

Data and AI Made Useful for the Front-Line

The information operators need to be high performers, available in real-time.

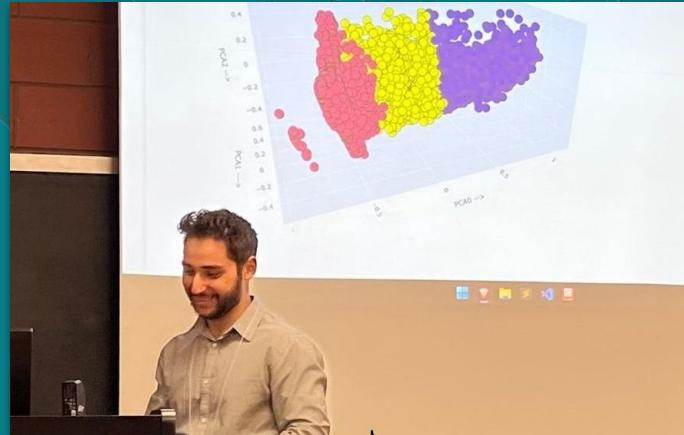


Joe Youssouf

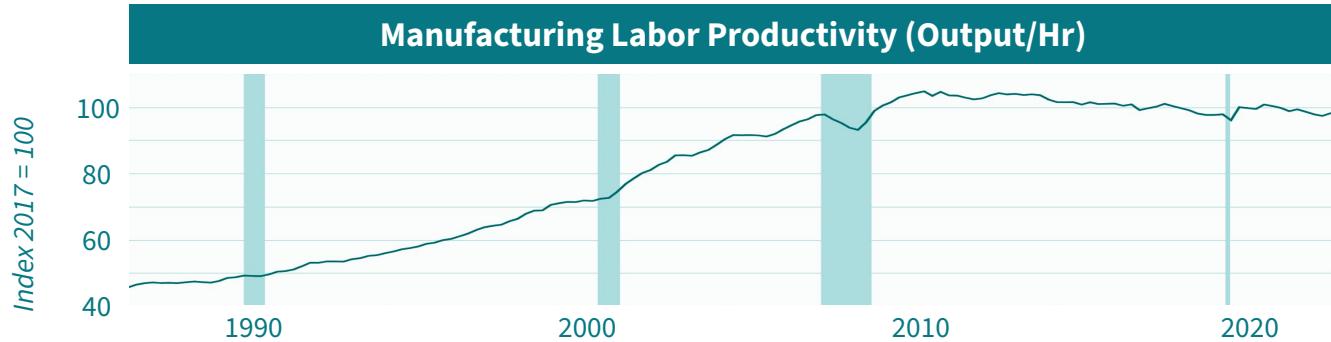
Data Scientist II
Oden Technologies

joseppy.ca

<https://github.com/JYoussouf/slides/gdg-devfest-2024>



A Perfect Storm for Manufacturers



A Typical Manufacturer's Workforce		
	<u>2018</u>	<u>2024</u>
Average Tenure	20 Years	3 Years
Average Time in Position	7 Years	9 Months
Average 3-Month Retention Rate	90%	50%

- ✖ Productivity Plateauing
- ✖ Workforce Challenges
- ✖ Demand & Asset Growth
- ✖ Margin & Competitive Pressures



Front-Line Challenges



Dependent on Operator Experience



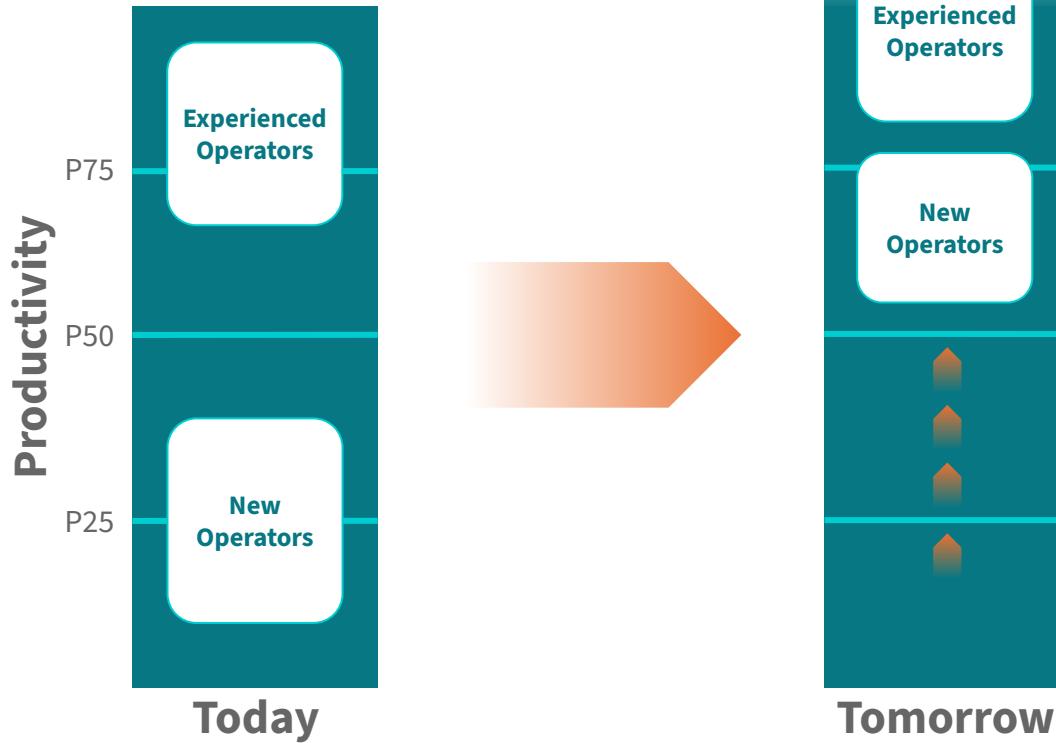
Decreasing Tenure



Losing Tribal Knowledge



Bridging the Productivity Gap





Empower the Front-Line
Real-Time AI Recommendations

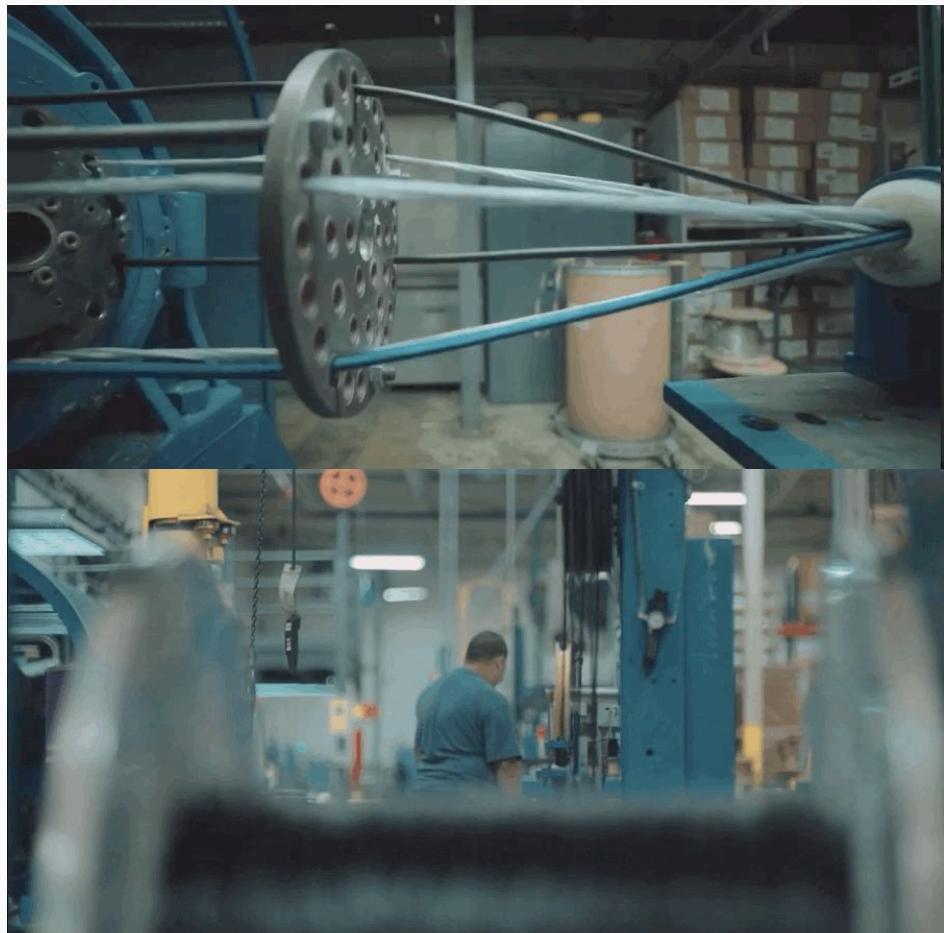


Oden's Customers

Medium to large manufacturers in plastics extrusion, injection molding, pipes, chemical, paper and pulp.

