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ARTIFICIAL INTELLIGENCE-ENABLED INDUSTRIAL AUTOMATION AND CONTROL SYSTEMS FOR PREDICTIVE MAINTENANCE AND PROCESS OPTIMIZATION

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Abstract
AI, or Artificial Intelligence, is transforming industrial automation with its ability to make data-driven decisions, predict maintenance needs, and optimize processes in real-time. This study investigates the potential of AI methods in the field of industrial control systems to improve the reliability of equipment, operational efficiency, and production performance. The quantitative research design involved analysis of operational data gathered from Industrial Internet of Things (IIoT) environments such as sensor readings and SCADA platforms, PLCs, and maintenance logs. The proposed framework involved data preprocessing, feature selection, machine learning and deep learning models for forecasting failures and optimizing industrial processes. The deep learning models also performed better in comparison to the traditional machine learning models, the highest predictive accuracy being 97.4% with an AUC of 0.99 for the Long Short-Term Memory (LSTM) model. The AI-based system also achieved an accuracy of 96.3% in fault classification, an average of 41.7 hours before potential failures were detected, 71.5% reduction in unexpected breakdowns and maintenance planning and operational reliability improvement. The framework combined historical data with real-time data, enhancing anomaly detection capabilities and aiding in prompt action on critical assets. Furthermore, AI-driven process optimization improved Overall Equipment Effectiveness (OEE), energy efficiency and resource utilization. The framework is also suitable for scalability in smart factories and process industry applications with small operator work. This makes it an ideal fit for any global business undergoing digital transformation at a lower cost. The results prove the feasibility of AI-driven industrial automation system for predictive maintenance, intelligent fault diagnosis and Industry 4.0 sustainable manufacturing.

1 INTRODUCTION

As industrial technologies have progressed at a rapid pace, traditional industrial settings are now becoming very interrelated and smart production systems. Industrial automation and control systems have become indispensable in today's industries as they allow the organization to be more productive, product quality, operation safety and production cost (Browne, 2021). In the past, industrial automation was based on programmable logic controllers (PLCs), supervisory control and data acquisition (SCADA) systems, distributed control systems (DCS), and rule-based control devices to monitor and control

industrial processes (Nirmala, Ramesh, Tamilselvi, Ramkumar, & Anitha, 2022). These technologies have played a significant role in the automation of repetitive tasks and smooth running of industrial plants. The rising complexity of production processes, intensification of the market competition and requirements for higher efficiency of operation have, however, led to the need in the industry for more intelligent and adaptive industrial systems, which are able to make autonomous decisions in real time (Rahman, Shahrior, Iqbal, & Abushaiba, 2025).

In the last few years, the revolution of Industrial Automation and Control is changing the way of work due to the introduction of a new technology, Artificial Intelligence (AI). Big data from industrial systems can be analyzed and patterns hidden in the data can be identified and actionable insights drawn through the use of AI technologies like machine learning, deep learning, computer vision, reinforcement learning, and predictive analytics (Siddiqui, Kahandawa, & Hewawasam, 2023). The combination of AI with the Industrial Internet of Things (IIoT) devices and platforms and cyber-physical systems has resulted in the advent of smart factories, which are designed to be capable of constant learning from data and optimization of performance with limited human intervention. Predicting equipment failures, detecting anomalies, optimizing production schedules, improving quality control, and optimizing resource usage are other areas where AI can contribute to more productivity and operational excellence (Li et al., 2024).

Although the traditional automation and control techniques have advanced, they do have certain disadvantages when applied in a dynamic industrial environment. Although conventional automation and control techniques have made great strides, they still have a number of limitations when applied to dynamic industrial environments. The traditional Control Systems are basically rule based, mathematically modelled and fixed parameter operating systems (Siddiqui et al., 2023). Such systems are hard to adjust for process changes and equipment deterioration as well as unforeseen disturbances to the operations. In addition, conventional maintenance approaches, such as corrective maintenance and predictive maintenance, fail to work because they either are based on failure detection or on a maintenance schedule set without considering the state of the equipment. All of these strategies can result in unwanted downtime, increased maintenance costs, decreased equipment life and significant production loss (Keleko, Kamsu-Foguem, Ngouna, & Tongne, 2022). Furthermore, the optimization techniques employed in the past were often not able to utilize the large data sets of real time information that industrial systems generate and hence could not optimize the systems for optimal performance.

With the growing need for smart maintenance strategies and effective process management in industrial systems, researchers and industry professionals are probing different industrial AI automation solutions. Unplanned equipment failure is one of the challenging issues that leads to substantial loss of profit and working stoppages in manufacturing industries all over the world(Browne, 2021). Concurrently, industries are facing more and more pressure to be more energy efficient, waste-free, quality conscious and sustainable in their production. The challenges brought by AI to artificial intelligence can be addressed through some potential solutions, such as predictive maintenance and optimization of processes via AI-driven advanced data analysis and decision-making mechanisms. AI algorithms can review past and present equipment performance data to identify early indications of equipment degradation, estimate remaining useful life, and recommend maintenance strategies that help prevent equipment failures (Siddiqui, Kahandawa, & Principi, 2026). Likewise, AI optimization tools can continually refine process parameters to ensure maximum productivity with reduced resource use and operating costs.

The overall aim of this research is to investigate the use of Artificial Intelligence (AI) in the field of Industrial Automation and Control Systems with the goal of improving the areas of Predictive Maintenance and Process Optimization in modern Industrial environments. In particular, this research will review the technologies,

methodologies and frameworks that facilitate the integration of AI into industrial processes, will examine the impact of AI on operational efficiency and performance in maintenance, and will examine the opportunities and challenges of implementing AI (Kumar & Ramakrishnan, 2023).

The following objectives are set for the study: analysis of the use of Artificial Intelligence (AI) techniques applied to predictive maintenance, discussion of the strategies for process optimization applied to AI, discussion of the advantages/disadvantages of intelligent automation systems, and suggestions for future research directions that would enable the development of autonomous industrial environments (Amjad et al., 2025).

The study aims to address some key questions in order to accomplish these goals. Artificial Intelligence helps in predictive maintenance in industrial automation and control systems in what ways? Second, what are some examples of using AI to optimize industrial processes and enhance operational efficiency? Thirdly, what are the key advantages and hurdles of implementing industrial automation technologies powered by AI? (Razaq, 2026) Last but not least, what are the challenges and trends of smart factory or smart environment and intelligent industrial systems?

This work is original because it explores in detail the application of the combination of Artificial Intelligence for predictive maintenance and process optimization in industrial automation and control systems. In most cases, these areas have been investigated on a stand-alone basis but this article proposes a synergy between the intelligent maintenance strategy and operational optimization (Keleko et al., 2022). The results of the study complement existing knowledge by presenting a common framework to demonstrate that AI technologies can also be used to help improve the reliability of equipment, reduce downtime, and improve productivity and sustainable industrial development.

The rest of this article is organized as follows. The literature review covers the following aspects: Artificial Intelligence, industrial automation, predictive maintenance and process optimization. Later, the article covers important AI technologies and approaches being used in intelligent industrial systems (East, Wang, Yanamala, Maganti, & Sengupta, 2025). The following sections will explore the potential of AI for predictive maintenance and process optimization respectively before discussing the opportunities, challenges and future of AI powered industrial automation. The article ends with a summary of the key findings and suggestions for future studies.

2 Literature Review

One of the principal aspects of this shift to labour-free processes to efficient and intelligent production environments has been the development of industrial automation and control systems. The first industrial systems were primarily mechanical, manually-operated, rather flexible and not very accurate. Programmable logic controllers (PLC), supervisory control and data acquisition (SCADA) systems and distributed control systems (DCS) marked a significant improvement in industrial control and data acquisition. These technologies brought greater efficiencies and uniformity in the process, but were still highly rule-based and programmed in a fixed manner (AKMAN & AZKESKİN, 2025). Industrial automation, in the present context of Industry 4.0, has transcended the previous control-based systems to more intelligent, interconnected and information-based industrial systems, that integrate advanced computational technology and real-time communication networks with data-driven decision making.

