

# Multiple Delay Dead-Time Compensation: From Stability- to Performance-Driven Configurations

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Based on a collaboration with *G. Meinsma*, *Z. J. Palmor*, and *D. Shneiderman*

# The theme of this talk

Problem-oriented control scheme for control of dead-time systems,

- **dead-time compensation** (DTC)

# Talk outline

Prolog: a friendly intro to dead-time compensation

Smith predictor: the first dead-time compensator

Single-delay dead-time compensation: analytical justifications

Multiple-delay dead-time compensation

Feedforward action Smith predictor (FASP)

From stability- to performance-oriented

Conclusions

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# Prolog: a friendly intro to dead-time compensation

Time-delay stabilization problem for  $n$ -dimensional equation

$$x[k + 1] = Ax[k] + Bu[k - h]$$

where  $x$  and  $u$  measurable and  $(A, B)$  controllable is equivalent to

Delay-free stabilization problem for  $(n + h)$ -dimensional state equation

$$\underbrace{\begin{bmatrix} u[k] \\ u[k-1] \\ \vdots \\ u[k-h+1] \\ x[k+1] \end{bmatrix}}_{x_a[k+1]} = \underbrace{\begin{bmatrix} 0 & \cdots & 0 & 0 & 0 \\ 1 & \cdots & 0 & 0 & 0 \\ \vdots & \ddots & \vdots & \vdots & \vdots \\ 0 & \cdots & 1 & 0 & 0 \\ 0 & \cdots & 0 & B & A \end{bmatrix}}_{A_a} \underbrace{\begin{bmatrix} u[k-1] \\ u[k-2] \\ \vdots \\ u[k-h] \\ x[k] \end{bmatrix}}_{x_a[k]} + \underbrace{\begin{bmatrix} 1 \\ 0 \\ \vdots \\ 0 \\ 0 \end{bmatrix}}_{B_a} u[k]$$

where  $x_a$  and  $u$  measurable and  $(A_a, B_a)$  controllable.

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where  $x_a$  and  $u$  measurable and  $(A_a, B_a)$  controllable.

## Pole placement

Controllability  $\implies \text{spec}(A_a + B_a F_a)$  can be assigned arbitrarily. But

$$\bullet A_a = \begin{bmatrix} 0 & \cdots & 0 & 0 & 0 \\ 1 & \cdots & 0 & 0 & 0 \\ \vdots & \ddots & \vdots & \vdots & \vdots \\ 0 & \cdots & 1 & 0 & 0 \\ \hline 0 & \cdots & 0 & B & A \end{bmatrix} \text{ has } h \text{ eigenvalues at the origin,}$$

which might make sense to keep untouched. With this in mind, applying the Ackermann's formula to

$$\chi_{cl,a}(z) = \chi_{cl}(z)z^h, \quad \text{for arbitrary } n\text{-order } \chi_{cl}(z)$$

and exploiting the structure of  $A_a$  and  $B_a$ , we end up with

$$F_a = F \left[ B \ AB \ \cdots \ A^{h-1}B \ A^h \right],$$

where  $F$  solves  $\det(A + BF) = \chi_{cl}(z)$ , which is  $n$ -dimensional (delay free).

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## Control law

The control law we just derived,

$$u[k] = F \left( A^h x[k] + \sum_{i=1}^h A^{i-1} B u[k-i] \right) \stackrel{\text{calc}}{=} F x[k+h],$$

can be interpreted as predictive state feedback.

Controllers of the form

$$\text{here, } \Pi(z) = \sum_{i=1}^h A^{i-1} B z^{-i}$$

where

- internal feedback aims at rendering  $\tilde{x}$  a prediction of  $x$
- primary part designed for a delay-free plant

called *dead-time compensators* (DTCs).

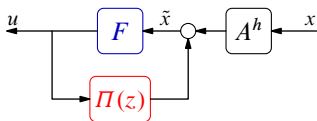
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Single-delay dead-time compensation: analytical justifications

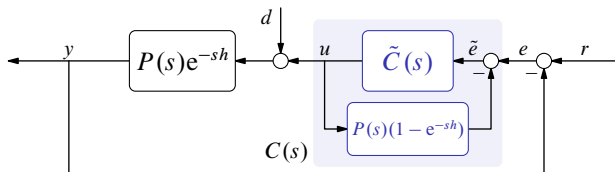
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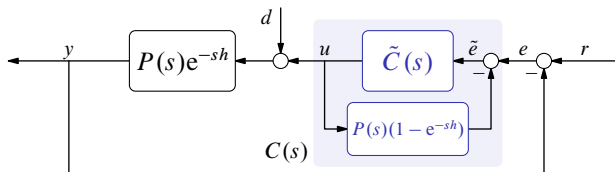
# Smith controller



Introduced by Otto J. M. Smith in 1957, comprises

- $P(s)(1 - e^{-sh})$  — **Smith predictor**  
w/o  $d$ , we have that  $\tilde{e} = (r - y) - P(1 - e^{-sh})u = r - Pu$  is prediction of delay-free  $e$
- $\tilde{C}(s)$  — **primary controller**  
designed for delay-free  $P(s)$

