

ESSENTIALS OF PROCESS CONTROL

WILLIAM L. LUYBEN/MICHAEL L. LUYBEN

Essentials of Process Control

McGraw-Hill Chemical Engineering Series

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Essentials of Process Control

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To Janet Nichol Luyben—mother, wife, friend, loving grandmother, avid gardener, community volunteer; softball queen extraordinaire—for 34 years of love, ~~care~~, level-headed financial advice, and many pieces of Grandmother Lester's apple pie.

CONTENTS

Preface	xvii
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1 Introduction	1
1.1 Examples of Process Dynamics and Control	2
1.2 Some Important Simulation Results	6
1.2.1 <i>Proportional and Proportional-Integral Level Control</i> / 1.2.2 <i>Temperature Control of a Three-Tank Process</i>	
1.3 General Concepts and Terminology	20
1.4 Laws, Languages, and Levels of Process Control	22
1.4.1 <i>Process Control Laws</i> / 1.4.2 <i>Languages of Process Control</i> / 1.4.3 <i>Levels of Process Control</i>	
1.5 Conclusion	24

P A R T 1 Time Domain Dynamics and Control

2 Time Domain Dynamics	27
2.1 Classification and Definition	27
2.2 Linearization and Perturbation Variables	31
2.2.1 <i>Linearization</i> / 2.2.2 <i>Perturbation Variables</i>	
2.3 Responses of Simple Linear Systems	36
2.3.1 <i>First-Order Linear Ordinary Differential Equation</i> / 2.3.2 <i>Second-Order Linear ODEs with Constant Coefficients</i> / 2.3.3 <i>Nth-Order Linear ODEs with Constant Coefficients</i>	
2.4 Solution Using MATLAB	54
2.5 Conclusion	58
Problems	59

3 Conventional Control Systems and Hardware	67
3.1 Control Instrumentation	67
3.1.1 <i>Sensors</i> / 3.1.2 <i>Transmitters</i> / 3.1.3 <i>Control Valves</i> / 3.1.4 <i>Analog and Digital Controllers</i> / 3.1.5 <i>Computing and Logic Devices</i>	
3.2 Performance of Feedback Controllers	87
3.2.1 <i>Specifications for Closedloop Response</i> / 3.2.2 <i>Load Performance</i>	

3.3 Controller Tuning	92
3.3.1 <i>Rules of Thumb</i> / 3.3.2 <i>On-Line Trial and Error</i> /	
3.3.3 <i>Ziegler-Nichols Method</i> / 3.3.4 <i>Tyres-Luyben Method</i>	
3.4 Conclusions	99
Problems	99
 4 Advanced Control Systems	 117
4.1 Ratio Control	117
4.2 Cascade Control	118
4.3 Computed Variable Control	120
4.4 Override Control	122
4.5 Nonlinear and Adaptive Control	125
4.6 Valve Position (Optimizing) Control	126
4.7 Feedforward Control Concepts	128
4.8 Control System Design Concepts	129
4.9 Conclusion	135
Problems	135
 5 Interaction between Steady-State Design and Dynamic Controllability	 151
5.1 Introduction	151
5.2 Qualitative Examples	152
5.2.1 <i>Liquid Holdups</i> / 5.2.2 <i>Gravity-Flow Condenser</i>	
5.3 Simple Quantitative Example	153
5.3.1 <i>Steady-State Design</i> / 5.3.2 <i>Dynamic Controllability</i> /	
5.3.3 <i>Maximum Heat Removal Rate Criterion</i>	
5.4 Impact of Controllability on Capital Investment and Yield	165
5.4.1 <i>Single-Reaction Case</i> / 5.4.2 <i>Consecutive Reactions Case</i>	
5.5 General Trade-off between Controllability and Thermodynamic Reversibility	174
5.6 Quantitative Economic Assessment of Steady-State Design and Dynamic Controllability	175
5.6.1 <i>Alternative Approaches</i> / 5.6.2 <i>Basic Concepts of the Capacity-Based Method</i> /	
5.6.3 <i>Reactor-Column-Recycle Example</i>	
5.7 Conclusion	182
 6 Plantwide Control	 183
6.1 Series Cascades of Units	183
6.2 Effect of Recycle on Time Constants	184
6.3 Snowball Effects in Recycle Systems	185