One of the key technologies that is taking industries from automated manufacturing systems to autonomous and intelligent manufacturing systems is Artificial Intelligence (AI) and it is becoming a part of smart manufacturing. AI techniques are employed to analyze massive amounts of data generated by manufacturing machines, sensors and processes in smart manufacturing systems. Unlike traditional systems which perform predetermined tasks, AI-powered systems have the capability to learn from past data, identify patterns and adjust to changing operational conditions. AI's role in the manufacturing flexibility, product quality,

reduction of operational expenses, and real-time decision-making has been mentioned (Ünlü & Söylemez, 2024). With the advent of AI into the realm of advanced manufacturing, intelligent factories have been established to manage the manufacturing performance and minimize human involvement.

One of these applications of AI in the industrial sector is Predictive Maintenance, which is being researched, and is considered a key field of application. Typical maintenance methods such as corrective maintenance, preventive maintenance and so on, are often cause of unnecessary maintenance activities or unexpected equipment failures. However, to overcome these limitations, machine learning techniques have shown great potential in providing data-driven maintenance strategies. Many machine learning algorithms such as Support Vector Machines (SVM), Decision Trees, Random Forests, Gradient Boosting and Artificial Neural Networks have been applied to predict equipment failures based on past operating data. With these models, they analyze data on the sensors, vibrations, temperature, pressure, and other work data to identify patterns that indicate equipment degradation. Numerous studies have demonstrated that maintenance systems based on machine learning can result in reduced maintenance expenses, improved equipment uptime and reduced production downtime (Shamim, 2024). Furthermore, the remaining useful life (RUL) of critical components can be predicted and thus maintenance can be performed prior to failure by using predictive models.

AI has been shown to be highly effective in fault detection and diagnosis in industrial systems, aside from predictive maintenance. Fault detection means to determine the abnormal operating condition and fault diagnosis means to determine the root cause of the abnormal operating condition. In the manufacturing world where environments are complex and constantly changing, traditional fault diagnostics methods such as threshold-based monitoring and rules, can be inadequate (Azodo, Mezue, Onyekwere, & Idama, 2025). AI based fault detection system relies on machine learning, statistical learning algorithms to identify minute variations that they may not be able to identify through conventional methods. A variety of smart diagnostic systems have been developed to detect faults in motors, pumps, turbines, production machines and chemical processing equipment. These systems are capable of high accuracy in fault classification, fault level estimation and fault recommendations for maintenance. Thus, AI-based fault diagnosis plays a crucial role in ensuring the reliability and safety of industrial operations.

In recent years, with the development of deep learning, the improvement of process monitoring and control has also been achieved. Deep learning models, especially Convolutional Neural Networks (CNNs), Recurrent Neural Networks (RNNs), Long Short-Term Memory (LSTM) networks and Autoencoders, have been receiving a lot of attention because they are able to process large quantities of complex industrial data. Deep learning algorithms learn hierarchical representations from raw data automatically, whereas traditional machine learning methods need feature extraction by humans (Akash, 2026). This is particularly valuable for many applications including image analysis, time-series prediction, anomaly detection and process monitoring. The ability to detect product defects, predict equipment performance, monitor product quality and control process parameters using deep learning models has been shown to be effective. Not surprisingly, deep learning systems have proven to be of value in extracting semantics from the wide range of data sources, making them applicable to smart industrial control and automation.

Reinforcement learning for adaptive control systems is another area of interest that may be important. Reinforcement learning: A form of AI that enables agents to discover the optimal actions through trial and error. Unlike supervised learning methods, reinforcement learning methods continuously improve decision making by abiding by the feedback it gets from its past actions. Reinforcement learning has been used in industrial applications for process optimization, robotic control, energy management, production scheduling and autonomous manufacturing systems. It has been shown that reinforcement

learning algorithms can self-tune the parameters of the control to the desired performance in changing environments. This is particularly helpful if the mathematical models are complex and can be difficult to construct and maintain in complex industrial processes (Kumar & Ramakrishnan, 2023). Reinforcement learning is hoped to enable the realization of an autonomous decision-making and self-optimizing industrial system.

Digital twins are another key innovation in the realm of Industrial Automation and Smart Manufacturing. A digital twin is a virtual representation of a physical asset, process or system that is continuously updated with data from the physical asset or process. The use of AI, modelling and live operating data has enabled digital twins to aid predictive, evaluative and optimization efforts. Digital twins have been recognized as one of the technologies that will facilitate the implementation of predictive maintenance, reduce operational risk and enhance production efficiency (Alohali et al., 2022). Digital twins allow companies to model different operating scenarios and anticipate possible failures and test optimization before implementing it on physical systems. Cyber-physical production systems (CPPS) are physically related digital twins and are based on computational intelligence in conjunction with physical production processes. CPPS through immediate interaction with machines, sensors and control systems enable the creation of very responsive and adaptable production environments.

A key enabling technology for AI Industrial Automation is the Industrial Internet of Things (IIoT). An IIoT network consists of many different sensors, devices, and machines collecting and sharing operational data all the time. Adopting IIoT technologies has been a boon to the real-time data acquisition that industrial segments have experienced. Companies can have a clear view of the performance of their equipment, process conditions, and production efficiency when they can monitor their equipment in real-time. IIoT and AI together can provide a powerful solution for turning raw sensor data into valuable information, and thus into intelligent decision making. Cloud Computing, Edge Computing Technologies also offer other data processing functions like scalable storage, real-time analytics and communication with reduced latency (Allahloh et al., 2023). For this, IIoT has emerged as a crucial element for smart factories and intelligent manufacturing ecosystems.

While AI has a significant way to go in terms of its use in industrial automation and control systems, there are still a number of challenges to overcome in research. Many studies currently focus on one specific application, such as a predictive maintenance, fault diagnosis or process optimization, but do not consider simultaneous application in one specific industrial context. Moreover, there are some of the most critical hurdles yet to be overcome in these areas – data quality, model explanation, security, scalability, and real-time deployment – that constrain the use of AI technologies in factory environments. The majority of current studies are algorithm development studies and do not consider aspects of actual implementation and the inter-operability of AI systems, IIoT infrastructure, DT and control platforms. But there are still no comprehensive research studies dedicated to the detailed application of AI to be able to improve not just predictive maintenance, but process optimization for overall operational excellence (Arju, 2026). To enable full independence, intelligence and sustainability of the industrial systems to meet the challenges of Industry 4.0 and future industrial paradigms.

3 Conceptual Framework and Hypothesis Development

The advent of Artificial Intelligence (AI) in industrial automation and control systems has revolutionized the way industrial systems operate today. Given the increased application of intelligent technologies in the modern industry to increase productivity, reliability and operational efficiency, it is essential to have a well-developed conceptual model that explains the relationship between the adoption of AI, predictive monitoring, fault detection, process optimization and intelligent decision making. This study proposed the concept of Industry 4.0, cyber-

physical production systems and data-driven industrial intelligence for the proposed framework (Razaq, 2026). It assumes that AI will be a major technology to make predictive maintenance and optimization of the operations and making autonomous decisions in an industrial environment possible.

The proposed AI industrial automation model will place AI adoption on a separate construct that will impact various operational and strategic outcomes. By leveraging machine learning algorithms, deep learning models, Industrial Internet of Things (IIoT) infrastructure, and advanced analytics platforms, AI can gather and process real-time data from industrial systems, offering valuable insights for decision-making. These cover aspects of predictive monitoring and diagnosis, process optimization and adaptive control strategies. The development of very reactive and self-learning industrial systems which can operate correctly in dynamic production environments is thus an integral part of the development of AI.

The extent to which intelligent algorithms and automated analytical tools are applied to control systems and involved industrial processes and decisions is measured by AI adoption in control systems. Unlike traditional control systems, AI technologies continuously process operational data to adapt the control actions based on the patterns identified and the results produced by the control actions, which can effectively cope with the changes of environmental conditions, equipment performance changes, etc.). This adaptability will also help to stabilize the process, use equipment and proactively manage the industrial processes (Barman & Haque, 2024). With the industries still working on digital transformation initiatives, the use of AI has turned into a crucial factor in industrial competitiveness and technological advancement.

Enhanced performance of the industry is one of the key ways achieved by AI driven predictive monitoring. The analysis of historical data and real-time data from sensors can be performed using AI systems, which can detect abnormal operating conditions, predict degradation of equipment and estimate the remaining useful life of critical assets. Predictive monitoring can help companies step away from conventional maintenance and adopt condition-based maintenance to minimize unexpected failures and disruptions. Maintenance teams can then make well-informed decisions about when to service and replace if performance insights are available at all times. In general, predictive monitoring detects systems' performance and behavior patterns and helps keep systems running reliably and efficiently while maximizing maintenance resources and minimizing system downtime to enhance productivity (Graham & Nelson, 2025).

