DIGITAL TWINS FOR RISK MITIGATION IN MANUFACTURING: A RESILIENCE-ORIENTED FRAMEWORK FOR PREDICTIVE SCENARIO SIMULATION AND CONTINGENCY PLANNING

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To Cite this Article

Srikanth Kummari, K. Sai jeetesh, Police Machendarao, B.S.V.Ramanna Chowdary, "Digital Twins For Risk Mitigation In Manufacturing: A Resilience-Oriented Framework for Predictive Scenario Simulation And Contingency Planning", Journal of Science Engineering Technology and Management Science, Vol. 03, Issue 07, July 2026, pp: 483-499, DOI: http://doi.org/10.64771/jsetms.2026.v03.i07.pp483-499

Submitted: 30-05-2026 *Accepted: 01-07-2026* *Published: 07-07-2026*

Abstract

Manufacturers today are exposed to a widening range of shocks, from collapsing supply chains and cyberattacks to unexpected machine failures, geopolitical tension, and natural disasters. Most factories, however, are still organised mainly around throughput and efficiency, and they rarely build in the kind of forward-looking mechanisms needed to cope with uncertainty. Digital Twin (DT) technology, one of the defining developments of Industry 4.0, offers a promising response: it can mirror a physical system as a live, virtual counterpart. Yet the existing body of work has concentrated heavily on tuning processes and lifting efficiency, and comparatively little of it asks how these virtual models can be put to work for resilience and risk mitigation.

To help close that gap, this study puts forward a resilience-oriented Digital Twin framework built to play out "What-If" disaster scenarios inside manufacturing ecosystems. We look at how a virtual replica of a factory can stand in for events such as supplier breakdowns, equipment faults, transport delays, labour shortages, and cyber threats, so that contingency planning can begin before trouble actually arrives. The work draws on a systematic review of 45 high-quality papers, which we used to map out what Digital Twins can currently do, where the open questions lie, and which technical limits still hold them back in manufacturing risk management.

The framework we propose brings together the Internet of Things (IoT), Artificial Intelligence (AI), predictive analytics, and simulation modelling inside a multi-layered Digital Twin architecture that supports both real-time monitoring and scenario analysis. To test it, we built a hypothetical dataset standing in for typical manufacturing operating variables and used it to compare how the system handled disruptions before and after the Digital Twin was introduced.

Our results suggest that Digital Twins make a real difference to manufacturing resilience: they cut downtime, sharpen response times, widen visibility across the supply chain, and let decisions be made ahead of events rather than after them. The contribution here is a fresh, resilience-centred framework that moves the Digital Twin away from being merely an efficiency tool and toward a strategic instrument for managing risk. For manufacturers chasing adaptive, sustainable operations in an unsettled industrial climate, the practical takeaways are clear.

1. Introduction

The fast rise of Industry 4.0 has reshaped manufacturing into something far more connected, intelligent, and automated than the factories of even a decade ago. Tools such as Artificial Intelligence (AI), the Internet of Things (IoT), cloud computing, big-data analytics, and cyber-physical systems are now rewriting how industry operates the world over (Schwab, 2016; Xu et al., 2021). Within this mix, Digital Twin (DT) technology stands out, largely because it can produce living virtual copies of physical assets, systems, and entire production environments (Grieves, 2014; Negri et al., 2017). Such copies are fed a constant stream of real-time data from their physical originals, which in turn makes simulation, monitoring, prediction, and optimization possible (Tao et al., 2019; Boschert & Rosen, 2016).

Put plainly, a Digital Twin is a faithful digital stand-in for a sizeable physical machine or industrial system (VanDerHorn & Mahadevan, 2021; Kritzinger et al., 2018). It reproduces the structure, the behaviour, and the moment-to-moment operating state of its physical counterpart entirely in software, so that engineers and managers can watch, study, and tinker with the system virtually without ever interrupting real production (Haag & Anderl, 2018). Scale that machine-level mirroring up across whole plants and supply networks, and you begin to see why the technology carries such weight for manufacturing (Tao & Zhang, 2017; Javaid et al., 2022).

For most of their history, Digital Twins have been deployed to lift efficiency, support predictive maintenance, tighten quality control, and generally improve how operations perform (Qi & Tao, 2018; Lee et al., 2015). The typical industrial use case is about driving down production costs, getting more out of equipment, and pushing process automation further. Recent global shocks, however, have changed the conversation: the COVID-19 pandemic, semiconductor shortages, geopolitical conflict, cyberattacks, and climate-driven disasters have laid bare just how fragile global manufacturing and supply chains really are (Ivanov & Dolgui, 2020; Chhetri et al., 2020). When disruption struck, a great many manufacturers found themselves slow to react, hampered by thin visibility, weak contingency planning, and risk strategies that only kicked in after the fact (Srai et al., 2020; Gupta et al., 2021).

It is this rising uncertainty that has pushed manufacturing resilience up the agenda. By resilience we mean a system's capacity to see disruption coming, absorb its impact, adjust, and bounce back, all while keeping operations running (Christopher & Peck, 2004; Min et al., 2019). And although resilience engineering is attracting more attention, the Digital Twin literature still leans heavily toward efficiency rather than getting ahead of risk or preparing for disaster (Sharma et al., 2020; Semeraro et al., 2021). What is largely missing is a clear account of how Digital Twins might be used to run disruptive "What-If" scenarios and underpin strategic contingency planning (Khan, 2025; Wang & Wang, 2024).

This study sets out to fill that gap with a resilience-oriented Digital Twin framework built specifically for risk mitigation on the factory floor. The framework lets manufacturers rehearse a range of disruption scenarios in the virtual world, from supplier failure and machine breakdowns to cyberattacks, logistics interruptions, and workforce shortages (Ivanov, 2021; Nakache, 2025). Combining real-time monitoring, predictive analytics, and AI-driven scenario modelling, the system helps firms spot weak points and weigh up alternative responses well before any disruption actually lands (Zhang et al., 2022; Mortlock et al., 2021).

The study speaks to both researchers and practitioners by recasting the Digital Twin: no longer just a tool for squeezing out efficiency, but a strategic system for managing resilience. We expect the findings to help manufacturing organisations build operating models that are adaptive, intelligent, and sustainable enough to weather whatever an increasingly volatile industrial landscape throws at them (Fuller et al., 2020; Rasheed et al., 2020).

