

Lecture Notes in Mechanical Engineering

Francisco J. G. Silva
António B. Pereira
Raul D. S. G. Campilho *Editors*


Flexible Automation and Intelligent Manufacturing: Establishing Bridges for More Sustainable Manufacturing Systems

Proceedings of FAIM 2023,
June 18–22, 2023, Porto, Portugal,
Volume 1: Modern Manufacturing

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Lecture Notes in Mechanical Engineering

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Preface

This volume of Lecture Notes in Mechanical Engineering (LNME) is one of two volumes including papers selected from the 32nd International Conference on Flexible Automation and Intelligent Manufacturing (FAIM 2023), held in Porto, Portugal, from June 18 to 22, 2023. The FAIM 2023 conference was organized by the School of Engineering, Polytechnic of Porto, located in Porto, Portugal.

Flexible Automation and Intelligent Manufacturing (FAIM) is a renowned international forum for academia and industry to disseminate novel research, theories, and practices relevant to automation and manufacturing. For over 30 years, the FAIM conference has provided a strong and continuous presence in the international manufacturing scene, addressing both technology and management aspects via scientific conference sessions, workshops, tutorials, and industry tours. Since 1991, FAIM has been hosted in prestigious universities on both sides of the Atlantic and, in recent years, in Asia. The conference attracts hundreds of global leaders in automation and manufacturing research who attend program sessions where rigorously peer-reviewed papers are presented during the multiple-day conference. The conference links researchers and industry practitioners in a continuous effort to bridge the gap between research and implementation.

FAIM 2023 received more than 400 contributions from over 40 countries and over 220 institutions around the world. After a two-stage double-blind review, the technical program committee accepted 263 papers. From these, 242 papers have been included in two LNME volumes, and 21 extended papers are published as fast-track articles in *Robotics and Computer-Integrated Manufacturing* and *The International Journal of Advanced Manufacturing Technology*. A selection of these LNME articles will be invited to submit substantially extended versions to special issues in ten international indexed journals, such as the *International Journal of Computer Integrated Manufacturing*, *Journal of Mechanical Engineering Science*, *Journal of Testing and Evaluation*, *Sustainability journal*, *Machines journal*, *Metals journal*, *Actuators journal*, *Systems journal*, *FME Transactions journal*, and *Technological Sustainability journal*. We are grateful to the authors for their contributions and would like to acknowledge the FAIM steering committee, advisory board committee, honorary chairs, the scientific committee members, and manuscript reviewers for their significant efforts, continuous support, sharing their expertise, and conducting manuscript reviews. Manuscript reviewers came from various locations around the world, performing 1339 reviews in total. With such effort and toughness, the high standards of the papers included in the FAIM program have been kept.

Special thanks to FAIM 2023's invited speakers: Jiju Antony (*Professor, Khalifa University, Abu Dhabi, UAE*), Daryl Powell (*Chief Scientist at SINTEF, Norway*), Marcello Pellicciari (*Professor, Director of the PhD School "E4E-Engineering for Economics, Economics for Engineering", University of Modena and Reggio Emilia, Modena, Italy*), Rodrigo Martins (*Professor, Nova School of Science and Technology, Lisboa, Portugal*), Alcibiades Guedes (*Professor at Faculty of Engineering, University of Porto, President*

of the Board & CEO at INEGI, Porto, Portugal), and Pedro Carreira (CEO at Continental Mabor, Lousado, Portugal).

The book *Flexible Automation and Intelligent Manufacturing: Establishing Bridges for More Sustainable Manufacturing Systems—Proceedings of FAIM 2023* has been organized in two LNME volumes. Volume 1 is mainly devoted to Mechanical Engineering, Robotics, Automation, Manufacturing Processes and Materials Processing, while Volume 2 is mainly focused on Industrial Management, Digital Transformation, Industry 4.0/5.0, Human Factors, Logistics, Sustainability, and related matters. In both volumes, the papers have been organized by topics, providing to the reader an excellent set of papers regarding each topic.

We appreciate the partnership with Springer, ConfTool, and our sponsors for their fantastic support during the preparation of FAIM 2023. Thank you very much to the FAIM 2023 organizing team, whose hard work was crucial to the success of the FAIM 2023 conference.

May 2023

Francisco J. G. Silva
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Contents