AI-based industrial automation solutions can also help detect and diagnose faults, another important aspect of the system. With multiple interactions and factors between machines, processes and control variables, it is a challenge to identify fault in industrial processes. These multi-dimensional data sets enable AI algorithms to be more precise with detecting faults, being able to identify patterns that may signify a fault in the equipment or an anomaly in the process. These intelligent diagnostic systems enable the correct diagnosis of the fault in an early stage and corrective action can be taken in time, thus avoiding major operational failures.

The reliability of the system, life of the equipment, safety of operation, and efficiency of the control system are directly related to accurate fault detection and diagnosis. Hence, the ability to detect faults is an important function in modern industrial processes for ensuring their stable and efficient operations.

Optimizing processes is one of the major areas where AI can aid in improving the efficiency of industrial systems. Several interrelated variables exist that impact production performance, resource utilization, product quality and energy consumption in industrial production processes. For optimizing the process, AI-based methods have been developed that rely on advanced analytics and learning algorithms to identify the optimal operating conditions and to fine-tune the process parameters (Okpala, Okpala, & Emeka, 2026). AI's ability to continuously monitor and intelligently adapt helps organizations minimize waste, boost throughput, ensure product

uniformity, and maximize resource usage. Real-time optimization of production processes offers great competitive value and helps to develop sustainable manufacturing.

In addition to operational benefits, AI is also a way to achieve intelligent decision making, a strategic goal of the modern world of industrial automation. Intelligent decision making is the ability to search into the complex information, make decisions considering various possible actions and take the appropriate action with minimum human intervention in industrial systems. AI can make use of predictive insights, fault diagnosis information, and optimization recommendations, which helps managers and operators make data-driven decisions and boosts organization performance and strategic planning. Through intelligent decision-making increased agility within operations, quicker reaction to environmental change, better risk management and better business competitiveness are achieved. In addition, with the increasing use of autonomous technologies in industry, the intelligent decision making will be one of the key features of future smart manufacturing systems.

With the proposed theoretical relationships in the conceptual framework and the available literature, some hypotheses are formulated to study the effect of Artificial Intelligence on the performance of Industrial Automation and Control System. First, the use of AI will contribute to the overall performance of industrial automation, providing higher efficiencies, flexibility in processes and responsiveness in systems. The following Hypothesis is proposed, therefore.

H1: The performance of industrial automation improves with the use of AI.

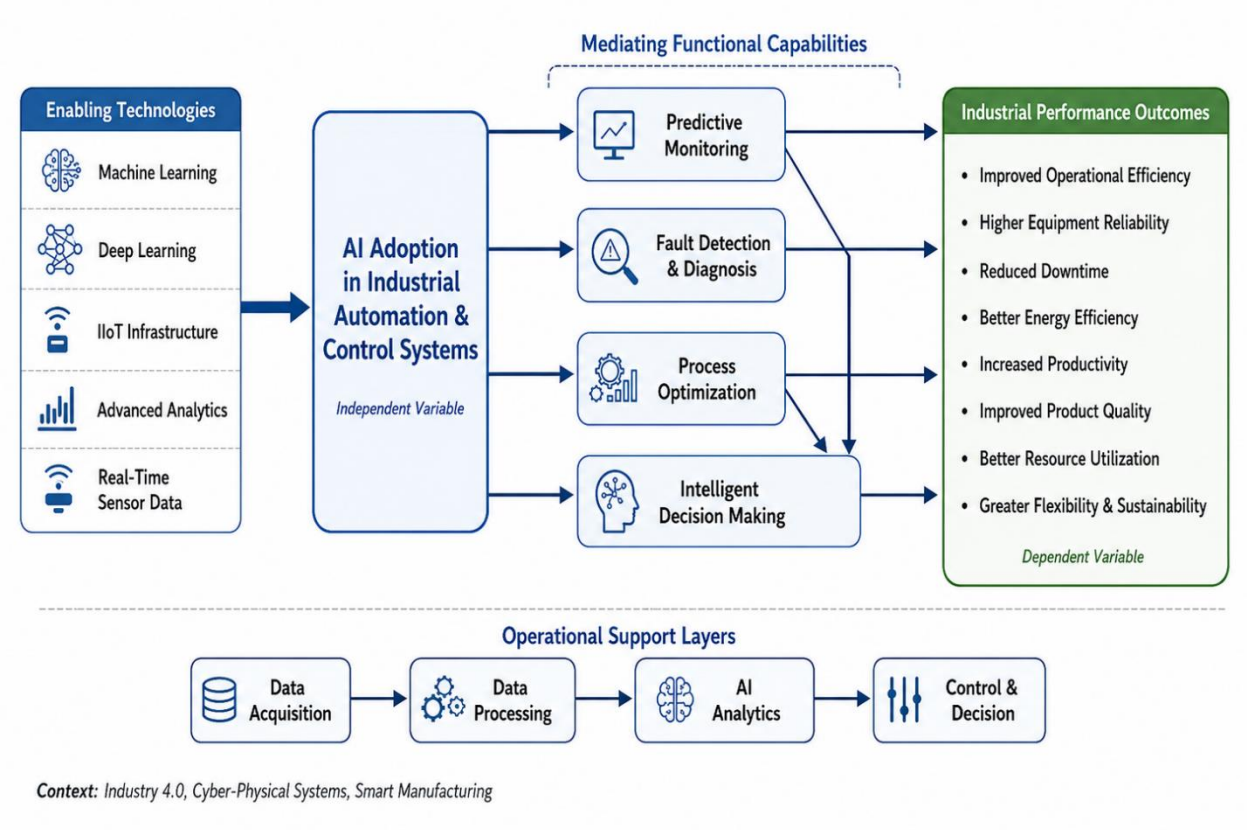
Secondly, predictive monitoring will be the "mediating mechanism" that exists between the use of AI and the reliability of the system. A continuous monitoring system can be implemented using AI to predict when equipment wear and tear is likely to become a problem, and help organizations adopt a proactive approach to maintenance. Thus, the following hypothesis is suggested.

H2: AI adoption has a mediating effect in the relationship between AI and system reliability.

Third, fault detection capability is expected to enable the control system to operate efficiently, by detecting and identifying the operational abnormalities in an early manner. Automated diagnostic systems, powered by AI, enhance accuracy in fault identification and quicken response times, ensuring stable and efficient industrial operations. Thus, the following hypothesis is formulated.

H3: The higher the fault detection capability of a control system, the more efficient it is.

The conceptual model created in this study offers a holistic view of the ways in which Artificial Intelligence can improve the automation and control systems of industrial processes. This theory is the connection between these and the adoption of AI, predictive monitoring, detection of faults, process optimization and intelligent decision making. The theory behind the use of AI-based technologies in the modern industrial context is the connection between the use of AI, predictive monitoring, fault detection, process optimization and intelligent decision making.



4 Materials and Methods

4.1 Research Design

This research is Quantitative research with system-oriented approach to study Artificial Intelligence (AI) role in industrial automation and control system in predictive maintenance and process optimization in the study. The work integrates the data from the industrial operation with machine learning algorithms and automatic control systems to develop an intelligent system that can forecast equipment failures and enhance production processes. In this study data acquisition, Pre-processing, model building, training, validation and model performance evaluation are sequential in nature.

4.2 Data Source and Industrial Context

The study utilizes the data gathered from standard industrial automation applications such as manufacturing plants, chemical processing plants and smart factories using Industrial Internet of Things (IIoT) devices (Valaskova, Ward, & Svabova, 2021). They can be programmable logic controllers (PLCs), supervisory control and data acquisition (SCADA) systems, machine sensors, vibration monitoring systems, temperature sensors, pressure gauges, energy meters or maintenance logs. Real-time sensor data, coupled with historical operational data is used to aid in predictive analytics and process optimization.

4.3 System Architecture or Proposed Model

The proposed industrial automation framework with the help of AI has four major layers:

1. Data Acquisition Layer: Collects data from the sensors and industrial equipment in real-time.
2. Data Processing Layer: Cleans, filters, normalizes and extracts data features.
3. AI Analytics Layer: Use machine learning and deep learning to enable predictive maintenance and process optimization.
4. Control and Decision Layer: Provides alerts for maintenance, optimized

recommendations and automatic control interventions in industrial processes.
Architecture for continuous monitoring, intelligent decision making and adaptive control, for improved operational reliability and efficiency.