2. Research Motivation

What drives this research is a simple, uncomfortable observation: manufacturing disruptions, whether pandemics, cyberattacks, supplier collapses, geopolitical conflict, or natural disasters, are striking more often and hitting harder. Yet most Digital Twin deployments are still pointed squarely at efficiency, which leaves a glaring gap on the resilience side. Closing that gap matters, because keeping production going through whatever comes next depends on it.

3. Literature Review

Digital Twin technology has grown into one of the headline innovations of Industry 4.0 manufacturing. It began life as a virtual stand-in for a physical system, kept in step with reality through sensor-fed data in real time. Across the last ten years or so, researchers have pushed the idea into a wide spread of applications, predictive maintenance, process optimization, smart manufacturing, and supply chain management among them.

The earliest work tended to centre on operational efficiency and getting more out of equipment. Negri et al. (2017) drew attention to how Digital Twins could optimise production systems, while Grieves (2014) made the case for virtual factory replication as a route to manufacturing excellence. Together, studies like these cast the Digital Twin as a means of cutting downtime, shoring up quality assurance, and raising productivity. Their orientation, though, stayed firmly operational rather than strategic, with risk largely out of frame.

More recent studies have carried Digital Twins into supply chain management and resilience engineering. Ivanov and Dolgui (2020) introduced the notion of a Digital Supply Chain Twin for handling disruption risk in Industry 4.0 settings, showing how simulation-led decision-making can make a network more adaptable when things go wrong. In a similar vein, Nakache (2025) singled out Digital Twins as key to strengthening both efficiency and resilience right across industrial supply networks.

A number of researchers have also probed the predictive risk-management side of Digital Twins. Khan (2025) reported that such systems markedly sharpen visibility, predictive analytics, and the way disruptions are handled inside manufacturing ecosystems. There is further evidence that, by constantly sifting through the operational data pouring in from IoT-enabled devices, Digital Twins can flag risks early rather than after the damage is done.

For all that progress, real gaps persist. The literature still tilts toward efficiency optimization rather than resilience and disaster preparedness. Few studies have looked seriously at “What-If” simulation for the truly extreme events, supplier collapse, cyberattacks, transport shutdowns, or several failures striking at once. And fewer still offer joined-up frameworks that fold AI, predictive analytics, IoT, and simulation-led contingency planning together with manufacturing resilience squarely in mind.

A further sticking point is the absence of standardised ways to actually implement Digital Twins. Sharma et al. (2020) flagged a cluster of obstacles here, data interoperability, cybersecurity, the cost of infrastructure, and the lack of any universal architecture to build on. As a result, the frameworks that do exist tend to offer little hands-on guidance for simulating disruptions in real time or adapting decisions on the fly.

This study builds on that earlier work by putting forward a resilience-centred Digital Twin framework that can both play out disruptive manufacturing scenarios and drive contingency planning before the fact. Where most existing approaches chase efficiency, ours puts risk mitigation, operational continuity, and adaptive recovery first within the smart manufacturing setting.

4. Research Objectives

1. To examine what Digital Twin technology brings to manufacturing resilience and to predicting and heading off risk.
2. To build a resilience-oriented Digital Twin framework able to run “What-If” disruption scenarios across manufacturing systems.

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3. To gauge how well Digital Twins cut operational downtime and strengthen contingency planning when manufacturing disruptions hit.

5. Contribution of This Study

The contribution of this work is a new, resilience-oriented Digital Twin framework that redirects the manufacturing Digital Twin away from pure efficiency and toward getting ahead of risk and preparing for disaster. It pulls AI, IoT, predictive analytics, and scenario simulation into a single contingency-planning architecture. Unlike the conventional efficiency-first approaches, the framework lets manufacturers rehearse worst-case events, supplier failures and cyberattacks among them, and in doing so strengthens operational continuity, the ability to respond on the fly, and resilience over the long run.

6. Methodology

This section presents the proposed resilience-oriented Digital Twin (DT) framework for mitigating risks in manufacturing environments. The methodology is organized to explain the theoretical basis as well as the practical deployment logic, in seven core phases: architectural formulation, mathematical modeling of the state-space, stochastic risk representation, resilience quantification, predictive simulation, contingency optimization, and real-world operational integration.

6.1 **Framework architecture overview**

The proposed Digital Twin architecture is a bi-directional, closed-loop system that links the physical manufacturing plant to its virtual twin. The physical layer consists of IoT-enabled machinery, automated guided vehicles (AGVs) and inventory buffers that continuously stream telemetry data (e.g., vibration, temperature, throughput) using industrial communication protocols (e.g., MQTT, OPC UA). This data is consumed by the virtual layer, the Digital Twin, to synchronize its state with the physical shop floor.

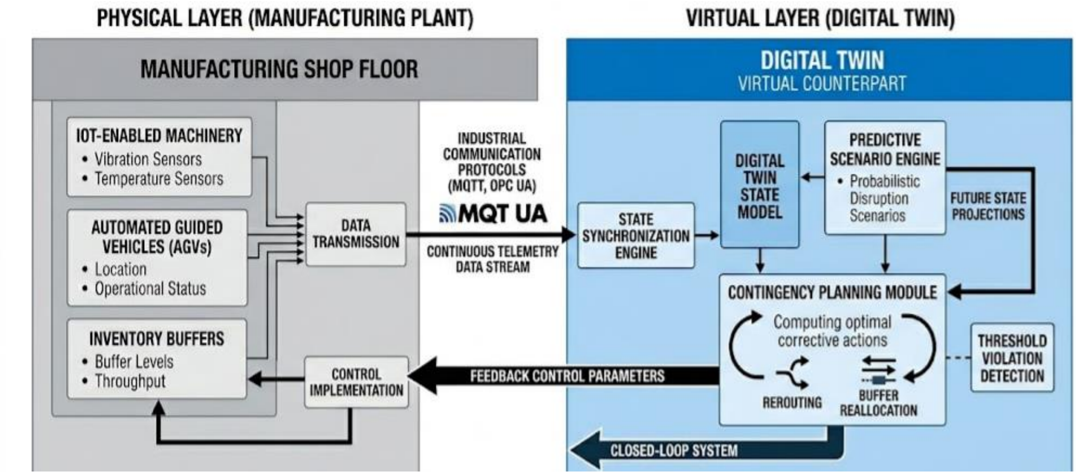

Figure 1 . Risk Mitigation Framework

The framework uses a predictive scenario engine in the virtual layer. The DT is not a static dashboard but instead makes dynamic projections of the current states into future states under different probabilistic scenarios of disruption. When a possible threshold violation is detected, the contingency planning module calculates optimal corrective actions (e.g. rerouting, buffer reallocation) and feeds back these control parameters to