# Closed-loop system



Closed-loop response

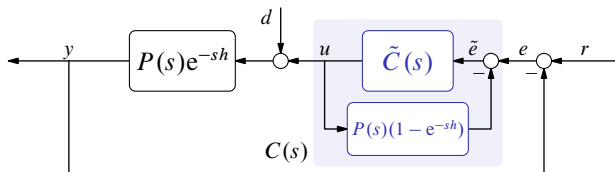
$$y = e^{-sh} \frac{P\tilde{C}}{1 + P\tilde{C}} r + \frac{1 + P\tilde{C}(1 - e^{-sh})}{1 + P\tilde{C}} Pd.$$

has no delay in denominators, meaning that

😊 delay eliminated from the characteristic equation

😊 reference response greatly simplified

## Closed-loop system



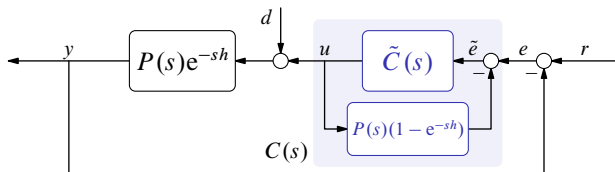
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## Success story

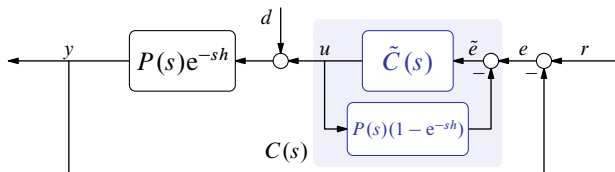


- intriguing properties  
numerous studies (zillions of papers, many book chapters)
- numerous modifications / generalizations  
modified Smith predictor, finite spectrum assignment, etcetera
- it does work  
many industrial applications, part of commercial controllers

Otto J. M. Smith listed in the ISA "Leaders of the Pack" list (2003) as one of the 50 most influential industry innovators since 1774.



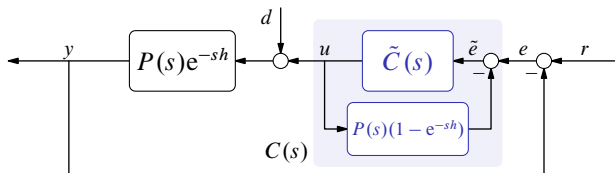
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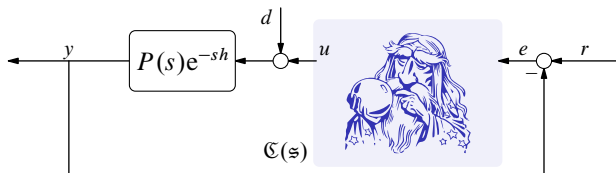
# “A process engineer’s crystal ball” (V. J. VanDoren)



So far as the structure of DTC is concerned:

- empirical approaches dominate  
driven mostly by engineering insight, with few attempts to be rigorous
  - many extensions/modifications, but few analytically justified  
structure postulated and then its properties analyzed
  - simulations as proofs
- ⇓
- quite a few misconceptions

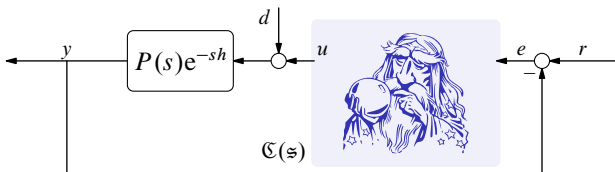
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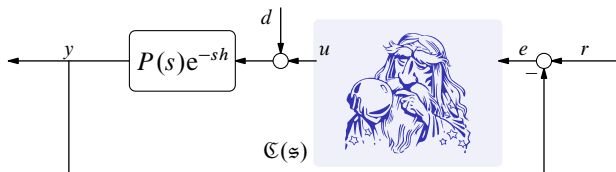
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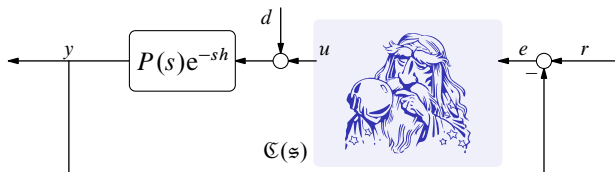
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## Urban legends (partial list)



- not efficient in disturbance attenuation
- intrinsically poor robustness
- stabilization induces “true” DTC controller structure
- artificial loop delays might be advantageous in multiple-delay systems

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# Stability

- ◇ **Stabilization** (Watanabe & Ito, 1981)  
stabilization via eliminating delays from the characteristic equation for unstable plants, introduced the **modified Smith predictor** (MSP)
- ◇ **Finite spectrum assignment** (Manitius & Olbrot, 1979; Lewis, 1979; Furukawa & Shimemura, 1983; et alii)  
state-predictor, observer-predictor; equivalent to MSP (Mirkin & Raskin, 2003)
- ◇ **Youla parametrization** (Mirkin & Raskin, 2003)  
parametrization of all stabilizing controllers, MSP
- ◇ **Coprime factorization** (Curtain, Weiss, & Weiss, 1996)  
MSP is an integral part of it
- ◇ **Robust stability** (Morari & Zafriou, 1989; Zwart & Bontsema, 1997; Mirkin & Raskin, 2003)  
DTCs maximize robustness radius for several uncertainty descriptions
- ◇ **Nonlinear systems** (Krstic, 2009)  
Lyapunov analysis

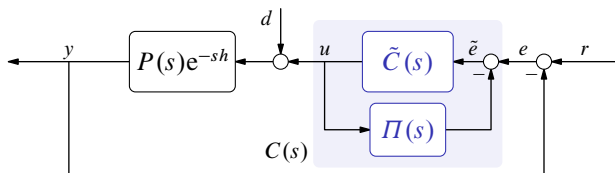


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# Stability-induced controller structure

Analytical approaches **bring about**<sup>1</sup> DTC controller structure



consisting of

- irrational  $\Pi(s)$  in **internal feedback**

only limited to be stable and such that  $\tilde{P}(s) := P(s)e^{-sh} + \Pi(s)$  rational; always exists

- Smith predictor corresponds to  $\Pi(s) = P(s)(1 - e^{-sh})$ , works only for stable  $P$
- modified Smith predictor yields  $\Pi(s)$  with finite impulse response (FIR)

- rational  $\tilde{C}(s)$  (primary controller)  
stabilizes rational  $\tilde{P}(s)$

<sup>1</sup>Controller structure **results from** solution procedure, not postulated beforehand.