Automation and Robotics

VR Driven Unsupervised Classification for Context Aware Human Robot Collaboration	3
<i>Ali Kamali Mohammadzadeh, Carlton Leroy Allen, and Sara Masoud</i>	
Environment for the Design and Automation of New Cable-Driven Parallel Robot Architectures	12
<i>Josué Rivera, Julio Garrido, Enrique Riveiro, and Diego Silva</i>	
Robot-Based Inspection of Freeform Components: Process Analysis and Challenges in Using a Lateral Scanning WLI	21
<i>Jessica Ehrbar, Daniel Schoepflin, and Thorsten Schüppstuhl</i>	
Development of a Robot-Based Handling System for a High Precision Manufacturing Cell	29
<i>George Papazetis, Evangelos Tzimas, Panorios Benardos, and George-Christopher Vosniakos</i>	
Transparent Object Classification and Location Using MmWave Radar Technology for Robotic Picking	37
<i>Ricardo N. C. Rodrigues, João Borges, and António H. J. Moreira</i>	
AI-Based Supervising System for Improved Safety in Shared Robotic Areas ...	46
<i>Ana Almeida and António H. J. Moreira</i>	
Vision Robotics for the Automatic Assessment of the Diabetic Foot	54
<i>Rui Mesquita, Tatiana Costa, Luis Coelho, and Manuel F. Silva</i>	
A Conceptual Framework for the Improvement of Robotic System Reliability Through Industry 4.0	62
<i>Dimitris Mourtzis, Sofia Tsoubou, and John Angelopoulos</i>	
Human-Robot Collaboration, Sustainable Manufacturing Perspective	71
<i>Robert Ojstersek, Borut Buchmeister, and Aljaz Javernik</i>	
Towards a Robotic Intervention for On-Land Archaeological Fieldwork in Prehistoric Sites	79
<i>L'hermite Tom, Cherlonneix Cyprien, Paul-Eric Dossou, and Laouenan Gaspard</i>	

UWB-Based Indoor Navigation in a Flexible Manufacturing System Using a Custom Quadrotor UAV	91
<i>Petros Savvakis, George-Christopher Vosniakos, Emmanuel Stathatos, Axel Debar-Monclair, Marek Chodnicki, and Panorios Benardos</i>	
Real-Time Defect and Object Detection in Assembly Line: A Case for In-Line Quality Inspection	99
<i>Milad Ashourpour, Ghazaleh Azizpour, and Kerstin Johansen</i>	
Using Computer Vision to Improve SME Performance	107
<i>Kokou C. Lissassi, Paul-Eric Dossou, and Christophe Sabourin</i>	
Cyber-Physical Systems Based Smart Manufacturing of Disinfectants: A Need, and Solution Driven by COVID-19 Pandemic	117
<i>Faiz Iqbal, Tushar Semwal, and Adam A. Stokes</i>	
CPPS-3D: A Methodology to Support Cyber Physical Production Systems Design, Development and Deployment	125
<i>Pedro F. Cunha, Dário Pelixo, and Rui Madeira</i>	
Reinforcement Learning-Based Model for Optimization of Cloud Manufacturing-Based Multi Objective Resource Scheduling: A Review	133
<i>Rasoul Rashidifar, F. Frank Chen, Mohammad Shahin, Ali Hosseinzadeh, Hamed Bouzary, and Awni Shahin</i>	
An Overview of Explainable Artificial Intelligence in the Industry 4.0 Context	141
<i>Pedro Teixeira, Eurico Vasco Amorim, Jörg Nagel, and Vitor Filipe</i>	
Analyzing the Effects of Different 3D-Model Acquisition Methods for Synthetic AI Training Data Generation and the Domain Gap	149
<i>Özge Beyza Albayrak, Daniel Schoepflin, Dirk Holst, Lars Möller, and Thorsten Schüppstuhl</i>	
Improving Regulations for Automated Design Checking Through Decision Analysis Good Practices: A Conceptual Application to the Construction Sector	160
<i>Ricardo J. G. Mateus, Francisco Silva Pinto, Judith Fauth, Miguel Azenha, José Granja, Ricardo Veludo, Bruno Muniz, João Reis, and Pedro Marques</i>	
Preliminary Design of an Automatic Palletizing System During the Pre-sales Stage	170
<i>Enrico Guidetti, Pietro Bilancia, Roberto Raffaelli, and Marcello Pellicciari</i>	

A New Equipment for Automatic Calibration of the Semmes-Weinstein Monofilament	179
<i>Pedro Castro-Martins and Luís Pinto-Coelho</i>	
Measuring the Moment-Curvature Relationship of a Steerable Catheter Using a Load Cell and Stereovision System	187
<i>Jajun Ryu, Jaeseong Choi, Taeyoung Kim, and Hwa Young Kim</i>	
Manufacturing Processes and Automation	
Study of the Best Operational Parameters in Laser Marking of Plastic Parts	199
<i>João Costa, Francisco J. G. Silva, Arnaldo G. Pinto, Isabel Mendes Pinto, and Vitor F. C. Sousa</i>	
Laser Marking on White-Coloured Polyoxymethylene (POM) Polymer Substrate: Challenges and Perspectives	208
<i>Stanley Udochukwu Ofoegbu, Paulo J. A. Rosa, Fábio A. O. Fernandes, António B. Pereira, and Pedro Fonseca</i>	
Influence of Laser Beam Intensity Distribution on Keyhole Geometry and Process Stability Using Green Laser Radiation	216
<i>Florian Kaufmann, Andreas Maier, Julian Schrauder, Stephan Roth, and Michael Schmidt</i>	
Application of Ontology Reasoning in Machining Process Planning – Case Study	228
<i>Peter Adjei, Felix Asare, Dušan Šormaz, Riad Al Hasan Abir, Mandvi Fuloria, David Koonce, and Saruda Seeharit</i>	
Experimental Research on the Dimensional and Geometrical Deviations of Features-of-Size Produced by Material Extrusion Processes	238
<i>Christos Vakouftsis, Georgios Kaisarlis, Vasilios Spitas, and Christopher G. Provatidis</i>	
Advanced Characterization Techniques of Multi-material Machining Tool Coatings	248
<i>R. D. F. S. Costa, A. M. P. Jesus, S. L. S. Simões, and M. L. S. Barbosa</i>	
Optimisation of CNC Machining Part Programs Exemplified for Rough-Milling of Pockets	257
<i>A. Iliopoulos and George-Christopher Vosniakos</i>	

