

## Table of Contents

Preface	
Francesco Longo, Michael Affenzeller, and Antonio Padovano	1
New approach to the fire risk and firefighting in small ships, as consequence of latest developments in Industry 4.0 for the use of hybrid propulsion.	
Valerio Ruggiero	4
A GEMMA-GRAFCET Methodology to enable Digital Twin based on Real-Time Coupling	
Giacomo Barbieri, and David Andres Gutierrez	13
Life cycle phases and design morphology for the implementation of a cooperative inventory pooling-system	
Yannic Hafner, Thomas Urban, and Johannes Fottner	24
A “low-cost” subtractive method for freshly finished 3D concrete printed structures	
Joseph CANOU, Maylis UHART, and Pierre DIAZ	32
Machine Learning and Statistics: A Study for assessing innovative Demand Forecasting Models	
Nikolas Ulrich Moroff, Ersin Kurt, and Josef Kamphues	40
Towards Mastering Variability in Software-Intensive Cyber-Physical Production Systems	
Rick Rabiser, and Alois Zoitl	50
Enhanced Agility for Assembly Tasks via Self-Sufficient Mobile Working Stations	
Rudolf Pichler, Daniel Strametz, and Martin Höffernig	60
MTConnect-based decision support system for local machine tool monitoring	
Carlos Felipe Erazo Navas, Alejandro Echavarria Yepes, Sepideh Abolghasem, and Giacomo Barbieri	69
Waste reduction in printing process by implementing a video inspection system as a human machine interface	
Pérez Juárez Carlos Alberto, Pérez Juárez Sonia Karina, Soler Anguiano Francisca Irene, and Ramos Álvarez Adrielly Nahomee	79
Reaching sustainability through a smart water crisis-proof industry	
Ramos Álvarez Adrielly Nahomee, Molina Soler Gloriveth de Fátima, Flores de la Mota Idalia, and Soler Anguiano Francisca Irene	86
Industry 4.0: advanced digital solutions implemented on a close power loop test bench	
Antonio Giallanza, Giuseppe Aiello, and Giuseppe Marannano	93
Extending the scope of reference models for smart factories	
Nuno Soares, Paula Monteiro, Francisco J. Duarte, and Ricardo J. Machado	102
Future of Raw Materials Logistics	
Sebastian Trojahn, and Alexander Teuber	112
Scalable model for industrial coffee roasting chamber	
Federico Di Palma, Francesca Iacono, Chiara Toffanin, Andrea Ziccardi, and Lalo Magni	122
Using Mixed Reality in Intralogistics - Are we ready yet?	
Werner Kurschl, Sebastian Pimminger, Johannes Schönböck, Mirjam Augstein, and Josef Altmann	132

First Results of a Survey on Manufacturing of the Future Christian Fries, Manuel Fechter, Gábor Nick, Ádám Szaller, and Thomas Bauernhansl . . . . .	142
Digital Manufacturing for Smart Small Satellites Systems Markus Krauß, Florian Leutert, Markus R. Scholz, Michael Fritscher, Robin Heß, Christian Lilje, and Klaus Schilling. . . . .	150
Improvement of manufacturing technologies through a modelling approach: an air-steam sterilization case-study Francesca Iacono, Jorge Lo Presti, Irene Schimperna, Sara Ferretti, Andrea Mezzadra, Lalo Magni, and Chiara Toffanin. . . . .	162
The association between network centrality measures and supply chain performance: The case of distribution networks Christian Wallmann, and Markus Gerschberger . . . . .	172
Towards digital cognitive clones for the decision-makers: adversarial training experiments Mariia Golovianko, Svitlana Gryshko, Vagan Terziyan, and Tuure Tuunanen . . . . .	180
A Multi-Layer Architecture for Near Real-Time Collaboration during Distributed Modeling and Simulation of Cyberphysical Systems Paul Lonauer, David Holzmann, Christina Leitner, Alexander Probst, Stefan Pöchhacker, Stefan Oberpeilsteiner, Johannes Schönböck, and Hans-Christian Jetter . . . . .	190