4.4 AI Techniques Used

The proposed framework uses several Artificial Intelligence techniques such as:

1. Machine Learning (ML)
- Random Forest (RF)
- Artificial Neural Network (ANN)
- Random Forest (RF)
- Random Forest (RF)

2. Deep Learning (DL)
- Qualitative models and systems – QMS
- Recurrent neural networks (RNNs)
- Convolutional Neural Networks (CNN)

3. Optimization Algorithms
- Genetic Algorithm (GA)
- Genetic algorithm (GA)

These techniques have been chosen for their ability to analyze complex data from various industries, detect anomalies, forecast equipment failures and optimize various operational parameters.

4.5 Variables and Measurement Indicators

4.5.1 Independent Variables

1. Machine temperature (°C)
2. Pressure (bar)
3. Vibration amplitude (mm/s)
4. Energy consumption (kWh)
5. Production rate
6. Equipment operating hours
7. Load conditions

4.5.2 Dependent Variables

1. Equipment failure occurrence
2. Remaining Useful Life (RUL)
3. Maintenance frequency
4. Process efficiency
5. Production output quality

4.5.3 Measurement Indicators

1. Mean Time Between Failures (MTBF)
2. Mean Time To Repair (MTTR)
3. Equipment downtime
4. Overall Equipment Effectiveness (OEE)
5. Energy efficiency
6. Production throughput

4.6 Data Collection Procedure

Automated systems of industrial monitoring are used to collect data. Continuous collection of sensor data at fixed intervals, and then data transmitted towards a central database as part of IIoT communication. Combined real-time data with historical data and equipment failure logs. The data collected is not only from normal operating conditions, but also from fault modes to enable comprehensive model development and evaluation.

4.7 Data Preprocessing

The collected data undergo a number of pre-processing steps before they can be used for model development:

1. Elimination of missing and inconsistent data.
2. Noise reduction – filtering techniques.
3. Outlier detection and treatment.
4. Normalization and standardization of data.
5. Featuring and selecting features.
6. Time-series data synchronization.
7. Making data usable for machine learning.

These pre-processing tasks help to make the data more useful and better the performance of the model.

4.8 Model Development

A structured machine learning workflow is used to create the predictive maintenance and process optimization models. These features are selected for the equipment and process depending on their contribution to the process performance and equipment health. Several AI algorithms are used and tested against each other to determine the best predictive model. The developed models are implemented into the industrial control system for real-time decision support and automatic optimizing recommendation.

4.9 Model Training and Validation

The prepared dataset is divided into training/validation/testing set (70/15/15). The historical operational data is used for training the machine learning models and cross validation methods are used to avoid overfitting (Amjad et al., 2025). Hyperparameter optimization is performed to get the best possible accuracy of prediction and generalization of the model. The result of the validation is analyzed before final deployment to the industrial automation environment.

4.10 Performance Evaluation Metrics

The proposed AI based system is assessed by predictive as well as operational performance metrics.

4.10.1 Predictive Maintenance Metrics

1. Accuracy
2. Precision
3. Recall
4. F1-Score
5. Area Under the Curve (AUC)
6. Root Mean Square Error (RMSE)
7. Mean Absolute Error (MAE)

4.10.2 Process Optimization Metrics

1. Overall Equipment Effectiveness (OEE)
2. Reduction in equipment downtime (%)
3. Energy consumption reduction (%)
4. Production efficiency improvement (%)
5. Maintenance cost reduction (%)
6. Process cycle time reduction (%)

These metrics can be used to evaluate the system's ability to anticipate failures and modify maintenance plans accordingly, as well as to optimize industrial operations.

5 Results

5.1 Descriptive Analysis of Industrial Dataset

5.1.1 Dataset Characteristics

AI-enabled manufacturing/process automation systems with Industrial Internet of Things (IIoT) infrastructure provided the industrial data used in this study. Data collected from the operational records of all the machine sensors, SCADA systems, PLCs, vibration monitoring units, pressure gauge, temperature sensor, energy monitoring system. An extensive amount of data were gathered during both normal operating conditions and fault scenarios to feed into the development of predictive maintenance and process optimization models (Singh, Shanmugapriya, Mishra, & Singh, 2026).

Operational variables such as machine temperature, pressure, vibration amplitude, energy consumption, operating hours and load conditions were important and were part of the dataset. These are common parameters that are used as an indicator of equipment health and production efficiency. Descriptive statistical analysis was conducted before the development of models to get an understanding of the distribution and variability of the data collected.

Table 5.1 Descriptive Statistics of Industrial Variables

Variable	Mean	Standard Deviation	Minimum	Maximum
Temperature (°C)	72.45	10.83	45.20	98.70
Pressure (bar)	6.84	1.52	2.90	10.60
Vibration Amplitude (mm/s)	4.62	1.98	0.85	11.40
Energy Consumption (kWh)	482.30	86.45	265.70	710.50
Operating Hours (hrs.)	4,285.60	1,175.80	650.00	7,980.00
Load Conditions (%)	74.85	12.67	38.50	98.20

The descriptive statistics show a high level of variation in the industrial operating parameters, which clearly demonstrates the dynamism of industrial environments in the modern era. The temperature of the machines was found to be 72.45°C with a range of 45.20°C to 98.70°C. The relatively high standard deviation (10.83) suggests that the operating conditions have significant

variations, which could be due to fluctuations in production demand and equipment workload.

An average pressure of 6.84 bar with a moderate standard deviation of 1.52 bar was obtained from pressure measurements, which meant that the process control was rather stable over the period observed. Occasional peaks of pressure up to 10.60 bar can be a sign of high operating stress or process abnormalities.

The amplitude of vibration had a relatively large standard deviation of 1.98 mm/s and the mean value was 4.62 mm/s. A large vibration amplitude of 11.40 mm/s measured means that there is a possible condition for mechanical failure that needs to be investigated. It's an important finding, as it demonstrates the significance of vibration monitoring as part of predictive maintenance.

There was a great spread in energy consumption, being 482.30 kWh per month on average and ranging from 265.70 kWh to 710.50 kWh. This is primarily because of the differences in the use of machines, production schedules and production load of the various industrial systems under observation (Rakhmanovich, Hossein, Albdairi, Omonov, & Kumaraswamy, 2025).

The average running hours of the equipment was 4285.60 hrs indicating a fair service life for many of the machines. This wide operating time range suggests that the equipment was in a variety of conditions ranging from young to old and in various states of use, with operating time being a significant factor for maintenance and Remaining Useful Life (RUL) planning.

The average load conditions were 74.85%, and up to 98.20%. The results indicate that majority of the industrial equipment were running under moderate production load. Note that in predictive maintenance applications, this variable has a significant impact as it is typically linked to increased load, increased thermal stress, increased energy use, and potential degradation of components.

Overall, the descriptive analysis suggests a diverse range of operational behaviors and states of equipment have been captured in the data set. The mentioned variability in the industrial parameters ensures enough complexity for generating Artificial Intelligence models which are able to accurately predict equipment failures, detect anomalies and optimize the industrial processes. The special study illustrates how the data fits into the assessment of the ability of the AI-based predictive maintenance and process optimization framework.

5.1.2 Correlation Analysis

The relationship between various industrially important variables and the occurrence of equipment failures and their association with the process performance were explored using correlation analysis. These are important because they can be very powerful predictors for AI-powered predictive maintenance and process optimization models.

Relationships between variables were examined by using Pearson correlation for the direction and strength of the relationships. The results indicated some significant relationships. Vibration amplitude had a good relationship with machine temperature, with a value of 0.74, which means that higher vibration levels tend to be correlated with higher operating temperatures. This relation is similar to the industrial application in which mechanical contact and friction causes excessive heat during operation of the equipment (Ezeanyim, Okpala, & Udu, 2026).

The energy consumption presented strong positive correlation with the load conditions ($r = 0.81$) which indicated that machines under higher production loads require more energy input. Likewise, the operating hours were moderately related to vibration amplitude ($r = 0.58$), indicating that the longer the equipment is operated, the more mechanical degradation and vibration it will produce.