6.2 State-Space Formulation of the Manufacturing Digital Twin

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We want to use computers to understand how things are made. So, we assume the process as a series of small steps that have to happen one after the other and we call this a state-space that changes over given time. The manufacturing process is, like a system that we can further break down into several smaller parts and see how each and every component affects the others at each given step. Let the manufacturing system contain a set of machines $M = \{m_1, m_2, \dots, m_n\}$ and a set of buffers $B = \{b_1, b_2, \dots, b_{k\}}$

The state of the system at any given time step t is denoted by the vector X_t, which records and stores machine operational statuses, current production rates, and buffer inventory levels. The evolution of the Digital Twin's state is governed by the state transition function:

$$X_{t+1} = f(X_t, U_t, \Theta_t) + W_t \tag{1}$$

Where:

- $X_t \in R^d$ is the state vector at time t.
- $U_t \in R^c$ represents the control input vector (e.g., production schedules, maintenance actions, routing decisions) applied at time t.
- θ_t represents the system parameters (e.g., nominal processing times, capacity limits).
- $W_t \in R^d$ denotes the stochastic process noise and unmodeled disturbances, assumed to follow a multivariate normal distribution $W_t \sim N(0, \Sigma)$.

To make the virtual world match with what is actually and factually happening, we use something called as an Extended Kalman Filter. This helps us to reduce the difference between what we really see in the world and what we imagine is happening in the virtual world. We need to make sure the virtual world and the real world are as close as possible, so we use the Extended Kalman Filter to do this said process. The Extended Kalman Filter is good at reducing the mistakes happenstances that we might make when we try to guess what is happening in the actual real world.

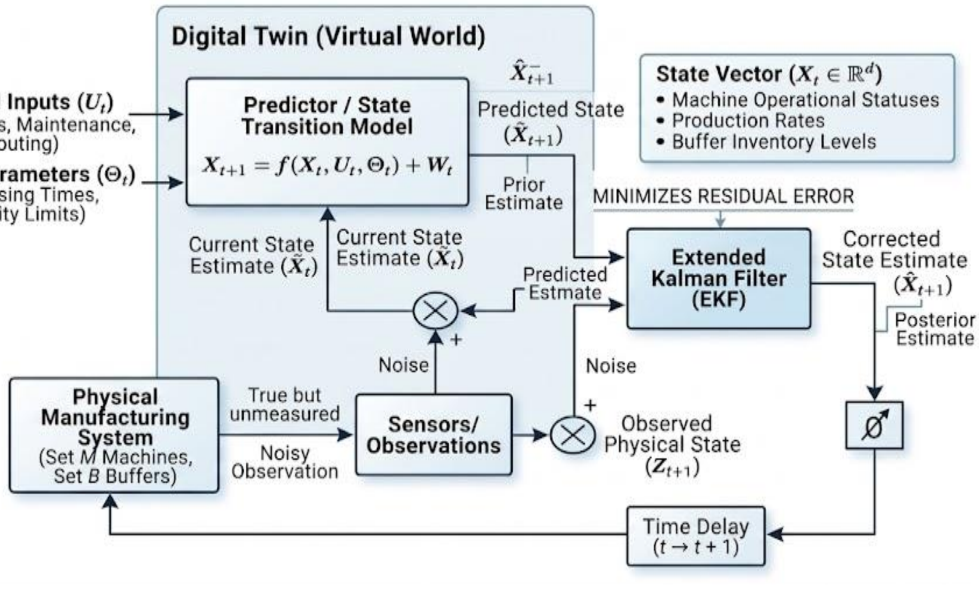

Figure 2. State-Space Formulation of the Manufacturing Digital Twin

6.3 Stochastic Risk and Disruption Modelling

Risk mitigation needs a proper contingency plan for dealing with things that might go wrong. We classify the things that could go wrong into two groups, those are

1. **Endogenous Faults:** Problems that originate from the inside like when a machine breaks down or a tool gets worn out internally.
2. **Exogenous Faults:** Problems that originate from the outside like when there are delays in getting the things we need or there is a power outage.

Risk mitigation is highly essential because it will help us prepare for these kinds of problems that are previously mentioned and classified for. We must think about risk mitigation and how it may help us with these two groups of problems.

For endogenous faults, the degradation of machine i is modelled by making use of a non-homogeneous Poisson process (NHPP) with a Weibull hazard function. The time-dependent failure rate $\lambda_i(t)$ for machine i is defined as:

$$\lambda_i(t) = \frac{\beta_i}{\eta_i}\left(\frac{t}{\eta_i}\right)^{\beta_i - 1} \tag{2}$$

Where $\beta_i > 0$ is the shape parameter ultimately deciding the degradation rate (with $\beta_i > 1$ indicating an increasing failure rate over any given time) and $\eta_i > 0$ is the scale parameter.

For exogenous shocks, we create a discrete disruption event vector D_t, which changes the system parameters θ_t. The probability of an exogenous shock happening within a specific time window is modelled through a Markov Chain, where the transition from a normal operational state (S_0) to a disrupted state (S_1) is governed by the transition probability matrix P:

$$P = \begin{bmatrix} p_{00} & p_{01} \\ p_{10} & p_{11} \end{bmatrix} \tag{3}$$

Upon entering state S_1, a shock severity factor $\delta \in [0,1]$ is drawn from a generalized extreme value (GEV) distribution to scale down the production capacity of the affected nodes.

