Contents

Section I
Introduction 1

Chapter 1
Why Process Control? 3
1.1 Historical Background 4
1.2 Role of Control in Process Industries 5
1.2.1 Traditional Role of Process Control 5
1.2.2 Expanded Role of Process Control 7
1.3 Objectives of Control 9
1.3.1 What About Performance? 10
1.3.2 Economic Benefits of Control 10
1.4 Summary 12
Continuing Problem 12

Chapter 2
Definitions and Terminology 15
2.1 Concepts and Definitions 15
2.2 Control Design Problem 18
2.3 Control System Design 21
2.4 Control Design Project 22
2.4.1 Preliminary Engineering 23
2.4.2 Detailed Engineering 24
2.4.3 Implementation 24
2.4.4 Installation 24
2.4.5 Commissioning 25
2.4.6 First Production Startup and Turnover 25
2.4.7 Training 25
2.5 Summary 25
Continuing Problem 25

Section I Additional Reading 27
Section I Exercises 29

Section II
Modeling for Control 35

Section II Additional Reading 95
Section II Exercises 97

Section III
Process Analysis 105

Chapter 7
Stability 107
7.1 Stability of Linear Systems 107
7.2 Input–Output Stability 111
7.3 Routh's Criterion 113
7.4 Root-Locus Method 116
7.5 Summary 117

Chapter 8
Dynamic Performance 119
8.1 First-Order Processes 119
8.2 Second-Order Processes 123
8.3 Multi-Capacity Processes 127
8.4 Effect of Zeros 133
8.5 Effect of Time Delays 136
8.6 Summary 137

Chapter 9
Frequency Response 139
9.1 What is Frequency Response? 139
9.2 Complex Numbers in Polar Coordinates 140
9.3 Construction of the Frequency Response 141
9.4 Evaluation of the Frequency Response 143
9.5 Bode Diagrams 145
9.6 Nyquist Diagrams 147
9.7 Summary 150

Section III Additional Reading 151
Section III Exercises 153

Section IV
Feedback Control 157

Chapter 10
Basic Elements of Feedback Control 159
10.1 Feedback Control Problem 159

10.2 Control Law 162
10.2.1 Proportional Mode 162
10.2.2 Integral Mode 164
10.2.3 Derivative Mode 164
10.2.4 Three-Mode Controller (PID) 164
10.3 Closed-Loop Transfer Functions 165
10.4 Closed-Loop Performance 167
10.4.1 Proportional Mode 167
10.4.2 Integral Mode 169
10.4.3 Derivative Mode 171
10.4.4 Integral Windup 172
10.5 Summary 173
Continuing Problem 173

Chapter 11
Stability Analysis of Closed-Loop Processes 177
11.1 Closed-Loop Stability 177
11.2 Routh's Criterion 179
11.3 Root-Locus Method 180
11.4 Frequency Response Methods 184
11.5 Summary 187
Continuing Problem 188

Chapter 12
Feedback Control Design 191
12.1 Design Objectives 191
12.1.1 Error-Based Criteria 192
12.2 Open-Loop Tuning (Cohen–Coon) Method 194
12.3 Closed-Loop Tuning (Ziegler–Nichols) Method 195
12.4 Autotuning (Relay) Controller 200
12.5 Practical Issues in PID Design 204
12.5.1 Direct and Reverse Action 205
12.5.2 Bumpless Transfer 206
12.5.3 PID Equation Forms 206
12.6 Summary 208
Continuing Problem 209

Section IV Additional Reading 211
Section IV Exercises 213

Section V
Multivariable Control 217

Chapter 13
Multivariable Systems: Special Cases 219
13.1 Cascade Control 219
13.2 Ratio Control 223
13.2.1 Ratio Computation 223
13.2.2 Set-Point Computation 223
13.3 Override Control 227
13.4 Summary 230
Continuing Problem 231

Chapter 14
Multivariable Systems: General Concepts 237
14.1 Characteristics of Multivariable Processes 237
14.2 Modeling of Multivariable Processes 238
14.3 Transfer Functions of Multivariable Processes 240
14.3.1 Poles and Zeros of MIMO Systems 242
14.4 Multivanable Feedback Control Structure 245
14.4.1 Closed-Loop Poles and Zeros 246
14.4.2 Stability of MIMO Closed-Loop Systems 247
14.5 Summary 249

Chapter 15
Design of Multivariable Controllers 251
15.1 MIMO Feedback Analysis 251
15.2 RGA Interaction Measure 256
15.2.1 Selection of Loops 258
15.3 Multiloop Controller Design 260
15.4 Design of Noninteracting Control Loops: Decouplers 261
15.5 Summary 265
Continuing Problem 265

Section V Additional Reading 273
Section V Exercises 275

Section VI
Model-Based Control 279

Chapter 16
Model-Based Control 281
16.1 Feedforward Control 281
16.1.1 Feedforward–Feedback Control Strategy 283
16.2 Delay Compensation (Smith Predictor) 284

16.3 Internal Model Control (IMC) Structure 287
16.3.1 Concept of Perfect Control 289
16.3.2 IMC Design Procedure 290
16.3.3 PID Tuning using IMC Rules 294
16.4 Summary 295
Continuing Problem 296