# Performance

## Early results:

- LQG optimal control (Kleinman, 1969)  
effectively invented observer-predictor controller (unfortunately, overlooked)
- SISO minimum variance control (Palmer, 1982)  
optimal controller can always be cast as Smith predictor if plant stable

## Recent problem-oriented solutions

- $H^\infty$  (Tadmor, 2000; Meinsma & Zwart, 2000; Mirkin, 2003)
- $H^2$  / LQG (Mirkin & Raskin, 2003)
- $L^1$  (Mirkin, 2006; Di Loreto *et al.*, 2008)

demonstrated that

- DTC is an intrinsic part of general optimal solutions

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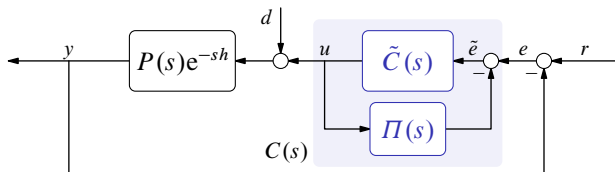
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# Performance-induced controller structure

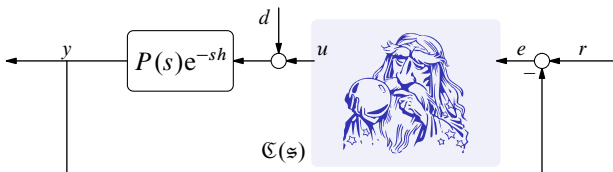


- irrational stable  $\Pi(s)$  in **internal feedback**
  - MSP in  $H^2$  and  $L^1$  cases
  - MSP + feedforward SP of (Palmor & Powers, 1985) for worst-case  $d$  in  $H^\infty$  case
- rational  $\tilde{C}(s)$   
solves corresponding problem for rational  $\tilde{P}(s) := P(s)e^{-sh} + \Pi(s)$

# Stability vs. performance: single-delay case

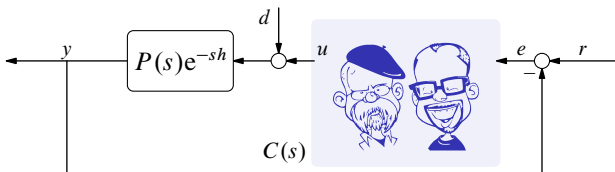
No conflict

# MythBusters



- not efficient in disturbance attenuation ← busted
- intrinsically poor robustness ← busted
- stabilization induces “true” DTC controller structure ← plausible
- artificial loop delays might be advantageous ← busted

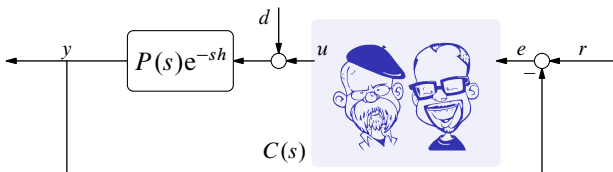
# MythBusters



- not efficient in disturbance attenuation ← **busted**
  - ↪ optimal disturbance attenuators ( $H^2$ ,  $H^\infty$ ,  $L^1$ ) are all DTCs
- intrinsically poor robustness ← **busted**
- stabilization induces “true” DTC controller structure ← **plausible**
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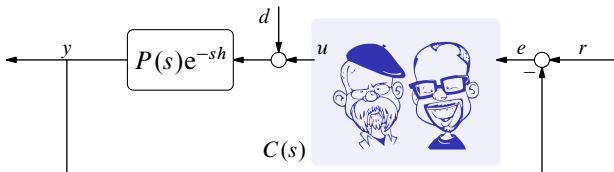


# MythBusters



- not efficient in disturbance attenuation ← **busted**
- intrinsically poor robustness ← **busted**
  - ↔ controllers maximizing complex robustness radii ( $H^\infty$ ,  $L^1$ ) are all DTCs
  - ↔ SP preserves robustness of delay-free design to uncertainty in  $P(s)$
- stabilization induces “true” DTC controller structure ← **plausible**
- artificial loop delays might be advantageous ← **busted**

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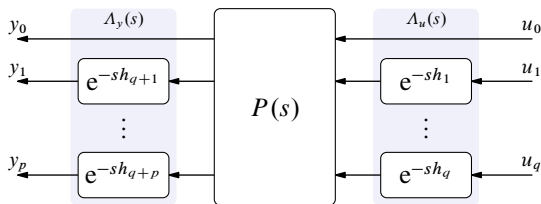
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## Multiple I/O delay systems

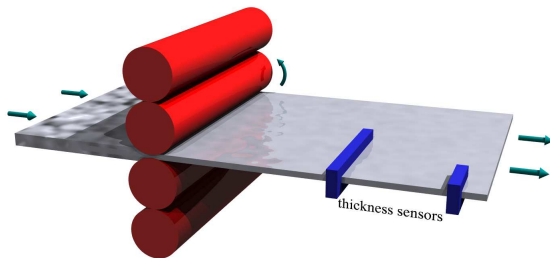
Different delays in different I/O channels:



where

$$\Lambda_u(s) = \begin{bmatrix} I & & & \\ & e^{-sh_1} I & & \\ & & \ddots & \\ & & & e^{-sh_q} I \end{bmatrix} \quad \text{and} \quad \Lambda_y(s) = \begin{bmatrix} I & & & \\ & e^{-sh_{q+1}} I & & \\ & & \ddots & \\ & & & e^{-sh_{q+p}} I \end{bmatrix}$$

