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.