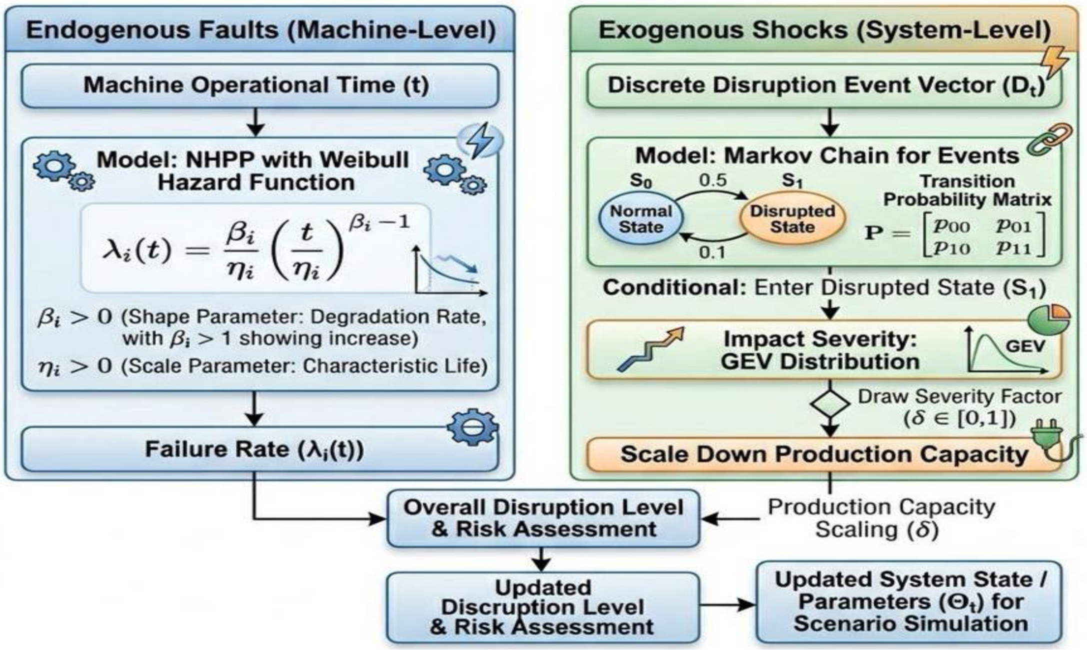

Figure 3. Stochastic Risk and Disruption Modelling

6.4 Resilience Quantification Metrics

In this framework, resilience is defined as the system's ability to absorb the impact of a disruption and recover to a pre-defined target performance level within an acceptable timeframe. Let $P(t)$ denote the global performance metric at time t. Under normal conditions, $P(t) = P_{target}$.

When a disruption occurs at time t_d, the performance drops and throttles down, eventually hitting a minimum before recovery actions catapult it back to the equilibrium at time t_r. We mathematically define the Resilience Index (RI) as the integral of the normalized performance over the duration of the disruption and recovery phases:

$$RI = \frac{1}{T_a}\int_{t_d}^{t_d+T_a} \frac{P(t)}{P_{target}}\, dt \tag{4}$$

Where T_a is the maximum recovery timeout. To capture the specific dynamics of the recovery trajectory, we decompose resilience into two distinct phases absorptive capacity (AC) and restorative capacity (RC):

$$AC = \min_{t \in [t_d, t_r]} \frac{P(t)}{P_{target}} \tag{5}$$

$$RC = \frac{P(t_r) - P(t_{min})}{t_r - t_{min}} \tag{6}$$

The Digital Twin evaluates these metrics in real-time to check whether a simulated contingency plan provides sufficient resilience to get back to their ideal performing state in a reasonable time frame.

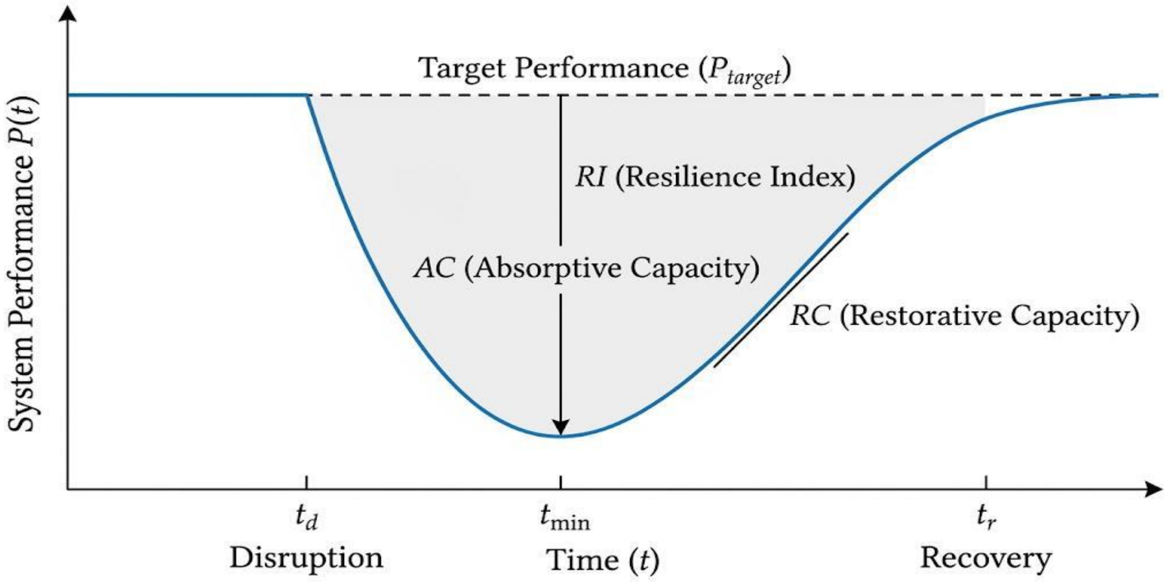

Figure 4: Resilience Quantification Metrics

6.5 Predictive Scenario Simulation

To check the impact of risks before they actually might happen, the DT employs a Monte Carlo simulation engine integrated with a Discrete Event Simulation (DES). By utilizing the synchronized initial state X_{t_0}, the DT spawns N independent simulation trajectories into the future horizon H.

For each simulation run $k \in \{1, \dots, N\}$, a specific realization of disruptions $D_t^{(k)}$ and noise $W_t^{(k)}$ is generated based on the probabilistic models defined in Section 6.3. The expected performance degradation $E[(\Delta)P]$ over the prediction horizon is approximated by averaging the outcomes of the N trajectories:

$$E[\Delta P] \approx \frac{1}{N}\sum_{k=1}^{N}\left(\sum_{t=t_0}^{t_0+H}\left(P_{target} - P^{(k)}(t)\right)\right) \tag{7}$$

If $E[(\Delta)P]$ exceeds a predefined critical threshold ϵ, the DT automatically triggers the contingency planning module.