## Example: hot strip mill profile control



- sensors for measuring thickness at edges and at the centerline located at different distances from the stand exit

# Stability

Direct extensions of single-delay results:

- Youla parametrization (Raskin, 2001; Moelja & Meinsma, 2003)
- finite spectrum assignment (Kwon & Pearson, 1980; Artstein, 1982; Fiagbedzi & Pearson, 1990)

Induced controller structure:

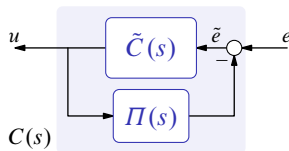
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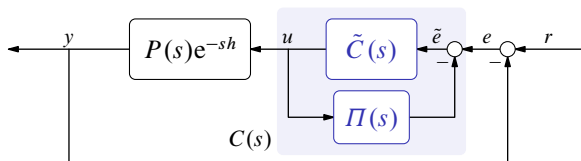
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## Performance

Choosing any stable DTC  $\Pi = \tilde{P} - P e^{-sh}$  with rational  $\tilde{P}$ ,



Single input delay: because  $P e^{-sh} = e^{-sh} P$ ,

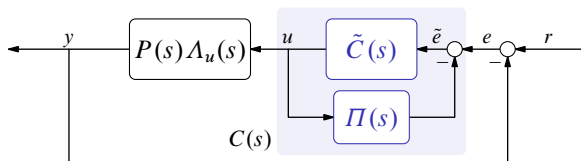
$$T_{ry} = P e^{-sh} \tilde{C} (I + \tilde{P} \tilde{C})^{-1} = \underbrace{e^{-sh}}_{\text{non-invertible}} \underbrace{P \tilde{C} (I + \tilde{P} \tilde{C})^{-1}}_{\text{rational}}$$

- ☺ irrational non-invertible **inner** (i.e., energy preserving) part is isolated
- ☺  $\tilde{C}$  designed ignoring  $e^{-sh}$   
more precisely, not accounting for  $e^{-sh}$  explicitly



## Performance

Choosing any stable DTC  $\Pi = \tilde{P} - P\Lambda_u$  with rational  $\tilde{P}$ ,



**Multiple input delays:** in general  $P\Lambda_u \neq \Lambda_u P$  (input channels mix up in  $y$ ), hence

$$T_{ry} = P\Lambda_u \tilde{C} (I + \tilde{P}\tilde{C})^{-1}$$

- ☹ hard to analyze  
non-invertible irrational  $\Lambda_u$  stuck in the middle
- ☹ poor performance if  $\tilde{C}$  designed ignoring  $\Lambda_u$   
noticed by Jerome & Ray (1986), who analyzed prior attempts

## State of the art: GMDC (Jerome & Ray, 1986)

Generalized multidelay compensator (GMDC) attempts to pull  $\Lambda_u$  through the output (the rearrangement test):

$$P\Lambda_u = \Lambda_u \tilde{P}_{JR} \quad \text{for some (irrational) causally invertible } \tilde{P}_{JR}.$$

If possible: set  $\Lambda_d = I$

If impossible: find artificial delays  $\Lambda_d$  such that  $P\Lambda_u\Lambda_d$  passes the test  
 always exists, just think of  $\Lambda_u = \begin{bmatrix} 1 & e^{-sh} \end{bmatrix}$ , for which  $\Lambda_d = \begin{bmatrix} e^{-sh} & 1 \end{bmatrix}$  results in  
 $\Lambda_u\Lambda_d = e^{-sh}I$  (single delay)

Then,

- choose  $\Pi = \tilde{P}_{JR} - P\Lambda_u\Lambda_d$
- design  $\tilde{C}$  for (possibly irrational)  $\tilde{P}_{JR}$

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- choose  $\Pi = \tilde{P}_{JR} - P\Lambda_u\Lambda_a$
- design  $\tilde{C}$  for (possibly irrational)  $\tilde{P}_{JR}$

## State of the art: GMDC (Jerome & Ray, 1986)

Generalized multidelay compensator (GMDC) attempts to pull  $\Lambda_u$  through the output (the rearrangement test):

$$P\Lambda_u = \Lambda_u \tilde{P}_{JR} \quad \text{for some (irrational) causally invertible } \tilde{P}_{JR}.$$

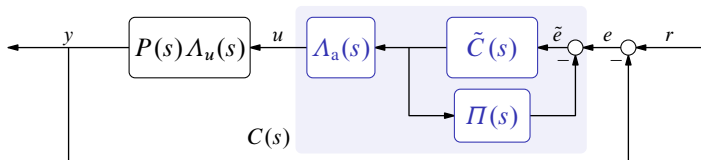
If possible: set  $\Lambda_a = I$

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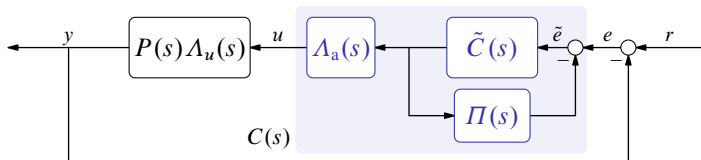
## GMDC (multiple input delays)



Two important aspects:

1. **artificial loop delays** might be added
2. **delays** might no longer be eliminated from the **characteristic equation**  
Jerome & Ray argued that this might be necessary to improve performance