NAM-CAM: Neural-Additive Models for Semi-analytic Descriptions of CAM Simulations	265
<i>Konstantin Ditschuneit, Adem Frenk, Markus Frings, Viktor Rudel, Stefan Dietzel, and Johannes S. Otterbach</i>	
Adaptive Toolpath Planning for Hybrid Manufacturing Based on Raw 3D Scanning Data	273
<i>Panagiotis Stavropoulos, Lydia Athanasopoulou, Thanassis Souflas, and Konstantinos Tzimanis</i>	
Machining of Individualized Milled Parts in a Skill-Based Production Environment	283
<i>Andreas Wagner, Magnus Volkmann, Jesko Hermann, and Martin Ruskowski</i>	
Tool Path Length Optimization in Drilling Operations: A Comparative Study	293
<i>Alaeddine Zouari, Dhouib Souhail, Fatma Lehyani, and José Carlos Sá</i>	
Feed Rate Optimization Using NC Cutting Load Maps	302
<i>N. H. Yoo, S. G. Kim, T. H. Kim, E. Y. Heo, and D. W. Kim</i>	
Some Challenges and Opportunities in Additive Manufacturing Industrialization Process	311
<i>Zahra Isania, Maria Pia Fanti, and Giuseppe Casalino</i>	
Design Parameters to Develop Porous Structures: Case Study Applied to DLP 3D Printing	319
<i>R. Rodrigues, P. Lopes, Luis Oliveira, L. Santana, and J. Lino Alves</i>	
Deep Learning Based Automatic Porosity Detection of Laser Powder Bed Fusion Additive Manufacturing	328
<i>Syed Ibn Mohsin, Behzad Farhang, Peng Wang, Yiran Yang, Narges Shayesteh, and Fazleena Badurdeen</i>	
Influence of Process Parameters on Compression Properties of 3D Printed Polyether-Ether-Ketone by Fused Filament Fabrication	336
<i>Erika Lannunziata, Alberto Giubilini, Abdollah Saboori, and Paolo Minetola</i>	
3D Printing of Polycaprolactone Scaffolds with Heterogenous Pore Size for Living Tissue Regeneration	345
<i>N. Manou, George-Christopher Vosniakos, and P. Kostazos</i>	

An Innovative Platform for Designing and Rapid Virtual Prototyping of Garments: The Case of <i>i-Mannequin</i>	354
<i>Evridiki Papachristou, Despoina Kalaitzi, and Michael Kaseris</i>	
Analysis of the Possibilities of Applying 3D Print Methods for the Needs of Ship-Building Industry	363
<i>Krzysztof Jasiński, Marek Chodnicki, Krzysztof Bobrowski, Krzysztof Lipiński, Marcin Kluczyk, and Adam Szeleziński</i>	
Development of a Large-Scale Artifact for a Wine Visitor Center Using Additive Manufacturing Technologies	371
<i>Luis Torres and Rui Mendonça</i>	
A Non-retracted Path Generation Algorithm for Material Extrusion Type of Additive Manufacturing	380
<i>Melih Ozcan, Yigit Hergul, and Ulas Yaman</i>	
Movement Tracking-Based In-Situ Monitoring System for Additive Manufacturing	388
<i>Gokula Vasantha, Ayse Aslan, Paul Lapok, Alistair Lawson, and Stuart Thomas</i>	
On the Development of a Compliant Mechanism for Displacement Amplification Produced by Selective Laser Sintering	399
<i>Alessandro Bove, Flaviana Calignano, Matteo Perrone, and Luca Iuliano</i>	
Analysis on the Effect of Energy Density on Mechanical Properties of Selective Laser Sintering Processed Polyamide-12	407
<i>P. Karmiris-Obratański, E. L. Papazoglou, N. E. Karkalos, and A. P. Markopoulos</i>	
Empirical Characterization of Track Dimensions for CMT-Based WAAM Processes	415
<i>Jacopo Lettori, Roberto Raffaeli, Pietro Bilancia, Milton Borsato, Margherita Peruzzini, and Marcello Pellicciari</i>	
Surface Roughness Measurement in Laser Powder Bed Fusion Manufacturing Process	425
<i>Vincenza Mercurio, Flaviana Calignano, Giovanni Marchiandi, and Luca Iuliano</i>	
Tuning Process Parameters to Control the Porosity of Parts Produced with Directed Energy Deposition	434
<i>Gabriele Piscopo, Eleonora Atzeni, Luca Iuliano, and Alessandro Salmi</i>	