Process and Quality Engineers looking to centralize, analyze, and act on their data.

Plant managers who are looking to optimize logistics, output, and cost.



The Oden Product Suite



Data Engine

Data Cleansing,
Contextualization,
Inferencing & Enrichment



Process AI

AI-Enabled Predictions
AI-Enabled Recommendations



Knowledge AI

AI-Enabled Work Instructions
Operator CoPilot

Pre-release



Factory Analytics

Ad-Hoc Reporting & Dashboarding
Data Analytics & Visualization



Data Connect

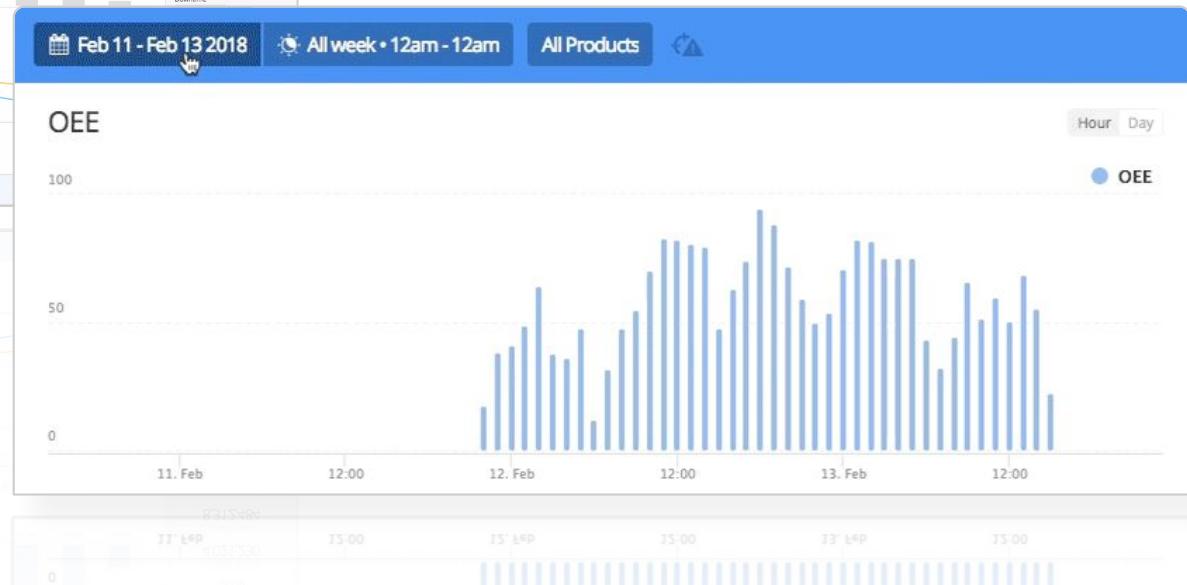
Live & Batch Data Export

Pre-release

Interactive Time-series Analysis

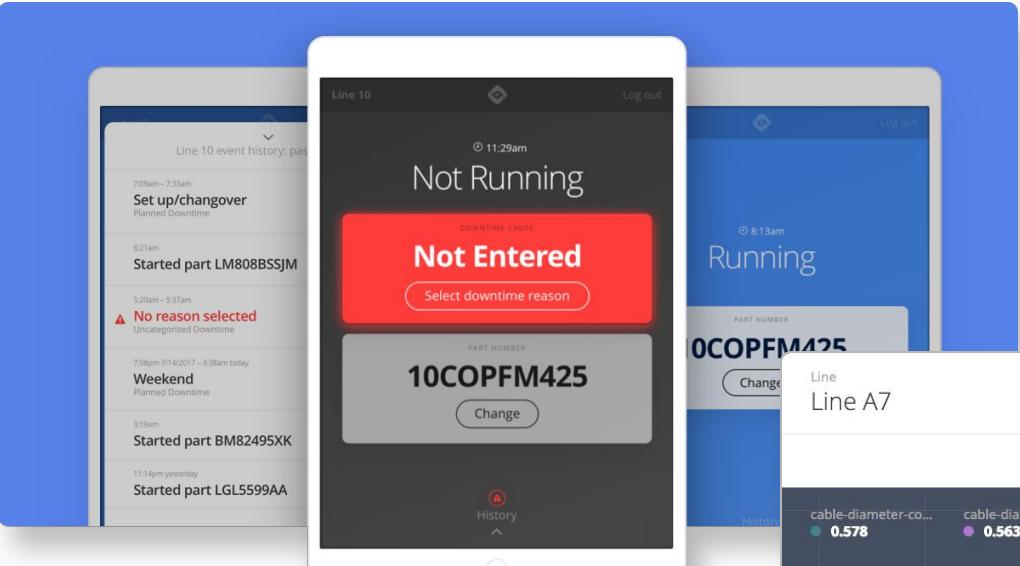


- Compare performance across different equipment.
- Visualize hourly uptime and key custom metrics.
- Calculations for analyzing and optimizing factory performance.



Real Time Manufacturing Data

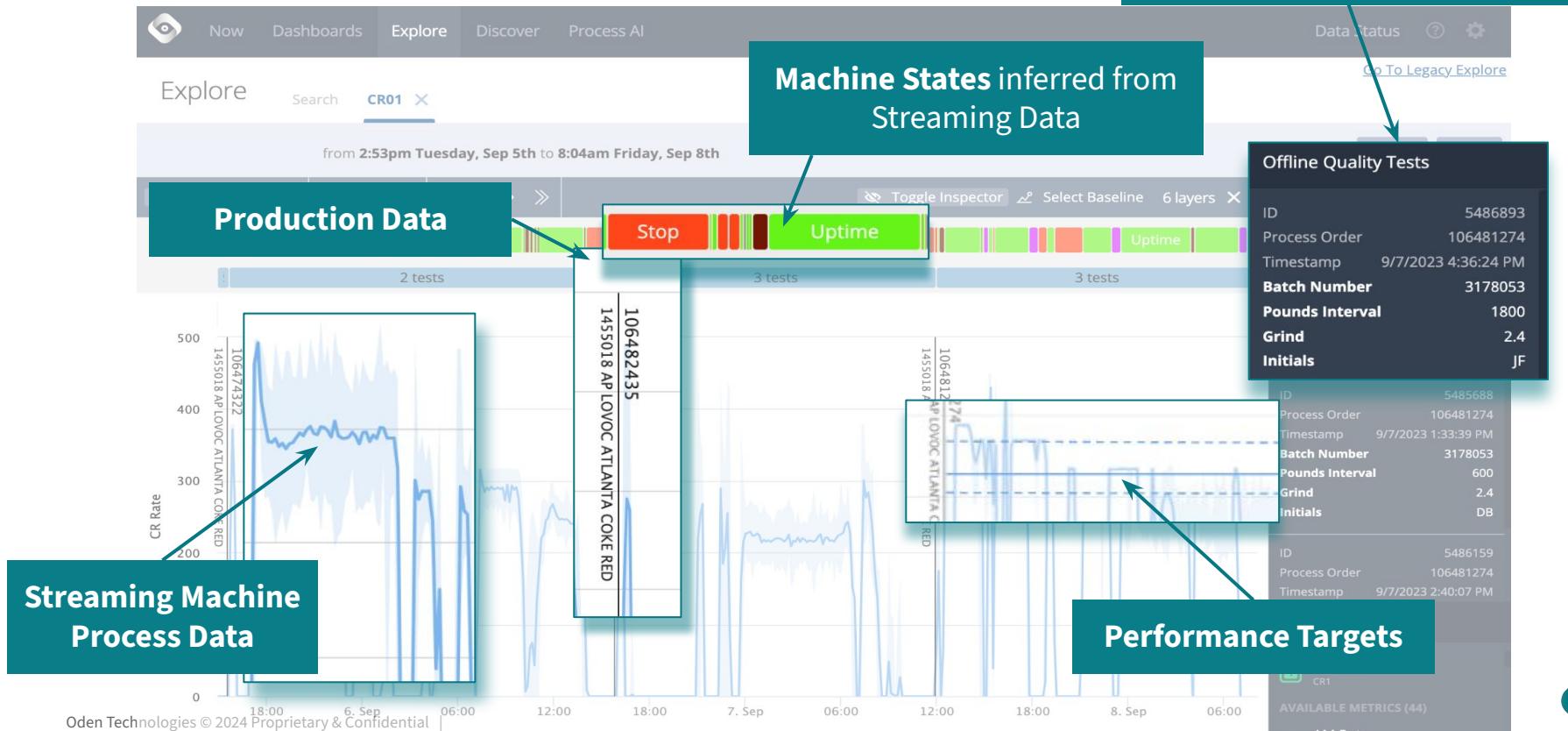
- Streaming second-by-second metrics
 - Interactive app that prompts on production state changes and collects user input.