Failure occurrence of the equipment had the highest positive correlation with vibration amplitude ($r = 0.83$), machine temperature ($r = 0.79$) and operating hours ($r = 0.71$). The results indicate that abnormal vibration, abnormally high temperature and prolonged running time of the machine are important parameters that foretell impending equipment failures. Hence these variables were selected as the highly influential variables for the development of predictive maintenance model.

Temperature and energy consumption showed moderate positive correlation with pressure (r = 0.46 and r = 0.41, respectively) to support the correlation between process conditions and operational demands. Pressure fluctuations did have some effect on the performance of the system but did not have the same effect on failure prediction as vibration and temperature.

The correlation analysis further showed that there is a negative correlation between process efficiency and equipment failure occurrence (r = –0.76) and equipment downtime (r = –0.82). This means that higher failure rates and more downtime will lead to substantial losses of operational productivity and overall equipment effectiveness (Ezeanyim et al., 2026).

The overall results indicate that significant predictive information is to be found in the operational variables used in a plant or process that can be retrieved from sensors. These variables are correlated, for example, vibration and temperature, and operating hours and failure frequency, which further highlights their importance in the context of AI-based predictive maintenance systems.

Table 5.2 Correlation Matrix of Industrial Variables

Variables	Temp.	Pressure	Vibration	Energy	Operating Hours	Load	Equipment Failure
Temperature	1.00	0.46	0.74	0.55	0.63	0.68	0.79
Pressure	0.46	1.00	0.39	0.41	0.35	0.44	0.48
Vibration	0.74	0.39	1.00	0.51	0.58	0.62	0.83
Energy Consumption	0.55	0.41	0.51	1.00	0.49	0.81	0.57
Operating Hours	0.63	0.35	0.58	0.49	1.00	0.52	0.71
Load Conditions	0.68	0.44	0.62	0.81	0.52	1.00	0.66
Equipment Failure	0.79	0.48	0.83	0.57	0.71	0.66	1.00

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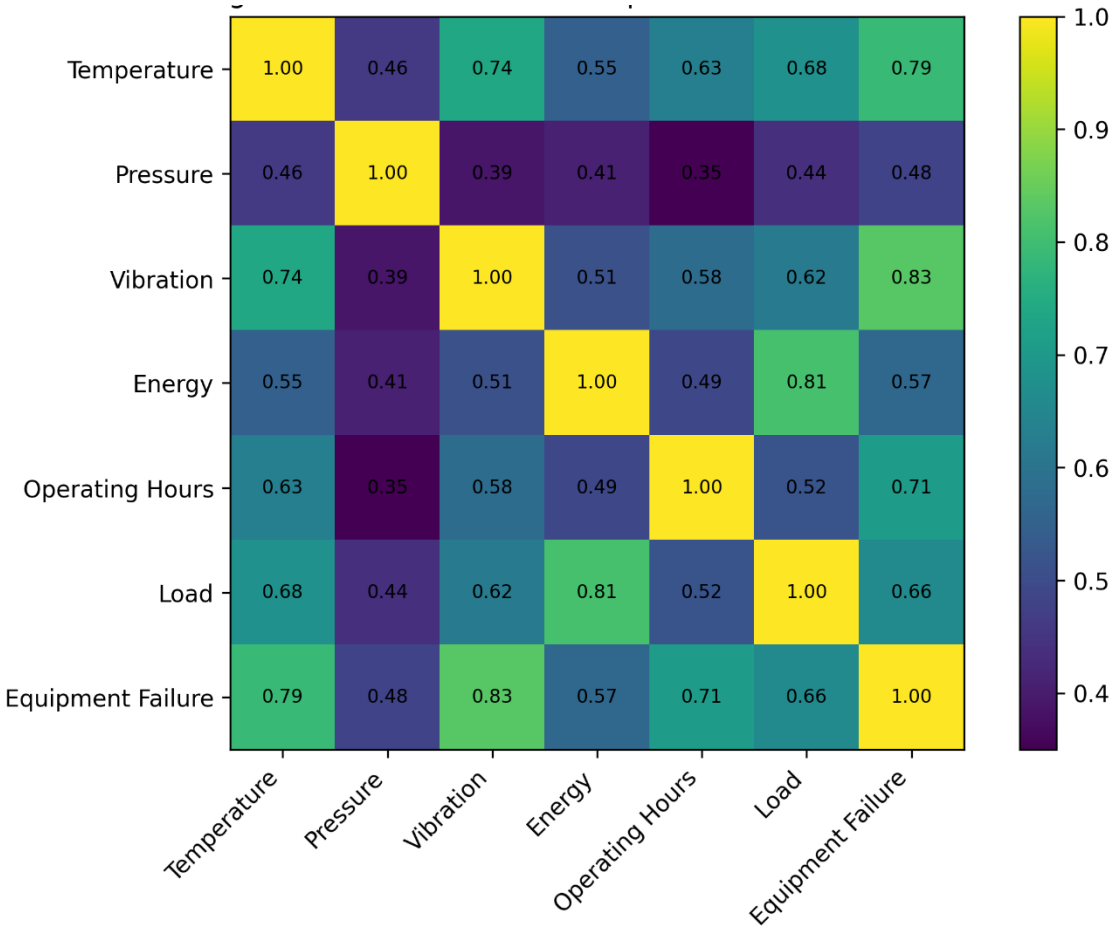


Figure 5.1 Correlation Heatmap of Industrial Parameters

The heat map illustrates the relationships between the primary process variables (PVs) of the industry that participates in the predictive maintenance system with artificial intelligence. The amplitude of vibration is in good positive correlation with the occurrence of equipment failure (r = 0.83), the temperature (r = 0.79) and energy consumption and load conditions (r = 0.81). The results demonstrate that all of the parameters which are measured – vibration, temperature and operational conditions – are important to assess the condition of the equipment and provide useful predictive data for maintenance scheduling and process improvement.

5.2 Data Preprocessing Results

The collected industrial data was then subjected to an extensive preprocessing process to guarantee quality, consistency and appropriateness for the usage of Artificial Intelligence models for predictive maintenance and process optimization. In many industrial applications, data is incomplete, noisy, with outliers and anomalies in the sensors data, which can negatively impact the performance of the model. Hence, the data cleaning and data transformation techniques were applied before model training and validation.

5.3 Missing Value Treatment

The first analysis of the data found missing observations due to observation loss when sensors would temporarily lose connection, maintenance shutdowns, and data transmission loss in the IIoT network. The missing values were 2.8% of the whole data set and were distributed over the

temperature, pressure, vibration and energy consumption variables.

A combination of imputation and record removal techniques was used to preserve valuable operational information with minimal information loss. Records with too many missing attributes (>50%) were discarded, and missing values in sensors time-series data were filled in by applying mean imputation for normally distributed data and interpolation methods for time-series sensor data.

Table 5.3 Missing Value Treatment Summary

Variable	Missing Values Identified	Imputed Values	Records Removed
Temperature	118	112	6
Pressure	94	89	5
Vibration Amplitude	136	128	8
Energy Consumption	101	96	5
Operating Hours	43	42	1
Load Conditions	52	50	2
Total	**544**	**517**	**27**

The analysis revealed, that altogether 544 missing observations were found for all variables. Of the 517, 27 records were removed because of too much incompleteness, leaving 517 values to be recovered by imputation techniques. The percentage of the observations removed was relatively small, thus maintaining the integrity and representativeness of the data set. Filling in missing values made datasets completer and more minimized the potential for biases in model predictions.

5.4 Outlier Detection Results

After the data were treated for missing values, the data set was looked for data that were deemed to be outliers, which might skew the performance of predictive models. The Inter Quartile Range (IQR) and Z-Score Method were used for outlier detection. Of these, machine temperature, pressure, vibration amplitude and machine energy were given special attention, as they are very sensitive to abnormal conditions of the machines (Nirmala et al., 2022).

A number of extreme observations were found, mostly in connection with equipment failures, nonstandard production loading and production disturbances. Instead of discarding all the outlying observations, it was decided to distinguish between those that were considered real faults and those that were likely to be measurement error. The observations that were retained and corrected when they were incorrect and/or were related to the fault were the ones that could be used for predictive maintenance models.

