

Integrating Machine Learning Into Simulation Processes

Dr. Abdulrahman Albarrak

Department of Computer Science, College of Computer and Information Sciences, Imam Mohammad
Ibn Saud Islamic University (IMSIU), Riyadh, Saudi Arabia,
E-mail: aalbarrak@imamu.edu.sa

Abstract

In a simulation process, the size and level of details at which a physical, biological, social, or computational system is being modeled or simulated, is huge. Machine learning based approaches are adopted to handle simulation complexity, ML based approaches are indispensable for the majority of applications in real life. The ML simulation merges rule-based and data-driven models in the attempt to furnish systems that are more adaptable, efficient, and precise. It is a hybrid model that gives more power to hard-coded parameter-based simulation models as these models learn and adapt from data in real-time. This paper considers machine learning-based simulation methods in the spheres of methods, application, problems, and future research. Simulation using ML is the shift of thinking from deterministic modeling to learning-type adaptive systems that can best accommodate uncertainty, complexity, and dynamic conditions more so than traditional models.

Keywords: Machine Learning, Simulation, Data-driven modeling, Hybrid systems, Real-time adaptation.

1. Introduction

Simulation presents a significant level of complexity, as it endeavors to replicate real-world systems that are frequently nonlinear, dynamic, and unpredictable. The intricacy of simulation processes arises from two main sources: the intrinsic complexity of the real-world system that is being represented and the complexity that is introduced through the construction and execution of the model. The integration of machine learning in simulation processes is a cutting-edge approach that is used to make simulations more realistic, predictive and adaptive. This integration is transforming areas such as the supply chain, manufacturing, finance, health care, urban planning and autonomous systems. Given that simulation aims to model reality as accurately as possible, complexity inherently emerges from the requirements for precision, scalability, and decision-making support. Incorporating Machine Learning (ML) into Simulation Processes results in a robust hybrid methodology that improves the functionalities of both technologies. This paper systematically examines hybrid approaches that integrate ML into the simulation process considering the challenges of design, and analysis.

1.1 Problem Statement

One cannot underestimate the power of simulation as a tool in the respective system with which people would envision a system, predict outcomes, and generally optimize funds in diverse types of disciplines. Process simulation, for example, will always be an operative aid in decision-making (Martin et al., 2016) and yet it has its constraints which will translate into direct handicap to strongly complex, dynamic, and uncertain real-world environments in their applicability. Such traditional methods tend to rely upon pre-specified mathematical formulas, hardcoded parameters, and rule-based systems that may not be capable of handling variability and nuance in complicated systems.

The primary problems with traditional simulation methods are their inflexibility to modify to changing situations, poor performance in dealing with incomplete or noisy data, and inability to simulate systems with unknown or only partially known underlying processes. Business process simulation model discovery from event logs has emerged as an answer to these shortcomings (Camargo et al., 2020). Moreover, since systems and data are becoming more complex in their exponential growth trend, complexity in the use of traditional simulations in computation and modeling is usually not possible.

The introduction of machine learning provides unparalleled opportunity to bridge these limitations through the introduction of adaptive, data-driven capability to simulation processes. Recent breakthroughs in simulation model discovery based on process mining (de Leoni et al., 2023) look promising, although integrating ML into simulation is not free of issues with obstacles like the simulation-to-reality gap, data quality problems, computational scalability problems, and need for proper validation methods.

1.2 Purpose of Applying Machine Learning to Simulation Processes

Usage of machine learning in simulation processes has the purpose of obtaining a broad range of main objectives, which solve the ineffectiveness of current methods and introduce new functionality in modeling complicated systems. The most important reasons are:

1. **Higher Accuracy and Higher Reality:** Simulations based on ML can learn from real-world data to enhance model precision and reduce the difference between simulated and real-world results. The more recent works in learning business process simulation models that refer to automated process discovery and deep learning demonstrate better prospects for high accuracy (Camargo et al., 2022). By using data-driven learning algorithms, the systems are able to identify complex patterns and relationships that can be difficult or impossible to detect with standard mathematical methods.
2. **Real-Time Adaptivity:** Unlike static traditional simulations that hitherto has been widely used, ML-Augmented systems can 'learn' and adjust to new circumstances, data and changing system behavior real-time. Efficiency of adaptation in real-time is an essential requirement for applications that include those with the need for real time decision support and dynamic response. Predictive business process monitoring supported by the use of LSTM neural networks is a clear case in point (Tax, Teinmaa et al., 2017).
3. **On Uncertainty and Incomplete information focus:** Neither-impossible-nor incomplete information is not issue for machine learners, and there is no big wall between the simulations and real world that has imperfect information. Deep learning was also found to be effective in addressing such uncertainties in the predictive modeling of process behavior (Evermann et al., 2017).
4. **Computational Saving:** Although training ML models is computationally expensive, the trained models can lead to fast inference and much reduced computational expense of sophisticated simulation given enough use cases or similar settings. Artificial neural

2. Background

2.1 Simulation Processes

The process management concepts constitute a foundation from which simulation methods of today are known (Dumas et al., 2013). Traditional simulation methods can be broadly categorized into different types, including discrete event simulation, continuous simulation, agent-based modeling, and Monte Carlo simulation, each applicable to particular requirements and fields of application.

