1. Roundtrip =18 mins
 360 mins per day
 2160 mins per week

Trips= 360/18= 20 trips per day
 2160/18= 120 trips per weeks

Forklifts= 5000/120= 41.67= 42forklifts in the warehouse
2. Planning Principal- A plan to determine what material needs to be moved, when and where it will be moved, and how it will be moved.

Automation Principal- Mechanization and automation depends on the specific operational requirements.

System Principal- A collection of elements working and interacting together as a unit to perform a common function.

Standardization Principal- The amount of material to be moved or stored as a unit.

Accounting and life-cycle cost Principal- The principal relating to the cost.

Work Principal- Use of gravity to to your advantage.

Environmental design principal- Where the facility's space is used effectively as possible.

Safety and ergonomics principal- Enhances safety conditions.