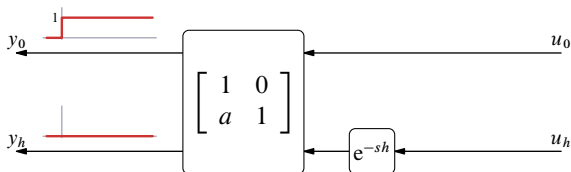
## GMDC (multiple input delays)



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1. **artificial loop delays** might be added ← appears **counterintuitive**
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## Artificial delays: additional motivation



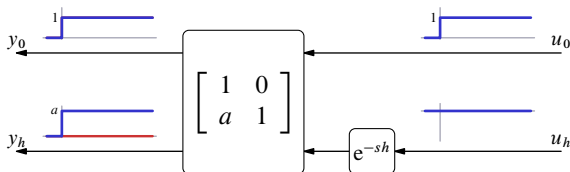
Goals:

$y_0(t) = u_0(t)$  tracks the unit step  $\mathbb{1}(t)$

$y_h(t) = u_h(t - h) + au_0(t)$  stays at zero

Arguments of Holt & Morari (1985), dynamic resilience theory:

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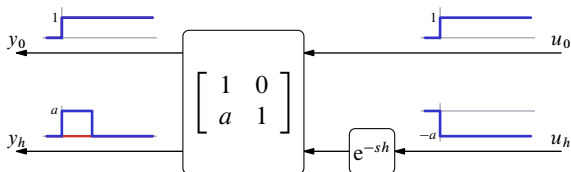
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  - hence, introducing artificial input delay may improve performance



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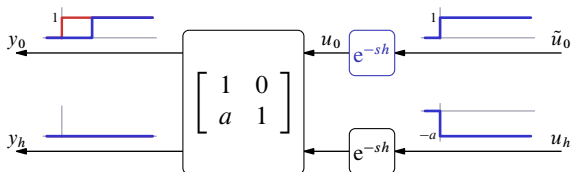
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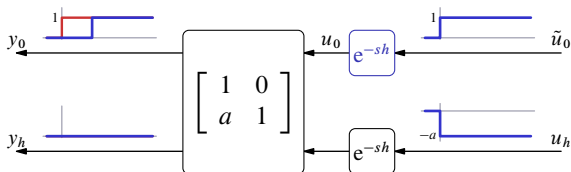
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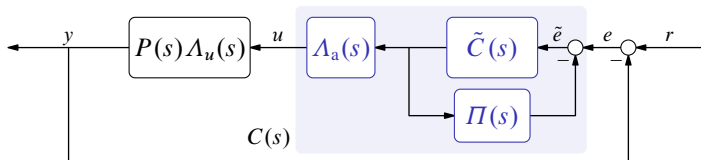
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# Stability vs. performance: multiple-delay case

Might conflict

# Talk outline

Prolog: a friendly intro to dead-time compensation

Smith predictor: the first dead-time compensator

Single-delay dead-time compensation: analytical justifications

Multiple-delay dead-time compensation

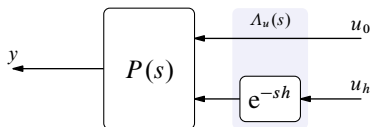
Feedforward action Smith predictor (FASP)

From stability- to performance-oriented

Conclusions

## Input adobe delay

To simplify exposition, consider



i.e., assume that

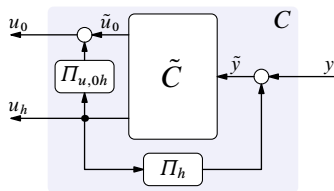
$$\Lambda_u(s) = \begin{bmatrix} I & 0 \\ 0 & e^{-sh} I \end{bmatrix} \quad \text{and} \quad \Lambda_y(s) = I.$$

- simplest nontrivial generalization of single-delay case
- captures the essence
- general case solved via nested recursion of adobe problems

## Starting point

### Technical outcome of

- multiple delay  $H^\infty$  solution (Meinsma & Mirkin, 2005)



with

1. rational  $\tilde{C}$
2. irrational (FIR)  $\Pi_h$
3. irrational (FIR)  $\Pi_{u,0h}$

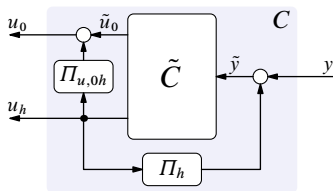
Resolved in (Mirkin, Palmor, & Shneidman, 2011).



## Starting point

Technical outcome of

- multiple delay  $H^\infty$  solution (Meinsma & Mirkin, 2005)



with

1. rational  $\tilde{C}$  ← conventional
2. irrational (FIR)  $\Pi_h$  ← conventional
3. irrational (FIR)  $\Pi_{u,0h}$  ← **unorthodox**

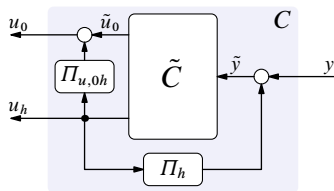
Called

- FASP** — feedforward action Smith predictor

## Starting point

Technical outcome of

- multiple delay  $H^\infty$  solution (Meinsma & Mirkin, 2005)



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1. rational  $\tilde{C}$
2. irrational (FIR)  $\Pi_h$
3. irrational (FIR)  $\Pi_{u,0h}$  ← rationale ???

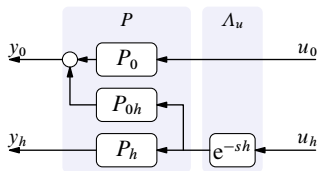
Resolved in (Mirkin, Palmor, & Shneiderman, 2011).