Discrete Event Simulation (DES) portrays systems as a sequence of events at specific points in time and is therefore highly applicable to simulation of queuing systems, manufacturing processes, and service processes. Event logs are today the standard for discrete simulation and business process modeling (Khodyrev & Popova, 2014). DES is extensively used in operations research and industrial engineering problems involving changes in system state as discrete points in time.

2.2 Machine Learning and Simulation

Machine learning is a field of artificial intelligence that keeps algorithms and statistical models which enable computer systems to learn and improve in a specific task by experience and data analysis without explicit programming for every situation. The field has evolved and increased significantly, particularly with deep learning, reinforcement learning, and ensemble methods. Machine learning is used to handle different issues in the simulation process model (see Figure 1).

Predictive Process Monitoring is the most exposed machine learning deployment in process environments. Predictive process monitoring is an area that provides the complete focus to ML deployments in process monitoring (Di Francescomarino & Ghidini, 2022). LSTM neural networks have been employed successfully for predictive business process monitoring processes (Tax et al., 2017).

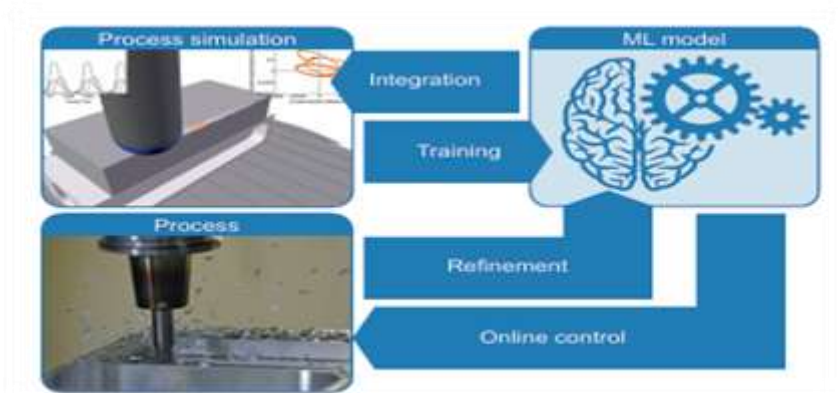


Figure 1: Concept of combining simulation and machine learning

Deep Learning to simulation has been of specific interest. Deep learning process behavior prediction shows the capability to identify advanced patterns in process data. (Evermann et al., 2017). Artificial neural network patient-focused appointment scheduling design and discrete event simulation are beneficial examples of application (Chang & Chang, 2018).

Neural Networks employed for Simulation Control perform well in manufacturing as well as operating environments. Simulation-based manufacturing control artificial neural networks provide improved system performance (Camargo et al., 2022). Simulation and machine learning for prediction of response time in processor-sharing queues are promising for queueing systems (Pender & Zhang, 2021).

TensorFlow integration has improved ML-simulation integration. Intelligent process empowerment in simulation through TensorFlow deep learning capability provides real-world implementation recommendations (Fuente et al., 2018). Integration enables the development of smarter and stronger simulation systems.

Data-aware process states are current research topics in the hybrid of ML and simulation. Data-aware process states research on activity probabilities in simulation models is aimed at enhancing accuracy (de Leoni et al., 2023). Machine learning and simulation runtime hybrid of business processes is newer research (Meneghello et al., 2023).

The meeting of these ML approaches with simulation technology brings with it the potential to construct hybrid systems that retain conventional models' interpretability and domain knowledge but also machine learning's flexibility and pattern search ability.

3. Simulation process Design

3.1 Environment Design

Environmental design in machine learning-based simulation systems is an elementary construction unit that determines the effectiveness, scalability, and usability of the overall simulation system. Design is a process of training to specify virtual environments that not only mimic actual systems but also expose the proper interfaces for machine learning algorithms to function, learn, and update.

Multi-fidelity Environment Architecture was a fresh approach to trading off simulation fidelity and expense. Modular Environment Framework accommodates dynamic and reusable simulation modules for the environment that are created and reconstructed in a similar manner for diverse applications and situations. Rapid prototyping, component reuse, and systematic testing across numerous conditions and scenarios are facilitated by such modularity. Process discovery concepts provide theoretical foundations for modularity in environment design (van der Aalst, 2022).

Dynamic Environment Adaptation allows simulation environment complexity, parameters, and structure to change at runtime based on imbedded ML models' learning path. The adaptive feature enables the environment to provide appropriate challenges and learning opportunities during training. Data-aware process mining processes further enhance this adaptive feature by having decision-making within processes be transparent through alignments (Estrada-Torres et al., 2021).

Clustering-Based Environment Configuration provides the means for the creation of different training scenarios. (Di Francescomarino et al., 2019).

3.2 Data Augmentation and Generation

Data augmentation and generation techniques are the heart of ML-augmented simulators, solving the general problem of low-frequency or scarce training data and improving model generalizability and strength. They are particularly indispensable in simulation contexts where real-world data acquisition is too expensive, dangerous, or prohibitive.

Process Log Augmentation utilizes actual event logs and mixes artificially generated process data with statistical trends and attributes of relevant actual process runs. Cycle time forecasting models provide standards for the identification of temporal patterns in process data (Estrada-Torres et al., 2021). The technique provides synthetic data that includes realistic process attributes to develop ML models that are consistent.

