Q

1 of 1

L Download ☐ Print Save to PDF Add to List More... >

Internetworking Indonesia Journal • Volume 9, Issue 1, Pages 59 - 64 • 2017

Document type
Article
Source type
Journal
ISSN
19429703

View more ✓

# Development of speech control for robotic hand using neural network and stream processing method

Haryanto, Ismoyo ; Ariyanto, Mochammad ; Caesarendra, Wahyu ; Dewoto, Hadianto K.

<sup>a</sup> Mechanical Engineering Department, Diponegoro University, Jl. Prof. Sudarto, SH - Tembalang, Semarang, 50275, Indonesia

Full text options V Export V

Abstract

Author keywords

SciVal Topics

Metrics

## **Abstract**

The purpose of this paper is to develop speech control for robotic hand using voice input. The voice signal acquired by microphone is processed in real time using stream processing for handling large amounts of data. The processed signal is recognized using Neural Network with tansig and softmax transfer function in hidden layer and output layer. The Network consists of 20 neurons in hidden layer. Eight frequency domain and five time domain features are employed in speech recognition system. The recognition results from ANN are sent to Arduino Uno to drive the robotic hand motion. Based on the experiment results, ANN can recognize the voice command with 95.9% in offline recognition and 90 %. in online real time recognition. The proposed of speech control system was also tested in noisy environment. The overall accuracy of speech control decreases 10 % in noisy environment. Speech control for robotic hand using stream processing method has been successfully developed. © 2017 IIJ.

### Author keywords

Feature calculation; Neural Network; Robotic hand; Speech; Stream processing

# Cited by 3 documents

Video emotion recognition based on Convolutional Neural Networks

Li, C., Shi, Y., Yi, X. (2021) Journal of Physics: Conference Series

Design and Implementation of A Human Prosthetic Hand

Keerthi, P.S., Al Mamun, S., Tonima, R.A. (2021) International Conference on Robotics, Electrical and Signal Processing Techniques

Deep temporal-spatial aggregation for video-based facial expression recognition

Pan, X., Guo, W., Guo, X. (2019) Symmetry

View all 3 citing documents

Inform me when this document is cited in Scopus:

Set citation alert >

#### Related documents

Speech control of robotic hand augmented with 3D animation using neural network

Ismail, R., Ariyanto, M., Caesarendra, W. (2016) IECBES 2016 - IEEE-EMBS Conference on Biomedical Engineering and Sciences

Comparative Study of Motion Recognition with Temporal Modelling of Electromyography for Thumb and Index Finger Movements aiming for Wearable Robotic Finger Exercises

Singhvi, S., Ren, H. (2019) ICARM 2018 - 2018 3rd International Conference on Advanced Robotics and Mechatronics

Pattern recognition of singlechannel sEMG signal using PCA and ANN method to classify nine hand movements

Arozi, M., Caesarendra, W., Ariyanto, M. (2020) Symmetry

View all related documents based on references

Find more related documents in Scopus based on:



# Source details



Q

Internetworking Indonesia Journal
Scopus coverage years: from 2009 to 2021

Publisher: Internetworking Indonesia

ISSN: 1942-9703

Subject area: (Computer Science: General Computer Science)

Source type: Journal

 SJR 2021 0.129

1.4

(i)

SNIP 2021 **0.257** 

57 <sup>(1)</sup>

CiteScore CiteScore rank & trend Scopus content coverage

i Improved CiteScore methodology

CiteScore 2021 counts the citations received in 2018-2021 to articles, reviews, conference papers, book chapters and data papers published in 2018-2021, and divides this by the number of publications published in 2018-2021. Learn more >

CiteScore 2021

 $1.4 = \frac{46 \text{ Citations } 2018 - 2021}{32 \text{ Documents } 2018 - 2021}$ 

Calculated on 05 May, 2022

CiteScoreTracker 2022 ①

 $0.6 = \frac{30 \text{ Citations to date}}{53 \text{ Documents to date}}$ 

Last updated on 05 February, 2023 • Updated monthly

# CiteScore rank 2021 ①

Category	Rank	Percentile	
Computer Science General Computer Science	#150/231	35th	