Vision Inspection Design for Systematic Production of Needle Beds: An Industrial Application	444
<i>Luis Freitas, Teresa Malheiro, A. Manuela Gonçalves, José Vicente, Filipe Pereira, Francisco Morais, João Bessa, and José Machado</i>	
Thermal Profile Prediction for Ball Grid Array Solder Joints Using Physic-Informed Artificial Neural Network	453
<i>Zhenxuan Zhang, Yuanyuan Li, Sang Won Yoon, Seungbae Park, and Daehan Won</i>	
Design and Validation of Fixation Points of Polymeric Components for the Automotive Industry	461
<i>R. J. O. Simões, Raul D. S. G. Campilho, Francisco J. G. Silva, and C. Prakash</i>	
Towards an Automatic Strategy for Conformal Cooling Design	470
<i>Sofia B. Rocha, Gonçalo Martins, Victor Neto, and Mónica S. A. Oliveira</i>	
Process Improvement in Zamak Injection Machines for Automotive Component Fabrication	479
<i>J. L. T. A. Pereira, Raul D. S. G. Campilho, Francisco J. G. Silva, I. J. Sánchez-Arce, and C. Prakash</i>	
EXPLAINS: Explainable Anomaly Prediction for SMT Solder Joints Using SPI Data	487
<i>Nieqing Cao, Daehan Won, and Sang Won Yoon</i>	
Leakage Inspection for the Scale-Up of Hydrogen Electrolyzers: A Case Study and Comparative Analysis of Technologies	496
<i>Christian Masuhr, Lukas Büsch, and Thorsten Schüppstuhl</i>	
Process Mining and TOPSIS Analysis for Identifying the Most Complex Combination Vehicle Model and Paint Color – A Case Study	509
<i>André Luiz Micosky, Cleiton Ferreira dos Santos, Alef Berg de Oliveira, Eduardo de Freitas Rocha Loures, and Eduardo Alves Portela Santos</i>	
Simulation Case Study for Improving Painting Tires Process Using the Fanuc Roboguide Software	517
<i>Adriano A. Santos, Jakub Haladus, Filipe Pereira, Carlos Felgueiras, and Rui Fazenda</i>	

Integral Quality Assurance Method for a CFRP Aircraft Fuselage Skin:
 Gap and Overlap Measurement for Thermoplastic AFP 525
*Monika Mayer, Alfons Schuster, Lars Brandt, Dominik Deden,
 and Frederic Fischer*

Conceptual Framework for Development of Intelligent Control Systems
 for Thermoplastics Injection Molding 535
Olga Ogorodnyk

Automation of Fitting Pipe Manufacturing in Shipbuilding 544
*Klara Pejić, Konstantin von Haugwitz, Martin-Christoph Wanner,
 and Wilko Flügge*

Development of a Recovery Process for Sanitary Ware Using Laser
 Technology 551
R. D. F. S. Costa, L. M. P. Durão, Arnaldo G. Pinto, and J. R. Ferreira

Statistical-Based Pick-and-Place Control 559
Jaewoo Kim, Daehan Won, and Sang Won Yoon

The Development of a Robotic Digital Twin for the Life Science Sector 567
*E. P. Hinchy, N. Cunningham, A. Doohan, M. Hassanpour, E. Nwanji,
 D. O'Malley, A. Ryan, and M. Zeinali*

Evaluating a Grey-Box System Identification Module for a Digital Twin 575
Jonathan Lesage and Robert W. Brennan

A Model-Based Digital Twin for Adaptive Trajectory Planning of a Robot
 for Mixed Packaging Process and Active Collision Avoidance 583
Alexios Chaloulos, Nikolaos Nikolakis, and Kosmas Alexopoulos

Data-Driven Discovery of Manufacturing Processes and Performance
 from Worker Localisation 592
*Ayse Aslan, Hanane El-Raoui, Jack Hanson, Gokula Vasantha,
 John Quigley, and Jonathan Corney*

Software-supported Hazards Identification for Plug & Produce Systems 603
*Waddah Mosa, Bassam Massouh, Mahmood Khabbazi,
 Mikael Eriksson, and Fredrik Danielsson*

Iterative Planning as a Holistic Framework for Production System-Wide
 Optimization Control Loops 611
David Dietrich, Michael Neubauer, Armin Lechler, and Alexander Verl

Towards Model-Based Assembly System Configuration Supported
by SysML and AutomationML 622
Jan-Erik Rath, Julian Koch, and Thorsten Schüppstuhl

Deep Reinforcement Learning-Based Approach to Dynamically Balance
Multi-manned Assembly Lines 633
*Romão Santos, Catarina Marques, César Toscano, Hugo M. Ferreira,
and Joel Ribeiro*

A New Genetic Algorithm Approach to Optimize the Workload Balance
in a Case Study of a Footwear Industry 641
Lísia Peroza Ruiz and Adelano Esposito

A Hybrid Model to Support Decision Making in Manufacturing 651
*Alef Berg de Oliveira, André Luiz Micosky,
Cleiton Ferreira dos Santos, Eduardo de Freitas Rocha Loures,
and Eduardo Alves Portela Santos*

Wireless Safety in Industrial 5G Networks 659
Simon Lamoth, Julian Goetz, Tatjana Legler, and Martin Ruskowski

Development of a Digital Thread for Orchestrating Data Along the Product
Lifecycle for Large-Part and High-Precision Manufacturing 668
*Félix Vidal, Lucía Alonso, Patrick de Luca, Yann Duplessis-Kergomard,
and Roberto Castillo*

Inspection of Part Placement Within Containers Using Point Cloud
Overlap Analysis for an Automotive Production Line 677
*Carlos M. Costa, Joana Dias, Rui Nascimento, Cláudia Rocha,
Germano Veiga, Armando Sousa, Ulrike Thomas, and Luís Rocha*