Sensor Shirt as Universal Platform for Real-Time Monitoring of Posture and Movements for Occupational Health and Ergonomics Phillip Petz, Florian Eibensteiner, and Josef Langer . . . . .	200
A literature review and cluster analysis of the Aachen production planning and control model under Industry 4.0 Jan-Phillip Herrmann, Sven Tackenberg, Elio Padoano, and Thilo Gamber . . . . .	208
A Comparison of Different Linearized Formulations for Progressive Flooding Simulations in Full-Scale Luca Braidotti, Germano Degan, Serena Bertagna, Vittorio Bucci, and Alberto Marinò . . . . .	219
Optimization of condition-based maintenance strategy prediction for aging automotive industrial equipment using FMEA Moyahabo Dominic Ramere, and Opeyeolu Timothy Laseinde . . . . .	229
Efficiency Improvement in polycrystalline solar panel using thermal control water spraying cooling Opeyeolu Timothy Laseinde, and Moyahabo Dominic Ramere . . . . .	239
High-quality sheet metal production using a model-based adaptive approach Christian Zehetner, Christian Reisinger, Wolfgang Kunze, Franz Hammelmüller, Rafael Eder, Helmut Holl, and Hans Irschik. . . . .	249
Explaining Learning Models in Manufacturing Processes Claudia V. Goldman, Michael Baltaxe, Debejyo Chakraborty, and Jorge Arinez . . . . .	259
Creating an Open-Source Augmented Reality Remote Support Tool for Industry: Challenges and Learnings Andrea Aschauer, Irene Reisner-Kollmann, and Josef Wolfartsberger . . . . .	269
Generation of 2.5D Deposition Strategies for LMD-based Additive Manufacturing Diego Montoya-Zapata, Carles Creus, Igor Ortiz, Piera Alvarez, Aitor Moreno, Jorge Posada, and Oscar Ruiz-Salguero . . . . .	280
A Human-Centered Assembly Workplace For Industry: Challenges and Lessons Learned Roman Froschauer, Werner Kurschl, Josef Wolfartsberger, Sebastian Pimminger, René Lindorfer, and Jakob Blattner. . . . .	290
Multi-mode Systems for Resilient Security in Industry 4.0 Michael Riegler, and Johannes Sametinger . . . . .	301

A model for the economic assessment of disassembly-line integration in traditional manufacturing processes	
Marco Sergio, Chiara Franciosi, and Raffaele Iannone . . . . .	308
An analytical framework for assessing cognitive capacity and processing speed of operators in industry 4.0	
Daniela Cavallo, Salvatore Digiesi, Francesco Facchini, and Giovanni Mummolo . . . . .	318
Biased random-key genetic algorithm for cobot assignment in an assembly/disassembly job shop scheduling problem	
Alexander Kinast, Karl F. Doerner, and Stefanie Rinderle-Ma . . . . .	328
Implications of embedded artificial intelligence - machine learning on safety of machinery	
Sara Anastasi, Marianna Madonna, and Luigi Monica . . . . .	338
pyBNBowTie: Python library for Bow-Tie Analysis based on Bayesian Networks	
Frank T. Zurheide, Eckehard Hermann, and Harald Lampesberger . . . . .	344
Trace reconstruction in system logs for processing with process mining	
Jasper Paul Jurgensen. . . . .	352
Functionalized additively manufactured parts for the manufacturing of the future	
Michela Sanguedolce, Giovanna Rotella, Maria Rosaria Saffioti, and Luigino Filice . . . . .	358
Route Duration Prediction in a Stochastic and Dynamic Vehicle Routing Problem with Short Delivery Deadlines	
Nikolaus Frohner, Matthias Horn, and Gunther R. Raidl . . . . .	366
Development of Digitalization in Production Industry – Impact on Productivity, Management and Human Work	
Tim Jeske, Marlene Würfels, and Frank Lennings . . . . .	371
CFD modeling in Industry 4.0: New perspectives for smart factories	
Luca Silvestri . . . . .	381
Industry 4.0 and human factor: How is technology changing the role of the maintenance operator?	