View CiteScore methodology ➤ CiteScore FAQ ➤ Add CiteScore to your site &

# www.InternetworkingIndonesia.org

# Internetworking Indonesia Journal

# The International Journal of ICT and Internet Development

Guest Editors' Introduction Endra Joelianto, Augie Widyotriatmo and Arjon Turnip	1
Accelerating IIOT Adoption with OPC UA Saju Eruvankai, Murugesan Muthukrishnan, and Anantharamaiah Kumar Mysore	3
Management of Laboratory Work for Designing Manufacturing Phases via the Ethernet Connection Anna Antonyová, Peter Antony, and Endra Joelianto	9
Classification of EEG Signals for Eye Focuses Using Artificial Neural Network Wahyu Caesarendra, Mochammad Ariyanto, Kharisma A. Pambudi, M. Faizal Amri, Arjon Turnip	15
Virtual Reality Flight Simulator Kelvin Valentino, Kevin Christian, and Endra Joelianto	21
Peat Water Treatment based Wireless Data Acquisition System for Flexible Remote Monitoring Arjon Turnip, Sutrisno S. Hutagalung, Imamul Muchlis, and M. Faizal Amri	27
Behavior-Based Humanoid Robot for Teaching Basic Mathematics Widodo Budiharto and Anggita Dian Cahyani	33
	(Continued)

A Business Architecture Modeling Methodology to Support

Audit of Information Technology Governance Using COBIT 4.1:

Mayang Anglingsari Putri, Vivin Ayu Lestari and Ismiarta Aknuranda

Implementation of Primary Health Care in Indonesia Dwi Cahya Astriya Nugraha, Ismiarta Aknuranda, Sri Andarini,

the Integration of Primary Health Care:

and Jack Roebijoso

Case Study in PT. XY

39

47

# Internetworking Indonesia Journal

The International Journal of ICT and Internet Development ISSN: 1942-9703

www.InternetworkingIndonesia.org

The Internetworking Indonesia Journal (III) is a peer reviewed international journal devoted to the timely study of Information and Communication Technology (ICT) and Internet development. The journal seeks high-quality research papers on the challenges and opportunities presented by information technology and the Internet, as well as their impact to society. Issues in the IIJ covers the broad areas of computing, communications, engineering (software & hardware) and the broader area of internet technologies.

The journal provides open access to all of its content on the principle that making research freely available to the public supports a greater global exchange of knowledge. This follows the philosophy of the Open Journal Systems (see the Public Knowledge Project at pkp.sfu.ca). The III issues are published electronically (PDF) and there are no subscription fees. Such access is associated with increased readership and increased citation of an author's work.

Journal mailing address: Internetworking Indonesia Journal, PO Box 397110 MIT Station, Cambridge, MA 02139, USA.

## Computing, Communications, Engineering & Internet Technologies

The Internetworking Indonesia Journal covers the broad technical areas of computing, communications, engineering and Internet Technologies.

Possible topics for papers include, but are not limited to the following:

- Information technology and information systems
- Communications technology
- Software and hardware engineering
- Algorithms and computation
- Applications and services
- Broadband and telecommunications technologies
- Mobile and wireless networks

- Internet infrastructure systems, protocols, standards and technologies
- Multimedia and content development
- Education and distant learning
- Open source software development and deployment
- Cloud Computing, SaaS, and Grid Computing

# Co-Editors

Thomas Hardjono, PhD (MIT, USA)

Henri Uranus, PhD (UPH, Indonesia)

Budi Rahardjo, PhD (ITB, Indonesia)

#### International Advisory Board

Prof. Edy Tri Baskoro, PhD (ITB, Indonesia) Mark Baugher, MA (Cisco Systems, USA) Lakshminath Dondeti, PhD (Qualcomm, USA) Paul England, PhD (Microsoft Research, USA) Brian Haberman, PhD (Johns Hopkins University, USA)

Prof. Svein Knapskog, PhD (NTNU, Norway) Prof. Bambang Parmanto, PhD (University of Pittsburgh, USA) Dr. Kuncoro Wastuwibowo, IEEE Indonesia

Prof. Wishnu Prasetya, PhD (Utrecht University, The Netherlands)

Graeme Proudler, PhD (HP Laboratories, UK) Prof. Susanto Rahardja, PhD (NUS, Singapore)

Prof. Jennifer Seberry, PhD (University of Wollongong, Australia) Prof. Willy Susilo, PhD (University of Wollongong, Australia) Prof. David Taniar, PhD (Monash University, Australia)

# Technical Review Board

Moch Arif Bijaksana, MSc (IT Telkom, Indonesia) Teddy Surya Gunawan, PhD (IIUM, Malaysia)

Brian Haberman, PhD (Johns Hopkins University, USA)