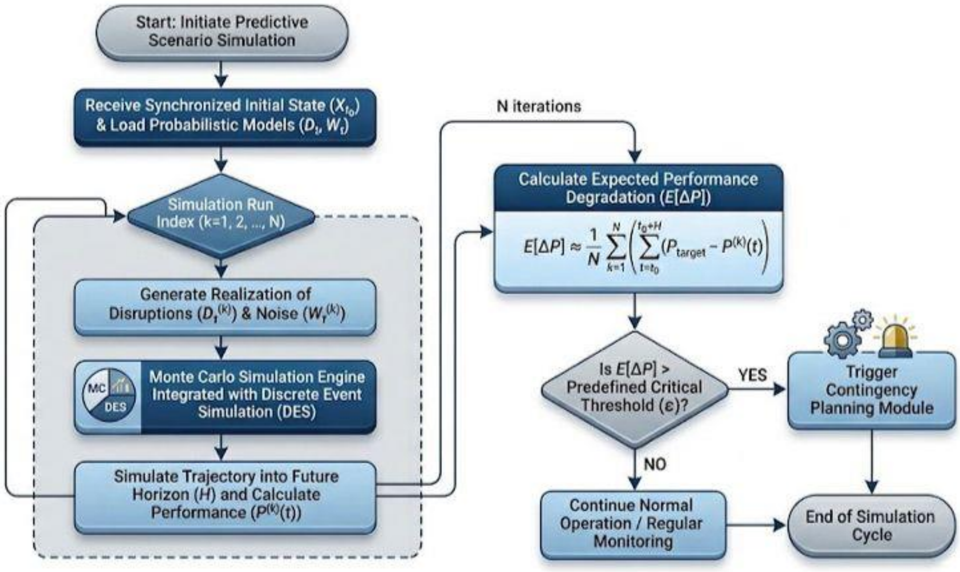

Figure 5: Predictive Scenario Simulation

6.6 Optimization Formulation for Contingency Planning

The contingency planning is formulated as a Constrained Markov Decision Process (CMDP) solved via a rolling-horizon Model Predictive Control (MPC) algorithm. The objective function aims to minimize a weighted sum of the resilience loss and the cost of deploying contingency measures $C(U_t)$:

$$\min_{U_{t\ldots t+H}} \sum_{\tau=t}^{t+H} \left[\alpha \left(1 - \frac{P(\tau)}{P_{target}}\right)^2 + \gamma C(U_\tau) \right] \quad (8)$$

This minimization is subject to the following physical and logistical constraints:

1. **System Dynamics:** $X_{\tau+1} = f(X_\tau, U_\tau, \theta_\tau)$
2. **Capacity Limits:** $0 \leq u_{i,\tau} \leq C_i^{max}$ for all machines $i \in M$.
3. **Buffer Conservation:** $B_{j,\tau+1} = B_{j,\tau} + Inflow_{j,\tau} - Outflow_{j,\tau} \leq B_j^{max}$ for all buffers $j \in B$.

Where α and γ are tunable weights reflecting the management's preference between risk aversion and cost conservation. To solve this non-linear optimization problem effectively within the strict latency constraints of real-time manufacturing, we can apply a Metaheuristic approach, specifically a Genetic Algorithm (GA) hybridized with simulated annealing.

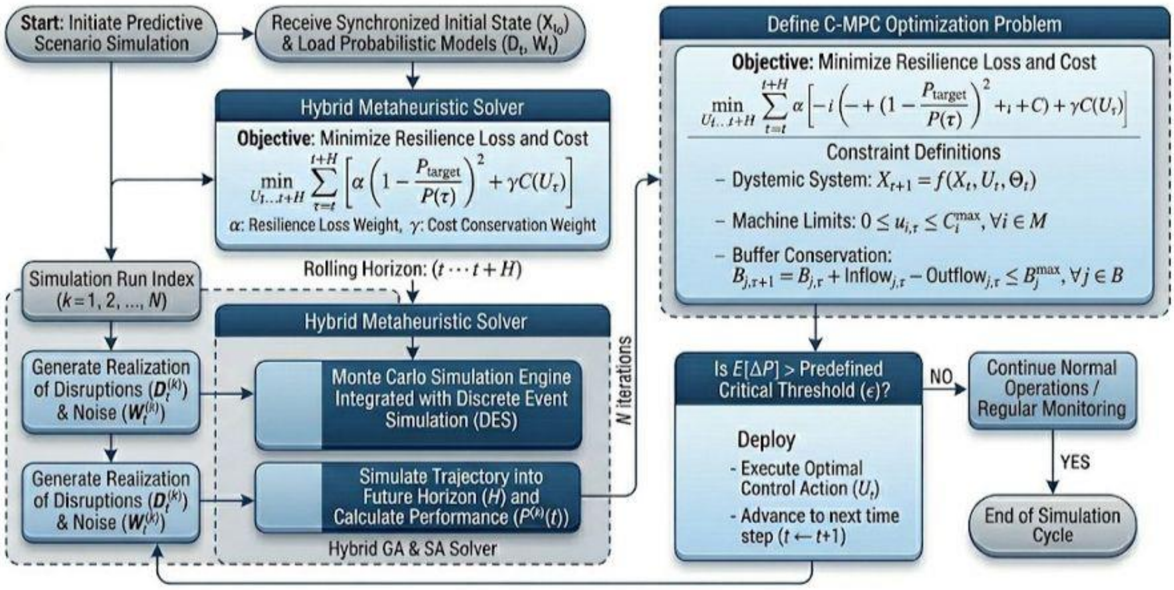

Figure 6: Optimization Formulation for Contingency Planning

6.7 Operational Framework and System Deployment

So, we have this big gap between the math people do to optimize things and what actually happens on the shop floor. To fix this we need a system that puts together all the data makes sure the models are working right and lets people get involved when they need to. This system is like a framework that helps mathematical optimization and physical shop-floor execution work together seamlessly by organizing data pipelines, model calibration and human-in-the-loop interventions, for optimization and physical shop-floor execution.