Tommaso Gallo, and Annalisa Santolamazza . . . . .	388
Industry 4.0 tools in lean production: A systematic literature review	
Tommaso Gallo, Chiara Cagnetti, Cecilia Silvestri, and Alessandro Ruggieri . . . . .	394
Lean production and Industry 4.0: Strategy/management or technique/implementation? A systematic literature review	
Chiara Cagnetti, Tommaso Gallo, Cecilia Silvestri, and Alessandro Ruggieri . . . . .	404
Industry 4.0 tools in innovative European firms: exploring their adoption and communication features through content analysis	
Michela Piccarozzi, Cecilia Silvestri, Barbara Aquilani, and Chiara Cagnetti . . . . .	414
Implementation of Industry 4.0 technology: New opportunities and challenges for maintenance strategy	
Gianpaolo Di Bona, Vittorio Cesarotti, Gabriella Arcese, and Tommaso Gallo . . . . .	424
Enabling technology for maintenance in a smart factory: A literature review	
Antonio Forcina, Vito Introna, and Alessandro Silvestri . . . . .	430
The role of Industry 4.0 enabling technologies for safety management: A systematic literature review	
Antonio Forcina, and Domenico Falcone . . . . .	436
The impact of Additive Manufacturing on Supply Chain design: a simulation study	
Marta Rinaldi, Mario Caterino, Pasquale Manco, Marcello Fera, and Roberto Macchiaroli . . . . .	446
Dynamic failure rate model of an electric motor comparing the Military Standard and Svenska Kullagerfabriken (SKF) methods	
Diego D’Urso, Ferdinando Chiacchio, Dario Borrometi, Antonio Costa, and Lucio Compagno . . . . .	456

Decay-parameter Diagnosis in Industrial Domains by Robustness through Isotonic Regression Salma Mahmoud, Florian Sobieczky, Jorge Martinez-Gil, Patrick Praher, and Bernhard Freudenthaler . . . .	466
Explaining a Random Forest With the Difference of Two ARIMA Models in an Industrial Fault Detection Scenario Anna-Christina Glock . . . . .	476
Simulation of ground bearing pressure profile under hydraulic crane outrigger mats for the verification of 16-point combined loading Ghulam Muhammad Ali, Asif Mansoor, Shuai Liu, Jacek Olearczyk, Ahmed Bouferguene, and Mohamed Al-Hussein. . . . .	482
CONTEXT: An Industry 4.0 Dataset of Contextual Faults in a Smart Factory Lukas Kaupp, Heiko Webert, Kawa Nazemi, Bernhard Humm, and Stephan Simons . . . . .	492
Evaluating the alignment of sequence diagrams with system behavior Atif Mashkoor, and Alexander Egyed . . . . .	502
Investigating the Potential of Smart Manufacturing Technologies Jan Zenisek, Norbert Wild, and Josef Wolfartsberger . . . . .	507
Driver Shift Planning for an Online Store with Short Delivery Times Matthias Horn, Nikolaus Frohner, and Günther R. Raidl . . . . .	517
Equipment Design Optimization Based on Digital Twin Under the Framework of Zero-Defect Manufacturing Dimitris Mourtzis, John Angelopoulos, and Nikos Panopoulos . . . . .	525
Real-life scheduling with rich constraints and dynamic properties – an extendable approach Michael Bögl, Anna Gattinger, Ionela Knospe, Manuel Schlenkrich, and Roman Stainko . . . . .	534
Large scale predictability analysis of process variables from injection molding machines Shailesh Tripathi, Christian Mittermayr, David Muhr, and Herbert Jodlbauer . . . . .	545
Developing an OPC UA Server for CNC Machines André Martins, João Lucas, Hugo Costelha, and Carlos Neves . . . . .	561
SRTP assessment of passenger ships: a simulation tool Serena Bertagna, Luca Braidotti, Ubaldo la Monaca, Alberto Marinò, Cristian Trombini, and Vittorio Bucci. . . . .	571
Business Process (4IR) Centric Optimization Modelling Megashnee Munsamy, and Arnesh Telukdarie. . . . .	581
COVID-19 supply chain resilience modelling for the dairy industry Inderasan Munien, and Arnesh Telukdarie. . . . .	591
A Classification-based Solution For Recommending Process Parameters of Production Processes Without Quality Measures Zhengtian Ai, Ingo Heinle, Christian Schelske, Hao Wang, Peter Krause, and Thomas Bäck . . . . .	600