Applications of Generative Models Process environments also have been novel applications of generative models. Successful LSTM models of business process training proves the ability to generate realistic process sequences of (Camargo et al., 2019). These types of generative approaches can generate substitute process scenarios without violating observed process trends.

Forecasting-Based Augmentation applies time series forecasting for process data augmentation. Scalable forecasting at scale accomplishes supply scalable approaches to generating temporal process data (Taylor & Letham, 2018). It is particularly well-suited for generating longer process sequences and inferring temporal change.

Knowledge-Driven Feature Engineering unites domain knowledge and data-driven techniques. The process from knowledge-driven to data-driven inter-case feature engineering is the direction toward more automated enrichment methods (Senderovich et al., 2021). The combining strategy benefits from both expert and automated discovery for all-around data enrichment.

Multi-modal Data Fusion combines different sources of process data to offer extensive training sets. The method is based on the expectation that different kinds of data contain complementary information, which can be utilized to create more complete and robust training examples for ML models when in combination with process simulations.

ML-based simulation frameworks (see Figure 2) to address the innate challenges of data unavailability, privacy, as full coverage needs for uncommon or outlier process conditions. Cutting-edge synthetic data generation methods enable the generation of realistic, diverse, and statistically representative process data sets that can serve as the basis for accurate model training and validation.

Generative Process Model Architectures have been proposed and new architectures of neurons have been proved to show immense potential in creating high-quality synthetic process data. Accurate business process simulation models learning exhibit the possibility of generating highly realistic process sequences (Camargo et al., 2022). These architectures are able to learn hard-to-model process distributions and generate data that preserves statistical properties of real process datasets.

Conditional Process Data Generation allows synthetic process data to be generated on a condition, scenario, or business requirement basis. It is best suited for application to process simulation scenario applications where process scenarios of a certain type must be created for targeted training or test processes.

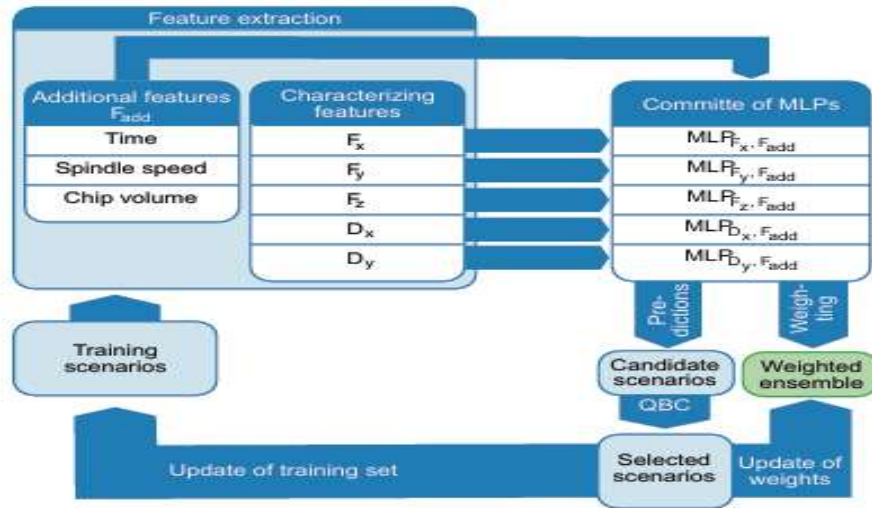


Figure 2: Data acquisition and prediction framework

3.3 Model Training

Model training in simulation environments with ML requires distinct methods that can deal with the specific issues, challenges, of simulation environments. Training must find a balance between model accuracy, computational cost, and a generalization ability under the specific nature of simulation data.

Curriculum Learning was shown to perform incredibly well in process simulation environments where difficulty of a process in training instances can be increased systematically while models are learning. The method starts from easy-to-handle process models and gradually introduces progressively more difficult scenarios, edge cases, and real-world ones. Curriculum learning avoids early convergence to poor solutions and improves overall model performance at process prediction tasks.

Transfer Learning allows the use of pre-trained models in a new process domain to analogous process applications with minimal further training. Transfer Learning is especially useful in process simulation applications where custom models for each process domain have to be built from scratch at time or resource expense. Pre-trained process models can be great places to start for expert processes without taking up training time and data.

LSTM-Based Training has particularly performed well in process situations. Valid LSTM representations of business processes enable training sequence-based models from process data (Camargo et al., 2019). These techniques represent temporal dependencies necessary for process behavior prediction.

Multi-task Learning allows a single model to learn multiple related process tasks at once in simulation contexts and achieve improved training and generalization. Multi-task Learning is especially useful when process simulation contexts have more than one related goal or models need to be able to perform more than one task in the same process system.

Active Learning methods facilitate process training optimization through the intelligent choice of most helpful process examples from large simulation sets of data. The method is able to lower training time and computational expense without reducing or compromising model precision in process prediction tasks.

Domain-specific Regularization Techniques are used to prevent simulation-specific pattern fitting rather than generalization to real process conditions. Regularization Techniques encompass process-conscious regularization techniques to allow models to learn solid and generalizable process patterns rather than simulation-specific outliers.

