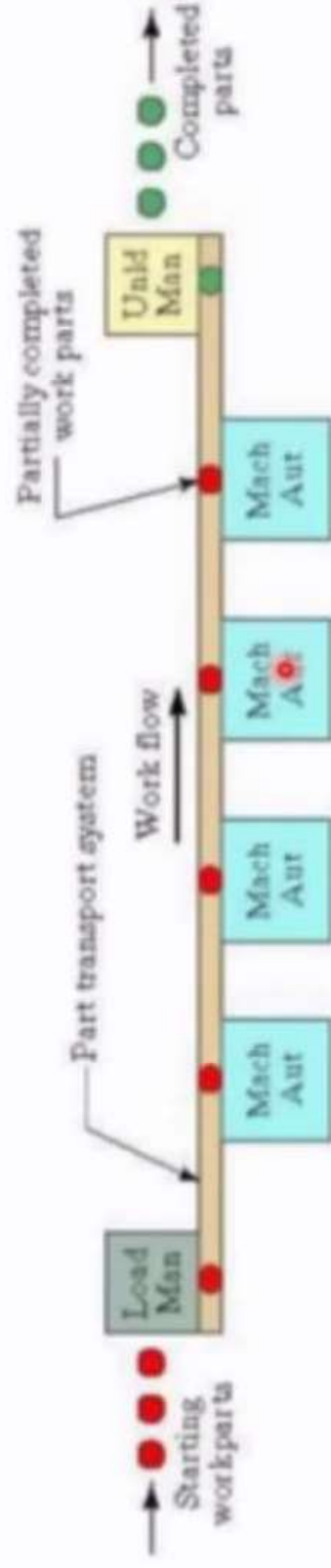


## **FMS Layout**

- The FMS layouts are Broadly Classified into the Following categories:
  1. FMS line layout
  2. FMS loop layout
  3. FMS Rectangular layout
  4. FMS ladder layout
  5. Open field layout
  6. Robot – centred cell.

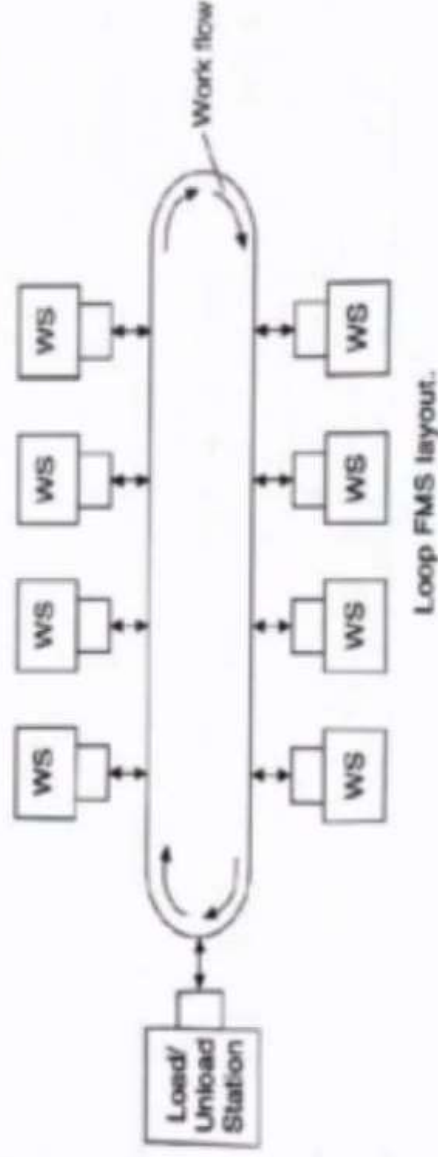
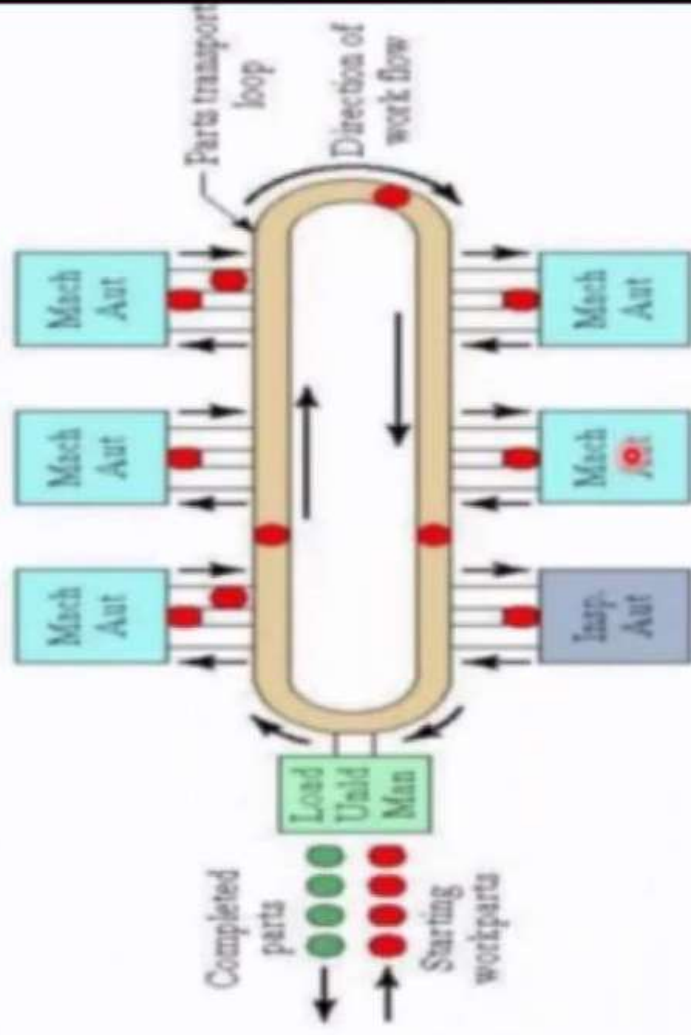
# 1. In-line or progressive FMS layout