Early life reliability growth testing with non-constant failure intensity Nikolaus Haselgruber, Shawn P. Capser, and Giorgio I. Vignati . . . . .	608
Smart Production Planning and Control: Technology Readiness Assessment Sameh M Saad, Ramin Bahadori, Hamidreza Jafarnejad, and Muhamad F Putra. . . . .	618
An Empirical Study of Task-Specific Limitations of the Overview+Detail Technique for Interactive Time Series Analysis Judith Friedl, Björn Zimmer, Lisa Perkhofer, Jan Zenisek, Peter Hofer, and Hans-Christian Jetter . . . . .	628
Evaluation of Information and Communication Technologies towards Industry 4.0 Alicia Mon, and Horacio René Del Giorgio . . . . .	639

Prototyping Machine-Learning-Supported Lead Time Prediction Using AutoML Janek Bender, and Jivka Ovtcharova . . . . .	649
IEC 61499 Device Management Model through the lenses of RMAS Andrea Bonci, Sauro Longhi, and Massimiliano Pirani . . . . .	656
Smart Factory Security: A Case Study on a Modular Smart Manufacturing System Federico Maggi, Marco Balduzzi, Rainer Vosseler, Martin Rösler, Walter Quadrini, Giacomo Tavola, Marcello Pogliani, Davide Quarta, and Stefano Zanero . . . . .	666
Taxonomy of generative adversarial networks for digital immunity of Industry 4.0 systems Vagan Terziyan, Svitlana Gryshko, and Mariia Golovianko . . . . .	676
A bibliometric analysis on collaborative robots in Logistics 4.0 environments Giorgia Atzeni, Giuseppe Vignali, Letizia Tebaldi, and Eleonora Bottani . . . . .	686
Clustering and Classification of Manufacturing Enterprises Regarding Their Industry 4.0 Reshoring Incentives Petra Unterberger, and Julian M. Müller . . . . .	696
Capacity planning of a mixed-model assembly line for prefabricated housebuilding elements Maria Anna Huka, Wolfgang Grenzfurtnr, Barbara Zauner, and Manfred Gronalt . . . . .	706
Optimization of the Use of Biomass Residues in the Poplar Plywood Sector Ivan Ferretti . . . . .	714
Review and analysis of blockchain projects in supply chain management Fabian Dietrich, Yiwen Ge, Ali Turgut, Louis Louw, and Daniel Palm . . . . .	724
Beyond federated learning: On confidentiality-critical machine learning applications in industry Werner Zellinger, Volkmar Wieser, Mohit Kumar, David Brunner, Natalia Shepeleva, Rafa Galvez, Josef Langer, Lukas Fischer, and Bernhard Moser . . . . .	734
A survey study on Industry 4.0 readiness level of Italian small and medium enterprises Alessia M.R. Tortora, Alfano Maria, Di Pasquale Valentina, Raffaele Iannone, and Cesare Pianese . . . . .	744
System simulation as decision support tool in ship design Marco Gianni, Vittorio Bucci, and Alberto Marinò . . . . .	754
An adaptive machine learning methodology to determine manufacturing process parameters for each part David Muhr, Shailesh Tripathi, and Herbert Jodlbauer . . . . .	764
DaQL 2.0: Measure Data Quality based on Entity Models Christian Lettner, Reinhard Stumptner, Werner Fragner, Franz Rauchenzauner, and Lisa Ehrlinger . . . . .	772
Parallel Metaheuristics for Shop Scheduling: enabling Industry 4.0 Pedro Coelho, and Cristovão Silva . . . . .	778
Thirty Years of Flexible Job-Shop Scheduling: A Bibliometric Study Pedro Coelho, Ana Pinto, Samuel Moniz, and Cristovão Silva . . . . .	787
Integrated production-distribution scheduling with energy considerations for efficient food supply chains Vittorio Solina, and Giovanni Mirabelli . . . . .	797
Conceptual Design of an Integrated Solution for Urban Logistics using Industry 4.0 principles Bruno Machado, Leonor Teixeira, Ana Luísa Ramos, and Carina Pimentel . . . . .	807
A systems dynamics approach to SME digitalization Radhakrishnan Viswanathan, and Arnesh Telukdarie . . . . .	816
Heuristic approaches for scheduling jobs and vehicles in a cyclic flexible manufacturing system Martin Gutjahr, Hans Kellerer, and Sophie N. Parragh . . . . .	825
Architecture for Data Acquisition in Research and Teaching Laboratories Walter Quadrini, Simone Galparoli, Domenico Daniele Nucera, Luca Fumagalli, and Elisa Negri . . . . .	833