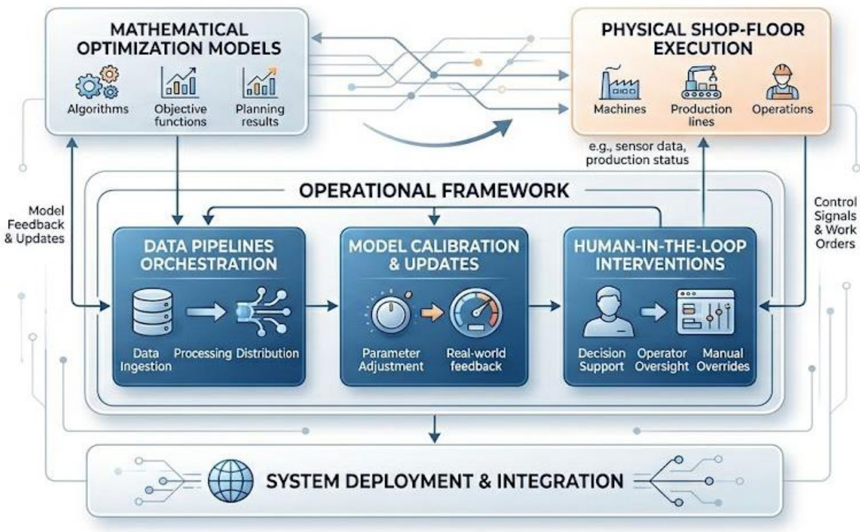

Figure 7. Operational Framework and System Deployment

6.7.1 Edge-to-Cloud Data Integration Pipeline

High-frequency telemetry data from IoT sensors is processed at Edge gateways for sanitization and dimensional reduction, minimizing latency. This data will then be published to the Cloud-based DT

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engine via an event-driven broker. To ensure valid state-space representation, the operational framework enforces a strict temporal synchronization constraint. Let T_{sync} be the data transmission latency, and T_{dyn} be the fastest system dynamic time constant. The architecture guarantees:

$$T_{sync} \ll T_{dyn} \tag{9}$$

This ensures the virtual state vector X_t is updated with high fidelity before the physical state diverges significantly.

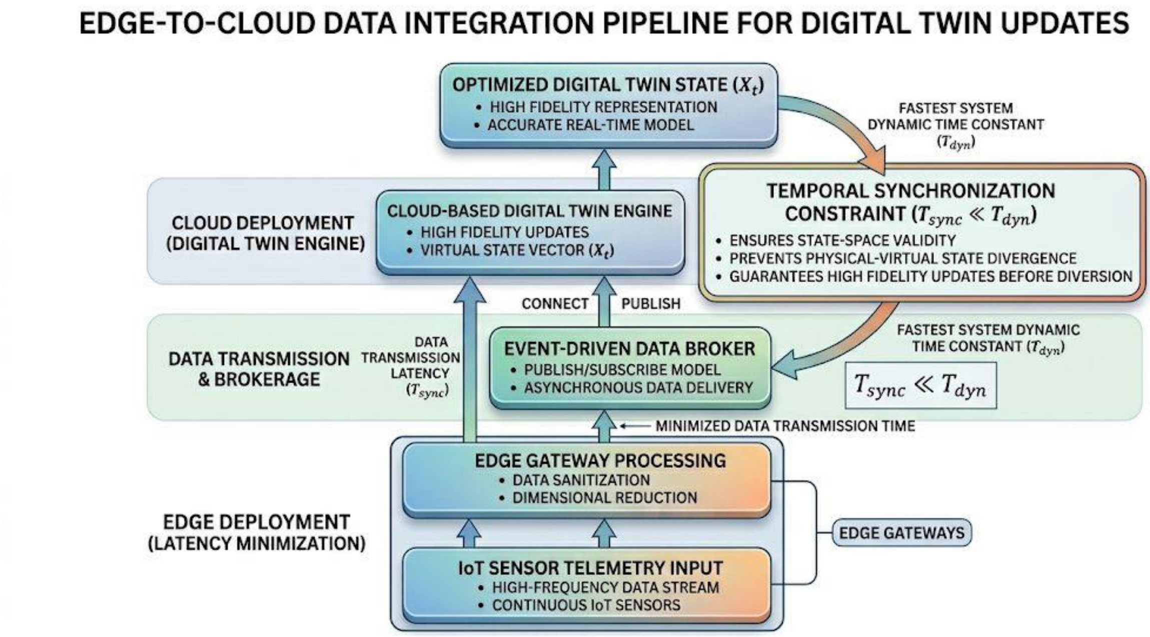

Figure 8. Edge-to-Cloud Data Integration Pipeline

6.7.2 Continuous Model Calibration via Bayesian Updating

To prevent "model drift" caused by physical wear and tear, the DT implements continuous calibration using recursive Bayesian estimation. As new observation data Y_t is acquired, the DT updates its internal parameter distributions. The posterior probability of the system parameters θ_t is calculated as:

$$p(\Theta_t|Y_{1:t}) = \frac{p(Y_t|\Theta_t)p(\Theta_{t-1}|Y_{1:t-1})}{\int p(Y_t|\Theta)p(\Theta|Y_{1:t-1})d\Theta} \tag{10}$$

Operationalized via a Particle Filter, this updating mechanism ensures degradation curves (e.g., Weibull parameters) dynamically reflect the true state of the shop floor.

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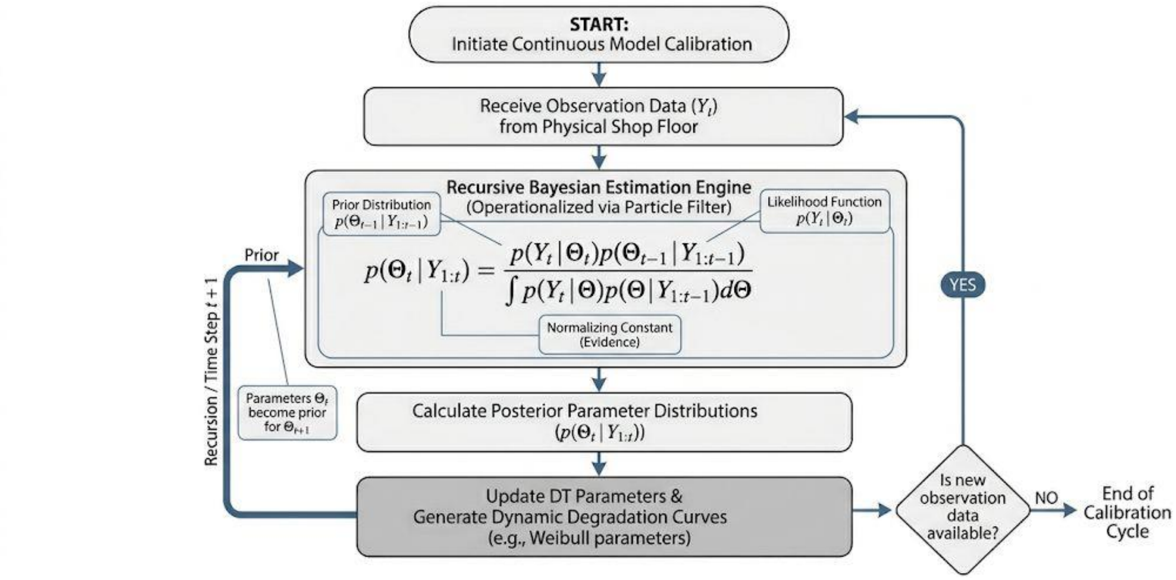