Data Contextualization

Oden Data Engine

Offline Quality Tests



Process AI: Real-Time Operator Recommendations

Now Dashboards Explore Discover Labs Process AI Data Status ⓘ ⚙️

Process AI Engineer Operator

LINE Paper Machine 02
PRODUCT 6528C962

Stable periods (10/12/2023 - 4/12/2024)
Select a point below to view the process settings for the given speed and cost

COST
\$0.25/ft
\$0.20/ft
\$0.15/ft
\$0.10/ft

LINE SPEED (FPM)
1000 1100 1200

● Stable period
● Current period
● Recommended period

LINE SPEED (FPM)
CURRENT 1,088.20 > RECOMMENDED 1,106.34

MATERIAL FLOW 2D
CURRENT 780.52 > RECOMMENDED 834.70

REFINER FLOW 2D
CURRENT 1,109.53 > RECOMMENDED 921.47

REFINER FLOW 2E
CURRENT 731.31 > RECOMMENDED 688.54

STEAM FLOW 1A
CURRENT 84.91 < RECOMMENDED 80.28

PAPER STRENGTH TENSILE
OFFLINE 354.05 PREDICTED 347.10 TARGET 330.00

MOISTURE CONTENT
OFFLINE 12.75 PREDICTED 12.62 TARGET 12.50

PAPER STRENGTH Z PLY
OFFLINE 178.35 PREDICTED 183.87 TARGET 180.00

Real-time predicted quality metrics

Overall goals and progress

CURRENT COST \$0.1772/ft PREDICTED COST \$0.1418/ft PREDICTED SAVINGS \$2,344.59/hr Start Run

The dashboard displays various process parameters and their recommended values. It includes a scatter plot of stable periods, a current cost vs. predicted cost section, and four quality metric sections (Paper Strength Tensile, Moisture Content, Paper Strength Z Ply, and Material Flow 2D) each with a line graph showing offline, predicted, and target values over time. A central callout highlights 'Real-time predicted quality metrics'.

Process AI: Incremental Recommendations for Paper

Now Dashboards Explore Discover Labs Process AI Data Status ⓘ ⚙

Process AI

Configure

GRADE CHANGE → MOISTURE → Z PLY → COST

LINE: Paper Machine 02
PRODUCT: 6528C962

Stable periods (3/15/2023 - 8/1/2023)
Select a point below to view its process settings

77.4000
77.3000
77.2000
77.1000
77.0000
76.9000

COST (\$/FT)

375 400 425

LINE SPEED (FPM)

CURRENT: 380.21 > RECOMMENDED: 399.93

MATERIAL FLOW 2D

CURRENT: 316.96 ✓ RECOMMENDED: 316.30

REFINER FLOW 2D

CURRENT: 345.52 >> RECOMMENDED: 402.94

PAPER STRENGTH Z PLY

OFFLINE: 80.228 PREDICTED: 82.71 TARGET: 132

84
83
82

08:30 09:00 09:30 10:00

Predicted

PAPER STRENGTH TENSILE

OFFLINE: 147.543 PREDICTED: 144.65 TARGET: 132

146
145
144

08:30 09:00 09:30 10:00

Predicted

MOISTURE CONTENT

OFFLINE: 5.102 PREDICTED: 5.051 TARGET: 5

5.0512
5.05115
5.0511

08:30 09:00 09:30 10:00

Predicted

CURRENT COST (\$/FT) 77.22
PREDICTED COST (\$/FT) 76.964
PREDICTED SAVINGS (\$/HR) 15.379

Get Rec Start Run

Process A1: Incremental Recommendations for Paper

The screenshot displays a process monitoring interface for a paper machine. At the top, a navigation bar includes 'Now', 'Dashboards', 'Explore', 'Discover', 'Labs', and 'Process AI'. On the far right, 'Data Status' and system settings are shown. The main area is titled 'Process AI' and shows a flowchart: GRADE CHANGE → MOISTURE → Z PLY → COST.

Process AI

MOISTURE

MATERIAL FLOW 2D
CURRENT: 316.86 | RECOMMENDED: 345.52

LINE SPEED (FPM)
CURRENT: 380.14 | RECOMMENDED: 465.87

REFINER FLOW 2D
CURRENT: 346.29 | RECOMMENDED: 358.42

REFINER FLOW 2E
CURRENT: 287.98 | RECOMMENDED: 343.29

STEAM FLOW 1A
CURRENT: 34.75 | RECOMMENDED: 34.95

PAPER STRENGTH Z PLY
OFFLINE: 80.228 | PREDICTED: 82.71 | TARGET: 132

PAPER STRENGTH TENSILE
OFFLINE: 147.543 | PREDICTED: 144.65 | TARGET: 132

MOISTURE CONTENT
OFFLINE: 5.102 | PREDICTED: 5.051 | TARGET: 5

CURRENT COST (\$/FT): 77.22

PREDICTED COST (\$/FT): -

PREDICTED SAVINGS (\$/HR): -

Get Rec | **Start Run**

Process AI: Incremental Recommendations for Paper

Now Dashboards Explore Discover Labs Process AI Data Status ⓘ ⚙

Process AI

Configure

LINE Paper Machine 02

PRODUCT 6528C962

Stable periods (3/15/2023 - 8/1/2023)
Select a point below to view its process settings

77.4000
77.3000
77.2000
77.1000
77.0000
76.9000

375 400 425

COST (\$/FT) LINE SPEED (FPM)

● Stable period ● Current period ○ Recommended period

GRADE CHANGE → MOISTURE → Z PLY → COST

MATERIAL FLOW 2D

CURRENT 316.79 ✓ RECOMMENDED 316.30

LINE SPEED (FPM)