Analysis and Assessment of Multi-Agent Systems for Production Planning
and Control 687
Julia Lena Huckert, Aleksandr Sidorenko, and Achim Wagner

A Conceptual Framework for Localization of Active Sound Sources
in Manufacturing Environment Based on Artificial Intelligence 699
Reza Jalayer, Masoud Jalayer, Carlotta Orsenigo, and Carlo Vercellis

Project-Based Collaborative Research and Training Roadmap
for Manufacturing Based on Industry 4.0 708
*Marek Chodnicki, Mariusz Deja, George-Christopher Vosniakos,
Panorios Benardos, Lihui Wang, Xi Vincent Wang, Thomas Braun,
and Robert Reimann*

Application of Ensemble Learning for Improving Failure Prediction
in Lithium-Ion Batteries 716
*Joelton Deonei Gotz, Gabriel Carrico Guerrero,
Gustavo Onofre Andreão, and Milton Borsato*

Machines and Mechanical Design

An Image Processing Approach for Morphology Characterization
of Serration in Ti-6Al-7Nb Chip Sliding Surface 727
Ana Horovistiz, Sílvia Carvalho, and J. P. Davim

Degradation-Based Design for Disassembly Assessment Using Network
Centrality Metrics 736
Header M. Alrufaifi, Joao Paulo Jacomini Prioli, and Jeremy L. Rickli

CAD/CAM/CAE

Rule-Based System for Assembly Planning Using Features 747
Dušan Šormaz and Anibal Careaga Campos

Generation of Conformal Cooling Channels on Generic Geometries:
An Assisted Automated Approach 755
*David Oliveira, Pedro Ribeiro, Gustavo Carreira,
and Miguel Belbut Gaspar*

On the Effects of Process Optimization for Ti-6Al-2Sn-4Zr-2Mo Lattice
Structures Produced by Electron Beam Powder Bed Fusion 763
*Manuela Galati, Massimo Giordano, Giovanni Rizza,
Abdollah Saboori, Paolo Antonioni, and Luca Iuliano*

Advanced Materials Processing and Characterization

A Review of INCONEL® Alloy’s Non-conventional Machining Processes 773
*A. F. V. Pedroso, Vitor F. C. Sousa, N. P. V. Sebbe, Francisco J. G. Silva,
Raul D. S. G. Campilho, R. C. M. Sales-Contini, and F. R. Nogueira*

Wear Behavior Analysis of TiN/TiAlN Coated Tools in Milling of Inconel
718 784
*N. P. V. Sebbe, F. Fernandes, Francisco J. G. Silva, Vitor F. C. Sousa,
R. C. M. Sales-Contini, Raul D. S. G. Campilho, and A. F. V. Pedroso*

A Brief Review of Injection-Mould Materials Hybrid Manufacturing Processes	796
<i>F. R. Nogueira, A. F. V. Pedroso, Vitor F. C. Sousa, N. P. V. Sebbe, R. C. M. Sales-Contini, and M. L. S. Barbosa</i>	
Studying the Machining Performance of DSS Steel Using Single and Multilayered TiAlSiN Coated Tools Deposited by HiPIMS	807
<i>Andresa Baptista, Gustavo F. Pinto, Vitor F. C. Sousa, Raul D. S. G. Campilho, and Filipe Fernandes</i>	
Characterization of Micro-nanostructured Thin Layers Used to Increase the Lifetime of Hip Prosthesis Components	819
<i>Liliana-Laura Badita-Voicu, Aurel Zapciu, Dorin Angelescu, and Adrian-Catalin Vociu</i>	
Optimization of Surface Roughness in Laser Cutting Process of Mild Steel Using RSM and GA Method	827
<i>Majid Shamlooei, Gabriele Zanon, Marco Brugnolli, Mattia Vanin, and Oreste S. Bursi</i>	
Non-destructive Crack Detection Methodologies in Green Compacts: An Overview	836
<i>Sameen Mustafa, Angelika Peer, and Franco Concli</i>	
The Importance of Patent Registration in the Way of Generating Wealth for Nations	848
<i>Gilberto Santos, Sandro Carvalho, José Carlos Sá, and Luis P. Ferreira</i>	
Innovative Maintenance	
Digital Transformation of Electrical Engineering Companies in the Czech Republic	859
<i>Andrea Benešová, František Steiner, and Jiří Tupa</i>	
A Value-Oriented Framework for Return Evaluation of Industry 4.0 Projects ...	871
<i>Alexander Dutra Tostes and Américo Azevedo</i>	
Digital Factory for Product Customization: A Proposal for a Decentralized Production System	879
<i>Hélio Castro, Fernando Câmara, Eduardo Câmara, and Paulo Ávila</i>	

Management

Online Hazard Detection in Reconfigurable Plug & Produce Systems	889
<i>Bassam Massouh, Fredrik Danielsson, Sudha Ramasamy, Mahmood Khabbazi, and Xiaoxiao Zhang</i>	
Sustainable Transport: A Systematic Literature Review	898
<i>João Reis, Joana Costa, Pedro Marques, Francisco Silva Pinto, and Ricardo J. G. Mateus</i>	
Framework Proposition for the Implementation of Task Shifting Practice: A Case Study in the Healthcare Sector	909
<i>Federica Costa, Najla Alemsan, Alberto Portioli Staudacher, and Guilherme Luz Tortorella</i>	