- It is most appropriate for systems in which the work parts progress from one workstation (WS) to the next in a well – defined sequence with no back flow.



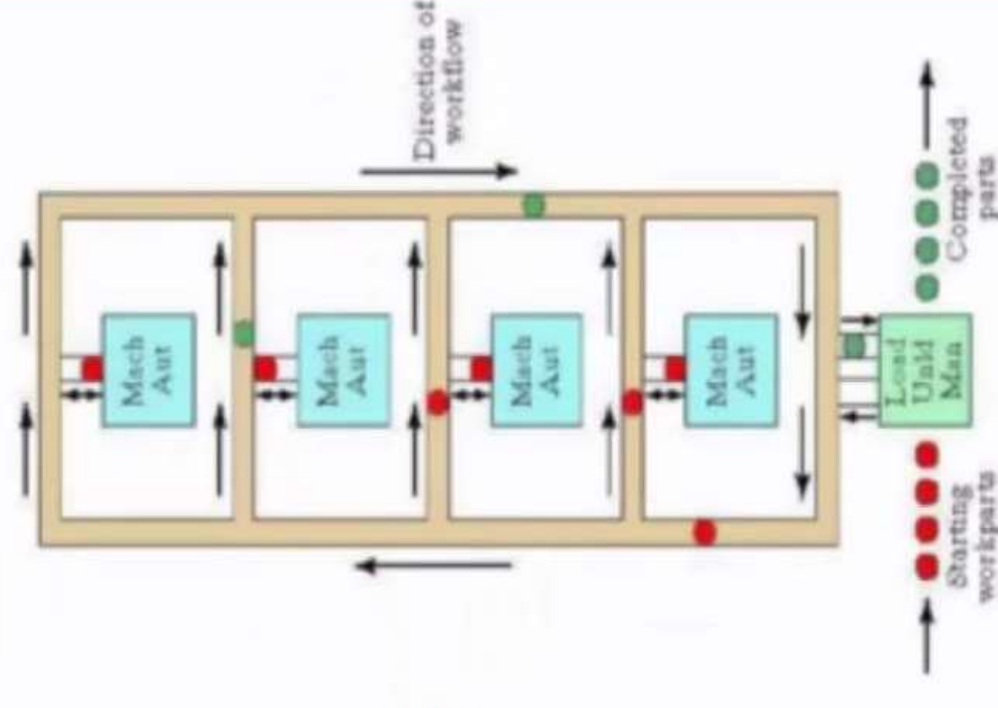
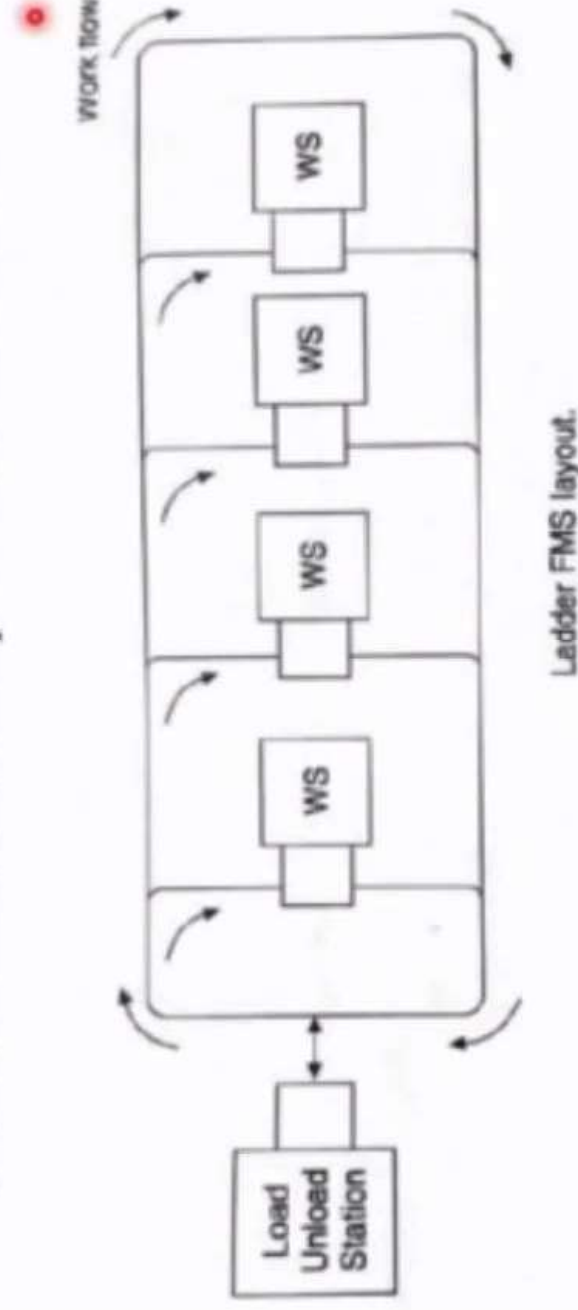
## 2. LOOP FMS Layout:

- In this layout work part usually flow in one direction along the loop with the capability at any workstation
- The load/unload stations are located at one end of the loop.



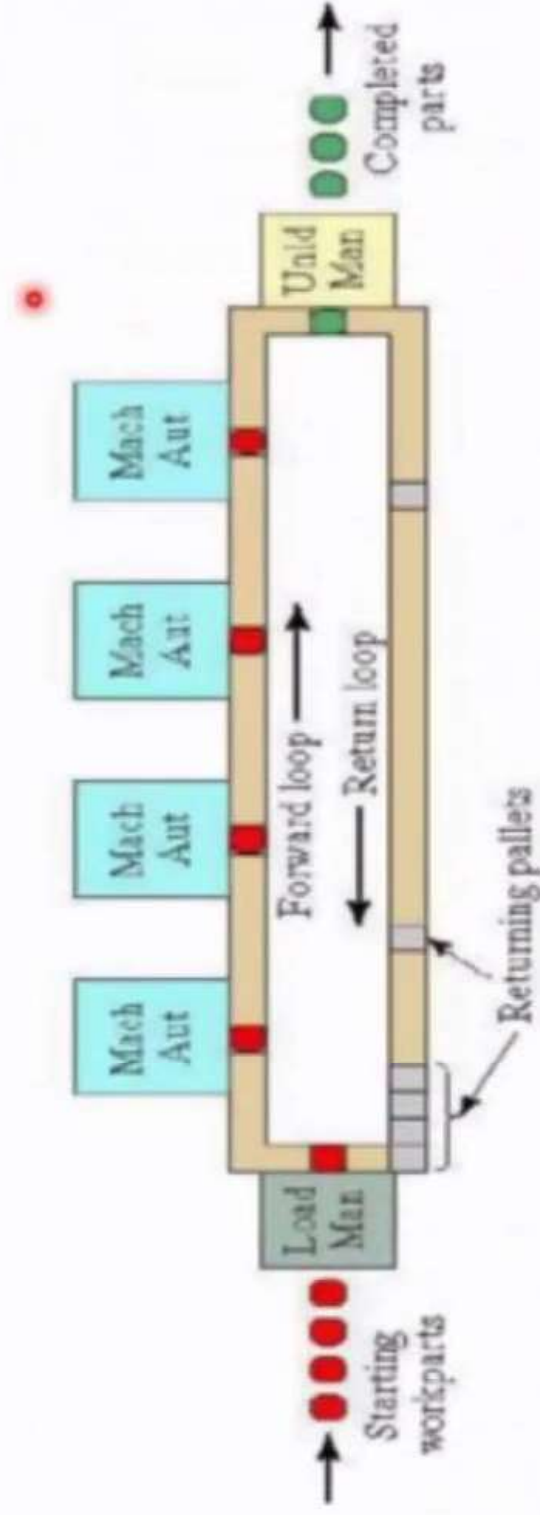
### 3. Ladder FMS Layout

- This type of layout contains rungs on which workstations are located.