CURRENT 380.27 > RECOMMENDED 399.93

REFINER FLOW 2D

CURRENT 345.14 >> RECOMMENDED 402.94

REFINER FLOW 2E

CURRENT 287.70 > RECOMMENDED 307.52

STEAM FLOW 1A

CURRENT 34.83 ✓ RECOMMENDED 31.55

PAPER STRENGTH Z PLY

OFFLINE 80.228 PREDICTED 82.71 TARGET 132

84
83
82

08:30 09:00 09:30 10:00

— Predicted

PAPER STRENGTH TENSILE

OFFLINE 147.543 PREDICTED 144.65 TARGET 132

146
145
144

08:30 09:00 09:30 10:00

— Predicted

MOISTURE CONTENT

OFFLINE 5.102 PREDICTED 5.051 TARGET 5

5.0512
5.05115
5.0511

08:30 09:00 09:30 10:00

— Predicted

CURRENT COST (\$/FT) 77.22

PREDICTED COST (\$/FT) 76.964

PREDICTED SAVINGS (\$/HR) 15.379

Get Rec Start Run

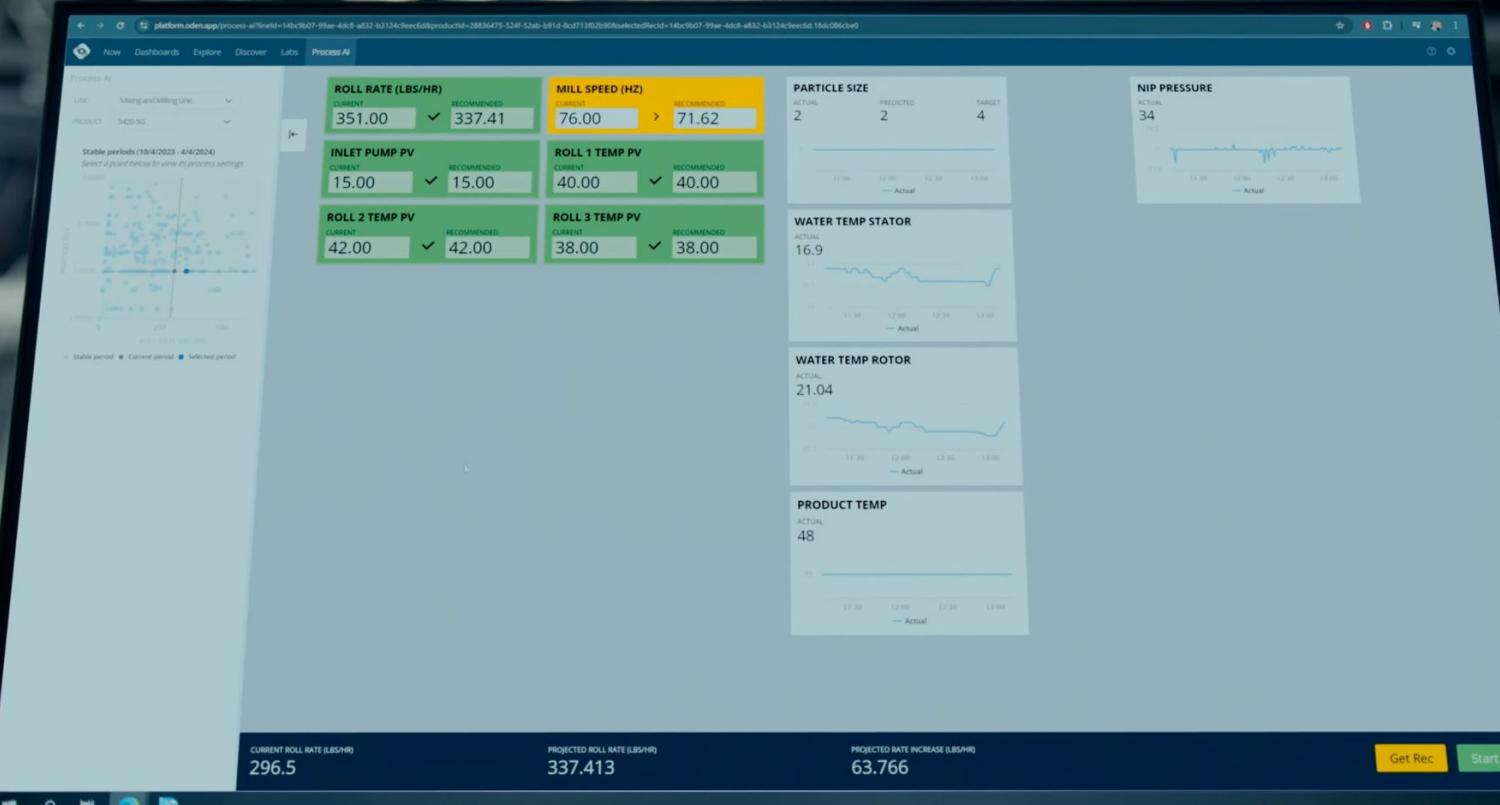
The dashboard displays various process parameters and their recommended values:

- MATERIAL FLOW 2D:** Current: 316.79, Recommended: 316.30
- LINE SPEED (FPM):** Current: 380.27, Recommended: 399.93
- REFINER FLOW 2D:** Current: 345.14, Recommended: 402.94
- REFINER FLOW 2E:** Current: 287.70, Recommended: 307.52
- STEAM FLOW 1A:** Current: 34.83, Recommended: 31.55

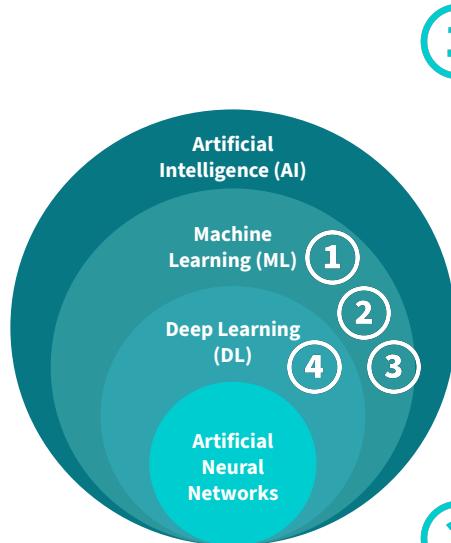
The dashboard also features three predictive time series charts:

- PAPER STRENGTH Z PLY:** Offline: 80.228, Predicted: 82.71, Target: 132
- PAPER STRENGTH TENSILE:** Offline: 147.543, Predicted: 144.65, Target: 132
- MOISTURE CONTENT:** Offline: 5.102, Predicted: 5.051, Target: 5

At the bottom, the current cost is \$77.22, the predicted cost is \$76.964, and the predicted savings is \$15.379 per hour.



AI/ML Techniques used in the Oden Product Suite



1 Linear Models

Uses: Predictive Quality

Benefits: Interpretability, fast, easy to train, scalable

Oden uses a variety of different approaches (LASSO, Elastic Net, PCA-Regression) to predict quality metrics. These are powerful as all of the model variables can be visualized and trust is built.

Oden also uses Deep Learning and other models for PQ problems to validate results.

2 Tree Models and Ensembles

Uses: Predictive Quality, Root Cause Analysis

Benefits: Interpretability, non-linear separations, handling categorical data

Used to identify key contributors separating periods of interest from baselines, i.e. changeover detection

3 Optimization Models

Uses: Process AI Recommendations

Benefits: Solve complex multi-objective multi-constraint problems

Oden uses optimization models to provide process setting recommendations directly to operators in real-time.

4 Deep Learning and Large Language Models

Uses: Stable Periods, Knowledge AI [in development]

Benefits: Powerful learning

Oden uses Deep Learning models for Stable Period analysis for Process AI, as well as in exploratory work with Knowledge AI and providing work instructions.