3.4 Testing and Validation

Verification and validation of ML simulation systems are issues that demand compound solutions to traditional simulation validation and verification of ML models. The hybrid systems need validation methods that ensure component dependability and system performance.

Cross-domain Validation is the term used to describe testing trained models against alternative process conditions and actual operating conditions for generalization capability. Cross-domain validation detects likely overfitting to individual simulation conditions and facilitates correct performance when exposed to scrambled operating conditions. Cross-domain validation is particularly required for safety-critical process applications where model dependability across conditions is critical.

Hierarchical Testing Frameworks employ greater than one level of verification spanning from unit testing of individual ML components to integration testing of the system as a whole. Hierarchical testing frameworks ensure each component works independently correctly and verify whether the integrated system meets generic performance requirements.

Process-Aware Validation utilizes process domain knowledge within validation processes. Data-aware process state discovery on activity likelihood has been used to solve validation issues relevant to process simulation models (de Leoni et al., 2023). The process ensures processes of validation are in accordance with business rules and process semantics.

Runtime Validation maintains ongoing monitoring of model performance at runtime deployment. Runtime combining simulation and machine learning with business operations facilitates real-time development and testing (Meneghello et al., 2023). Continuous validation is required to enable system dependability under changing operating conditions in tackling the above challenge.

Statistical Process Validation applies statistical prediction capacity and process reliability determination techniques to a large extent. Statistical techniques provide quantitative system performance measures and demarcate areas of process improvement in process-specific tasks.

Process validation in the real world is the ultimate test for ML-based process simulation systems, wherein simulated predictions are validated against real process performance. Real-world process validation is subject to rigorous experimental design and statistical analysis to overcome the unavoidable differences between simulated and real-world process conditions.

The challenge is much harder with adaptive process systems that evolve their behavior over a time interval. Process verification techniques may not necessarily apply in systems that learn every day and evolve based on emerging business needs.

Final hypothesis testing in ML-based simulation systems finishes the process of system development and verification and provides final evidence or proof of system capability, limitation, and reliability. Verification involves rigorous statistical testing, extensive testing, and cautious interpretation of results at this stage.

4. Transfer to Real World

Incidentally, the biggest and most challenging problem throughout the entire process of development is the deployment of ML-based simulation systems to real-world applications. Deployment means overcoming the simulation-to-reality gap without any compromises on model performance, safety, and reliability in diverse real-world environments.

Process Domain Adaptation fills the gap between process running simulated and process environments real with a sequence of processes made up of adaptive development methodologies and statistical alignment. Gradual Process Deployment is the deployment of ML-enabled systems into real process operations in phases, starting with low-stakes process tasks and increasingly deploying higher-stakes functions as confidence and validation are obtained. It facilitates close monitoring, tuning, and learning on deployment.

Hybrid Human-Process Systems combine human control and monitoring capabilities and automatic ML decision-making with safety nets and domain knowledge in the transition from simulation to reality. The systems have human control of process-critical decisions but use ML for efficiency and performance optimizations.

Real-time Process Adaptation enables systems in deployment to learn and enhance repeatedly from real process experience, with performance and reliability growing progressively better over time. Adaptation mechanisms must balance process stability and adaptation rate so that operational behavior is not compromised.

Process Safety and Failsafe Systems will be deployed with the ability to detect off-nominal process operation, recover to nominal safe operating conditions, and alert human operators when ML systems detect process conditions outside those encountered during training.

Continuous Process Learning systems enable learning by long process run with stability of operations guaranteed. Long-term learning ability is required in support of changing business needs and varied operating conditions.

5. Empirical Function Support of ML Models

Empirical function verification of ML models provides a mandatory link of data-driven learning to process knowledge, providing theoretical foundation and practical constraints that allow models to be progressively sound and interpretable. Synergy provides the potential of ML models being integrated with understood process principles and enabled optimal data-driven flexibility.

Process-Informed Neural Networks embed process rules, constraints, and empirical relationships within models of neural networks in a manner such that learned models by

them adhere to fundamental process principles and learn data-dependent patterns. It has been an effective alternative for process prediction tasks where knowledge regarding a domain must be maintained.

Empirical Process Constraint Integration is the integration of established process relationships and business rules as constraints in ML optimization processes. Constraints direct learning to process-meaningful solutions instead of process-infeasible or unruly process operation.

Hybrid Process Modeling combines neural network learning and symbolic process reasoning to enable the capability of systems to learn to use automatically empirical process correlations without degrading business semantics and interpretability. This combines the strengths of conventional process modeling and the strengths of contemporary ML practice.

Multi-level Process Integration uses empirical functions to cover gaps across levels of process analysis, from activity prediction up to end-to-end process outcomes. Integration makes end-to-end modeling feasible for process systems of complexity with computational tractability.

Process Uncertainty Propagation establishes behavior of process uncertainty in empirical relations and effect upon aggregate model prediction, e.g., informative information regarding risk assessment and decision-making in real-world process applications.

Decision Point Integration combines decision mining output with meta-learning ML models such that learned behavior does not trivialize specified decision patterns. Decision mining approaches offer a foundation for leveraging decision logic within ML-based process systems (Rozinat & van der Aalst, 2006).

6. Constraint-based Learning

Constraint-based learning in simulation systems with ML provides the promise of having domain knowledge, process rules, and operational constraints expressed in learning constraints. It therefore enables keeping learned models within operating specifications boundaries while performance specifications are being optimized.