- This layout reduces the average distance travelled to transfer work parts between stations.



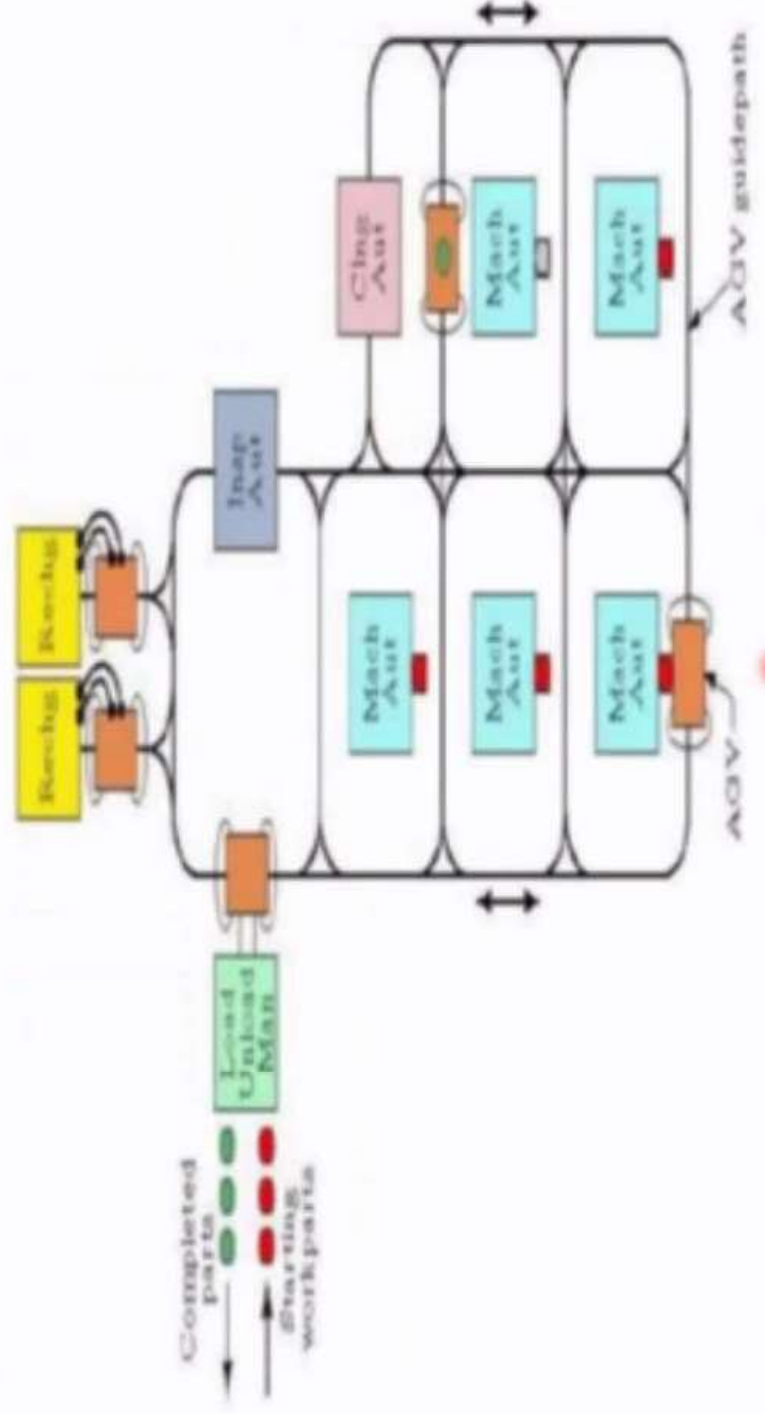
## 4. Rectangular FMS layout:-

- Rectangular layout allows recirculation of pallets back to the first station in the sequence after unloading at the final station..



