Real-time workshop digital twin scheduling platform for discrete manufacturing

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Abstract. Compared with other production methods, multi-variety, small-batch production driven by order become a lot more sensitive to the disturbances of workshop environment, orders, and processing equipment. This makes a great impact on workshop scheduling. Aiming at this problem, this paper designs a real-time workshop digital twin scheduling platform for discrete manufacturing. It improves the flexibility of the intelligent workshop and the response processing speed after dynamic disturbance. The platform can real-time monitor of the physical workshop and track orders, products, equipment and other information. Further, the platform and visualization technology were explored to work together. Then, the true display of changes after production line decision was displayed. It enables managers to carry out production scheduling verification in the virtual workshop, which reduces the repeated changes of physical workshop production scheduling. Finally, the platform was verified in a discrete manufacturing workshop. The scheduling platform based on digital twins helps manager to immersivity develop factory production strategies. The production efficiency was then enhanced. The platform can ensure the effective operation of the manufacturing system.

1. Introduction
At present, a kind of personalized production driven by customer orders with multiple varieties, small batches and fast delivery is widely used in the discrete manufacturing industry.[1-2]. This mode is easy to cause the mismatch between the production mode and the production scheduling plan[3], and product failures during processing cannot be effectively and accurately located and predicted[4]. Therefore, a new way to solve this problem is needed.

In the process of workshop scheduling research, the initial focus was on research, rule heuristic algorithm, and simulation scheduling[5-8]. With the widespread application of the new generation of intelligent technologies such as the Internet of Things and artificial intelligence[9], Digital Twin (DT) is used as the best technical way to upgrade traditional factories to smart factories and an effective way to improve production intelligence[10, 11]. Digital Twin (DT) has the characteristics of real-time virtual and real interaction and forward-looking optimization to guide production configuration, which can realize the efficient production of products. Tao Fei et al. proposed the concept of digital twin workshop, and conducted detailed research and elaboration on the key enabling technologies required by the system of the digital twin workshop[12]. Zhang Haijun et al. proposed a digital twin-driven intelligent workshop architecture, which can improve the optimal allocation of dynamic resources in the workshop[13]. Nikolakis N and others took advantage of the real-time simulation capabilities of the digital twin to optimize the
formulation and debugging of the production plan by the workshop personnel, and used the knowledge management system to capture the variable dynamic knowledge data implicit in the execution of the task, which solved the problem of ignoring the real-time changes of the production system during the work process in traditional digital simulation tools [14]. In order to improve the situation where traditional simulation tools ignore the changeable production environment of the production system, Delbrügger T et al. built a digital twin model of the production workshop based on digital twin technology to simulate various changes in the production system [15], Zhuang Cunbo et al. proposed an intelligent production management and control service framework model for the assembly workshop of complex products, and established the production management and control service of the assembly workshop based on twin data [16]. In addition, other researchers also discussed the application of big data technology in product maintenance [17], fault detection [18], fault prediction [19], risk assessment [20], production scheduling [21-22] and other fields.

In order to solve the above problems, this research proposes a new way to solve the problem of discrete manufacturing production scheduling based on digital twin and scheduling technology-real-time workshop digital twin scheduling platform. This technology combines digital twins with scheduling. By studying the application process of the real-time workshop digital twin scheduling platform for managers, the framework model of the real-time workshop digital twin scheduling platform is formulated, and the scheduling configuration model based on the digital twin is constructed. Take the production workshop of an enterprise as an example to establish a device-level digital twin model from the real environment to the digital environment. Finally, a real-time workshop digital twin scheduling platform is formed. The platform displays workshop scheduling data and operating data in real time.

2. Design of a real-time workshop digital twin scheduling platform
This paper constructs the framework model of the real-time workshop digital twin scheduling platform. The framework has user service layer, digital twin model layer, production scheduling plan management, network transmission storage layer, and physical device layer. As shown in Figure 1, the arrows indicate the flow of information between the various layers. The framework includes a visual interaction engine that can perform 3D visualization functions, a scheduling engine for scheduling rules, a set of web-based status detection integrated management applications, and an application program interface that exposes order analysis and processing.