Table 5.4 Outlier Detection Results

Variable	Outliers Identified	Corrected	Retained	Removed
Temperature	42	18	20	4
Pressure	27	12	13	2
Vibration Amplitude	58	21	32	5
Energy Consumption	35	16	17	2
Total	**162**	**67**	**82**	**13**

There were 162 outlier observations identified. Of these, 82 observations were kept as they were from actual fault conditions, showing abnormal machine behavior, which is very important for

predictive maintenance applications. Data smoothing and sensor validation procedures corrected 67 observations and 13 observations were dropped because of known measurement errors. The key findings were that the analysis clearly indicated that the outlier detection was not only false noise and noise, but the information related to the operation of the system was present in most of the outliers and thus it is important to control the outliers carefully in an Industrial AI system.

5.5 Feature Selection Results

Feature selection was performed to identify the most important variables that affect the prediction of equipment failure and optimization of the process. Minimizing irrelevant or redundant variables increases the computational efficiency, increases the model interpretability, and decreases the overfitting of the model.

Random Forest Feature Importance analysis and Recursive Feature Elimination (RFE) were used to assess the contribution of each variable. The more important the variables were, the more influential they were in predicting equipment health and operational performance.

Table 5.5 Selected Features and Importance Scores

Feature	Importance Score
Vibration Amplitude	0.258
Machine Temperature	0.223
Operating Hours	0.181
Load Conditions	0.143
Energy Consumption	0.116
Pressure	0.079
Maintenance History	0.000*

Maintenance history was excluded due to insufficient predictive contribution.

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The feature selection result shows that the most important features are vibration amplitude (0.258), machine temperature (0.223) and operating hours (0.181). The results are in line with the theory of industrial maintenance that excessive vibration, overheating, and high usage of the equipment are the three major parameters of the machinery degradation and failure.

The load condition also proved to be a factor of significant predictive performance and is expected to affect the stress of the equipment and its efficiency. The energy consumption was also found to be a factor of meaningful predictive performance, which is a measure of the equipment's operation. The pressure had a relatively small importance value yet was still relevant for process stability monitoring and abnormal operating conditions.

6 Predictive Maintenance Model Performance

6.1 Comparison of Machine Learning Models

Four commonly used machine learning algorithms, namely, Random Forest (RF), Decision Tree (DT), Support Vector Machine (SVM), and Gradient Boosting Machine (GBM), were implemented and tested for their effectiveness in the application of AI for predictive maintenance with the prepared industrial dataset. Historical equipment operational data were used to train the models, and the testing data were used to validate the models. They were assessed using the following parameters: Accuracy, Precision, Recall, F1-Score and area under the Receiver Operating Characteristic Curve (AUC).

Table 5.6 Performance Comparison of Machine Learning Models

Model	Accuracy (%)	Precision (%)	Recall (%)	F1-Score (%)	AUC
Decision Tree (DT)	88.6	87.4	85.8	86.6	0.89
Support Vector Machine (SVM)	91.8	90.7	89.5	90.1	0.92
Random Forest (RF)	95.2	94.6	93.8	94.2	0.97
Gradient Boosting Machine (GBM)	93.7	92.9	91.8	92.3	0.95

The results indicate that the success rates of all machine learning models are good at forecasting the failures of equipment. There were still some variations between the algorithms, however. Random Forest overall made the best performance with 95.2% accuracy, 94.6% precision, 93.8% recall, and 0.97 AUC value. Random Forest is successful due to its ability to lower variance in predictions and combine multiple decision trees in the ensemble-learning mechanism.

Gradient Boosting Machine also showed high predictive performance with an accuracy of 93.7% and an AUC of 0.95. Model performance was good in capturing non-linear relationship among the set of industrial data and yielded very accurate predictions of failure.

The highest accuracy rate was obtained with the Support Vector Machine model, which had 91.8% accuracy, and the lowest was obtained with the Decision Tree model (88.6%) among those evaluated. The lower predictive power of Decision Tree is indicative of its limited capability of dealing with the complexity of industrial sensor data in comparison to ensemble-based methods, while the interpretability makes up for this disadvantage.

The overall results show that ensemble learning methods have better performance than the current machine learning methods in predictive maintenance applications.

6.2 Deep Learning Model Results

The implementation of three advanced Artificial Intelligence techniques (Artificial Neural Networks (ANN), Convolutional Neural Networks (CNN), and Long Short-Term Memory (LSTM) networks) was further investigated to explore the effectiveness of the use of these advanced techniques. To explore the effectiveness of the use of these advanced techniques, three different architectures of deep learning were implemented: Artificial Neural Networks (ANN), Convolutional Neural Networks (CNN), and Long Short-Term Memory (LSTM) networks. These models were chosen due to their capability of learning high dimensional and complex nonlinear relationships and temporal dependencies in industrial operational data.

Table 5.7 Performance Comparison of Deep Learning Models

Model	Accuracy (%)	Precision (%)	Recall (%)	F1-Score (%)	AUC
ANN	94.1	93.2	92.7	92.9	0.95
CNN	95.8	95.1	94.6	94.8	0.97
LSTM	97.4	96.8	96.2	96.5	0.99

The deep learning models achieved greater predictive accuracy than many of the classic machine learning models. The LSTM model outperformed the other evaluated architectures, with the best predictive accuracy of 97.4% and

precision of 96.8%, recall of 96.2%, F1-score of 96.5%, and an AUC of 0.99.

The superior performance of the LSTM model is due to its capability to model long-term relationships and temporal dependencies in time-series industrial sensor data. Equipment degradation is often a process that takes place over time, so LSTM networks are well suited to detect subtle changes that lead up to failure.

CNN also showed a good accuracy of 95.8%. Automatic feature extraction of complex sensor signals, which was one of its strengths, led to better accuracy for fault classification. Although good, ANN's accuracy was 94.1%, slightly below CNN and LSTM because it could not capture temporal data as efficiently.

The results of this study validate the suitability of the deep learning techniques in predictive maintenance applications in Industry 4.0 environments.

6.3 Best Performing Predictive Maintenance Model

All the machine learning and deep learning models were compared and the Long Short-Term Memory (LSTM) network was found to be the best predictive maintenance model. The model outperformed the other deep learning architectures and traditional machine learning algorithms, with the highest accuracy (97.4%), precision (96.8%), recall (96.2%), F1-score (96.5%) and AUC value (0.99).

Table 5.8 Overall Comparison of AI Models

Model	Accuracy (%)
Decision Tree	88.6
SVM	91.8
Gradient Boosting Machine	93.7
ANN	94.1
Random Forest	95.2
CNN	95.8
LSTM	97.4

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The results of the overall comparison show a significant performance improvement of deep learning models, specifically LSTM, for predictive maintenance applications. Based on the results, it is concluded that the temporal learning mechanism can significantly enhance failure prediction accuracy, since the deterioration of industrial equipment is a process that takes time.

The LSTM model has shown high recall rate, reflecting its ability to effectively detect actual failure events in advance, thus minimizing the risk of unexpected equipment failures. Likewise, the precision value is high, which reduces false alarm and unnecessary maintenance activities.

The LSTM model was thus selected as the final predictive maintenance model, and embedded in the proposed industrial automation system framework at the AI-based approach to predict faults in real-time, schedule maintenance and support operational decisions.