Chapter 17
Model Uncertainty and Robustness 307
17.1 IMC Structure with Model Uncertainty 307
17.2 Description of Model Uncertainty 308
17.2.1 Additive Uncertainty 308
17.2.2 Multiplicative Uncertainty 309
17.2.3 Estimation of Uncertainty Bounds 309
17.3 IMC Design Under Model Uncertainty 311
17.3.1 Robust Stability 312
17.3.2 Robust Performance 313
17.4 Summary 317

Chapter 18
Model Predictive Control (MPC) 319
18.1 General Principles 319
18.1.1 Model Forms 321
18.2 Dynamic Matrix Control 323
18.2.1 SISO Unconstrained DMC Problem 325
18.2.2 Controller Tuning 326
18.3 Treatment of Process Constraints 327
18.4 State-Space Formulation of MPC 331
18.4.1 Infinite Horizon Problem 332
18.5 Summary 334
Continuing Problem 335

Chapter 19
Practical Control of Nonlinear Processes 341
19.1 Operating Regime Modeling Approach 341
19.1.1 Global Model Structure 343
19.2 Gain-Scheduling Controller 346
19.2.1 Determination of Process Gains 349
19.2.2 Gain-Scheduling Implementation 349
19.3 Multimodel Controller Design 352
19.3.1 Multimodel MPC 354
19.4 Summary 357

Section VI Additional Reading 359
Section VI Exercises 361

Section VII
Control in Modem Manufacturing 365

Chapter 20
Plantwide Process Control 367
20.1 Fundamentals of Plantwide Control 368
20.1.1 Material Recycle 369
20.1.2 Energy Integration 369
20.1.3 Chemical Component Inventories 370
20.2 Plantwide Control Design Procedure 373
20.3 Importance of Simulations for Plantwide Control 377
20.4 Targeting Economics and Environment 383
20.4.1 Economically Conscious Processes 383
20.4.2 Environmentally Conscious Processes 383
20.4.3 Process Integration for Economic and Environmental Improvement 384
20.4.4 Plantwide Control of Integrated Processes 385
20.5 Summary 389

Chapter 21
Industrial Control Technology 393
21.1 Evolution of Industrial Control technology 393
21.2 Generic Industrial Control Systems Architecture 394
21.2.1 Supervisory Environment 394
21.2.2 Control Environment 396
21.2.3 Communication Environment 396
21.2.4 Data Exchange 397
21.3 Summary 405
Continuing Problem 405

Chapter 22
Role of Process Control in Modem Manufacturing 411
22.1 Expanded Role of Control in Modem Manufacturing 411
22.2 Integrated Control Systems 419
22.3 Summary 425

Chapter 23
Data Processing and Reconciliation 429
23.1 Dealing with Missing Points 429
23.2 Outliers 432

23.3 Characterizing Process Data 434
23.4 Modeling Process Data 437
23.4.1 Model Fitting Based on Least-Squares Estimation 438
23.5 Data Reconciliation 439
23.6 Issues in Data Reconciliation 442
23.6.1 Process Model 442
23.6.2 Classification of Process Variables 444
23.6.3 Linear Data Reconciliation with Unmeasured Variables 445
23.6.4 Gross Errors 446
23.7 Summary 448

Chapter 24
Process Monitoring 449
24.1 Statistical Process Control 449
24.1.1 Control Charts 450
24.1.2 Control Chart Interpretation 451
24.1.3 Multivariate Charts 452
24.2 Principal Component Analysis (PCA) 453
24.2.1 Calculation of PCA 453
24.3 Multivariate Performance Monitoring 458
24.3.1 Elliptical Normal Operation region 460
24.3.2 T^2 and SPE Charts 462
24.3.3 Contribution Plots 463
24.4 Fault Diagnosis and Classification 463
24.5 Controller Performance Monitoring (CPM) 470
24.5.1 State Classification 472
24.5.2 Model Validation 472
24.5.3 Stochastic Performance Monitoring 473
24.5.4 Controller Oscillation Assessment 474
24.6 Summary 475

Section VII Additional Reading 477
Section VII Exercises 479

Appendix A
Linearization 483
A.1 Basic Steps in Linearization 483
A.2 Linearization Generalized 486

Appendix B
Laplace Transformation 491
B.1 Definition 491
B.2 Laplace Transform of Some Typical Functions 491

B.3 Some Useful Properties of the Laplace Transform 493
B.4 Partial Fraction Expansion 495

Appendix C
Matrix Operations 499
C.1 Vectors and Matrices 499
C.1.1 Special Matrices 500
C.2 Determinant and Inverse 500
C.3 Eigenvalue Decomposition 502
C.4 Singular-Value Decomposition 503
C.5 Vector and Matrix Norms 504

Appendix D
Basic Statistics 507
D.1 Sample Mean and Standard Deviation 507
D.2 Random Variables and Probability Distributions 508
D.3 Gaussian (Normal) Distribution 509
D.4 Correlations and Covariance 511
D.5 χ^2 and F Distributions 512

Index 515