Hard Process Constraints are strict commitments to be met regardless of all other circumstances, i.e., safety or regulatory or mandatory business commitments. They are maintained by the medium of exceptional optimization techniques, penalty systems, or design changes that prevent constraint violations in process circumstances.

Soft Process Constraints are strict rules or tendencies that should be adhered to if at all feasible but would in certain instances be broken. The constraints are typically addressed by penalty term weight factors or multi-objective optimization approaches which compromise constraint satisfaction for process improvement.

Temporal Process Constraints are constraints that span several process steps or time periods, e.g., resource constraints, causality constraints, or stability of a process over long time periods. These constraints require learning algorithms particularly suited to handle sequential dependencies and long-term influences of a process.

Multi-agent Process Coordination occurs when multiple ML agents share a common process simulation environment and require coordination processes to meet both individual agent constraints as well as global process objectives.

Dynamic Process Constraint Adaptability facilitates dynamic, evolving definitions of constraints according to operating modes, process states, or learning outcomes. Dynamic business situations subject process systems to such variation since statically specified process constraints may become overly restrictive or outdated.

Process Compliance Integration guarantees conformity to regulation and business rules in acquired behavior. It finds utility in process use when non-compliance results in adverse legal or business consequence.

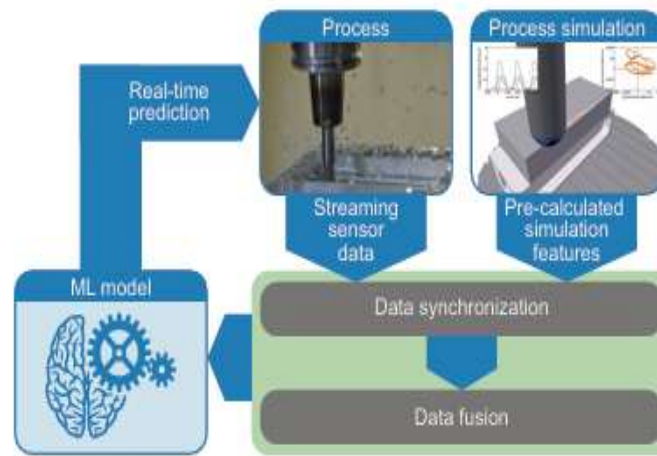


Figure 3: Framework for synchronizing and fusing simulation and sensor data

Multi-modal Process Data is the need for process datasets of different kinds of process data, such as activity sequences, resource information, timestamps, and case attributes as in Figure 3. Strong generative models are able to generate coherent multi-modal process datasets with intra-data-type as well as intra-process-domain consistency.

Process Quality Evaluation requires advanced measures and methodologies that not only capture statistical proximity to real process data, but also utility of simulated data to subsequent process analysis activities.

7. Virtual Test beds

Virtual testbeds are cutting-edge simulation-based experimentation, verification, and optimization platforms for simulated but real controlled environments of ML-based systems. Virtual testbeds provide useful intermediate steps between mere simulation and real release, with the sanctum of high-intensity system testing.

High-fidelity Process Environment Modeling produces testbeds that may reproduce real process environments, whether it is resources scarcity, organizational design, or operating

culture. Sophisticated process modeling techniques produce realistic test cases for virtual testbeds process-based applications.

Process Scenario Generation feature enables virtual testbeds to dynamically generate sets of varied test scenarios like unforeseen events, bottlenecking scenarios, and stress scenarios which cannot or do not exist to simulate in real process environments. The feature supports exhaustive testing across varied process scenarios.

Real-time Process Performance Monitoring provides real-time process behavior, performance measure, and trouble detection analysis during virtual testing. High-end monitoring enables systematic process trouble identification and performance tuning. Scalability and Process Parallelization capability enables concurrent multiple process tests, parameter sweeps, and comparison analyses to be efficiently handled by virtual testbeds. Such scalability is unavoidable for process system intensive analysis.

Real process system integration by process-in-the-loop techniques provides for the integration of real process hardware into simulated testbeds with scripted testbeds. Real process system integration is rigorous verification of virtual testbed output against actual process response.

Process Compliance Testing tests ML-based systems for business rule compliance and regulatory process compliance under a variety of test scenarios and operating conditions.

8. Reinforcement Learning Environments

Reinforcement learning environments are simulation software especially created to provide training, testing, and optimizing RL agents in process settings. The environments provide the medium to construct intelligent agents with the capability to learn optimal process behaviors through experience and interaction.

Multi-agent Process Learning systems may be employed in the learning of a network of interacting agents with diverse process stakeholders in an effort to design cooperative and competitive process improvement systems. The systems are to be designed with sophisticated coordination mechanisms as well as reward schemes that would propel favorable process outcomes.

Process Curriculum Design enables process complexity and challenge development as a leadership role in process elemental tasking to elevated levels of process optimization behavior. Process Curriculum Design has been used with breathtaking success in high-strength, generalizable process management skill design.

Process Reward Engineering techniques enable reward functions to be designed that constrain desired process behavior to defect-free forms such as reward hacking or bad process solutions. Intelligent reward design entails being familiar with the process domain as well as considering business constraints.