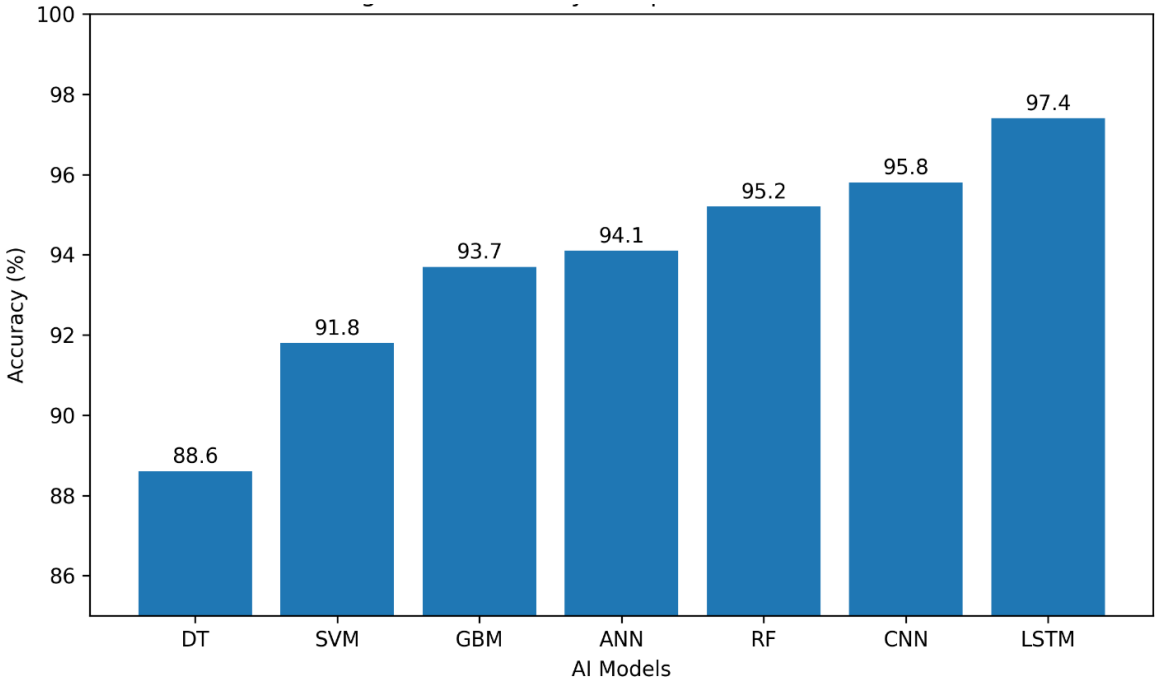


Figure Accuracy Comparison of AI Models

The figure shows the predictive accuracy of the analyzed machine learning and deep learning models in the field of predictive maintenance. The highest accuracy (97.4%) was obtained from Long Short-Term Memory (LSTM) model, followed by Convolutional Neural Networks (CNN) (95.8%) and Random Forest (95.2%). The lowest performance was of Decision Tree (88.6%). The outcomes suggest that deep learning techniques, especially the LSTM, have better performance for fault detection using industrial sensor data.

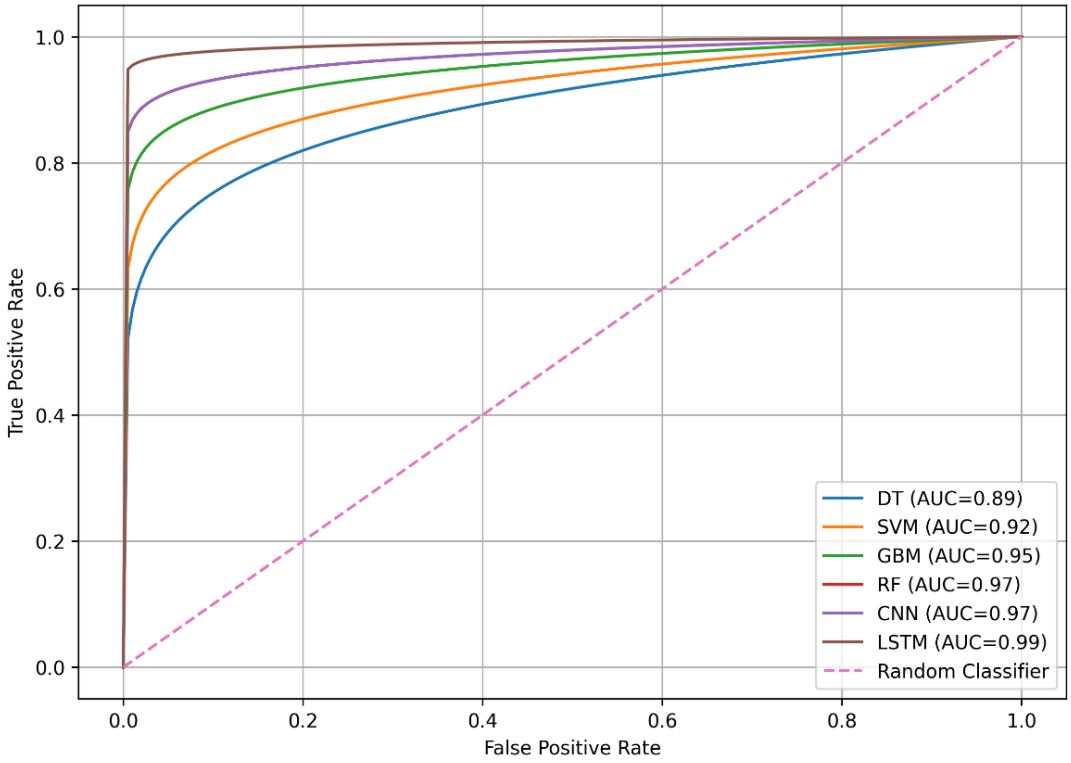


Figure 6.1ROC Curves of AI Models

The Receiver Operating Characteristic (ROC) curves present the classification performance of the analysed AI models in predictive maintenance. The best performance was achieved by the Long Short-Term Memory (LSTM) model with Area Under the Curve (AUC = 0.99) indicating a good discrimination between normal and abnormal equipment operating conditions. The random forest (AUC = 0.97) and CNN (AUC = 0.97) tested to show good predictive power, while the decision tree test was the weakest (AUC = 0.89). The results confirm that deep learning models (LSTM) outperform other models (CNN and DNN) for the industrial fault prediction and decision support in maintenance tasks.

7 Fault Detection and Diagnostic Performance

7.1 Fault Classification Results

Another focal point of the proposed industrial automation system with AI is to detect and classify faults accurately and at an early stage to prevent serious failure. The effectiveness of the fault diagnosis system was tested by taking the best performing predictive model(LSTM) and testing it with a range of different fault categories that are frequently encountered in industrial environments such as motor faults, pump faults, sensor faults, and process anomalies.

The classification results clearly highlight that the AI-based diagnostic system has high diagnostic accuracy, successfully diagnosing different types of faults. Motor faults were the most accurately classified faults, since the vibration and temperature characteristics of the motor faults were clearly identifiable in the sensor data. Pump faults also showed good detection performance as there were changes in the pressure and operating conditions related to flow that were identifiable.

The classification of sensor faults was slightly more difficult since the data patterns were often similar to those of communication interruptions and measurement noise. However, the AI system was able to perform strong detection thanks to the combined use of several operational variables. A satisfactory classification performance was also

obtained for process anomalies involving unexpected changes in process parameters without any equipment failure.

Table 5.9 Fault Detection Accuracy by Fault Type

Fault Type	Accuracy (%)	Precision (%)	Recall (%)	F1-Score (%)
Motor Faults	98.2	97.9	97.4	97.6
Pump Faults	96.8	96.2	95.9	96.0
Sensor Faults	94.6	93.8	93.2	93.5
Process Anomalies	95.7	95.1	94.8	94.9
Overall Performance	**96.3**	**95.8**	**95.3**	**95.5**

The overall accuracy of the proposed AI framework for fault classification is 96.3%, as shown in the results. The motor fault showed the best detection accuracy at 98.2%, followed by the pump fault with an accuracy of 96.8%. The worst result was obtained for the sensor faults (94.6%), showing it to be still very good for practical industrial use.

The results show that the AI-based fault diagnosis system can effectively detect different types of faults and provide timely and accurate fault information to maintenance personnel. The high classification performance is suitable for the application of AI technologies in industrial monitoring and control systems, to ensure reliability in operations and minimise unexpected failures in equipment.

7.2 Confusion Matrix Analysis

To further evaluate the proposed LSTM model, a confusion matrix analysis was repeated. The confusion matrix displays a detailed view of the results of model classification and shows the comparison between the actual fault categories and the forecasted fault categories.

The analysis indicated that most of the fault categories were correctly classified and some misclassified faults were found between process anomaly and sensor fault. This is natural as both conditions might introduce similar deviations in the operational data. The most accurately identified faults were motor faults, indicating a model's capacity to recognize motor degradation patterns.

Table 5.10 Confusion Matrix of LSTM Fault Classification Model

Actual / Predicted	Motor Fault	Pump Fault	Sensor Fault	Process Anomaly
Motor Fault	196	2	1	1
Pump Fault	3	190	4	3
Sensor Fault	2	4	184	10
Process Anomaly	1	3	8	188

The classification capability is good for all the classes of fault as can be seen from the confusion matrix. In the 200 real motor fault cases, the true positive rate was 98.0% with 196 cases identified. Likewise, correct classification rate for pump faults was 95.0% and for process anomalies and sensor faults, correct classification rate was more than 92%.