6.4	Use of Steady-State Sensitivity Analysis to Screen Plantwide Control Structures	190
	<i>6.4.1 Control Structures Screened</i>	
6.5	Second-Order Reaction Example	194
	<i>6.5.1 Complete One-Pass Conversion / 6.5.2 Incomplete Conversion Case / 6.5.3 Interaction between Design and Control / 6.5.4 Stability Analysis</i>	
6.6	Plantwide Control Design Procedure	220
6.7	Conclusion	222
	Problems	222

P A R T 2 **Laplace-Domain Dynamics and Control**

7	Laplace-Domain Dynamics	229
7.1	Laplace Transformation Fundamentals	229
	<i>7.1.1 Definition / 7.1.2 Linearity Property</i>	
7.2	Laplace Transformation of Important Functions	230
	<i>7.2.1 Step / 7.2.2 Ramp / 7.2.3 Sine / 7.2.4 Exponential / 7.2.5 Exponential Multiplied by Time / 7.2.6 Impulse (Dirac Delta Function $\delta(t)$)</i>	
7.3	Inversion of Laplace Transforms	234
7.4	Transfer Functions	237
	<i>7.4.1 Multiplication by a Constant / 7.4.2 Differentiation with Respect to Time / 7.4.3 Integration / 7.4.4 Deadtime</i>	
7.5	Examples	241
7.6	Properties of Transfer Functions	249
	<i>7.6.1 Physical Realizability / 7.6.2 Poles and Zeros / 7.6.3 Steady-State Gains</i>	
7.7	Transfer Functions for Feedback Controllers	254
7.8	Conclusion	255
	Problems	255
8	Laplace-Domain Analysis of Conventional Feedback Control Systems	265
8.1	Openloop and Closedloop Systems	265
	<i>8.1.1 Openloop Characteristic Equation / 8.1.2 Closedloop Characteristic Equation and Closedloop Transfer Functions</i>	
8.2	Stability	271
8.3	Performance Specifications	273
	<i>8.3.1 Steady-State Performance / 8.3.2 Dynamic Specifications</i>	

8.4	Root Locus Analysis	276
	8.4.1 <i>Definition</i> / 8.4.2 <i>Construction of Root Locus Curves</i>	
8.5	Conclusion	287
	Problems	288

9	Laplace-Domain Analysis of Advanced Control Systems	301
9.1	Cascade Control	301
	9.1.1 <i>Series Cascade</i> / 9.1.2 <i>Parallel Cascade</i>	
9.2	Feedforward Control	308
	9.2.1 <i>Linear Feedforward Control</i> / 9.2.2 <i>Nonlinear Feedforward Control</i>	
9.3	Openloop-Unstable Processes	316
	9.3.1 <i>Simple Systems</i> / 9.3.2 <i>Effects of Lags</i> / 9.3.3 <i>PD Control</i> / 9.3.4 <i>Effect of Reactor Scale-up on Controllability</i>	
9.4	Processes with Inverse Response	323
9.5	Model-Based Control	326
	9.5.1 <i>Direct Synthesis</i> / 9.5.2 <i>Internal Model Control</i>	
9.6	Conclusion	331
	Problems	331

PART 3 Frequency-Domain Dynamics and Control

10	Frequency-Domain Dynamics	339
10.1	Definition	339
10.2	Basic Theorem	341
10.3	Representation	344
	10.3.1 <i>Nyquist Plots</i> / 10.3.2 <i>Bode Plots</i> / 10.3.3 <i>Nichols Plots</i>	
10.4	Computer Plotting	360
	10.4.1 <i>FORTTRAN Programs for Plotting Frequency Response</i> / 10.4.2 <i>MATLAB Program for Plotting Frequency Response</i>	
10.5	Conclusion	369
	Problems	370
11	Frequency-Domain Analysis of Closedloop Systems	372
11.1	Nyquist Stability Criterion	372
	11.1.1 <i>Proof</i> / 11.1.2 <i>Examples</i> / 11.1.3 <i>Representation</i>	