## Upper triangular case

Assume<sup>2</sup> first that

$$P(s) = \begin{bmatrix} P_0(s) & P_{0h}(s) \\ 0 & P_h(s) \end{bmatrix} \text{ with square and invertible } P_0(s)$$

or



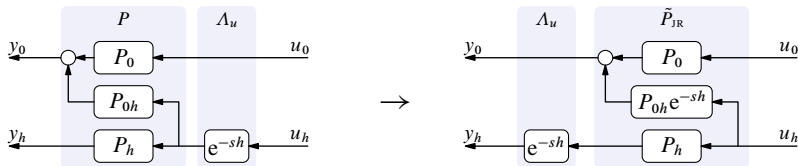
where

$y_0$  affected by mixture of delay-free and delayed input channels

$y_h$  affected only by delayed input channel

<sup>2</sup>This is the only class passing the rearrangement test.

## Upper triangular case: pulling $\Lambda_u$ through $y$



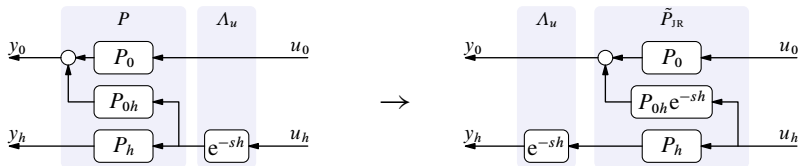
- this is where Jerome & Ray stopped

$$\tilde{P}_{JR} = \begin{bmatrix} P_0 & P_{0h}e^{-sh} \\ 0 & P_h \end{bmatrix} \text{ is causally invertible}$$

where rational  $\tilde{P}_{0h}$  and stable (irrational)  $\Pi_{u,0h}$  are such that

$$P_0^{-1}P_{0h}e^{-sh} = P_0^{-1}\tilde{P}_{0h} - \Pi_{u,0h}$$

## Upper triangular case: pulling $\Lambda_u$ through $y$

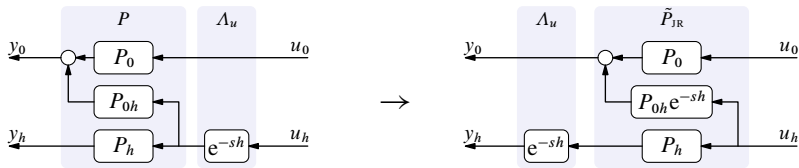


$$\begin{aligned}
 y_0 &= P_0 u_0 + P_{0h} e^{-sh} u_h \\
 &= P_0 (u_0 + P_0^{-1} P_{0h} e^{-sh} u_h) \\
 &= P_0 (u_0 + (P_0^{-1} \tilde{P}_{0h} - \Pi_{u,0h}) u_h) \\
 &= P_0 (u_0 - \Pi_{u,0h} u_h) + \tilde{P}_{0h} u_h,
 \end{aligned}$$

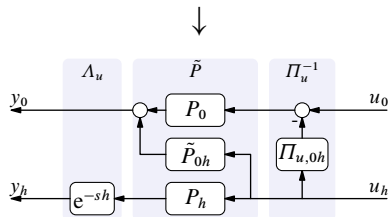
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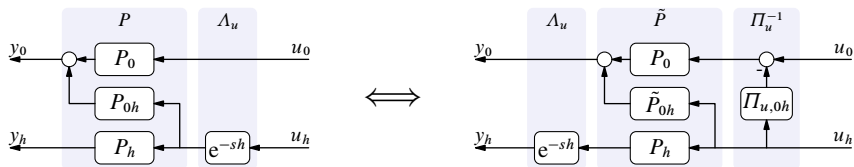
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## Upper triangular case: pulling $\Lambda_u$ through $y$ (contd)



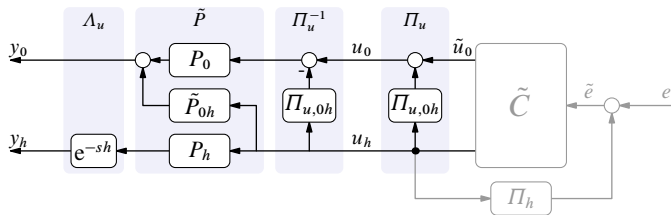
where

- $\Lambda_u$  is (non-invertible) output delay
- $\tilde{P}$  is rational
- irrational

$$\Pi_u := \begin{bmatrix} I & \Pi_{u,0h} \\ 0 & I \end{bmatrix} \quad \left( \text{with } \Pi_u^{-1} = \begin{bmatrix} I & -\Pi_{u,0h} \\ 0 & I \end{bmatrix} \right)$$

is bi-stable  $\implies$  can be **canceled** (by control law  $u = \Pi_u \tilde{u}$ ).

# Upper triangular case: canceling $\Pi_u^{-1}$ by FASP



Thus, now

$y_0$  affected only by delay-free input channel

$y_h$  affected only by delayed input channel

In other words, FASP interchannel block

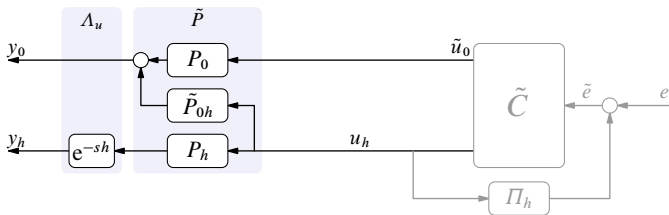
- $\Pi_{u,0h}$  compensates for delay in “delay-free” output  $y_0$

and then FASP feedback block

- $\Pi_h$  eliminates delays from characteristic equation



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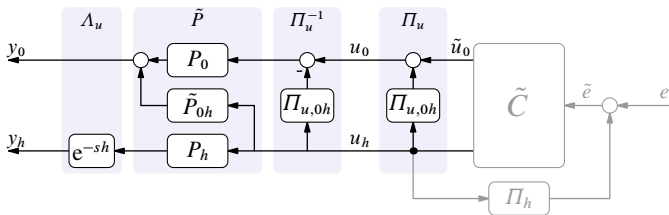
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## General case