Lean, Kaizen, Quality and Productivity





A Review of Value Stream Mapping (VSM) for Viable Business Process Management Among Agro-Allied Companies During the 4IR	919
<i>Makinde Oluwafemi Ajayi and Opeyeolu Timothy Laseinde</i>	
Outsourcing Optimization in Footwear Industry: The Case of a Portuguese Company	929
<i>Eliana Costa e Silva, Raquel Francisco, Sandra P. Sousa, and Vítor Braga</i>	

Author Index	939
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Automation and Robotics



VR Driven Unsupervised Classification for Context Aware Human Robot Collaboration

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Abstract. Human behavior, despite its complexity, follows structured principles that, if understood, will result in more reliable and effective collaborative automation environments. Characterizing human behavior in collaborative automation systems based on understanding the underlying context allows for novel advances in robotic human behavior sensing, processing, and predicting. Here, virtual reality, through integration of HTC Vive Arena Pro Eye Bundle, Leap Motion, and Unity 3D game engine, is used for safe and secure data collection on humans' movements and body language in human robot collaborative environments. This paper proposes an unsupervised classification framework through integration of dynamic time warping and k-means clustering algorithm to enable robotics agents to understand humans' intentions based on their body movements. Results display that the proposed framework is capable of identifying underlying intentions with an average accuracy, recall, and precision of 85%, 73%, and 75%, respectively.

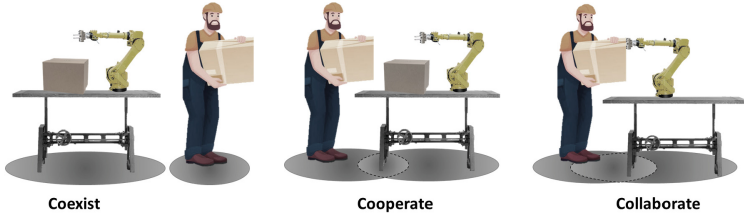
Keywords: Human Robot Interaction · Virtual Reality · Unsupervised Classification

1 Introduction

Human-robot interaction (HRI) is a diverse field of research with huge economic impact. The collaborative robots is estimated to reach over \$1.43 billion by 2027, having a significant impact on the Gross Domestic Product (GDP) of various economies [1]. HRI is already used in manufacturing environments, space applications, rescue robotics, and more [2–4] Human–robot interaction is defined as “the process of conveying human intentions and interpreting task descriptions into a sequence of robot motions complying with robot capabilities and working requirements” [5]. In manufacturing, industrial robots, equipped with different sensors, can be adapted to do many different industrial tasks [6]. HRI in manufacturing faces challenges such as ensuring safety and efficiency. To address these challenges, it is critical for robots understand humans' intentions and the underlying context [7].

As demonstrated in Fig. 1, HRI can be classified into the following three classes: First, Human–Robot Coexistence, which is defined as the capability of sharing the workspace between humans and robots without requiring mutual contact or coordination of actions

and intentions [8]. Second, Human–robot cooperation, in which humans and robots work on the same goal and occupy the same time and space, simultaneously. The cooperation requires advanced technologies and techniques for collision detection and collision avoidance [9]. Third, Human–robot collaboration, performing complex tasks with direct human interactions, where explicit contact between human and robot exists [6].



Aspects	Human Robot Interaction		
Space	Separated	Shared	Shared
Tasks	Unrelated	Linked	Shared
Contact	Impossible	Possible	Desired
Context Awareness	Not necessary	Minimal	Necessary

Fig. 1. The three forms of human-robot interaction [7].

Humans and robots collaborating is on a common objective form a team with complementary skills, in which an agreed-upon strategy is necessary for effective collaboration amongst all parties. Also, humans and robots need to be aware of the intents of the other team members. Based on which, a robot can design its own behaviors that will ultimately result in the achievement of the shared objective through perceiving and understanding the surroundings as well as making decisions and plan ahead [10].

The goal of this study is to create a virtual platform that enables safe yet realistic context-aware human-robot collaboration. To this end, this study develops a Virtual Reality (VR) platform for safe data collection, while proposes an unsupervised classification framework through integration of dynamic time warping (DTW) and k-means algorithm for intent prediction. This enables robotics agents to predict and understand human intents from their physical cues. In the remainder of the paper, Sect. 2 reviews the literature of the topic. Section 3 provides the methodology of the research. Results and discussion are provided in Sect. 4 and, Sect. 5 concludes the paper.

2 Literature Review

The literature of human intention recognition (classification) is diverse and has caught the attention of researchers from both industry and academia [11]. Intention recognition is also known as activity recognition, plan recognition, goal recognition, behavior recognition. In this work, we define intention recognition as the process of determining what an observed agent intends to do in the immediate future [12]. Recognizing the goal of the observed agent is an important aspect in human-robot interaction, as this understanding enables effective interaction and also proactive behavior modification in order to prevent accidents or resolve issues that may arise.

