Plant 3 Controls & Automation Systems Assessment

Q2 2025 Quarterly Review

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Next Review: September 30, 2025

Executive Summary

Plant 3 controls infrastructure continues to support production targets but faces increasing maintenance burden and capacity constraints. Several legacy systems are approaching end-of-life, and manual processes remain significant bottlenecks. Recommend strategic upgrade planning for 2026 implementation.

Current System Overview

PLC Infrastructure

- **Primary Systems:** 4x Allen-Bradley ControlLogix 5580 (installed 2019)
- **Legacy Systems:** 2x SLC 5/05 (installed 2011) - **END OF LIFE**
- **I/O Distribution:** Mix of remote I/O and local expansion modules
- **Programming Platform:** RSLogix 5000 with some legacy RSLogix 500

SCADA/HMI Systems

- **Primary SCADA:** Wonderware System Platform 2017 R2
- **Operator Stations:** 6x panel-mounted HMIs (mix of vintages)
- **Historical Data:** 3-year retention, some gaps in trending
- **Alarm Management:** Basic alarming, no advanced analytics

Communication Infrastructure

- **Plant Network:** Ethernet/IP backbone with some DeviceNet legacy
- **Wireless:** Limited coverage, aging infrastructure
- **Remote Access:** VPN-based, security concerns noted

- **Protocol Mix:** Ethernet/IP, Modbus RTU, some proprietary protocols

Safety Systems

- **Safety PLCs:** 2x Allen-Bradley GuardLogix (2020)
- **Emergency Stop Network:** DeviceNet-based, some single points of failure
- **Safety Interlocks:** Mix of hardwired and programmable safety
- **SIL Ratings:** Most loops SIL 1, critical processes SIL 2

Performance Metrics (Q2 2025)

System Availability

- **Overall Automation Uptime:** 94.2%
- **SCADA System Availability:** 97.8%
- **Network Connectivity:** 96.1%
- **HMI Response Time:** Average 2.3 seconds (target: <1.5s)

Maintenance Burden

- **Planned Maintenance Hours:** 340 hours
- **Unplanned Downtime Events:** 23 incidents
- **Average Response Time:** 47 minutes
- **Critical Spare Parts Inventory:** $127K

Production Impact

- **Automation-Related Downtime:** 1.8% of total production time
- **Manual Override Events:** 156 instances
- **Process Optimization Opportunities:** 12 identified, 3 implemented

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Current Challenges & Bottlenecks

Equipment End-of-Life Issues

1. **SLC 5/05 Systems (Lines 2 & 4)**
   - Discontinued hardware, difficult parts sourcing
   - No vendor support after December 2025
   - Integration challenges with newer systems

2. **Legacy HMI Panels**
    - Slow response times affecting operator efficiency
    - Limited diagnostic capabilities
    - Inconsistent user interfaces across lines

Capacity Constraints

1. **I/O Limitations**
    - Current systems at 78% capacity
    - Future expansion requiring additional hardware
    - Cable tray space becoming limited
2. **Communication Bandwidth**
    - Network congestion during peak operations
    - Historical data collection impacting real-time performance

Manual Process Bottlenecks

1. **Quality Control Data Entry**
    - 4 hours daily manual data logging
    - Error-prone transcription processes
    - Delayed reporting to management
2. **Recipe Management**
    - Manual recipe changeovers taking 45 minutes average
    - Version control issues with paper-based procedures

Integration Gaps

1. **MES Connectivity**
    - Limited integration with production scheduling
    - Manual work order processing
2. **Maintenance System Interface**
    - No automated work order generation from alarms
    - Asset data synchronization issues

Safety & Compliance Status

Regulatory Compliance

- **OSHA Compliance:** Current, next audit scheduled October 2025
- **EPA Emissions Monitoring:** Automated systems functioning
- **FDA Requirements:** Manual documentation burden noted

Safety System Performance

- **Safety System Availability:** 99.1%
- **False Trip Rate:** 2.3 per month (target: <2.0)
- **Safety Training:** All operators current, next cycle due Q1 2026

Technology Refresh Opportunities

High-Impact Improvements

1. **Legacy PLC Migration**
   - Replace SLC 5/05 systems with ControlLogix platform
   - Standardize programming environment
   - Improve diagnostic capabilities
2. **HMI Modernization**
   - Implement consistent operator interface design
   - Add mobile device support for maintenance
   - Integrate advanced alarm management
3. **Network Infrastructure Upgrade**
   - Expand Ethernet/IP coverage
   - Implement managed switches with VLAN segmentation
   - Upgrade wireless infrastructure for mobile devices

Process Optimization Potential

1. **Advanced Process Control**
   - Implement model predictive control on critical loops
   - Add statistical process control monitoring
   - Automated quality control data collection
2. **Predictive Maintenance**
   - Vibration monitoring on critical equipment

- Thermal imaging integration
- Automated maintenance scheduling

Resource Requirements

Staffing

- **Controls Engineering:** 1.5 FTE for upgrade project management
- **Technician Support:** 2 FTE during implementation phases
- **Training Requirements:** 40 hours per operator for new systems

Infrastructure

- **Electrical:** Panel space assessment required for I/O expansion
- **IT Support:** Network infrastructure planning and security review
- **Physical Space:** Control room layout modifications needed

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Risk Assessment

High Risk Items

1. **SLC 5/05 Hardware Failure** - Probability: High, Impact: Critical
2. **Legacy HMI Panel Failures** - Probability: Medium, Impact: High
3. **Network Infrastructure Overload** - Probability: Medium, Impact: Medium

Mitigation Strategies

- Maintain critical spare parts inventory
- Develop emergency bypass procedures
- Create system backup and recovery protocols

Budget Considerations

Estimated Ranges (Preliminary)

- **PLC Hardware Refresh:** $180K - $220K
- **HMI System Upgrade:** $95K - $125K
- **Network Infrastructure:** $65K - $85K
- **Engineering & Implementation:** $150K - $200K

- **Training & Documentation:** $25K - $35K

Total Estimated Range: $515K - $665K

Note: These are preliminary estimates for planning purposes. Detailed quotes required for budget approval.

Recommendations

Phase 1 (Q4 2025 - Q1 2026)

1. Replace SLC 5/05 systems on Lines 2 & 4
2. Upgrade critical HMI panels
3. Begin network infrastructure assessment

Phase 2 (Q2 2026 - Q3 2026)

1. Complete HMI standardization
2. Implement advanced alarm management
3. Expand Ethernet/IP network coverage

Phase 3 (Q4 2026)

1. Deploy advanced process control features
2. Integrate predictive maintenance systems
3. Complete operator training program

Next Steps

1. **Executive Review Meeting** - Present findings to operations leadership
2. **Vendor Consultations** - Engage with automation suppliers for detailed proposals
3. **Budget Planning** - Work with finance team on capital expenditure approval
4. **Project Charter Development** - Define scope, timeline, and resource allocation

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Document Control:

- **Classification:** Internal Use Only
- **Distribution:** Operations Leadership, Engineering Team, Maintenance Management
- **Retention:** 7 years per corporate policy

- **Next Update:** September 30, 2025

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