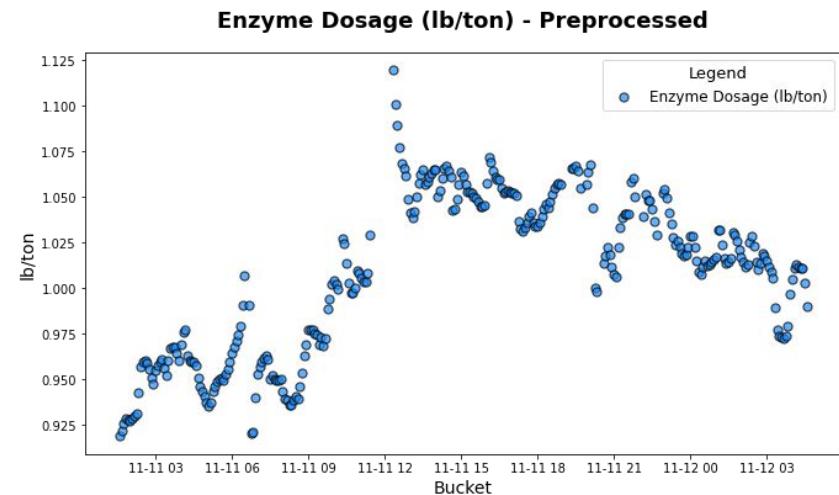
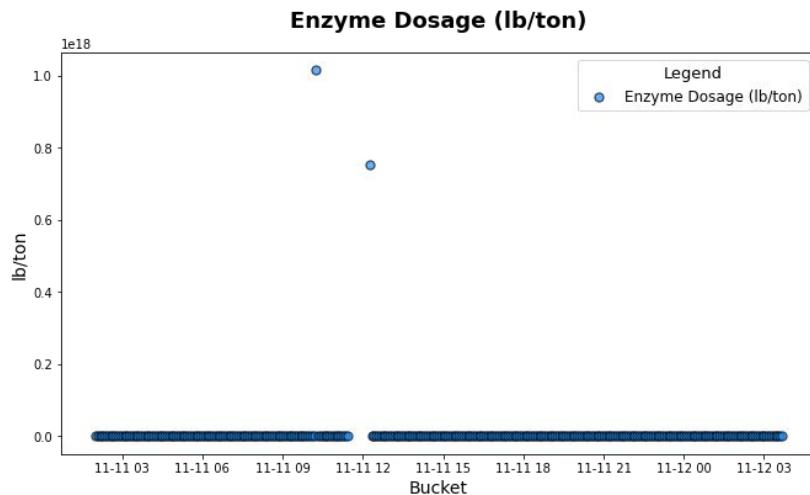
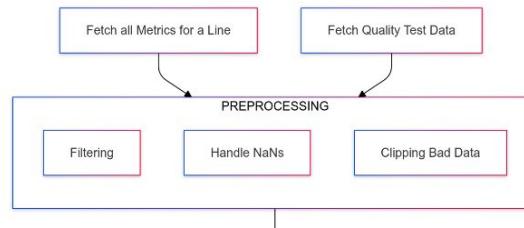
Problem Statement: Predictive Quality

Use multi-dimensional time series signatures:

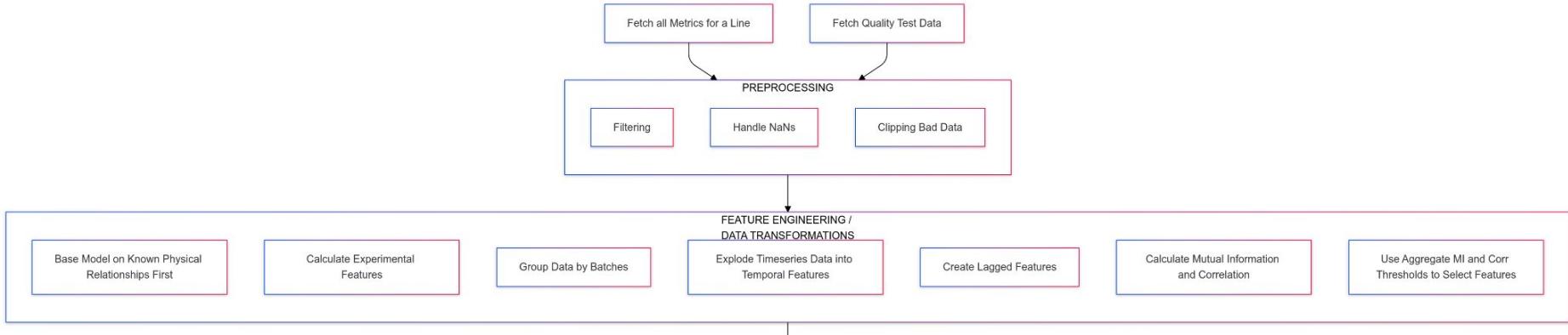
To predict a single quality test **label** at the end of each run:



Example PQ Pipeline - Preprocessing

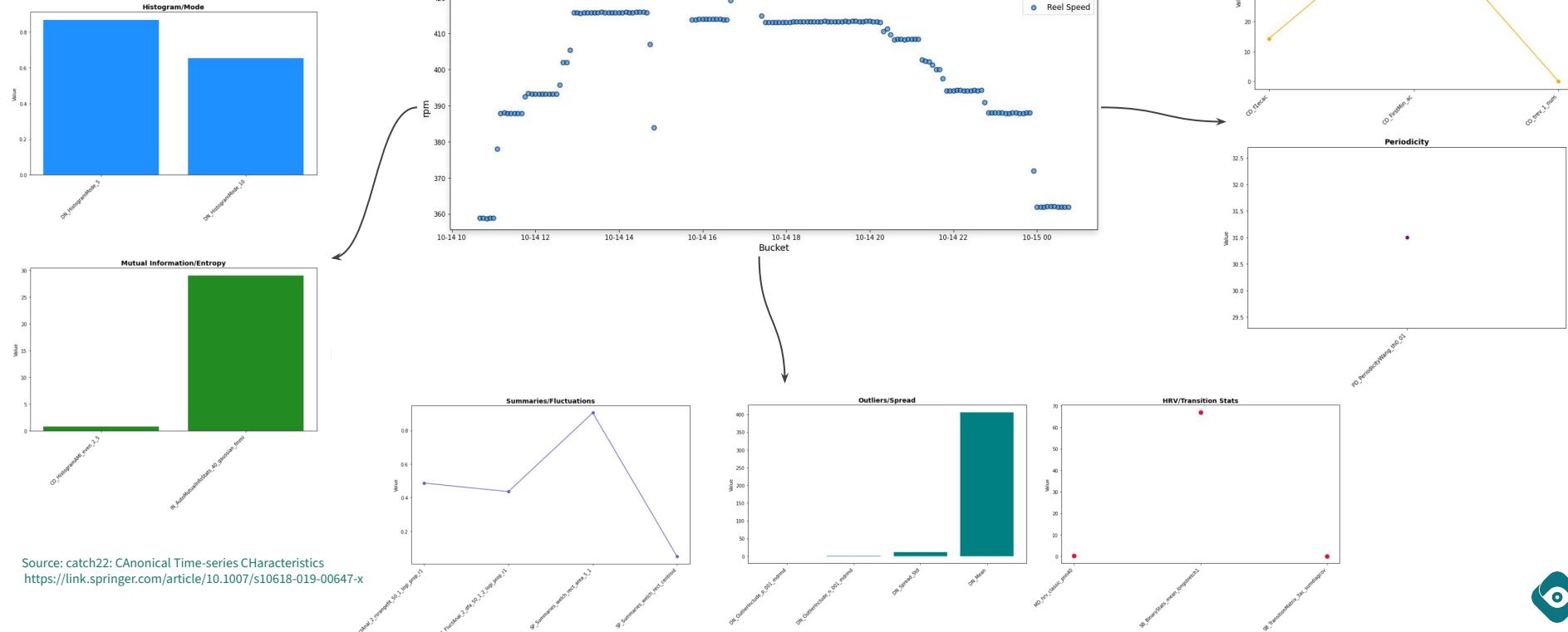


Example PQ Pipeline - Feature Engineering



Example PQ Pipeline - Feature Engineering

Time Series Decomposition into Core Stats



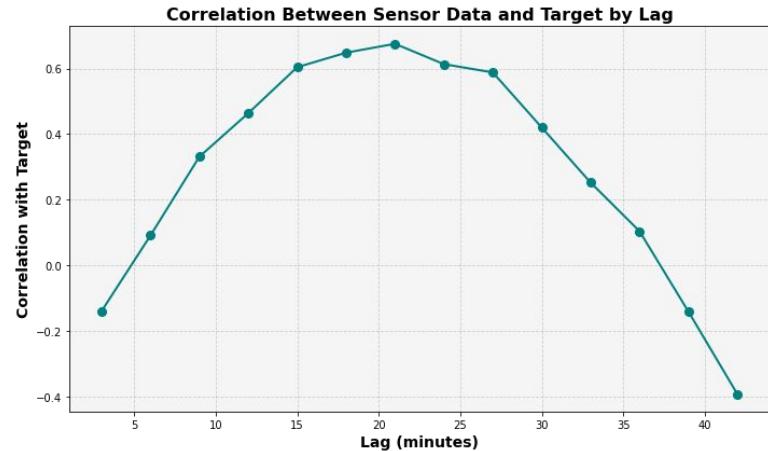
Feature Selection and the Lag Effect

A change in one metric may not impact output quality for N minutes.

