

A Panel Discussion
on the
NSF Workshop on Manufacturing Systems Integration

R. A. Volz and A. W. Naylor
The University of Michigan

1. Introduction

Systems integration is an activity which until now has been largely handled on an ad hoc basis, often with disastrous effects and almost always with more work than was originally anticipated. The difficulties appear to compound rapidly with increasing complexity of the interconnections among subcomponents, and appear at several different levels, e.g. algorithmic, mechanical interconnections, electrical interconnections, communication protocols, software and data. Moreover, a broad spectrum of people is involved, and communication of common problems and solutions is often lacking. To investigate the causes underlying systems integration problems a workshop involving a broad range of experts was sponsored by the National Science Foundation. The workshop was organized by the Robotics Laboratory of The University of Michigan, and held at St. Clair, Michigan in November, 1983.

The underlying premises were

- Further and wider integration of manufacturing automation will be broadly beneficial.
- In spite of its benefits integration of manufacturing automation is taking place at an unacceptably slow pace.
- A basic research program in systems integration methodologies is needed to support and foster acceleration of integration of manufacturing.

The goals of the workshop were twofold. First, the extent to which the above three premises are true was to be determined. In particular, workshop participants were asked to answer the following questions:

- What does systems integration mean in your area?
- How much systems integration is desirable? Will it be a major aid to manufacturing, or has it been overvalued?
- Is systems integration taking place at an unacceptably slow pace?
- What research areas would it be appropriate for NSF to fund under the heading of systems integration?
- Is the necessary work in systems integration primarily standards work, or is it research?

The views of industry were to be particularly important in making these determinations.

Second, the workshop would bring together and establish communication among researchers from industry and the academic world who are working on various aspects of the

integration of manufacturing automation. This was considered particularly important given the broad range of people concerned with the various aspects of integration.

The results of the workshop will be disseminated in several ways. This panel discussion is one of them. In addition, a written report is being prepared (completion is expected in May, 1986). An audio recording was made of the entire workshop, and a complete transcription of it has been prepared. A videotape of the final reporting session is being prepared.

2. The Technological Area

The integration of manufacturing automation at the cell and factory floor levels was the technological area of interest. The workshop started with the following tentative characterizations.

The cell level is characterized by a modest number of machines and devices in close proximity, having a great deal of interaction. Significant time intervals are short: microseconds up to minutes. Geometric coordinates, shape, high level sensor based motion control and contact constraints are important. Variables are often real valued. The cell level involves such activities as adaptive control of machines, closely coordinated control of multiple robots and machines, task level planning of robot and machine operations, trajectory planning and the building of tools to support these activities.

The factory floor level is a collection of cells, each with its own cell level description. Here, concerns are with the flow of materials, tools, parts, and information throughout the manufacturing facility. Elements are somewhat more loosely coupled, than at the cell level. Significant times are typically measured in seconds and minutes (e.g., the time required to load a machine with a part, to create a part program, to move a part from one machine to another, to bring together two pieces for assembly). It is sufficient to identify a location by name, not coordinates; to characterize a cell by its capabilities or simply "execute" programs for, say, NC machines and robots. Typical constraints are of the form "At most one pallet can be at machine #4." Variables are usually logical integers or names.

It is not only systems' integration at the cell and factory floor levels individually that is of interest, but integration of activities across these levels as well. The interconnections between the cell and factory floor levels are often in the form of commands to the cell level and status reports to the factory

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manufacturing The book is aimed at several audiences Firstly it provides the research community with an overview of the present state of the art features in manufacturing along with references in the literature Secondly the book will be useful as supporting material for a graduate level course on product modeling and realization Finally the book will also be valuable to industrial companies who are assessing the significance of features for their business *Concurrent Product Design* Rajit Gadh,1994 Transactions of the North American Manufacturing Research Institution of SME. ,1996 Proceedings ,1997

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Table of Contents Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume

1. Understanding the eBook Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - The Rise of Digital Reading Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Advantages of eBooks Over Traditional Books
2. Identifying Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - User-Friendly Interface
4. Exploring eBook Recommendations from Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Personalized Recommendations
 - Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume User Reviews and Ratings
 - Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume and Bestseller Lists
5. Accessing Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume Free and Paid eBooks
 - Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume Public Domain eBooks
 - Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume eBook Subscription

- Services
 - Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume Budget-Friendly Options
- 6. Navigating Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume eBook Formats
 - ePub, PDF, MOBI, and More
 - Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume Compatibility with Devices
 - Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Highlighting and Note-Taking Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Interactive Elements Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
- 8. Staying Engaged with Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
- 9. Balancing eBooks and Physical Books Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Setting Reading Goals Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume

- Fact-Checking eBook Content of Proceedings Of The 1993 Nsf Design And Manufacturing Systems Conference Volume
- Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends
 - Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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