Human intention/activity recognition based on images or videos has received plenty of attention recently in the field of computer vision. The occlusion problem, however, reduces the accuracy of visual-based recognitions [13]. Wearable devices, on the other hand, immediately sense human body movements, providing real-time information on the body status. Additionally, a variety of low-cost wearable gadgets are available on the market and are frequently employed in intention recognition [14].

Among the studies that addressed the problem of human intention recognition, Stiefmeire et al. [15] utilized ultrasonic sensors for worker activity recognition using a Hidden Markov Model. In their following study, the authors proposed a string-matching based classification approach using multiple sensors for recognizing worker activities in a manufacturing setting [16]. Koskimaki et al. classified five activities for industrial assembly lines using a wrist-worn Inertial Measurement Unit (IMU) sensor and a K-Nearest Neighbor model [17]. Using inputs from a smartwatch combined with an IMU sensor, Maekawa et al. [18] proposed an unsupervised approach for lead time estimation of manufacturing activities.

Zhu et al. [19] addressed human intention recognition by designing a hidden Markov based recognition algorithm to classify hand gestures using an inertial sensor worn on finger of the subject. Zhu et al. tackled motion intention recognition using an inertial sensor and a deep convolution neural network (CNN) to extract discriminant features from temporal gait period [20]. Sun et al. used muscle electrical signals and joint angle signals as motion data and utilized K-Nearest Neighbor algorithm to identify four gait motion modes including walking naturally, climbing stairs, descending stairs, and crossing obstacles [21].

Wen and Wang [22] proposed an intention recognition algorithm based on multi-modal spatiotemporal feature fusion using the data collected by multimodal sensors. Masoud et al. [23] proposed a task recognition framework to identify undergoing tasks in pseudo real-time using a pair of data glove for grafting operations. This study offers a distinct contribution to the existing body of knowledge and provides a fresh and unique approach to the study of human-robot interaction by integrating the advantages of a virtual immersive platform and an unsupervised classification for context aware HRI.

3 Methodology

As displayed in Fig. 2, our proposed framework for intention classification consists of two main phases: First, creating an immersive virtual platform, which is used for safe data collection and second, unsupervised classification using K-means and dynamic time warping. In data acquisition and processing phase, we develop an interactive physics-based model via Unity 3D game engine. The developed model is integrated with HTC-Vive room scale pro eye arena bundle and leap motion controller to create the immersive virtual platform for data collection. The data collected through this immersive platform (Unity) is then cleaned and processed using open source python libraries. In the training and intention classification phase, the processed data is used to train our unsupervised intention classification model.

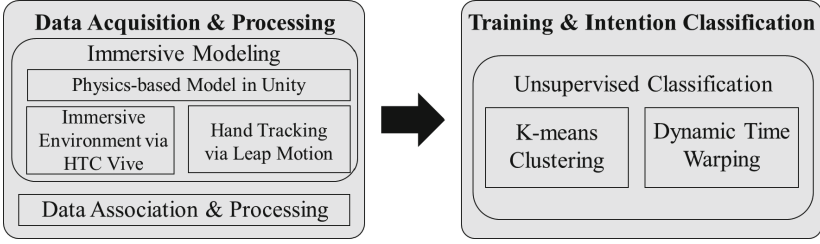


Fig. 2. Our proposed intention classification framework.

3.1 Immersive Virtual Reality Platform

To build the immersive platform, HTC-Vive pro eye arena bundle is used to model the immersive environment while Leap Motion controller replaces the typical controllers to enable users interact with the virtual environment using their hands. Leap motion controller captures the hands' gestures and movements using optical hand tracking sensors with high accuracy. Leap Motion controller can be mounted on the HTC VIVE head mounted display and connects communicate with the system via a USB cable. HTC VIVE also connects to the computation unit (Dell XPS 15 7590) via HDMI cables. HTC VIVE connects to Unity through VIVE port API package, while Leap Motion relies on its own package, UltraLeap plugin. Unity platform allows us to create a safe realistic physics-based manufacturing shop floor, where users can interact with equipment (Fig. 3).

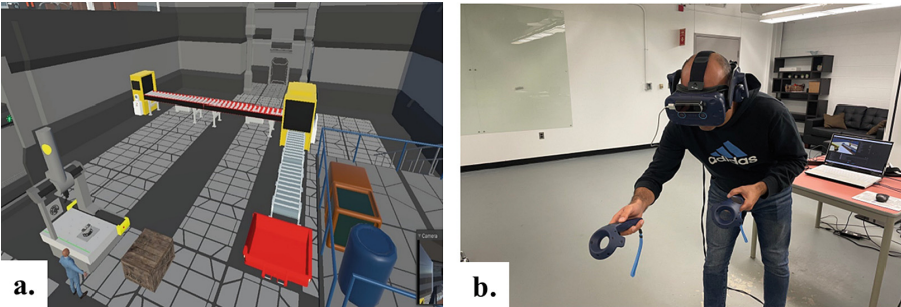


Fig. 3. a. The VR model, developed via Unity 3D game engine, b. The experimental setup for data collection.