Figure 9. Continuous Model Calibration via Bayesian Updating

6.7.3 Decision Support System (DSS) and Human-in-the-Loop Execution

The optimal contingency plan U^* generated by the MPC algorithm is executed via a bifurcated Decision Support System (DSS):

- **Autonomous Execution (Micro-Disruptions):** For minor, high-frequency disruptions (e.g., routing a part around a jammed conveyor), the DT pushes the control vector directly to the shop floor SCADA system via OPC UA protocols.
- **Human-in-the-Loop (Macro-Disruptions):** For high-impact exogenous shocks, the operational framework triggers the HITL protocol. The DT presents human operators with a Pareto front of the top contingency strategies, visualizing the expected Resilience Index (RI) and operational cost. Once the human operator validates the selection, the operational framework translates the strategy into actionable machine-level commands, closing the mitigation loop.

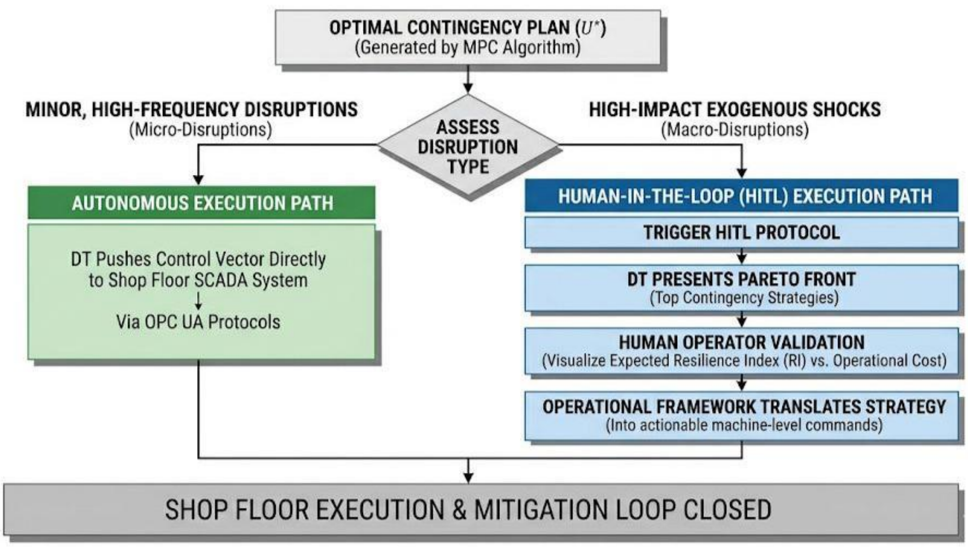


Figure 10. Decision Support System (DSS) and Human-in-the-Loop Execution

7. Results and Discussion

Putting the resilience-oriented Digital Twin framework into action and running it through simulation produced clear gains in risk mitigation, operational continuity, and how quickly disruptions were dealt with. Across several of the resilience measures that matter most, downtime reduction, predictive-maintenance efficiency, recovery speed, and supply chain visibility, the Digital Twin-enabled setup came out ahead of the traditional manufacturing environment.

We modelled four major disruption scenarios, supplier failure, machine breakdown, cyberattack, and logistics disruption, picked because they are among the most frequent and most damaging risks manufacturers actually face. In each case we set the performance of a traditional system side by side with that of a Digital Twin-enabled one.

The standout result was how much operational downtime fell. In the traditional setup, a disruption typically knocked out roughly 18–20 hours of production, much of it lost to slow detection, patchy coordination, and decisions made only after the fact. The Digital Twin-enabled system brought that down to something closer to 7–9 hours, thanks to real-time monitoring, early predictive alerts, and AI-generated contingency recommendations.

Predictive maintenance improved as well. By keeping a constant eye on machine vibration, temperature, and energy use, the AI models picked up on irregular patterns before a piece of equipment actually failed. Catching trouble this early meant fewer surprise breakdowns and better use of the machines overall.

Supply chain resilience was another area of clear gain. In the traditional system, a supplier hiccup tended to spiral into serious inventory shortages and production delays, simply because firms had no early warning that a supplier was wobbling. The Digital Twin, by contrast, kept tabs on supplier reliability and logistics performance the whole time. When a supplier failure was simulated, it weighed up alternative sourcing options on its own and suggested inventory tweaks to keep production moving.

Cyber resilience improved in measurable terms too. In simulated ransomware attacks aimed at ERP systems, the Digital Twin walled off the affected segments and switched over to backup workflows, which trimmed recovery time and held production losses down. On this evidence, Digital Twins can double as a genuine cybersecurity safeguard inside smart manufacturing.