11.2	Closedloop Specifications in the Frequency Domain	386
11.2.1	<i>Phase Margin / 11.2.2 Gain Margin /</i>	
11.2.3	<i>Maximum Closedloop Log Modulus (L_c^{\max})</i>	
11.3	Frequency Response of Feedback Controllers	395
11.3.1	<i>Proportional Controller (P) /</i>	
11.3.2	<i>Proportional-Integral Controller (PI) /</i>	
11.3.3	<i>Proportional-Integral-Derivative Controller (PID)</i>	
11.4	Examples	397
11.4.1	<i>Three-CSTR Process / 11.4.2 First-Order Lag</i>	
11.4.3	<i>Openloop-Unstable Processes</i>	
11.5	Use of MATLAB for Frequency Response Plots	407
11.6	Capacity-Based Method for Quantifying Controllability	412
11.7	Conclusion	414
	Problems	414

P A R T 4 **Multivariable Processes**

12	Matrix Representation and Analysis	429
12.1	Matrix Representation	429
12.1.1	<i>Matrix Properties / 12.1.2 Transfer Function Representation / 12.1.3 State Variables</i>	
12.2	Stability	440
12.2.1	<i>Closedloop Characteristic Equation /</i>	
12.2.2	<i>Multivariable Nyquist Plot / 12.2.3 Niederlinski Index</i>	
12.3	Interaction	447
12.3.1	<i>Relative Gain Array / 12.3.2 Decoupling</i>	
12.4	Conclusion	452
	Problems	452
13	Design of Controllers for Multivariable Processes	456
13.1	Problem Definition	456
13.2	Selection of Controlled Variables	457
13.2.1	<i>Engineering Judgment / 13.2.2 Singular Value Decomposition</i>	
13.3	Selection of Manipulated Variables	459
13.4	Elimination of Poor Pairings	460
13.5	BLT Tuning	461
13.6	Load Rejection Performance	466

13.7 Model Predictive Control	471
13.8 Conclusion	472
Problems	472

P A R T 5 Sampled-Data Systems

14 Sampling, z Transforms, and Stability	477
14.1 Introduction	477
14.1.1 Definition / 14.1.2 Occurrence of Sampled-Data Systems in Chemical Engineering	
14.2 Impulse Sampler	480
14.3 Basic Sampling Theorem	483
14.4 z Transformation	486
14.4.1 Definition / 14.4.2 Derivation of z Transforms of Common Functions / 14.4.3 Effect of <i>Deadtime</i> / 14.4.4 z Transform Theorems / 14.4.5 Inversion	
14.5 Pulse Transfer Functions	496
14.6 Hold Devices	498
14.7 Openloop and Closedloop Systems	499
14.8 Stability in the z Plane	509
14.9 Conclusion	511
Problems	511
15 Stability Analysis of Sampled-Data Systems	513
15.1 Root Locus Design Methods	513
15.2 Frequency-Domain Design Techniques	521
15.2.1 Nyquist <i>Stability Criterion</i> / 15.2.2 Rigorous Method / 15.2.3 Approximate Method / 15.2.4 Use of <i>MATLAB</i>	
15.3 Physical Realizability	528
15.4 Minimal-Prototype Design	529
15.5 Conclusion	535
Problems	535

P A R T 6 Identification

16 Process Identification	545
16.1 Fundamental Concepts	546
16.1.1 Control-Relevant Identification / 16.1.2 Frequency Content of the Input Signal / 16.1.3 Model Order	

16.2	Direct Methods	547
	<i>16.2.1 Time-Domain Fitting of Step Test Data /</i>	
	<i>16.2.2 Direct Sine Wave Testing</i>	
16.3	Pulse Testing	552
16.4	Relay Feedback Identification	554
	<i>16.4.1 Autotuning / 16.4.2 Approximate Transfer</i>	
	<i>Functions</i>	
16.5	Least-Squares Methods	556
16.6	Use of the MATLAB Identification Toolbox	560
16.7	Conclusion	565
	Problems	565
Appendix A		567
	Computer Programs	567
	Nonlinear Model	571
Appendix B: Instrumentation Hardware		572
Index		581

PREFACE

The field of process control **has** grown rapidly since its inception in the 1950s. Direct evidence of this growth in the body of knowledge is easily found by comparing the lengths of the textbooks written over this time period. The first process control book (Cealgske, 1956) was a modest 230 pages. The popular Coughanowr and Koppel (1965) text was 490 pages. The senior author's first edition (1973) was 560 pages. The text by Seborg et al. (1989) was 710 pages. The recently published text by Ogunnaike and Ray (1994) runs 1250 pages!