How can we find N?

If available, ask a Domain Expert!

Otherwise, we can estimate this with lagged features, and ranking metrics (e.g. corr)



bucket	cd821ae1-c69b-5d37-b751-84c28bcf14e9	cd821ae1-c69b-5d37-b751-84c28bcf14e9_lag_5min	cd821ae1-c69b-5d37-b751-84c28bcf14e9_lag_20min	cd821ae1-c69b-5d37-b751-84c28bcf14e9_lag_60min
2024-04-09 19:30:00+00:00	2.053912	1.997217	2.514325	2.594364
2024-04-09 19:35:00+00:00	2.027539	2.065962	2.516855	2.779457
2024-04-09 19:40:00+00:00	2.014745	2.091880	2.469408	2.942021
2024-04-09 19:45:00+00:00	2.015056	2.080691	2.381821	2.937846
2024-04-09 19:50:00+00:00	1.985830	2.084497	2.358898	2.894803
...
2024-11-14 23:35:00+00:00	3.318202	3.758257	3.936180	3.781135
2024-11-14 23:40:00+00:00	3.298853	3.529197	3.918642	3.784988
2024-11-14 23:45:00+00:00	3.275909	3.468211	3.874753	3.764397
2024-11-14 23:50:00+00:00	3.304411	3.396445	3.864001	3.851068
2024-11-14 23:55:00+00:00	3.321725	3.347016	3.862047	3.946134

31806 rows x 4 columns



Feature Selection and Ranking Metrics

Feature Space:

-> 100's to 1000's of raw & transformed metrics

Systematic Filtering Methods:

1. Human-In-The-Loop Feedback (Physics-Based/ State-Space Modelling)

2. Mutual Information/ Absolute Correlation Scores

3. Concentration of Noise/“Bad Data”, nunique(), etc.

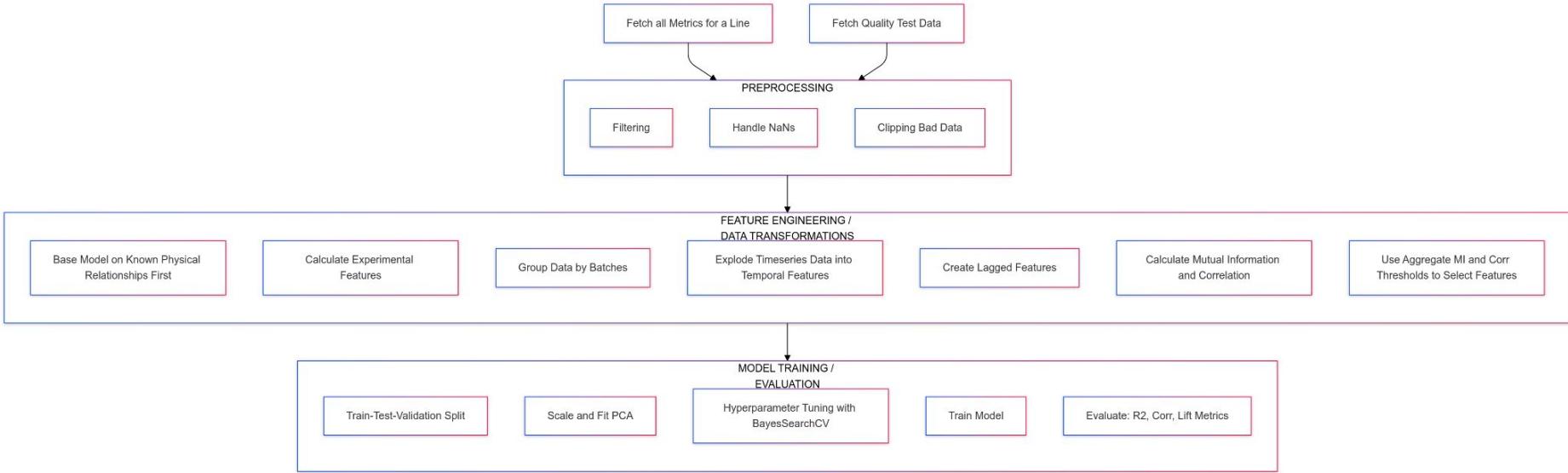
metric	mutual_information	abs_correlation	unique_values
10119216-9108-48b8-835b-29a83ae4bc5f-CO_Histog...	0.007816	0.020257	352
671b338c-b982-4dbe-adb0-393126f8f64c-CO_FirstM...	0.028868	0.082565	11
b6c70614-6e25-4a7b-86f7-a02702fedcf7-FC_LocalS...	0.028162	0.037197	10
d6786dea-bf97-43d0-83d3-60d9e1b0c88e-DN_Histog...	0.000168	0.004669	1378
experiment_7-FC_LocalSimple_mean3_stderr	0.000000	0.002482	1378
...
306f4d01-8f33-5c89-ad05-11bf51b3b050-MD_hrv_cl...	0.000000	0.022463	20
1d2e853d-f2e5-58e2-af68-baaf57d4fa12-CO_EMBED2...	0.012775	0.006904	1378
e2644829-1edb-50e9-8f20-4a3c97788227-DN_Spread...	0.000000	0.034116	1378
b3a5ca35-34e2-5eaf-83df-85617f630f0e-SB_Binary...	0.000603	0.080383	10
b6c70614-6e25-4a7b-86f7-a02702fedcf7-CO_Histog...	0.000563	0.005759	327

$$I(X, Y) = - \sum_{x_i, y_i} p(x_i, y_i) \log_2 \frac{p(x_i, y_i)}{p(x_i)p(y_i)}.$$

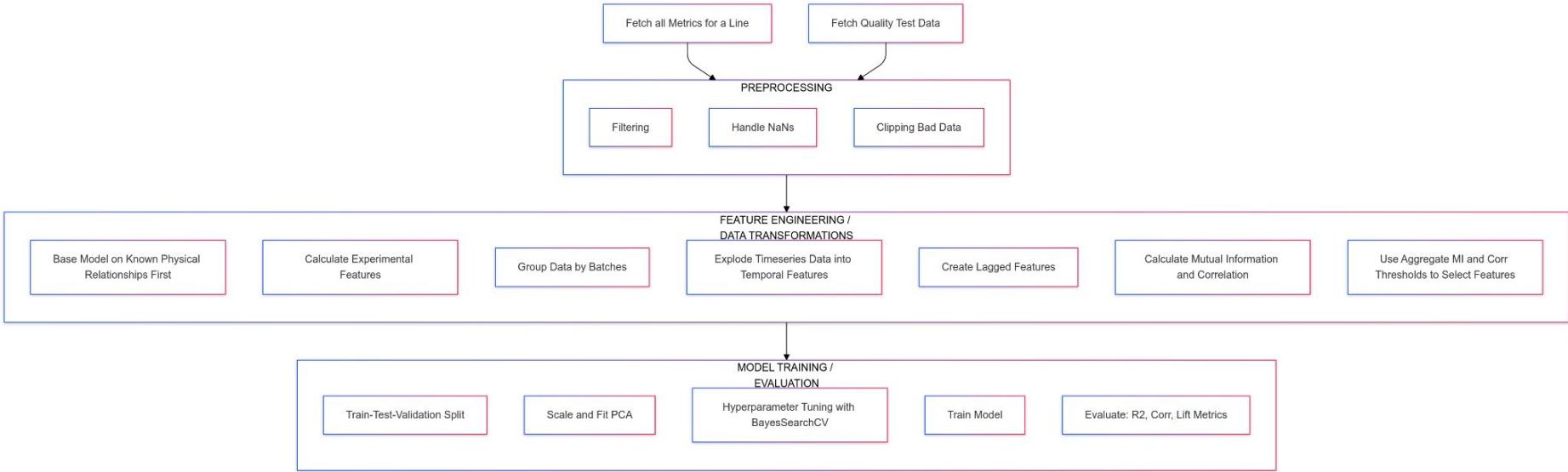
```
-> from sklearn.feature_selection import  
    mutual_info_regression  
-> pd.Series.corr(labels)  
-> pd.Series.nunique()
```