Instead of  $P\Lambda_u = \Lambda_u \tilde{P}\Pi_u^{-1}$ , factor (quite technical)

$$P(s)\Lambda_u(s) = \Psi_y(s)\tilde{P}(s)\Pi_u^{-1}(s)$$

where

- $\tilde{P}(s)$  is rational  
having the same order and poles as  $P(s)$
- $\Pi_u(s) := \begin{bmatrix} I & \Pi_{u,0h}(s) \\ 0 & I \end{bmatrix}$  is bi-stable  
with FIR  $\Pi_{u,0h}$ , exactly as in the triangle case
- $\Psi_y(s)$  is **inner** (i.e., stable and energy preserving)  
also FIR; the next best thing to  $\Lambda_u$

## The role of $\Pi_u$

Partition  $P = \begin{bmatrix} P_0 & P_h \end{bmatrix}$  (compatibly with input channels). Then

$$y = P\Lambda_u u = P_0 u_0 + e^{-sh} P_h u_h$$

has **delay-free** and **delayed** parts **mixed** in it. Feedforward compensation of FASP,  $u = \Pi_u \tilde{u}$ , yields

$$y = P\Lambda_u \Pi_u \tilde{u} = \underbrace{P_0 \tilde{u}_0}_{y_0} + e^{-sh} \underbrace{(I - Q_0) P_h u_h}_{y_h}$$

where

- $Q_0(j\omega)$  is orthogonal projection onto the image of  $P_0(j\omega)$  so that  $P_0(j\omega) \perp (I - Q_0(j\omega)) P_h(j\omega)$  and, hence,  $y_0 \perp y_h$ .

Thus, feedforward part of FASP

- renders delay-free ( $y_0$ ) and delayed ( $y_h$ ) parts of  $y$  orthogonal (in  $L^2(\mathbb{R})$ )

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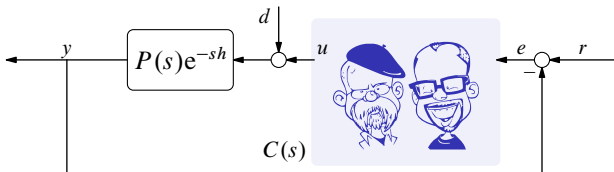
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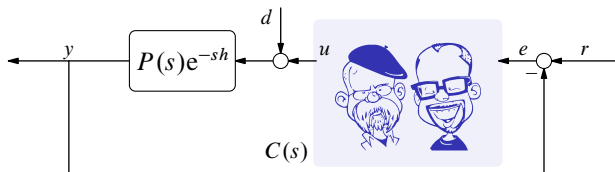
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# MythBusters



- not efficient in disturbance attenuation ← **busted**
- intrinsically poor robustness ← **busted**
- stabilization induces “true” DTC controller structure ← **plausible**
- artificial loop delays might be advantageous ← **busted**

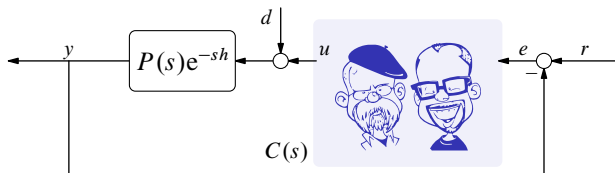
# MythBusters



- not efficient in disturbance attenuation ← **busted**
- intrinsically poor robustness ← **busted**
- stabilization induces “true” DTC controller structure ← **busted**
  - ↪ stability-induced DTC might conflict with performance requirements
  - ↪ multiple-delay DTC should be performance dependent
- artificial loop delays might be advantageous ← **busted**



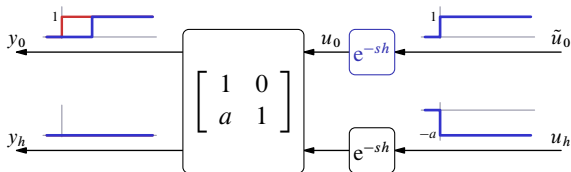
# MythBusters



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- intrinsically poor robustness ← **busted**
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- artificial loop delays might be advantageous ← **busted**  
 ⇨ at least, not for the reason they’ve been believed so hitherto

# adding artificial delays

GMDC:



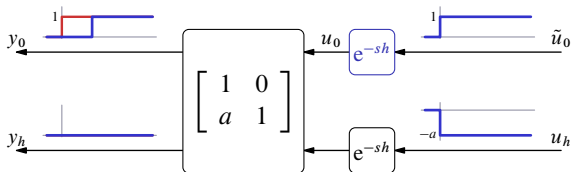
error energy:  $\|e\|_2^2 = h$  (independent of  $a$ ).

FASP (here  $\eta := 1/(1+a^2)$ ):

error energy:  $\|e\|_2^2 = \frac{a^2}{1+a^2}h < h$  (always better, especially if  $|a|$  small).