Process Environment Randomization methods allow RL-trained agents to generalize under real process conditions by training them in varied training conditions. Efficient learning is facilitated, and overlearning to certain process simulation conditions is prevented through controlled randomization of the process parameters.

Process Safety Integration allows for learning safe process behavior and compliance with operational limits by RL agents during training and deployment. Safe RL process strategy entails constraint satisfaction and learning performance preservation processes.

Dynamic Process Adaptation enables modification of RL environments with respect to changing process requirements and conditions so that trained agents can conform to new business requirements and operational constraints.

9. Real-world Applications

9.1 Autonomous Vehicles

Autonomous vehicle simulation based on machine learning has revolutionized autonomous system development, testing, and validation. Machine learning-based simulation tools provide safe, scalable, and economical platforms on which autonomous vehicle technology can be developed, tested, and validated for an enormous number of driving scenarios and conditions.

Perception System Training makes use of simulation sensor data from radar, LiDAR, and cameras for training ML object detection, classification, and tracking models. Simulation platforms offer realistic sensor data replicating weather, lighting, and traffic conditions. Physics-based sensor simulation enables trained models to mimic the complexity and limitation of actual sensor systems.

Simulated worlds that mimic heavy traffic, road geometries, and other unexpected situations greatly enhances Path Planning and Decision Making algorithms. Simulation enables simulation of millions of driving situations that would be too expensive or risky to reproduce in the physical world. by RL-based training

ML-based simulation systems can automatically build difficult scenarios while yielding statistical coverage of the safety-critical conditions needed. Safety Testing and Verification leverages synthetic scenario generation for generating full test suites for edge cases, near-miss cases, and rare cases of the utmost significance in safety analysis.

9.2 Molecular and Material Science

Drug Discovery and Development employs ML-assisted molecular simulations for drug-target interaction prediction, molecular property optimization, and candidate therapeutic molecule screening. Generative models propose novel molecular structures and physics-constrained simulations estimate their feasibility and properties.

Material Property Prediction employs ML algorithms, pre-trained on simulated data, to predict material properties from molecular structure, allowing for high-throughput screening of candidate materials for desired applications. The approach significantly shortens the discovery timeframe at substantially lower experimental costs.

Protein Folding and Function Prediction employs sophisticated neural network architecture and molecular dynamics simulation for predicting protein structures and functions. Recent developments in protein structure prediction illustrate the potential of ML-enabled solutions to solve difficult biological problems.

9.3 Robotics

Simulation-based deployment of ML-enabled robotics revolutionized robot development, learning, and deployment across domains from industrial manufacturing automation to service robotics. Simulation is a secure, scalable environment where sophisticated robotic behavior and capability can be developed.

Manipulation and Grasping skills are learned from training in simulated worlds that model object properties, contact physics, and sensor measurements. State-of-the-art physics simulation engines allow contact force, friction, and object deformation to be realistically modeled. Navigation and Localization models are learned from various simulated worlds that model varying terrains, obstacles, and sensor conditions. Domain randomization techniques are applied to train models such that models generalize well to the real world.

Human-Robot Interaction training utilizes simulated social worlds and replication of human behavior to educate robots to behave naturally, securely, and economically in various situations.

9.4 Supply Chain Optimization

Supply chain optimization from ML-based simulation provides knowledge in dealing with intricate, dynamic supply chains and uncertainty, disruption, and optimization problems. These systems incorporate conventional supply chain modeling with adaptive ML capability.

Demand Forecasting combines multiple data sources and machine learning predictive models with supply chain simulation for optimal demand precision and lowest inventory expense. Historical precedent and scenario-based models created using simulation-trained time-series model predictions provide effective demand forecasting.

Distribution and Logistics optimization algorithms utilize RL agents that learn from simulated supply chain scenarios to ascertain the most effective routes, scheduling, and resource allocation. They learn to optimize through experience and minimize mistakes over time under dynamic conditions.

Risk Planning and Resilience entails developing scenarios and stress testing vs. test supply chain scenarios to recognize vulnerabilities and develop contingency plans. ML models can be utilized for predictive modeling and minimizing the impact of various disruption scenarios.

9.5 Healthcare

Uses of ML simulation in the medical field vary from education and training of health care workers to drug development and treatment planning. Applications leverage simulation capabilities to circumvent ethical, safety, and cost concerns in health care applications.

Medical Training and Education employs human-simulating patient simulations and ML models to provide secure, reproducible training settings for health care staff. Virtual patients can be offered representative symptoms, treatment response, and disease progression patterns.

Treatment Planning and Optimization integrates patient-specific simulation with ML prediction capability in a way that optimizes treatment plans and predicts outcomes. Patient-

specific simulation models allow physicians to contrast various treatments and choose optimal practices.

Epidemic modeling and Public Health applications utilize ML-based simulation to simulate disease spread, contrast intervention tactics, and inform public health intervention. Models use various data sources and have the ability to react and adjust in various scenarios in times of health crisis.

9.6 Defense

ML-supported simulation defense applications range from training, strategy development, and system test needs through security and safety needs. Such applications require high-level models of advanced, adversary systems and multi-agent behavior.

Strategic Planning and Wargaming employs ML-supported simulation to mimic complex scenarios, test strategies, and provide for decision-making processes. High-level agent-based models simulate numerous actors and how they behave in realistic conflict environments.

