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# Predictive analytics in quality assurance for assembly processes: lessons learned from a case study at an industry 4.0 demonstration cell

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## Abstract

Quality assurance (QA) is an important task in manufacturing to assess whether products meet their specifications. However, QA might be expensive, time-consuming, incomplete, or delayed. This paper presents a solution for predictive analytics in QA based on machine sensor values during production while employing machine-learning models based on logistic regression in a controlled environment. Furthermore, we present lessons learned while implementing this model, which helps to reduce complexity in further industrial applications. The paper's outcome proves that the developed model was able to predict product quality, as well as to identify the correlation between machine-status and faulty product occurrence.

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**Keywords:** Machine-Learning; Predictive Quality; Production; Quality Assurance; Logistic Regression

## 1. Introduction

(AP:

- Products' quality must always be guaranteed.
- In certain cases (especially in series assembly production) there is a delay between quality inspection and end of the production process high potential for producing scrap
- By doing quality inspection based on samples, there is still a risk of sending NOK parts to customers
- The cost of quality checks might be expensive
- Quality assurance is normally done at the end of production (for assembly processes)
- Early prediction of the production's quality would help to decrease the amount of scrap and the risk of sending NOK parts to customers
- Variable predictions by using machine learning models is currently widely used in diverse fields due to its

accurate predictions with the data collected from the machines, prediction models can be implemented for specific predicted values

## 2. Related Works

### 2.1. Quality check in production

The quality control of production processes and products is one part of the general quality management and contains the measures and activities needed to fulfill the quality requirements [4]. According to Illés, currently there are three established tools and methods of quality control [4]: The Statistical Process Control (SPC), Auditing, and Total Quality Control (TQC). The SPC is used for checking the quality of the products with statistical techniques and contains methods like acceptance sampling or quality control charts [7]. It can take place before and after a manufacturing process as off-line SPC or implemented in the manufacturing process as in-line SPC.

With SPC, large batches can be checked, but it is only possible, if the variance of the product quality is small enough, to ensure process capability [5]. Auditing, in this case especially product and process auditing, is the most fundamental quality control technique. Product and process auditing is the independent examination of product and process quality to provide information. This is executed by an independent auditor, based on sampling, or checking records. But the auditor is just reporting incorrect processes or products. The required adapting is done by others [3]. This is associated with higher costs compared to a quality control based on a machine learning model. The concept of TQC is to extend the scope of quality control to the whole company and product life cycle, by involving all departments of the organization [4]. The quality characteristics of a product can be classified as variables or attributes. Variables are measurable characteristics, which are shown as numbers. On the contrary, attributes are not measurable and can only take the value go or no-go [6]. The advantage of variable measurements is that in the event of a defective intermediate or end product, precise measured values are available, which enable precise adjustment of the process parameters. This allows the desired quality to be restored. With that in mind, a predictive quality control is a promising solution.

(AP:

- How quality check is done in production
- Concepts and sampling plan
- **Attributive vs Variable measurements [VM has higher measurement accuracy, reason why it's better to use regression model]**

)

## 2.2. Predictive analytics in production

(AP: Predictive analytics as concepts. Implementation in production

- Predictive Maintenance
- Scheduling
- Other

If happens to be something with P.A. Quality Check

- Predictive analytics in production focusing in QA
- Existing approaches and methods

Note: Ideal is to find a gap in the literature, that proves why do we do it and why it is important )

## 3. The case industry 4.0 demonstration cell

In our work we applied a case-based research approach [8] to answer the research question. One central motivation for a case-based research approach is to gain insights for real needs, rather than to develop theories without practical relevance [2].

Fig. 1. The industry simulation cell. (MW: TODO: Find image.)