Dwi Handoko, PhD (BPPT, Indonesia) Martin Gilje Jaatun, PhD (SINTEF, Norway)

Endra Joelianto (ITB, Indonesia) Mira Kartiwi, PhD (IIUM, Malaysia) Maciei Machulak, PhD (Google, USA)

Ihan Martoyo (UPH, Indonesia)

Jesus Molina, PhD (Fujitsu Laboratories of America)

Bobby Nazief, PhD (UI, Indonesia)

Anto Satriyo Nugroho, PhD (BPPT, Indonesia) Muhammad Suryanegara (UI, Indonesia)

Bernardi Pranggono, PhD (University of Leeds, UK)

Bambang Prastowo, PhD (UGM, Indonesia) Bambang Riyanto, PhD (ITB, Indonesia)

Andriyan Bayu Suksmono, PhD (ITB, Indonesia)

Setiadi Yazid, PhD (UI, Indonesia)

# **Internetworking Indonesia Journal**

- Home
- Journal
- Current Issue
- Submissions
- Contact

# IIJ Vol. 9 / No. 1 (2017)

Papers from the 2016 International Conference on Industrial Internet of Things

# **Guest Editors' Introduction**

Endra Joelianto, Augie Widyotriatmo and Arjon Turnip (PDF)

# **Accelerating IIOT Adoption with OPC UA**

Saju Eruvankai, Murugesan Muthukrishnan and Anantharamaiah Kumar Mysore (PDF)

# Management of Laboratory Work for Designing Manufacturing Phases via the Ethernet Connection Anna Antonyová, Peter Antony, and Endra Joelianto (PDF)

# Classification of EEG Signals for Eye Focuses Using Artificial Neural Network

Wahyu Caesarendra, Mochammad Ariyanto, Kharisma A. Pambudi, M. Faizal Amri, Arjon Turnip (PDF)

# Virtual Reality Flight Simulator

Kelvin Valentino, Kevin Christian, and Endra Joelianto (PDF)

### Peat Water Treatment based Wireless Data Acquisition System for Flexible Remote Monitoring

Arjon Turnip, Sutrisno S. Hutagalung, Imamul Muchlis, and M. Faizal Amri (PDF)

# **Behavior-Based Humanoid Robot for Teaching Basic Mathematics**

Widodo Budiharto and Anggita Dian Cahyani (PDF)

# A Business Architecture Modeling Methodology to Support the Integration of Primary Health Care: Implementation of Primary Health Care in Indonesia

Dwi Cahya Astriya Nugraha, Ismiarta Aknuranda, Sri Andarini, and Jack Roebijoso (PDF)

# Audit of Information Technology Governance Using COBIT 4.1: Case Study in PT. XY

Mayang Anglingsari Putri, Vivin Ayu Lestari and Ismiarta Aknuranda (PDF)

# **Backpropagation Neural Networks Training for EEG-SSVEP Classification of Emotion Recognition**

Arjon Turnip, Artha Ivonita Simbolon, M. Faizal Amri, Poltak Sihombing, Roby Harlen Setiadi and Edi Mulyana

(PDF)

# Development of Speech Control for Robotic Hand Using Neural Network and Stream Processing Method Ismoyo Haryanto, Mochammad Ariyanto, Wahyu Caesarendra, Hadianto K. Dewoto (PDF)

# Exploring Personality Prediction from Text on Social Media: A Literature Review Veronica Ong, Anneke D. S. Rahmanto, Williem, and Derwin Suhartono (PDF)

# **Usability Evaluation of E-Government: A Case Study of E-Finance** Vivin Ayu Lestari, Ismiarta Aknuranda, and Mayang Anglingsari Putri (**PDF**)

# Development of a Portable Location-Aware Wind and Solar Weather Logger for Renewable Energy Prospecting

Arko Djajadi, Jimmy K. Setiawan and Cepi M. Hanafi (PDF)

**Urban Traffic Simulation Using SUMO Open Source Tools** Muhammad Zaky, Davindra G. Airulla, Endra Joelianto and Herman Y. Sutarto (**PDF**)

Developing Learning Media of Teaching of 8051 Microprocessor in Data Retrieval to Support the ALFHE Darwis Robinson Manalu and Dahlan R.P. Sitompul (PDF)

Table of Contents and Covers: Vol. 9/No. 1 (PDF)

### **Open Access Publication Policy**

The *Internetworking Indonesia Journal* (IIJ) provides open access to all of its content on the principle that making research freely available to the public supports a greater global exchange of knowledge. This follows the philosophy of the Open Journal Systems (see the Public Knowledge Project at pkp.sfu.ca). The IIJ issues are published electronically (PDF) and there are no subscription fees. Such access is associated with increased readership and increased citation of an author's work.