Stacking and transporting steel slabs using high-capacity vehicles Biljana Roljic, Sebastian Leitner, and Karl F. Doerner . . . . .	843
PRIORITISING REQUIREMENTS OF INFORMATIONAL SHORT FOOD SUPPLY CHAIN PLATFORMS USING A FUZZY APPROACH Patrick R Burgess, and Funlade T Sunmola . . . . .	852
Protecting Intellectual Property Rights of Industrial Software Thomas Ziebermayr . . . . .	862
Anonymization as homeomorphic data space transformation for privacy-preserving deep learning Anastasiia Girka, Vagan Terziyan, Mariia Gavriushenko, and Andrii Gontarenko . . . . .	867
Human Aspects in Collaborative Order Picking – Letting Robotic Agents Learn About Human Discomfort Yaxu Niu, Frederik Schulte, and Rudy R. Negenborn . . . . .	877
Context-Aware Blockchain-Based Sustainable Supply Chain Visibility Management Funlade T. Sunmola . . . . .	887
LiSC Model: an innovative paradigm for Liquid Supply Chain Mariacarmela Passarelli, Giuseppina Ambrogio, Luigino Filice, Alfio Cariola, and Vincenzo Straffalaci . . . . .	893
Drift Detection Analytics for IoT Sensors Sathyan Munirathinam . . . . .	903
Digital divide, skills and perceptions on smart working in Italy: from necessity to opportunity Antonella Petrillo, Fabio De Felice, and Laura Petrillo . . . . .	913
Temperature simulation and control for lab-scale convection dehydrators Ccalli Pacco, Honorato . . . . .	922
Preliminary design of AR/SOFC cogeneration energy system using livestock waste O. Corigliano, G. De Lorenzo, and P. Fragiaco . . . . .	935
Recent Developments Towards Industry 4.0 Oriented Predictive Maintenance in Induction Motors Maria Drakaki, Yannis L. Karnavas, Panagiotis Tzionas, and Ioannis D. Chasiotis . . . . .	943
Microwave photonics approach as a novel smart fabrication technique of a radio communication jammers Mikhail E. Belkin, Dmitriy Fofanov, and Alexander Sigov . . . . .	950
Smart operators: How Industry 4.0 is affecting the worker's performance in manufacturing contexts Di Pasquale Valentina, De Simone Valentina, Miranda Salvatore, and Riemma Stefano . . . . .	958
Procedure model for the development and launch of intelligent assistance systems Paul Reichardt, Sebastian Lang, and Tobias Reggelin . . . . .	968
Open-source discrete-event simulation software for applications in production and logistics: An alternative to commercial tools? Sebastian Lang, Tobias Reggelin, Marcel Müller, and Abdulrahman Nahhas . . . . .	978
Dynamic online optimization in the context of smart manufacturing: an overview Viktoria A. Hauder, Andreas Beham, Stefan Wagner, Karl F. Doerner, and Michael Affenzeller . . . . .	988
Developing an Artificial Intelligence Framework to Assess Shipbuilding and Repair Sub-Tier Supply Chains Risk Rafael Diaz, Katherine Smith, Beatriz Acero, Francesco Longo, and Antonio Padovano . . . . .	996
Explainability of AI-predictions based on psychological profiling Simon Neugebauer, Lukas Rippitsch, Florian Sobieczky, and Manuela Geiß . . . . .	1003
The Sustainable Role of Human Factor in I4.0 scenarios Sotirios Panagou, Fabio Fruggiero, and Alfredo Lambiase . . . . .	1013
Statistical Process Control of assembly lines in a manufacturing plant: Process Capability assessment Eleonora Bottani, Roberto Montanari, Andrea Volpi, Letizia Tebaldi, and Giulio Di Maria . . . . .	1024

Economic evaluation of automated guided vehicles usage in a food company Letizia Tebaldi, Giulio Di Maria, Andrea Volpi, Roberto Montanari, and Eleonora Bottani . . . . .	1034
Fuzzy Cognitive Map-Based Knowledge Representation of Hazardous Industrial Operations Francesco Longo, Antonio Padovano, Letizia Nicoletti, Caterina Fusto, Mohaiad Elbasheer, and Rafael Diaz. . . . .	1042
Human factors, ergonomics and Industry 4.0 in the Oil&Gas industry: a bibliometric analysis Francesco Longo, Antonio Padovano, Lucia Gazzaneo, Jessica Frangella, and Rafael Diaz . . . . .	1049