Training and Simulation systems provide simulated, responsive training environments to warfighters, including ML-based opposing forces and dynamic scenario generation. They are intended to react to trainee performance and provide tailored learning experiences.

System Development and Testing uses ML-augmented simulation to support defense system development and testing in real-world and secure settings. Virtual test capability offers end-to-end testing with security and cost benefits.

9.7 Weather and Climate Modeling

Weather and climatic forecasting is probably the most challenging application of ML-augmented simulation, where physical climate models are paired with ML-conformable forecasting and pattern recognition. This application addresses in terms of needing more accurate and computationally less expensive climatic forecasting.

Short-term weather forecasting integrates ML models with traditional numerical weather prediction models for enhanced forecasting and range of prediction.

9.8 Gaming

ML-enabled simulation Game applications have transformed game development and gaming experience with more naturalistic, dynamic, and interactive virtual worlds. They demonstrate the entertainment and education value of next-generation simulation technology.

Procedural Content Generation uses generative models to construct diverse, high-quality game content like levels, quests, and narratives. ML-based content generation provides unlimited variety without any compromise in quality and coherence.

Player Modeling and Personalization uses ML analysis of user behavior to personalize game play, manage difficulty levels, and provide content on recommendation. Such systems improve player satisfaction and retention.

Non-Player Character (NPC) Behavior Building implements RL and behavior modeling to develop intelligent, responsive NPCs that participate in realistic, dynamic game-playing experiences. The NPCs acquire knowledge from the player's actions and modify their plan accordingly.

10. Challenges

10.1 Simulation-to-Reality Gap

It triggers performance deterioration, emergent behavior, and safety problems as systems are simulated and then employed in real worlds. Simulation-to-reality gap is most likely one of the most basic problems in ML-embedded simulation systems, the validity of the difference between simulated and actual worlds.

Model Fidelity vs. Computational Efficiency Trade-offs are still the challenge to be addressed in the realistic simulation vs. computationally tractable requirement trade-off. Models of high fidelity, realistic descriptions require significantly more computational resources, whereas low fidelity models must compromise on crucial features of real behavior.

Process Modeling constraints are used when defining validity in process simulation contexts, particularly in human behavior simulation, resource dynamics, and organizational constraints. Poor process simulation can lead to learned behavior that is outstanding in simulation but fails to be exceptional when implemented in real life due to differences in the human decision-making mechanisms, availability of resources, or organizational policies.

Environmental Unpredictability and Variability Environmental unpredictability and variability in real-world environments are generally greater than realistic to simulate. Organizational behavior, policy change, human behavior variability, and system development are aspects of variability difficult to properly model in process simulation.

Domain Randomization Approaches have all been partial solutions to the simulation-to-reality challenge, but learning best randomization parameters and that randomization improves and does not worsen real-world performance is still a challenge.

10.2 Synthetic Data Bias

Bias in "synthetic" data is an inherent problem that can reinforce and "amplify" existing biases as well as introduce new classes of systematic error into "ML-embedded" simulation systems. Detection and compensation of the biases are central to building equitable "fair", reliable, and resilient "systems".

Training Data Bias Propagation is the impact that results from biases included in the first set of process logs being amplified by using generative models to generate synthetic data. Historical biases, sampling biases, and representation gaps can be amplified instead of addressed through synthetic data generation. Process mining methods need to be extremely careful concerning the possibility of bias in event log data (van der Aalst, 2022).

Limitations of Generative Model The limitations can introduce systematic biases through model architecture design choices, training, or optimization targets. Mode collapse, training instability, and architectural constraints can potentially provide simulated process data that is not representative enough of the whole range of realistic process conditions.

Synthetic process data renders it difficult to detect and quantify biases in such data, particularly where the biases are nuanced or sophisticated with downstream ML models. Intrinsic methods of bias detection may not be appropriate for process-specific applications of synthetic data.

Process Fairness Problems are particularly difficult to resolve if abstract process data are used to obtain decision mechanisms affecting multiple stakeholders or organizational subunits. It is always difficult to ensure fairness for all such groups at the expense of process performance.

10.3 Control Condition and Function Regularity

Trade-offs between Stability and Adaptability balancing include contradictions between providing process stability and enabling ongoing learning and adaptation. Systems must balance the desire for stable, predictable process behavior with the capacity to change and learn to improve in response to evolving business circumstances.

Process Constraint Satisfaction is demanding where ML models need to satisfy several, possibly conflicting process constraints simultaneously to optimize performance goals. Guaranteeing learned behavior within tolerable business boundaries necessitates proficiency in high-level constraint management.

Function Approximation Quality affects process systems that use ML in their reliability and predictability, particularly in such applications where neural networks are used to approximate intricate process functions that must maintain a property such as regulatory compliance or business rules compliance.

10.4 Computational Complexity and Scalability Challenges Computational complexity and scalability challenges limit the practical implementation of ML-integrated simulation systems, particularly for real-time large-scale process applications. Some of these challenges involve computational resource requirements and algorithm complexity problems.

Computational Requirements For larger, more complicated ML models combined with high-fidelity process models, computational demands can be extremely expensive in custom hardware, distributed processing, and lengthy training times. Computational cost does not generally increase linearly with data volume and process complexity.