#### No publication fees

There is no publication fees to authors for publishing in the IIJ. This is consistent with the open access philosophy adopted by the IIJ.

# Indexing

The IIJ is currently indexed by SCOPUS and Google Scholar. The contents of the IIJ issues are also covered by Elsevier.

#### **Publication Language**

The primary language of the IIJ is English. Note that the IIJ does not accept requests for the translation of submitted manuscripts.

# **Publication Ethics Statement**

# Development of Speech Control for Robotic Hand Using Neural Network and Stream Processing Method

Ismoyo Haryanto, Mochammad Ariyanto, Wahyu Caesarendra and Hadianto K. Dewoto

Abstract— The purpose of this paper is to develop speech control for robotic hand using voice input. The voice signal acquired by microphone is processed in real time using stream processing for handling large amounts of data. The processed signal is recognized using Neural Network with tansig and softmax transfer function in hidden layer and output layer. The Network consists of 20 neurons in hidden layer. Eight frequency domain and five time domain features are employed in speech recognition system. The recognition results from ANN are sent to Arduino Uno to drive the robotic hand motion. Based on the experiment results, ANN can recognize the voice command with 95.9% in offline recognition and 90 %. in online real time recognition. The proposed of speech control system was also tested in noisy environment. The overall accuracy of speech control decreases 10 % in noisy environment. Speech control for robotic hand using stream processing method has been successfully developed.

*Index Terms*—Robotic hand, Speech, Neural Network, Feature calculation, Stream processing.

# I. INTRODUCTION

ARTIFICIAL neural network have been widely used in pattern recognition, nonlinear regression, and control system due to its performance result. In this study, the research will develop speech control of robotic hand using stream processing method based on artificial neural network (ANN). The neural network has been successfully implemented in speech recognition as studied in literatures [1,2]. ANN can recognize the speech recognition with good performance. The other common classification methods are Hidden Markov models as in [3], support vector machines [4], and dynamic time warping [5].

Feature extraction is one of the most important steps in speech recognition system. It extracts useful features from the raw data which can help the classifier to make decisions. The common features that are commonly used in speech recognition are Mel Frequency Cepstral Coefficients (MFCC) and Linear Predictive Coding Coefficients (LPCC). In this paper, thirteen features that have been widely used due to its performance in Electromyography (EMG) analysis are employed in this speech control of robotic hand.

Manuscript received October 22, 2016.

I. Haryanto, M. Ariyanto and W. Caesarendra are with the Mechanical Engineering Department, Diponegoro University, Jl. Prof. Sudarto, SH – Tembalang, Semarang 50275, Indonesia (e-mail: <a href="issmoyo h@undip.ac.id">ismoyo h@undip.ac.id</a>; <a href="mailto:ari\_janto5@undip.ac.id">ari\_janto5@undip.ac.id</a>; <a href="www.wcasearendra@gmail.com">w.casearendra@gmail.com</a>).

Hadianto K. Dewoto was with the Mechanical Engineering Department, Diponegoro University, Jl. Prof. Sudarto, SH – Tembalang, Semarang 50275, Indonesia (e-mail: hadykun@gmail.com).

This paper will focus on developing a speech control of robotic hand using stream processing method. Stream processing is employed to handle large data that comes from acquired speech command. One of common challenges in speech recognition is the noise. In order to reduce the effect of noise, the sound from noisy room is recorded and added in data input for training data in neural network. The robustness of proposed speech system will be tested in quiet and noisy room.

# II. FEATURE CALCULATIONS

In this paper, thirteen features which comprises of eight frequency domain and five time domain features is selected and utilized in this study. These features have been found in many literatures giving the maximum classification performance in EMG analysis [6-8]. The frequency domain features are MNF, MDF, PKF, MNP, TTP, SM1, SM2, SM3. The time domain features are LOG, DASDV, MN, WL, ZC. The features can be summarized in Table 1. In frequency domain,  $f_j$  is spectrum frequency at frequency bin j,  $P_j$  is the signal power spectrum at frequency bin j, and M is length of the frequency bin. In time domain,  $x_i$  denotes the voice signal in a segment i and N represent the length of input signal Final Stage.