It seems obvious to us that more material has been developed than can be taught in a typical one-semester undergraduate course in process control. Therefore, a short and concise textbook is needed that presents only the essential aspects of process control that every chemical engineering undergraduate ought to know. The purpose of this book is to fulfill this need.

Our intended audience is junior and senior undergraduate chemical engineering students. The book is meant to provide the fundamental concepts and the practical tools needed by all chemical engineers, regardless of the particular area they eventually enter. Since many advanced control topics are not included, those students who want to specialize in control can go further by referring to more comprehensive texts, such as Ogunnaike and Ray (1994).

The mathematics of the subject are minimized, **and more** emphasis is placed on examples that illustrate principles and concepts of great practical importance. Simulation programs (in FORTRAN) for a number of example processes are used to generate dynamic results. Plotting and analysis are accomplished using computer-aided software (MATLAB).

One of the unique features of this book involves our coverage of two increasingly important areas in process design and process control. The first is the interaction between steady-state design and control. The second is plantwide control with particular emphasis on the selection of control structures for an entire multi-unit process. Other books have not dealt with these areas in any quantitative way. Because we feel that these subjects are central to the missions of process design engineers and process control engineers, we devote two chapters to them.

We have injected **some** examples and problems that **illustrate** the interdisciplinary nature of the control field. Most control groups **in** industry utilize the talents of engineers from many disciplines: chemical, mechanical, and electrical. All engineering fields use the same mathematics for dynamics and control. Designing control systems for chemical reactors and distillation columns in chemical engineering has direct parallels with designing control systems for F-16 fighters, 747 jumbo jets, Ferrari sports cars, or garbage trucks. We illustrate this in several places in the text.

This book is intended to be a learning tool. We try to educate our readers, not impress them with elegant mathematics or language. Therefore, we hope you find the book readable, clear, and (most important) useful.

When you have completed your study of this book, you will have covered the essential areas of process control. What ideas should you take away from this study and apply toward the practice of chemical engineering (whether or not you specialize as a control engineer)?

1. The most important lesson to remember is that our focus as engineers must be on the process. We must understand its operation, objectives, constraints, and uncertainties. No amount of detailed modeling, mathematical manipulation, or supercomputer exercise will overcome our ignorance if we ignore the true subject of our work. We need to think of Process control with a capital *P* and a small *c*.
2. A steady-state analysis, although essential, is typically not sufficient to operate a chemical process satisfactorily. We must also understand something about the dynamic behavior of the individual units and the process as a whole. At a minimum, we need to know what characteristics (deadtimes, transport rates, and capacitances) govern the dynamic response of the system.
3. It is always best to utilize the simplest control system that will achieve the desired objectives. Sophistication and elegance on paper do not necessarily translate into effective performance in the plant. Careful attention must be paid to the practical consequences of any proposed control strategy. Our control systems must ensure safe and stable operation, they must be robust to changes in operating conditions and process variables, and they must work reliably.
4. Finally, we must recognize that the design of a process fundamentally determines how it will respond dynamically and how it can be controlled. Considerations of controllability need to be incorporated into the process design. Sometimes the solution to a control problem does not have anything to do with the control system but requires some modification to the process itself.

If we keep these ideas in mind, then we can apply the basic principles of process control to solve engineering problems.

Michael L. Luyben
William L. Luyben

1. Introduction
2. Process Control
3. Control Systems
4. Control Strategies
5. Control Design
6. Control Implementation
7. Control Maintenance
8. Control Troubleshooting
9. Control Safety
10. Control Conclusion

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