Fig.1 Framework model of real-time workshop digital twin scheduling platform
The user service layer opens the order entry and supply chain entry interfaces for customers. After communicating with manufacturing experts, customers submit content such as product manufacturing methods and supply chain requirements to the digital twin model layer. In the digital twin model layer, there is a digital twin model that contains the definition of equipment functional units on the processing line. The digital twin layer will parse and re-encode the submitted information, and submit the re-encoded information to the production scheduling layer. The production scheduling layer performs scheduling based on the submitted information and the production line change information uploaded by the monitoring database, and returns the scheduling information to the model layer. The model layer transmits the content of the scheduling information to the user layer, and uses virtual reality technology to view the scheduling content. The model layer sends the manager's decision-making plan to the production line for execution. The physical device layer collects the information and data generated during the manufacturing process in the physical world, and transmits it to the monitoring database through the industrial network layer for synchronous monitoring with the digital twin model layer. The data information is transmitted to the production scheduling layer for production scheduling re-planning. Therefore, the industrial network layer consists of a communication interface that transmits manufacturing data and a database that stores data for synchronization. The network transmission storage contains three databases: one database is used to store the monitored production line status information, one database is used to store customer production orders, and one database contains the virtual model of the production line and the production plan schedule.

The framework model unifies the real workshop events, scheduling algorithm, and workshop monitoring through the digital twin model. Solve the problem that each module of the platform is independent of each other and data sharing is difficult. Through the way of data monitoring, real-time transmission of changed data to the virtual workshop and scheduling plan management, to achieve rapid transmission of overall platform data.

3. System implementation and verification

Based on the above research, using tools such as Unreal engine 4 to develop a real-time workshop digital twin scheduling platform. The platform is applied in a manufacturing workshop of a discrete industry to realize the input and collection of processes, products, and orders, combined with the production line status for scheduling, and realize real-time monitoring of site and equipment data in a high-fidelity virtual workshop.

According to the actual production workshop of the enterprise, as shown in Figure 2, the key equipment information is formed through the digital twin high-fidelity model construction method, so that it has a highly restored and highly realistic appearance. As shown in Figure 8, build the internal logic of logistics carts, cranes, pallet exchange lines, robotic arms, machine tools, and logistics pallets, and package them as a workshop digital twin overall model, so that each device model has control motion and data communication ability to exchange. Through database communication, the real-time data on the production line is transferred to the digital twin model to realize the physical and virtual twin movement.
In the scheduling planning process, the product, process, and bill of materials are first taken as input conditions of the production line and brought to the platform. The platform passes the input conditions to the scheduling algorithm in the solving thread, and the scheduling algorithm starts to calculate. When the result set is generated and fed back to the digital twin environment in the platform, the manager can observe the scheduling results in the digital twin environment and determine the final plan. At the same time, any disturbance on the production line will be passed to the data monitoring. In the case of monitoring the disturbance, the digital twin environment will pass the disturbance to the solving thread, and the solving thread will recalculate the scheduling and solve the new scheduling result. The manager re-observes the results and issues new instructions. Figure 3 is the production scheduling interface, in which the Gantt chart, time axis, and time multiplier functions are provided. Click on the device to query the device status at the current time and production resource information.
4. Conclusion
This research combines the actual production scheduling requirements encountered in the discrete manufacturing workshop to construct a digital twin high-fidelity model. The platform realizes the synchronization of the on-site data of the discrete manufacturing workshop with the twin model, and proposes a real-time scheduling configuration model of the digital twin. On this basis, a real-time workshop digital twin scheduling platform for discrete manufacturing was developed. This platform realizes the intelligent scheduling of the workshop. Through the twin model, users can understand the changes of future workshop equipment in the current scheduling. The platform is not only limited to the field of scheduling, but the realized function also monitors the disturbance situation on the manufacturing workshop site. In the follow-up work, we will go deep into the equipment processing link to realize the digital twin of the whole life cycle of the manufacturing process.

Acknowledgments
Thanks to the National Science and Technology Major Project (No.2019ZX04024001), Beijing Science and Technology Plan (Z201100006720008), National Natural Science Foundation of China (No.51975019), and Beijing Municipal Education Commission Science and Technology Plan General Project (KM201810005013) for funding this project.

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