Our dataset of activities is established based on the literature of the topic and the available datasets (e.g., UCI, WISDM, GAMI) including activities such as standing idle (ST), walking (WA), bending (BE), and sitting (SI). Then, subjects are recruited and asked to stand in the middle of a designated zone, wear the immersive technology, and perform the assigned activity in a natural way. The data are collected during performing the tasks by the subjects at a frequency of 0.2 s. Next, the collected observations are imputed, normalized, and outliers are dropped.

3.2 Unsupervised Classification

The proposed unsupervised classification integrates k-means clustering and dynamic time warping. K-means algorithm is selected due to its scalability, guarantee of convergence, and ease of generalization. To the best of our knowledge, this is the first time this proposed integration is used in intention recognition literature.

K-means Algorithm

K-means algorithm addresses the problem of clustering m elements (with n features) into k groups using the method of the lowest cost function (J), as shown in (1), which is usually the sum of each element's n -dimensional *Euclidean distance* to their closest group centroids. The constituents of the j th group are $m(j)$. The n -dimensional feature values of each element inside a group determine the centroids. The K-means algorithm recalculates the group centroids, updates the cost function, and assigns all other elements to the closest group. K-means repeatedly performs these tasks until achieving the lowest cost function [24].

$$J(C) = \sum_{j=1}^k \sum_{i=1}^{m(j)} x_i^{(j)} - C_j^2 \quad (1)$$

where $X = \{x_1, x_2, \dots, x_m\}$ and $C = \{c_1, c_2, \dots, c_k\}$ are the set of elements and centroids. Typically, Euclidean distance is the foundation of classification (or clustering). However, such a simplistic measure is not applicable to the observations that vary in size. As Euclidean distance is susceptible to even the slightest deviations in the size of comparing entities (time axis in case of time series), DTW replaces Euclidean distance in this study.

Dynamic Time Warping

Introduced by Berndt and Clifford [25], DTW provides a one-to-many match rather than being restricted to one-to-one matches. Given two members with f and d lengths, u_i ($i = 1, 2, 3, \dots, f$) and v_j ($j = 1, 2, 3, \dots, d$), a matrix $S_{i,j}$ is calculated as follows [25]:

$$S_{i,0} = S_{0,j} = 0 \quad (2)$$

$$S_{1,1} = (u_1 - v_1)^2 \quad (3)$$

$$S_{i,j} = \min(S_{i-1,j}, S_{i,j-1}, S_{i-1,j-1}) + (u_i - v_j)^2 \quad (4)$$

where the DTW distance is the minimum value of the sums of $(u_i - v_j)^2$, calculated along several paths. The path that minimizes this sum is typically a warped curve. Dynamic time warping is a well established measure of difference between the sequences that vary in length. The observations collected in this study also have different lengths depending on the activities and how they are performed by the subjects.

Here, we start by collecting historical data and labeling the historical time series with the gestures generating them. Then, for any incoming time series read by the sensors, DTW takes place to collect time series of similar shapes. Finally, cluster centroids will

be computed (or recomputed) with respect to reported DTW. Here the cluster centroid averages a subset from a set of time series within the measured DTW space. As a result, instead of a point, each centroid is a time series taking the average shape of the time series assigned to the cluster. The proposed framework label new time series by minimizing the DTW distance measures among the time series within clusters and their corresponding centroids.

4 Results and Discussion

In this study, 5 participants performed the assigned activities multiple times and 72216 data points were collected. During data pre-processing, 27966 data points were discarded. The remaining data points formed 125 observations, where each observation contains 16 features and variable number of time stamps (e.g., varying from 39 to 354). The features include headset forward vector (x, y, z), headset position (x, y, z), headset rotation (x, y, z), headset velocity (x, y, z), headset angular velocity (x, y, z), and timestamp. The processed observations are divided into train and test sets according to an 80/20 ratio. Four commonly used metrics, namely accuracy, precision, recall, and F-1 score, (5) to (8), are selected to evaluate the performance of our proposed unsupervised classification algorithm.

$$Accuracy = \frac{TrueNegative + TruePositive}{TrueNegative + TruePositive + FalsePositive + FalseNegative} \quad (5)$$

$$Precision = \frac{TruePositive}{TruePositive + FalsePositive} \quad (6)$$

$$Recall = \frac{TruePositive}{TruePositive + FalseNegative} \quad (7)$$

$$F - 1Score = 2 \times \frac{Precision * Recall}{Precision + Recall} \quad (8)$$

Although accuracy quantifies the ratio of correctly identified classes (intentions here), it cannot handle the imbalanced datasets. As a result, metrics such as precision, recall, and F-1 score are calculated to report the performance of our proposed model given our imbalanced dataset. While recall sheds light on the ratio of the relevant observations correctly classified by our trained models, precision represents the ratio of relevant observations. F-1 score, as the harmonic mean of recall and precision, combines these performance metrics into a single one. Relying on these metrics, we compared the performance of our proposed unsupervised classifier against the traditional k-means as displayed in Fig. 4.

As displayed in Fig. 4, our proposed model outperforms traditional k-means in accuracy, precision, recall, and F-1 score, by 39% (i.e., 85%-46%), 42% (i.e., 75%-33%), 27% (i.e., 73%-46%), and 36% (i.e., 74%-38%) over the test set, respectively. Justifying the performance gap between the proposed method and traditional k-means can be attributed to superiority of DTW on comparing time series and traditional k-means weakness in handling high dimensional data.