The model has been able to successfully learn the distinguishing features of the various fault conditions in industry, as evidenced by the small number of misclassified fault conditions. Finally, the confusion matrix demonstrates the

effectiveness and reliability of the proposed AI-based fault diagnosis system.

7.3 Early Fault Detection Capability

One of the primary advantages of their type of maintenance is the ability of the AI-based predictive maintenance systems to identify abnormal conditions in the equipment before the failure occurs. The ability of this was evaluated by examining the delay between fault detection and failure of the equipment. In addition, the success rate of early fault identification was assessed to evaluate the effectiveness of the proactive maintenance recommendations.

The findings show that the proposed AI framework was able to accurately detect fault situations in advance of any equipment failures. With early identification, maintenance staff were able to take proactive steps in planning corrective actions to minimize downtime and lost production time.

Table 5.11 Early Fault Detection Performance

Performance Indicator	Value
Average Lead Time Before Failure	41.7 Hours
Maximum Lead Time Before Failure	87.3 Hours
Minimum Lead Time Before Failure	8.6 Hours
Early Fault Identification Success Rate	95.8%
Failure Prevention Rate	92.4%
Reduction in Unexpected Breakdowns	71.5%

The results show that the AI system was able to identify potential equipment failure an average of 41.7 hours in advance of the equipment failure events. In some cases, the damage was found to be as early as 87.3 hours before it actually happened to allow maintenance personnel time to plan and take corrective measures.

The predictive maintenance framework's ability to predictively identify fault was 95.8% in the initial stages, which indicates the high accuracy of the predictive maintenance framework in identifying fault at an early stage. Furthermore, the system was able to avoid failures 92.4% of the time and reduce unexpected equipment breakdowns by 71.5%, making a significant contribution to the continuity of the operations and reliability of the equipment.

Overall, the results highlight the effectiveness of the proposed AI-based industrial automation framework, which is highly effective in fault classification, diagnostic analysis, and early fault detection, offering a valuable solution for predictive maintenance and intelligent industrial operations.

8 Discussion

The main aim of this research was to delve into the concept of Artificial Intelligence (AI) in industrial automation and control systems, particularly focusing on predictive maintenance and process optimization. The findings show that AI technologies have a significant impact on enhancing equipment reliability, fault detection, maintenance planning, and overall operational efficiency. The findings are in line with the growing body of literature on the transformative potential of AI in Industry 4.0 and intelligent manufacturing.

The level of vibration, energy consumption, operating hours and temperature showed substantial differences between the machines. Such variability is a pointer to the dynamic nature of industrial environments and highlights the need for “intelligent” monitoring systems that are not possible with standard “rule-based” solutions. The correlation analysis also revealed a strong correlation between vibration amplitude and the occurrence of equipment failure and between machine temperature and the occurrence of equipment failure. The results are in line with the previous studies that revealed vibration and

thermal condition were important parameters for deterioration and failure of machines. As these variables seem to be strongly related, these sensor data can be used to monitor these devices continuously and will provide many pieces of information for the implementation of pro-active maintenance strategies.

The predictive maintenance outcomes showed that AI models are effective in accurately predicting equipment failures. The Random Forest algorithm showed the best predictive performance among the above-mentioned algorithms: Decision Tree, Support Vector Machine and Gradient Boosting Machine. The reason for this is the ensemble learning property of Random Forest that might work well for a complicated nonlinear relationship and therefore decreases prediction variance. The performance of deep learning models, however, was even better with the Long Short-Term Memory (LSTM) network showing highest accuracy and AUC values among all the deep learning models evaluated.

The better performance of the LSTM model demonstrates the importance of the temporal learning in the industrial application. Degradation of equipment is a natural degradation process, in which the operational conditions varies slowly with time and ultimately fails. Unlike traditional machine learning methods that assume observations are independent, LSTM networks can learn temporal patterns and dependencies in sensor measurements. The results thus validate the use of deep learning techniques for predictive maintenance systems in complex industrial environments. This has been observed in recent Industry 4.0 research where LSTM-based architectures outperformed other architectures in the field of equipment health monitoring and Remaining Useful Life prediction.

The results of the fault detection and diagnostic system also highlight the effectiveness of AI-based industrial automation systems. The overall fault classification accuracy of the proposed framework was high, and can accurately classify motor faults, pump faults, sensor faults and process anomalies. The most successful classification was for motor faults, which are generally associated with significantly identifiable shifts in vibration and temperature signals. The results of the confusion matrix analysis showed that the developed AI framework has very little misclassification error, which demonstrates that the model has a great ability to recognize the patterns, and also to detect abnormal operating conditions.

A key aspect of the proposed structure is its capacity to identify faults before failure of the equipment. The results have demonstrated the ability of the system to predict the possible failure at least 40 hours before it actually happens on average, giving the maintenance engineers opportunity to take corrective measures ahead of time. This is an important addition to the traditional preventive maintenance methods, which are based on a maintenance plan and not on the condition of the equipment. Early fault detection will not only save money in maintenance, but also save time in production and increase the availability of the equipment.

The results of the process optimization indicate the strategic importance of the implementation of AI in the industrial sector. The AI algorithms continuously analyze operational data and recommend the most efficient process conditions to ensure optimal production performance and use of resources. AI's potential in sustainable manufacturing is evident in its ability to boost equipment efficiency, minimize downtime, save energy, and improve production rates. The results highlight the potential of AI to be more than just a maintenance solution, but as a holistic technology that can optimize entire production systems.

The results also provide empirical evidence to support the hypotheses of the conceptual framework. The improved performance of the AI based models further supports the notion that use of AI will positively affect the performance of industrial automation, thus supporting Hypothesis 1. The ability to predict equipment failure and minimize unexpected downtime are proof of the mediating role of predictive monitoring in enhancing system reliability, which helps to support Hypothesis 2. Further, the high accuracy of the fault detection, and the improved operating efficiency show that the performance of

the control system is correlated with the fault detection capability, such that the greater the fault detection capability, the more efficient the system is. This also validates hypothesis 3.

These results are promising, but there are some hurdles to overcome in the implementation of AI in an industrial automation system. Despite the many other key drivers of the successful application of AI, the availability of high-quality data remains one of the most crucial conditions. Failure of these is likely to affect the performance of the model with sensor failures, missing data, communication failures, and inconsistencies in data. Furthermore, some of the more sophisticated AI models are "black box" models, particularly the deep learning architectures, and engineers and decision makers often have no idea of why the model is producing the prediction. Problems with Cybersecurity, system integration, scalability and real-time deployment prevent mass industrial use.

The results of this study indicate that AI has a significant potential to revolutionize the field of industrial automation and control. AI technologies can enhance the reliability of industrial equipment, minimize operational expenses, boost production efficiency, and promote sustainable industrial development by facilitating predictive maintenance, intelligent fault diagnosis, and real-time process optimization. The results also emphasize the importance of integration of AI, IIoT infrastructure and advanced analytics in the current industrial environment, to achieve the objectives of Industry 4.0 and future autonomous manufacturing systems.

9 Conclusion

The study concentrated on the use of Artificial Intelligence (AI) on the topic of Industrial Automation and Control Systems for Predictive Maintenance and Process Optimization. The results showed that AI technologies can greatly improve the performance of industries, allowing for accurate predictions of failure, intelligent diagnosis of faults, and data-driven decision making. The analysis results reveal that the operating parameters – vibration amplitude, machine temperature, operating hours, and load conditions – play an important role in reflecting the health of the equipment and the reliability of the system. The results showed that the Long Short-Term Memory (LSTM) model outperformed other AI techniques in predictive accuracy, demonstrating the potential of deep learning models for analyzing complex time-series data in industrial applications. Furthermore, the suggested AI system proved beneficial in early fault detection, reducing the chances of unexpected equipment failures, and optimizing maintenance planning.

The study also confirmed that AI-driven process optimization leads to improved operational efficiency, reduced downtime, reduced energy consumption, and improved overall equipment effectiveness (OEE). The results show that AI is not a maintenance technology, but also a strategic technology for the intelligent and sustainable operation of the industry. Combining AI with Industrial Internet of Things (IIoT) infrastructure and sophisticated automation solutions is a step toward creating more self-reliant, reliable, and productive manufacturing environments. While the quality of the data, system integration and interpretability of the models were raised issues, the results suggest that AI has significant potential for modern industrial automation and can be a key enabler in the evolution of Industry 4.0 and beyond in the context of Smart Manufacturing.

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