#### III. NEURAL NETWORK

Artificial Neural Network (ANN) is utilized in speech recognition system to recognize speech command from user. The general structure of ANN can be depicted in Figure 1. The structure of feed-forward ANN model comprises of three-layers of nodes. ANN is widely used to perform complex tasks such as control systems, pattern recognition, forecasting, identification, speech, and computer vision.

The first output neuron in hidden layer can calculated using equation (1) and the first output neuron in the output layer is defined in (2).

$$a^{\mathsf{I}} = f^{\mathsf{I}}(IWp + b^{\mathsf{I}}) \tag{1}$$

$$a^{2} = f^{2}(LW(f^{1}(IWp + b^{1})) + b^{2})$$
(2)

ISSN: 1942-9703 / © 2017 IIJ

# Accelerating IIOT Adoption with OPC UA

Saju Eruvankai, Murugesan Muthukrishnan and Anantharamaiah Kumar Mysore

Abstract— In this new era of pervasive computing and anytime, anywhere information, manufacturing industry has rightfully evinced lot of interest in adopting internet of things in significant measure. Industrial IoT adoption offers immense value for manufacturing across the value chain for many functions like material tracking, production performance, in-line quality inspection, asset maintenance, and to churn out new innovative service models. The OPC UA standard provides interoperability in industrial automation by creating and maintaining open specifications that standardize communication of acquired process data, alarm and event records, historical data, and batch data to multi-vendor enterprise systems and between production devices. This paper details out the challenges faced during IIOT adoption in a typical Automation industry and provides an OPC UA based framework to resolve these challenges and demonstrates the application of this concept in a proof of concept implementation of an OPC UA adapter. The results indicated better performance, superior integration capabilities as compared to a traditional industrial protocol gateway.

Index Terms—OPC UA, HOT, IT/OT Convergence, Data Analytics with OPC UA

# I. INTRODUCTION

Manufacturing industry is witnessing tremendous progress across the automation layers right from sensors to machines, controllers to machine systems, due to advancements in smart sensing, integrated electronics, communication technologies and development of micro/nano-electromechanical systems (MEMS/NEMS). This has led to Industrial Internet of Things (IIoT) initiative being a major component of Industrial 4.0 and Smart Manufacturing drive. Needless to mention these advancements will influence every industrial manufacturing domain be it process or discrete and calls for their calibrated adoption for creating and sustaining competitive market leadership.

The number of cellular machine-to-machine (M2M) connections in industrial automation applications is predicted to grow at a compound annual rate of 23.2 percent—from 2.5 million connections at the end of 2013 to about 7.1 million connections by 2018 [1]. With IoT devices projected to increase to about 3 devices per person in next five years, this domination of connected machines and sensor networks would only create more volume and veracity of data and the real

Manuscript received June 30, 2016.

Saju Eruvankai is currently with Advanced Engineering Group, Engineering Services, Infosys Ltd., India

Murugesan Muthukrishnan is currently with Advanced Engineering Group, Engineering Services, Infosys Ltd., India

Anantharamaiah Kumar Mysore is currently with Advanced Engineering Group, Engineering Services, Infosys Ltd., India.

challenge would be made to ensure accurate, real time visibility of the information for decision making and redefinition of the ecosystem. The information flows in industrial systems is increasing across all levels of the plant and the need is accommodate plant information for vertical, horizontal as well as across the lifecycle of production equipment [2]. It is indeed compelling the market players to acquire and create new business models to realize and tap the vast opportunities opened up by IOT.

However, there are significant concerns for adopting Industrial IoT solutions primarily around data security, reliability of data communication, interoperability and scalability. The concerns are primarily due to the fact that the hitherto employed proprietary interfaces for machine data collection, process systems, communication protocols with SCADA or their implementation might be exposed to vulnerabilities in an IIoT deployment scenario. Further the emergence of IT-OT convergence necessitates interoperability between Industrial devices. Devices also need to be programmed for firmware updates across its lifecycle and its access might need to be restricted based on the end user role and responsibility. Additionally the communication network should be able to handle requirements for reliable data connection even in case of temporary link failures. Many industrial IOT gateways provide the necessary bridge between shop floor sensor networks and traditional communication networks for connecting to the internet [3]. protocols like MQTT, CoAP, AMQP, XMPP, and JMS are adopted for connectivity. The IoT gateway functionalities have moved from the traditional technological interoperability to include aspects of remote configuration, dynamic provisioning, on the air software updates to information model based integration. OPC-UA facilitate industrial IOT through its scalable and secure service oriented architecture. The idea of RESTful extension of OPC-UA is also being mooted [4].

