Contents

1 Introduction 1
1.1 Scope of Process Control 1
1.2 Proportional–Integral–Derivative Control Performance 2
1.3 Relay Feedback Identification 5
1.4 Conclusion 6
1.5 References 7

2 Features of Proportional–Integral–Derivative Control 9
2.1 Proportional–Integral–Derivative Controller 9
2.1.1 Proportional Control 9
2.1.2 Proportional–Integral Control 10
2.1.3 Proportional–Integral–Derivative Control 12
2.2 Proportional–Integral–Derivative Implementation 13
2.2.1 Reset Windup 13
2.2.2 Arrangement of Derivative Action 15
2.3 Proportional–Integral–Derivative Tuning Rules 17
2.3.1 Ziegler–Nichols Types of Tuning Rules 17
2.3.2 Model-based Tuning 19
2.4 Conclusion 20
2.5 References 20

3 Relay Feedback 23
3.1 Experimental Design 24
3.2 Approximate Transfer Functions: Frequency-domain Modeling 26
3.2.1 Simple Approach 27
3.2.2 Improved Algorithm 30
3.2.3 Parameter Estimation 32
3.2.4 Examples 32
3.3 Approximate Transfer Functions: Time-domain Modeling 36
3.3.1 Derivation for a Second-order Overdamped System 39
3.3.2 Results 41

3.3.3 Validation 44
3.4 Conclusion 44
3.5 References 46

4 Shape of Relay 47
4.1 Shapes of Relay Response 47
4.1.1 Shapes 48
4.1.2 Model Structures 50
4.1.2.1 First-order Plus Dead Time 50
4.1.2.2 Second-order Plus Small Dead Time 51
4.1.2.3 High Order 52
4.2 Identification 52
4.2.1 Identification of Category 1: First-order Plus Dead Time 52
4.2.1.1 Category 1a: True First-order Plus Dead Time 52
4.2.1.2 Category 1b: Approximated First-order Plus Dead Time 55
4.2.2 Identification of Category 2: Second-order Plus Small Dead Time 56
4.2.3 Identification of Category 3:High order 58
4.2.4 Validation 59
4.3 Implications for Control 62
4.3.1 Proportional–Integral–Derivative Control 62
4.3.1.1 Category 1: First-order Plus Dead Time 62
4.3.1.2 Category 2: Second-order Plus Small Dead Time 64
4.3.1.3 Category 3: High Order 64
4.3.2 Results 64
4.3.3 Extension 70
4.3.3.1 Dead-time-Dominant Process 70
4.3.3.2 Higher Order Process 71
4.4 Conclusion 72
4.5 References 73

5 Improved Relay Feedback 75
5.1 Analysis 76
5.1.1 Ideal (On–Off) Relay Feedback 76
5.1.2 Saturation Relay Feedback 78
5.1.3 Potential Problem 83
5.2 Improved Experimental Design 84
5.2.1 Selection of the Slope of Saturation Relay 84
5.2.2 Procedure 89
5.3 Applications 89
5.4 Conclusion 95
5.5 References 96

6 Multivariable Systems 97
6.1 Concept 97
6.1.1 Single-input–Single-output Autotuning 97
6.1.2 Multiple-input–Multiple-output Autotuning 99
6.2 Theory 101

6.2.1 Sequential Design 101
6.2.2 Process Characteristics 104
6.2.3 Sequential Identification 108
6.3 Controller Tuning 111
6.3.1 Potential Problem in Ziegler–Nichols Tuning 111
6.3.2 Modified Ziegler–Nichols Method 111
6.3.3 Performance Evaluation: Linear Model 115
6.4 Properties 117
6.4.1 Convergence 117
6.4.2 Tuning Sequence 119
6.4.3 Problem of Variable Pairing 120
6.4.4 Summary of Procedure 122
6.5 Applications 123
6.5.1 Moderate-purity Column 123
6.5.2 High-purity Column 124
6.5.3 T4 Column 128
6.6 Conclusion 130
6.7 References 130
Appendix 132