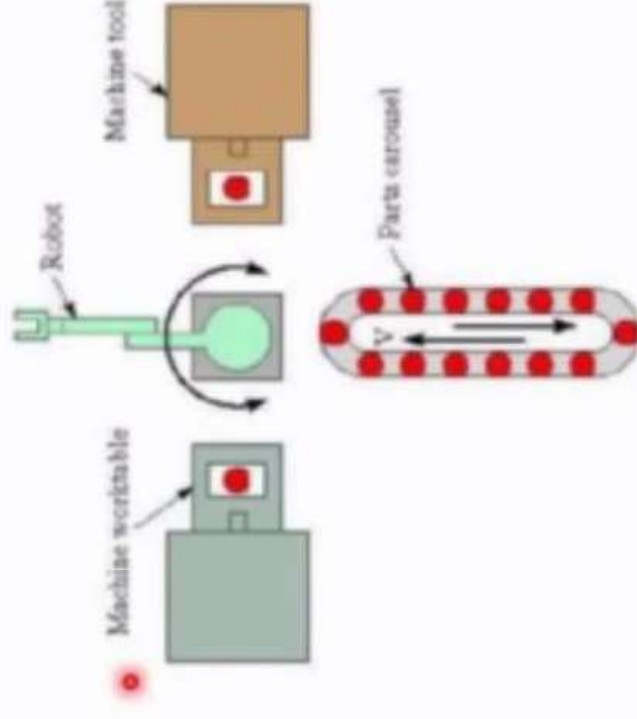
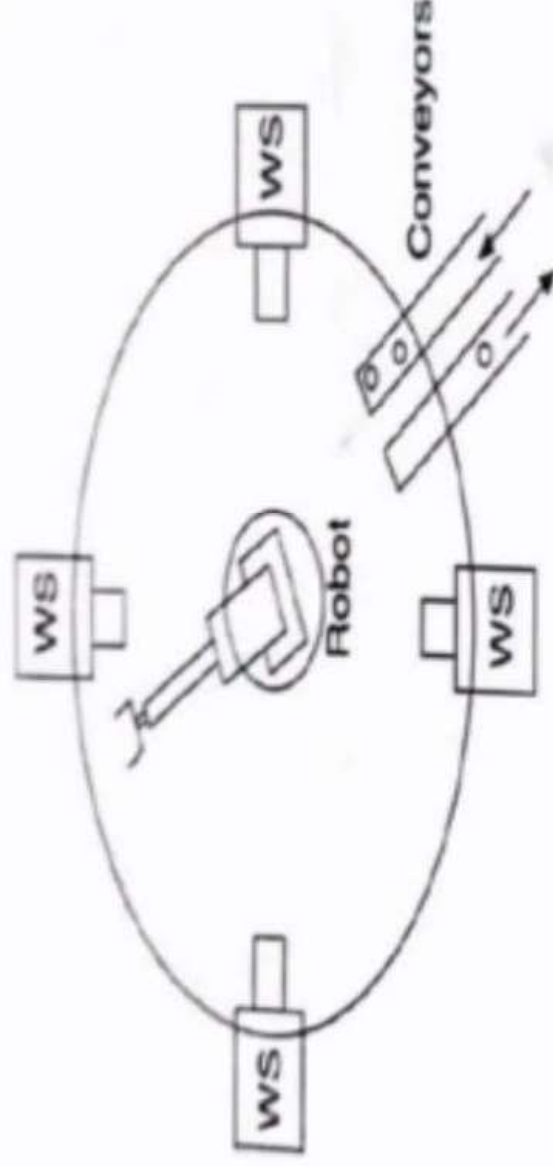
## 5. Open – field FMS layout

- The open field layout configuration consists of Loops, ladders, and sliding organised to achieve the desired processing requirements
- This is appropriate for a large family of parts.



## 6. Robot – Centred FMS layout

- In this the robot is located at the approximate centre of the layout and the other workstations are arranged around it.
- Industrial robot equipped with grippers may be used for the handling of rotational parts.
- The type of layout is well – suited for handling of cylindrical or disk shaped parts.



Robot-centred FMS layout.