Example PQ Pipeline - Train/Deploy



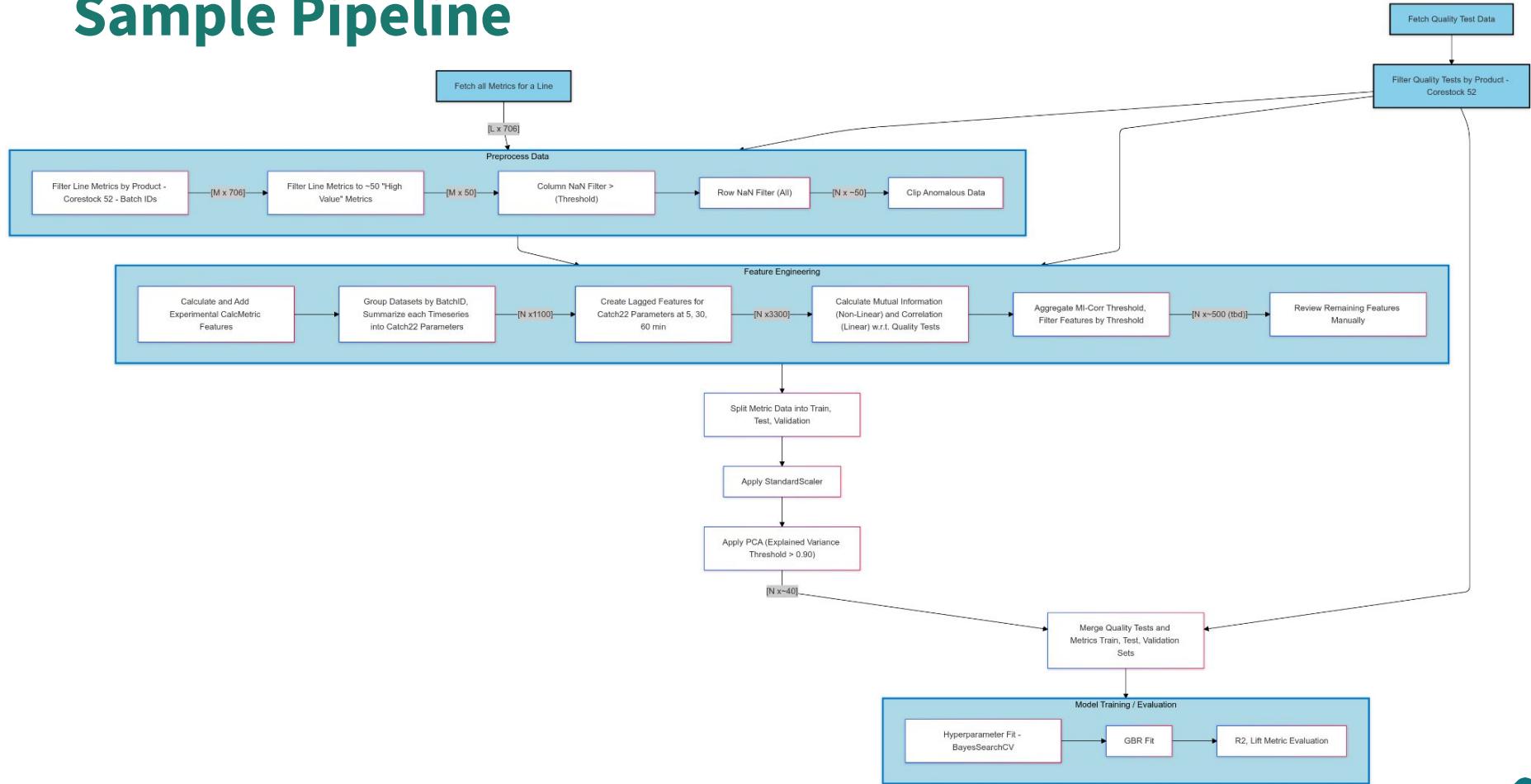
Example PQ Pipeline - Train/Deploy



Example Pipeline - Registered to MLFlow



Sample Pipeline



MLFlow Artifacts

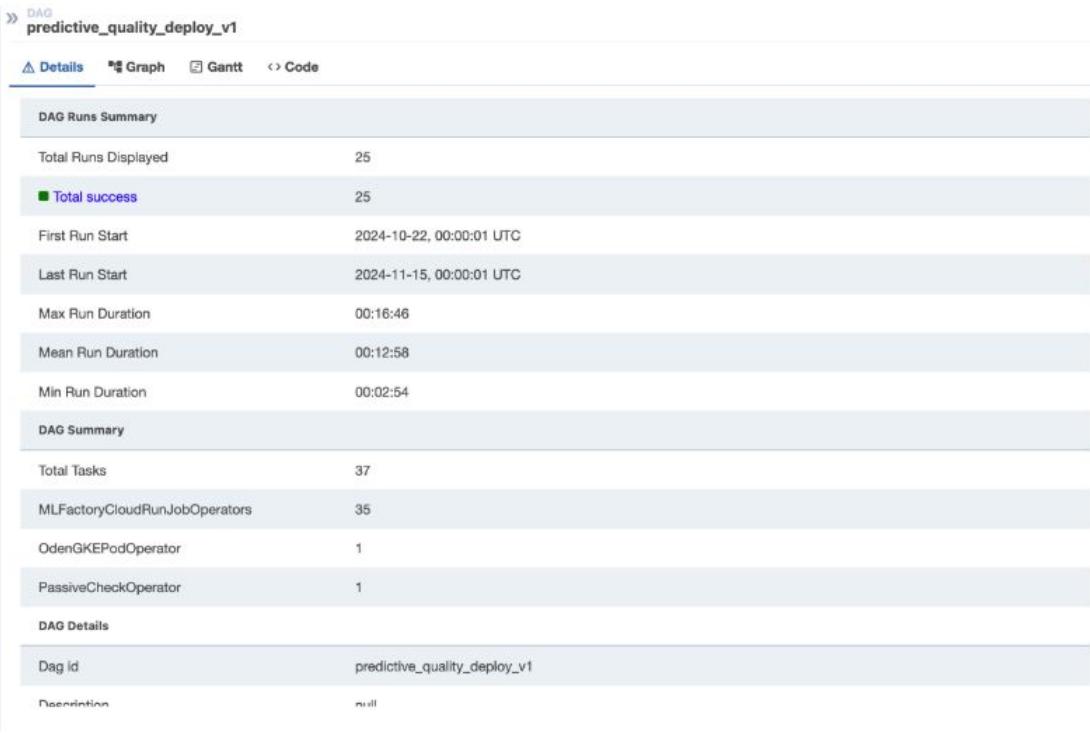
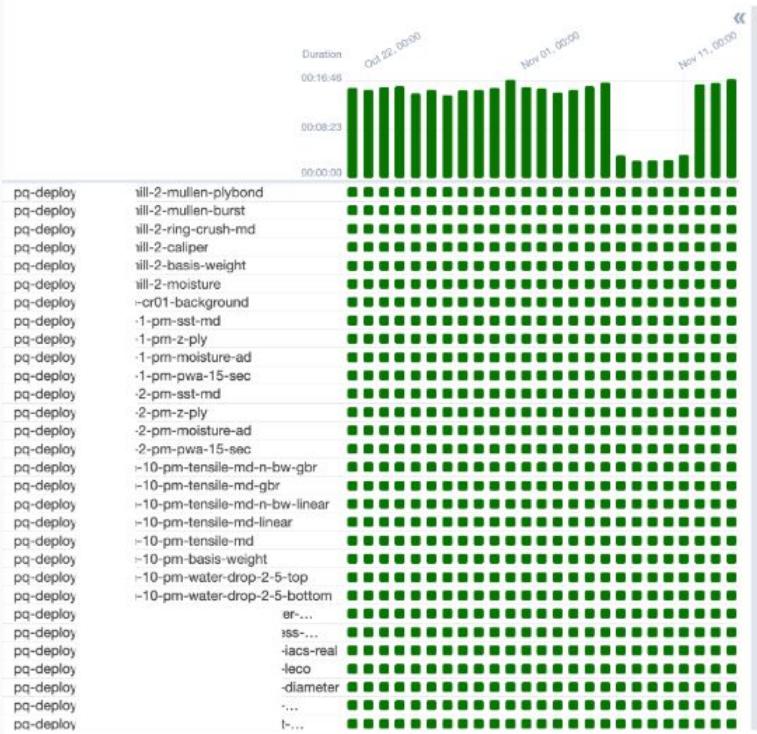
PQ_v2_All_Features_PCA_Tuned