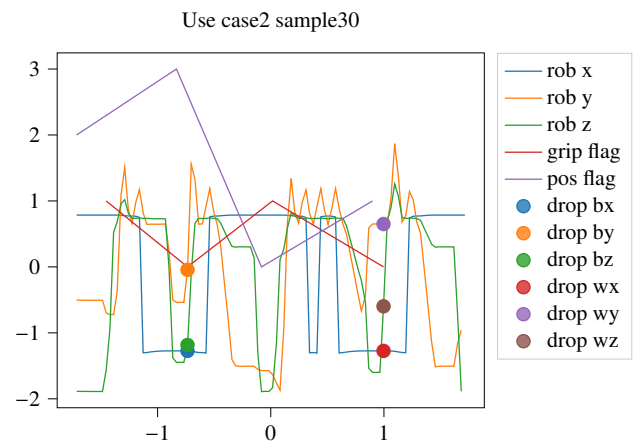


Fig. 2. Robot arm movement patterns. We show the movement of the cell's robot arm, its grippers and an encoding of the overall position in the system. The changes in the grip flag are triggered, when the gripper opens or closes. Zero indicates an open, while one indicates a closed gripper. The position flags marks the state of the cell's arm. 0 means the black disk is in store, one that the black disk is in the gate, two that the white disk is in store and three that the white disk is located in gate.

In addition case-based research approaches have already been successfully applied in the area of quality prediction based on process parameters (see, for example, ...). Our case is a production demonstration cell composed of conveyer belts, a universal robot and a wide range of sensor technology. The demonstration cell is executing an stylized assembly process where two disks are to be stacked on top of each other. The quality of the pseudo products is evaluated via the concentricity of both parts to be assembled. The demonstration cell is configured to imitate certain situations that occur in real applications. For example, it is possible to simulate failures in the motors, problems with the conveyor belts or incorrect positioning of an object by the robot arm, which causes anomalies in the vibration sensors, temperature rise, fluctuations in the air pressure system and other deviations. Based on the sensor values and process parameters, we want to predict the concentricity of the assembled parts prior to actual quality check. Due to its manageable size and high degree of scalability, findings gained with the demonstration cell can be transferred to various real assembly processes and use cases.

(AP: What is the demozelle and why it is relevant as study case Description of the assemble process in the Demozelle Incl pictures )

## 4. Methods

Data is collected from the demonstration cell and analyzed.

### 4.1. Measurement

(DSt: - what is this section about? )

|                        |       |
|------------------------|-------|
| Support Vector Machine | 95.%  |
| Multilinear Perceptron | 95.%  |
| Random Forest          | 100.% |

Table 1. Method comparison for our anomaly detection task using the industry demo data test set.

## 4.2. Machine Learning

We compare Support Vector Machines (SVM), Multilinear Perceptrons [1] as well as Random forests in the task of quality prediction.

## 5. Experiments

### 5.1. Recording the data

**(DSt: - could we include collection via OPCUA server? or manually? )**

### 5.2. Classifier optimization and testing

The robot's position at disc drop is marked in Figure 2. The quality prediction problem is framed as a classification task. The input vectors which we feed into our classifiers consists of the arm positions at the disc drops for both discs in three dimensions, as well as the largest recorded belt speed of all three belts. The interpretation of the quality measurement is used as the training target. It can be good or bad which we encode as zero and one.

We work with a total of 132 measurements. Each containing arm and belt data logs of individual cell runs. 20 samples are set aside at random for testing purposes, leaving 112 training samples. The random number generator seed is set to one in order to ensure the train and test set splits are identical for all experiments.

We compare a total of three different classifier architectures on the data. A Support Vector Machine (SVM), a multilinear perceptron and a Random Forest structure. All three methods are trained using standard hyperparameters.<sup>1</sup> Results are shown in table 1. For 55 of the total 132 samples quality measurements indicate a problem. This sets the baseline over the entire data set, that would be obtained by simply labeling all samples as good. Over the entire data set, we require to classify more than 58.3% of the data correctly. The test set contains eight incorrect samples. We would therefore expect any naive classifier to produce a 60% accuracy, which we have to beat. In Table 1, we observe that this is indeed the case for all three approaches evaluated here. The random forest performed best in this case.

## 6. Conclusion

### 6.1. Lesson Learned

**(AP: explain experiences by doing the research)**

## 7. Conclusion

### Acknowledgments

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<sup>1</sup> In order to allow exact reproduction of these results source code is available at <https://github.com/manubrain/Demo-Cell-Classification>