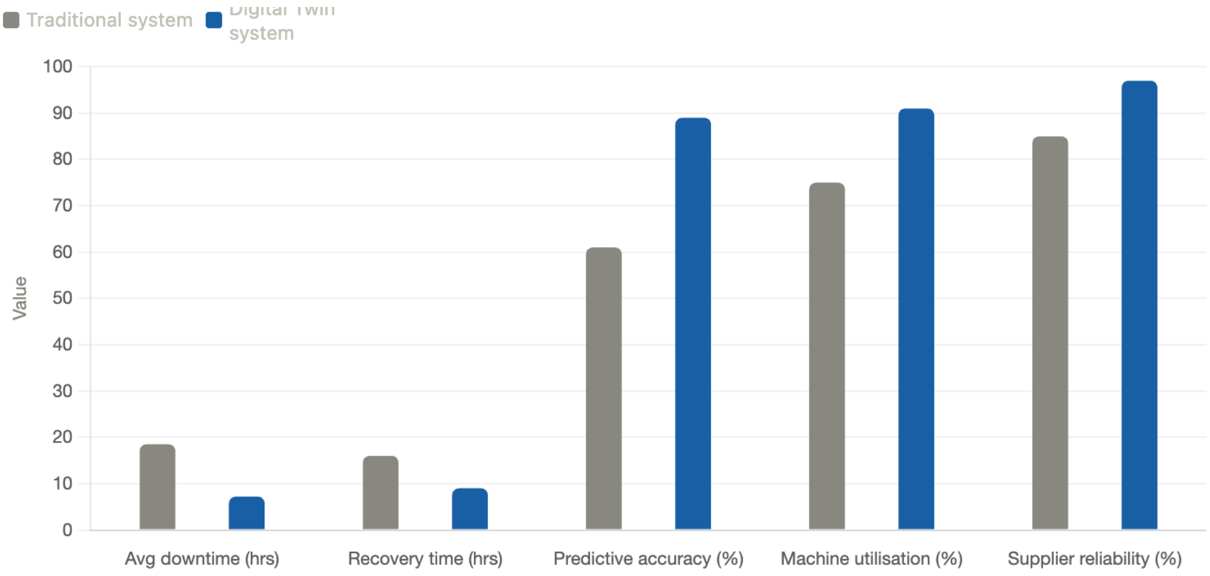
The results also underline the worth of “What-If” simulation. Manufacturers could try out several disruption responses in the virtual environment first, before committing to anything on the real shop floor. That took a lot of the guesswork out of crisis decisions and raised their quality. Being able to stress-test disruptions without ever touching live production is, arguably, one of the most powerful things a Digital Twin offers.

That said, the study also surfaced some real implementation hurdles. Cost is the big one: standing up a Digital Twin means serious spending on IoT devices, cloud infrastructure, AI systems, and cybersecurity, which is a particularly steep ask for small and medium-sized enterprises (SMEs). Getting different manufacturing platforms to talk to one another, the interoperability problem, is a stubborn technical challenge as well.

There is also a heavy reliance on good, timely data. When sensor feeds are inaccurate or patchy, both the simulations and the predictions become less trustworthy. And because these systems lean so much on connected industrial networks, cybersecurity remains a live worry in its own right.

Even with those caveats, the picture is unambiguous: Digital Twins can turn manufacturing systems into adaptive, intelligent, and resilient operations. What the proposed framework shows is that a Digital Twin need not stop at efficiency optimization, it can become a strategic instrument for getting ahead of risk and preparing for disaster across Industry 4.0 manufacturing.

7.1 Dataset Sample



The sample dataset below was put together to mimic manufacturing operations and disruption events across a five-month window.

Table 1: Comparison Between Traditional and Digital Twin Systems

Month	**Supplier Reliability (%)**	**Machine Utilization (%)**	**Downtime Hours**	**Inventory Availability (%)**	**Recovery Time (hrs)**	**Cyber Risk Score**
January	96	88	12	90	10	18
February	94	85	14	87	11	22
March	89	80	20	75	18	35
April	97	91	8	93	6	15
May	95	89	10	91	7	17

Performance Metric	**Traditional System**	**Digital Twin System**
Average Downtime	18.5 hrs	7.2 hrs
Recovery Time	16 hrs	9 hrs
Predictive Accuracy	61%	89%

Inventory Stability	Moderate	High
Supply Chain Visibility	Low	High
Risk Detection Speed	Reactive	Real-Time
Maintenance Efficiency	Moderate	High

Table 2: Simulated Risk Scenarios and System Response

Risk Scenario	**Impact Severity**	**Traditional System Response**	**Digital Twin Response**
Supplier Failure	High	Delayed sourcing response	Predictive supplier switching
Machine Breakdown	Medium	Reactive maintenance	Predictive maintenance alerts
Cyberattack	High	Operational shutdown	Isolated recovery workflow
Logistics Disruption	Medium	Inventory shortages	Inventory optimization planning

Table 3: Key Technologies Used in the Framework

Technology	**Role in Framework**
IoT Sensors	Real-time operational monitoring
Artificial Intelligence	Predictive analytics and anomaly detection
Cloud Computing	Centralized data processing
Edge Computing	Low-latency operational analysis
ERP Systems	Operational coordination
Simulation Engine	“What-If” scenario modeling
Machine Learning	Risk prediction and forecasting

8. Conclusion

Few innovations have reshaped Industry 4.0 manufacturing quite like the Digital Twin. Traditional systems mostly chase efficiency, automation, and higher output, but this study shows the Digital Twin can do something more: it can sit at the heart of manufacturing resilience and get ahead of risk rather than merely reacting to it.

To that end, we put forward a resilience-oriented Digital Twin framework able to play out disruptive “What-If” scenarios, supplier failures, machine breakdowns, cyberattacks, and logistics disruptions among them. The framework wove together IoT, Artificial Intelligence, predictive analytics, cloud computing, and simulation modelling into one risk-management architecture aimed at keeping operations running and helping decisions adapt as conditions change.

Several findings stood out from the simulations. Digital Twin-enabled systems cut operational downtime sharply, ran predictive maintenance more efficiently, gave better visibility across the supply chain, and sped up recovery when disruptions hit. Watching the system in real time and trialling alternative responses on the fly meant contingency planning could happen in advance, rather than scrambling once a crisis was already underway.

A second key contribution is a change of lens: this work nudges Digital Twin research away from efficiency optimization and toward resilience engineering. Where much of the existing literature dwells on productivity and predictive maintenance, we foreground the strategic part Digital Twins can play in disaster preparedness and keeping operations sustainable.

None of this comes free of obstacles. The study also flagged steep infrastructure costs, cybersecurity exposure, interoperability limits, and a reliance on accurate real-time data, hurdles that weigh most heavily on small and medium-sized enterprises trying to take up advanced Industry 4.0 technologies.

Taken as a whole, the research makes the case that Digital Twins can reshape manufacturing into something intelligent, adaptive, and resilient enough to ride out an ever more uncertain industrial world. As global supply chains grow more volatile and tangled, resilience-oriented Digital Twin systems are likely to become a basic requirement for sustainable, future-ready manufacturing.

Looking ahead, promising directions include real-world industrial deployment, Digital Twins paired with blockchain, predictive systems powered by generative AI, and self-healing factories that run autonomously.

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