7 Load Disturbance 135
7.1 Problems 135
7.1.1 Step Change versus Continuous Cycling 135
7.1.2 Effect of Load Change on Relay Feedback Test 138
7.2 Analyses 139
7.2.1 Causes of Errors 139
7.2.2 Output-biased Relay Feedback System 142
7.2.3 Derivation of Bias Value δ_o 144
7.2.3.1 Effect of Load Disturbance 144
7.2.3.2 Opposite Effect from Output-biased Relay 146
7.3 Summary of Procedure 148
7.4 Applications 149
7.4.1 Linear System 150
7.4.2 Binary Distillation Column 152
7.5 Conclusion 153
7.6 References 154

8 Multiple Models for Process Nonlinearity 155
8.1 Autotuning and Local Model 156
8.2 Model Scheduling 157
8.2.1 Takagi–Sugeno Fuzzy Model 157
8.2.1.1 Single Input Systems 158
8.2.1.2 Multiple Inputs Systems 160
8.2.2 Selection of Scheduled Variable 162
8.3 Nonlinear Control Applications 163
8.3.1 Transfer Function System 163
8.3.2 Tennessee Eastman Process 167

8.4 Conclusion 173
8.5 References 173

9 Control Performance Monitoring 175
9.1 Shape Factor for Monitoring 176
9.1.1 Shapes of the Relay Feedback 176
9.2 Performance Monitoring and Assessment 179
9.2.1 Optimal Performance 179
9.2.2 Proposed Monitoring and Assessment Procedure 180
9.2.2.1 Case 1: $\tau_I/\tau = 1$ 180
9.2.2.2 Case 2: $\tau_I/\tau > 1$ 180
9.2.2.3 Case 3: $\tau_I/\tau < 1$ 181
9.2.3 Illustrative Examples 184
9.3 Applications 188
9.3.1 Second-order Plus Dead Time Processes 188
9.3.2 High-order Processes 193
9.4 Conclusion 196
9.5 References 196

10 Imperfect Actuators 197
10.1 Potential Problems 197
10.2 Identification Procedure 202
10.2.1 Two-step Procedure 202
10.2.2 Simultaneous Identification 205
10.3 Applications 206
10.3.1 Linear Systems 206
10.3.1.1 Noise-free System 206
10.3.1.2 Systems with Measurement Noise 207
10.3.1.3 Load Disturbance 210
10.3.2 Nonlinear Process 212
10.3.2.1 Two-step Procedure 212
10.3.2.2 Simultaneous Procedure 212
10.4 Conclusion 216
10.5 References 217

11 Autotuning for Plantwide Control Systems 219
11.1 Recycle Plant 219
11.2 Control Structure Design 222
11.2.1 Unbalanced Schemes 222
11.2.1.1 Column Overwork 222
11.2.1.2 Reactor Overwork 226
11.2.2 Balanced Scheme 227
11.2.3 Controllability 228
11.2.4 Operability 231
11.3 Controller Tuning for Entire Plant 232
11.3.1 Tuning Steps 233

11.3.1.1 Inventory Control 233
11.3.1.2 Ratio Control 233
11.3.1.3 Quality Loop 235
11.3.2 Closed-loop Performance 238
11.4 Conclusion 242
11.5 References 242

12 Guidelines for Autotune Procedure 245
12.1 Process Characteristics 245
12.1.1 The Shape 245
12.1.2 Load Disturbance 246
12.1.3 Nonlinearity 246
12.1.4 Noise 247
12.1.5 Imperfect Actuator 248
12.2 Available Relays 248
12.3 Specifications 249
12.3.1 Direct Tuning 249
12.3.2 Model-based Tuning 251
12.3.3 Multiloop System 252
12.4 Discussion 256
12.5 Conclusion 257
12.6 References 258

Index 259