Infosys offers a versatile OPC UA based IIoT solution framework which has scalability right from individual sensor devices to sensor systems and connectivity across the automation network with applications in the enterprise. Furthermore, it offers valuable benefits with unique security safeguards along with standard based communication and interoperability. This article provides details about the Infosys solution for secure and reliable communication to address these problems faced by the industry.

ISSN: 1942-9703 / © 2017 IIJ

# Manufacturing Phases via the Ethernet Connection

Anna Antonyová, Member, IEEE, Peter Antony, and Endra Joelianto, Member, IEEE

Abstract—Management of pre-labelling phases in production the boxes, which are used as packages, requires office with the suitable environment for dealing with customers as well as the laboratory for the prototype production. To meet the requirements of the customers taking into account the possibilities of material, it is necessary to manage the testing the quality of corrugated paper, which is mostly used for production the boxes as well as testing the designed sample as prototype. Ethernet network can provide the suitable connection for transmission the data between office and laboratory. The connection includes especially plotter to design boxes and measurement devices to control the boxes quality. The devices as well as their connections were originally designed and constructed under the leadership of Peter Antony, as one of the coauthors.

Index Terms—Computer network management, Ethernet networks, Instrumentation and measurement, Testing

#### I. INTRODUCTION

NTERNET and in specific cases Ethernet applications have become an integral part of the present development. Also, the service sector is more widely available, for example through mobile applications [1]. Cloud computing plays an important role not only for services but also for global business in general [4]. Interactive Internet multimedia applications require also real-time communication including synchronization [3]. Professor Robert Štefko with his colleagues [5] stresses importance in setting the proper ways to manage the communication for detecting and solving demanding situations.

Embedded systems in connection with multimedia computing [5] are included in particular industrial applications. Managing proper connections especially between

Manuscript received July 1, 2016. This research was supported by the University of Prešov in Prešov International Research Grant no.4363-6-14/16 entitled "Modeling of Environmental Management Processes".

- A. Antonyová is with the Department of Mathematical Methods and Managerial Informatics, University of Prešov in Prešov, Faculty of Management, Prešov, 08001 Slovak Republic. (Mobile: +421-910435189; e-mail: antonyova@gmail.com).
- P. Antony, is with APmikro, Prešov, 08001 Slovak Republic (e-mail: peteantony@gmail.com).
- E. Joelianto is with the Instrumentation and Control Research Group, Faculty of Industrial Technology, Bandung Institute of Technology, Bandung, 40132 Indonesia (e-mail: ejoel@tf.itb.ac.id, corresponding author).

control and production parts of industrial processes may influence the resulting efficiency and safety of the manufacturing process [6]. In our previous work [7], we used Internet connection to set the parameters for the proper function of the water cleaner. It not only increased operational reliability but also security of the service.

Our new research aims to managing the modern laboratory with full functioning regarding the designing the prototypes of boxes with the Ethernet connection to the central office. Reliable data transfer is conditioned by several factors: the optical connection, the selected data system control as well as double data backup. However, each laboratory device has its own control system. The reliability of data transmission is superior to other parameters such as bit rate.

#### II. MATERIALS AND METHODS USED IN LABORATORY WORK

The company, where we realized our research, has its own laboratory to construct the prototypes of boxes as packages. The constructed boxes are subsequently tested regarding the quality of the used material as well as the finished product. The finished product is measured for their strength and quality parameters.

Figure 1 shows a plotter. Plotter is used for drawing, cutting and pre-labeling the samples for bending. All those operations are necessary to produce prototypes of boxes. Plotter was designed and constructed with Ing. Peter Antony, the coauthor, in such a way that it can be managed from the laboratory through a central computer with Linux operating system. For adjusting a typical process, a control via an infrared remote controller can be used. This feature is mainly used when setting the depth of cut, the initial operating point within the area of material and the depth of the bend. Draft drawings for prototyping boxes takes place in another part of the company's buildings, at the office.

The office is equipped especially for a better customer contact. The prototype of the box can be made as follows on the basis of specific customer requirements, in accordance with the appropriate choice of process flow as well as the possibilities of a certain material. Customer requirements influence the choice for a specific type of corrugated board which is usually used for the boxes production. Prototype testing is important also for the specific requirements such as wet environment for storage of goods in boxes, suitability of

ISSN: 1942-9703 / © 2017 IIJ