

# Contents

Abstract .....	2
Resumen .....	3
Resum .....	4
Acknowledgments.....	5
Contents .....	6
1    Introduction .....	9
1.1.    Motivation .....	9
1.2.    Objectives and Contributions .....	13
1.3.    Structure of the thesis.....	14
2    Related Work and theoretical framework.....	16
2.1.    Pharmaceutical manufacturing process .....	16
2.1.1.    Fluid bed dryer operations .....	18
2.1.2.    Improvements in the drying process .....	20
2.1.3.    Psychometrics and fluid bed dryer .....	22
2.1.4.    Energy consumption advances in fluid bed dryer machines .....	23
2.2.    Industry 4.0 in the pharmaceutical industry .....	24
2.2.1.    Industrial revolution in pharmaceutical manufacturing.....	24
2.2.2.    From Industry 4.0 to Pharma 4.0 .....	27
2.2.3.    Digital Twin technology and Industry 4.0.....	29
2.3.    Machine Learning applied to manufacturing.....	31
2.3.1.    Introduction to machine learning .....	31
2.3.2.    Machine learning algorithms .....	32
2.3.3.    Machine learning applied to energy reduction in the manufacturing industry	
35	
2.4.    Introduction to Cloud Computing and IIOT .....	36
2.4.1.    Cloud Computing IaaS, SaaS and PaaS.....	36
2.4.2.    Edge computing.....	38

2.4.3. Industrial Internet of Things (IIOT) .....	40
2.4.4. Communications gateway OPC UA .....	41
2.5. Microsoft Azure Cloud Computing platform.....	42
2.5.1. MS Azure Databricks .....	43
2.5.2. MS Machine Learning.....	44
2.5.3. MS Azure Data Factory.....	46
2.5.4. MS Azure Data Lake.....	48
2.5.5. MS Azure IOT Hub .....	49
2.6. Conclusions .....	50
3 Data capture and exploratory data analysis (EDA) .....	52
3.1. Proposed methodology .....	54
3.2. Data Capture .....	56
3.3. Exploratory Data Analysis.....	59
3.3.1. Psychometric model .....	60
3.3.2. Sensor Exploratory Data Analysis.....	64
3.3.3. Preheating phase analysis.....	68
3.3.4. Evaluation of preheating phase for two years production .....	71
3.4. Conclusions .....	75
4 Machine Learning model development.....	77
4.1. Proposed methodology .....	77
4.2. Data selection.....	79
4.3. Machine learning algorithms benchmarking .....	82
4.4. Catboost algorithm.....	85
4.5. Evaluation of ML algorithms .....	87
4.6. Catboost adaptation to the fluid bed dyer.....	89
4.6.1. Catboost model configuration .....	89
4.6.2. Analysis of Catboost model .....	91
4.7. Evaluation of the model with fluid bed dryer data .....	104
4.7.1. Preheating temperature analysis .....	104

4.7.2. Time duration analysis .....	105
4.7.3. Energy saving analysis .....	106
4.8. Conclusions .....	108
5 Fluid Bed Dryer Cloud-IIOT architecture.....	110
5.1. On premise and Cloud Computing set- up .....	112
5.1.1. On premise IOT .....	113
5.2. Data Ingestion and storage .....	115
5.2.1. Containers .....	118
5.3. Machine Learning model deployment .....	121
5.4. Process monitoring .....	127
5.5. Visualization .....	129
5.6. Fluid Bed Dryer Cloud-IIOT energy savings evaluation .....	133
5.6.1. Real-time batch energy savings analysis .....	135
5.6.2. Real-time fluid bed dryer time and energy savings.....	141
5.7. Conclusions .....	148
6 Conclusions and Future Work .....	149
6.1. Conclusions .....	149
6.2. Publications and contributions. ....	150
6.2.1. Research projects.....	151
6.2.2. Publications in scientific journals.....	151
6.2.3. Conferences .....	152
6.2.4. Awards .....	152
6.3. Future work.....	153
6.3.1. Drying process implementation.....	153
6.3.2. Drug product end-to-end architecture .....	154
6.3.3. Signal alert device .....	155
List of Figures .....	156
List of Tables .....	159
Bibliography .....	160