Overview Model metrics System metrics **Artifacts**

- ▼ **data_split**
 - ☒ test_split.csv
 - ☒ train_split.csv
- ▼ **model**
 - **metadata**
 - 📄 MLmodel
 - 📄 conda.yaml
 - 📄 model.pkl
 - 📄 python_env.yaml
 - 📄 requirements.txt
 - ▼ **model_outputs**
 - ☒ model_predictions.csv
 - **model_params**
 - 📄 dataflow_config.json
 - 📄 inference_metadata.json
 - 📄 pipeline_vis.html
 - 📄 pq_training.log

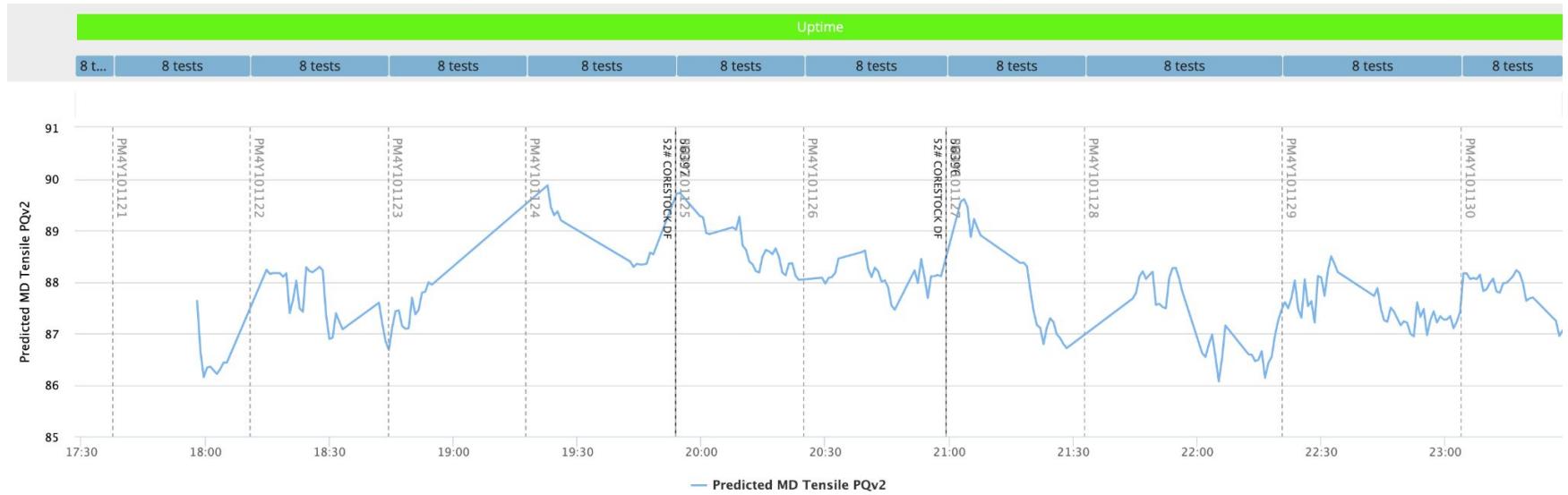


Model Deployment via Apache Airflow



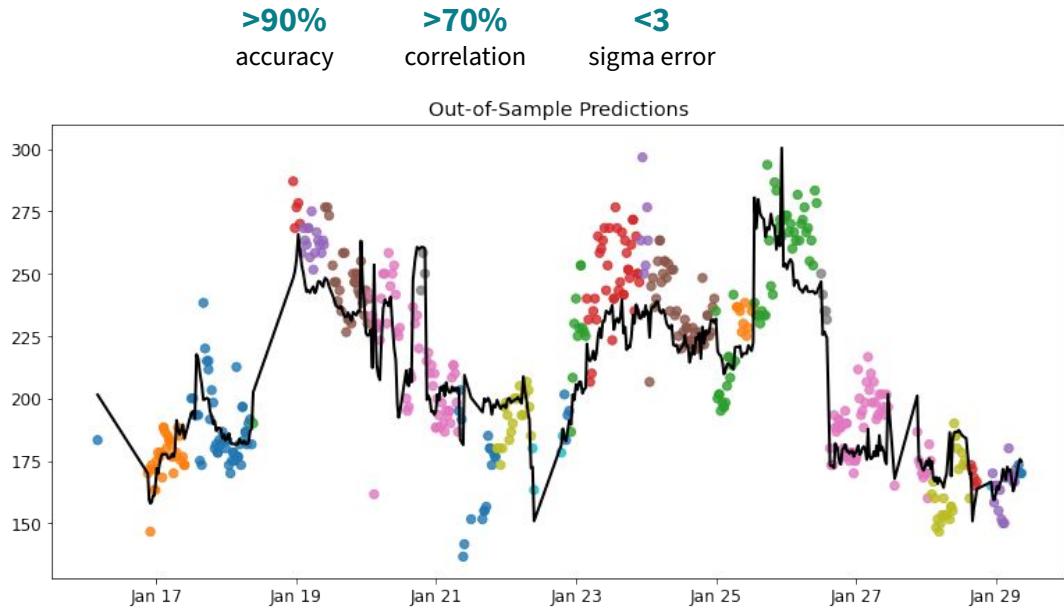
Real-Time Predictions with Dataflow (Google Cloud)

- DataFlow job manages real-time inference/ posting predictions to the Oden Platform



Key Variables Example: Paper

Predictive Quality Model Development



Ply Bond - Paper	
Key Variable	Coefficient
#7 Vat Flow	-6.5224
#10 Vat Flow	-4.1779
Shared Waste Water	-4.0135
2nd Press Bottom Felt Vacuum	-3.5552
Bone Dry Weight (scanner)	-3.3621
Production Rate (tons/hr)	-2.8738
D Refiner HPDT	2.2074
1st Dryer Section Speed	2.988
C Refiner KW	3.1313
C Refiner HPDT	3.1394
% Target	3.5729
#1 Vat Lvl Output	3.5746
D Refiner KW	4.0107
Total HPDT	8.8416

Total Process Variables: 127

Model Variables: 38

Key Variables: 14



Tangible Results for Pulp & Paper

Fortune 500 Paper Customer

Goal: Optimize speed & reduce input Costs while maintaining quality

Solution: Oden Process AI + Data Engine, first 6 months

3% Increase to Line Speed
(\$440K benefit/year)

5% Reduction in Material &
Energy Costs
(\$505K benefit/year)



\$900K+
Savings / Year



Tangible Results for Wire & Cable

Customer: #1 Electrical cable producer in North America

Goal: Increase production through higher line speeds

Solution: Oden Process AI

When: 90 days from go-live

Scope: 2 extrusion lines, many products

Who: 20 Operators of varying experience

Results:

+20%

Increase in
Production Rate

+5.3M_{ft}

Additional Feet
Produced over 90
days





Thank You!

oden.io

joseppy.ca



Webinar

Making AI Work for Front-Line Labor Challenges

Nov 19 at 1pm ET



Mark Fosdike
CEO



Peter Brand
Co-Founder



Kyle Winters
Initiatives & Community,
NA Manufacturing &
Supply Chains



Samuel Parra
NA Manufacturing
Integration Leader



Pradeep Paul
Director of
Manufacturing
Intelligence