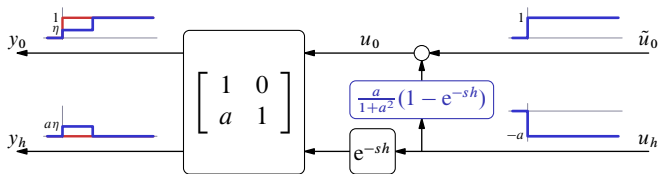
## No need in adding artificial delays

GMDC:



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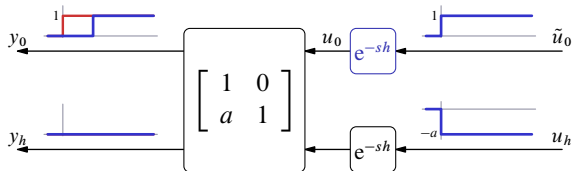
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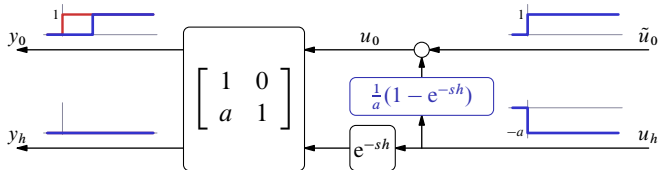
## Doing it FASP way

GMDC:



☹️ robustness harmed anyway

FASP:



☺️ decoupling without sacrificing robustness

☹️ not universal

# Stability vs. performance: multiple-delay case

No conflict

# Talk outline

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Multiple-delay dead-time compensation

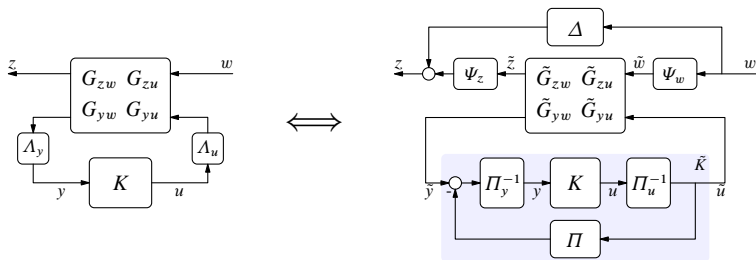
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Conclusions

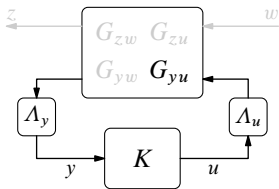
## General case (Mirkin, Palmor, & Shneiderman, 2011)

By applying adobe loop shifting recursively as in (Meinsma & Mirkin, 2005)



- $\tilde{G}$  rational with the same “ $A$ ” matrix as  $G$
- $\Psi_z$  and  $\Psi_w$  inner and FIR
- $\Delta$  stable, FIR, and  $\Delta \perp \Psi_z T_{\tilde{z}\tilde{w}} \Psi_w$  in  $H^2$  for every  $T_{\tilde{z}\tilde{w}} \in H^2$
- $\Pi_u$  and  $\Pi_y$  bistable and FIR
- $\Pi$  stable and FIR

# Stability



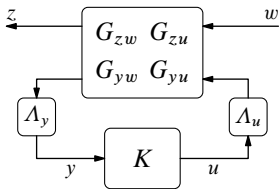
Effectively,

- only “ $\Lambda_y - G_{yu} - \Lambda_u - K$ ” loop

needs to be analyzed



# Performance



Closed-loop system is

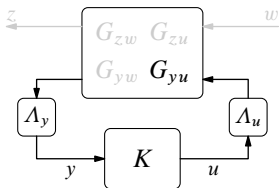
$$T_{zw} = G_{zw} + G_{zu} \Lambda_u K (I - \Lambda_y G_{yu} \Lambda_u K)^{-1} \Lambda_y G_{yw}$$

and it

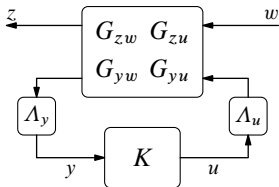
- depends on all components of  $G$

## Qualitative difference

Conventional DTC: structure depends only on  $G_{yu}$  (real plant)

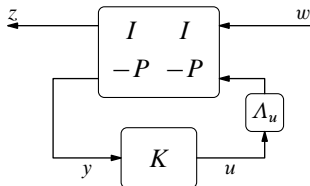


FASP: structure also depends on  $G_{zu}$  (effect of  $u$  on performance measure  $z$ ) and  $G_{yw}$  (effect of exogeneous signal  $w$  on  $y$ )



# Example

$$S_{\text{in}} = (I + \Lambda_u KP)^{-1}:$$

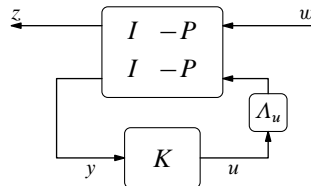


It

- induces conventional DTC

( $G_{zu} = I$  commutes with  $\Lambda_u$ ).

$$S_{\text{out}} = (I + P\Lambda_u K)^{-1}:$$



It

- induces FASP

( $G_{zu} = -P$  might not commute with  $\Lambda_u$ ).

# Talk outline

Prolog: a friendly intro to dead-time compensation

Smith predictor: the first dead-time compensator

Single-delay dead-time compensation: analytical justifications

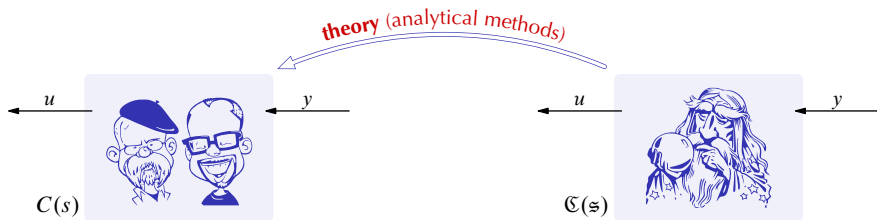
Multiple-delay dead-time compensation

Feedforward action Smith predictor (FASP)

From stability- to performance-oriented

Conclusions

# First message



## Second message

Paradigm shift is in order