Real-time Process Inference Constraints put constraints on the complexity of ML models that can be passed on to real-time process solutions. There is always a challenging trade-off between model complexity and inference speed requirements in all scenarios, particularly in sub-second response time business processes.

Memory and Storage ML-based process simulation systems are computationally intensive for large process state spaces, large neural networks, or large process data sets. Equilibration of these loads so that the system is under these loads is required.

Distributed Computing Scalability ML-based process simulations on multiple nodes of computers are challenging, e.g., communication overhead, synchronization, load balancing, and fault tolerance in process-oriented distributed systems.

Model Optimization and Model Compression techniques ease computational challenges at the expense of model capability or accuracy. Effective compression techniques that preserve the essence of process modeling capability and reduce computational requirements are a challenge.

10.5 Ethical Considerations

Ethical concerns in ML-environment simulation systems belong to a broad category of problems that pertain to fairness, transparency, accountability, and societal impact. They are given more weight in consideration of the reality that the systems are being utilized more in application contexts that affect and impact the well-being of human beings and organizational decision-making.

11. Conclusion

The infusion of machine learning into simulation workflows is an applied science revolution that is at its very essence of more or less flipping on its head how we simulate, learn from, and optimize complex systems in nearly every domain. This overview of the big picture has mapped the approaches, applications, complications, and potential of this new frontier technology, and in doing so both the tremendous potentiality and inherent complexity involved with this marriage of technologies has been made evident.

Technological innovation in ML-enabled simulation has achieved record breakthroughs across several fields. The development of advanced environment modeling tools, new data augmentation techniques, and novel training paradigms has enabled it to build simulation systems much better than the traditional approach. Incorporating process-guided learning, constraint-based optimization, and multi-fidelity modeling has provided solid foundations for building trustworthy, interpretable systems that combine the merits of data-driven learning and domain knowledge.

Process Mining Integration has been an immensely successful innovation, with automatic simulation model discovery of business processes from event logs allowing for new opportunities for data-driven process modeling (Camargo et al., 2020). From data-driven to knowledge-driven is a paradigm shift for process knowledge and process system optimization (Senderovich et al., 2021).

Successful application across a broad spectrum of fields from autonomous transportation to medicine demonstrates the broad applicability and usefulness of ML-based simulation techniques. All of these applications have realized revolutionary improvements in accuracy, productivity, and responsiveness over traditional approaches and have enabled entirely new things that were previously impractical or impossible. The ability to handle uncertainty, adapt in real time to evolving conditions, and learn in general from experience has been particularly valuable in complicated, dynamic environments.

Technical Challenges for this survey are indicative of the advancement of being in a position where simulation and ML technology can be seamlessly integrated. Simulation reality gap is a long-standing challenge that needs ongoing R&D. Synthetic data bias, computational scalability, and system reliability vs. adaptive capability are all new technical challenges that need innovative solutions.

Process-Specific Issues have been recognized as important for effective deployment. Effective analysis of data-aware process states and their influence on simulation correctness determines the necessity for domain-specific optimizations (de Leoni et al., 2023). Runtime interaction of business process simulation and machine learning is consistent with state-of-the-art developments in the field (Meneghello et al., 2023).

Social and Ethical Implications are now mandatory areas of ML-based simulation designing and implementation. Fairness, explainability, accountability, and responsibility are all issues that must be addressed and dealt with beforehand at the designing stage. The potential for impact on high-stakes decisions affecting human well-being makes such systems require rigorous ethical frameworks as well as monitoring systems.

Future Research Directions suggested by this survey include continued evolution of more sophisticated integration techniques, improved techniques for bridging the reality-to-simulation gap, and improved techniques for assessing fairness and reliability. Standardized evaluation frameworks, benchmarks, and best practices created will be instrumental in the advancement of the field and broader acceptance of the technologies.

Interdisciplinary Collaboration has played a major role in the successful evolution of ML-infused simulations because thereby all the machine learning, systems engineering, ethics, and domain expertise has been infused. Even greater collaboration among the disciplines will be needed for addressing extremely interconnectedly complex problems and harnessing the full potential of these methodologies.

The results of this questionnaire unequivocally speak to the reality that simulation with ML incorporated therein is not an additive enhancement to ongoing practice but an innovation needed to bring new potential and applications heretofore impossible into the realm of the possible. As mounting computational power and methodological refinement continue, the impact of these technologies can only be expected to reach far into many fields.

Best practices derived from this survey are conservative equilibrium of the reality-gap in system design with the presupposition of good verification and validation practice, ethical concern in all stages in the development process, and usage of interdisciplinary methods integrating technical competencies with subject matter competencies and ethical considerations.

Continued advancement in ML-based simulation will open up new avenues to learning about and optimizing intricate systems and aid in resolving some of humanity's most deeply rooted problems. Bringing the complete potential of this promise to fruition will require continued research, dedication to grasping and alleviating ethical issues, and thoroughly deliberated reflection in line with safety, equity, and the common good.

Machine learning and simulation technology can only become more ubiquitous and sophisticated in the years to come, and will revolutionize the way we will be creating and optimizing complicated systems in a broad variety of industries. The foundation established by the research and development work being carried out is an excellent base to build further advances and innovations on this vital front.

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