SM-32 (Rev. 9-57) REFERENCE

SHELL OIL COMPANY

DATE MARCH 4, 1973

TO PROCESS SUPERINTENDENT -
EAST OPERATIONS

FROM PROCESS MANAGER
CATALYTIC CRACKING
NORCO REFINERY

cc - Circulate: Refinery Manager
Refinery Superintedent
Chief Technologist

SUBJECT PUBLISHING OF CO FURNACE CONTROL DATA

As you know, I have been working on my PHD dissertation in the area of Process Control. Recently I implemented one of the techniques from my dissertation research on the Cat Cracker CO Furnace. The technique is working exceeding well and substantiates the theory on which my dissertation is based. I would like to obtain permission from the company to publish this data in my dissertation. The use of actual process data will give the dissertation credibility and statue.

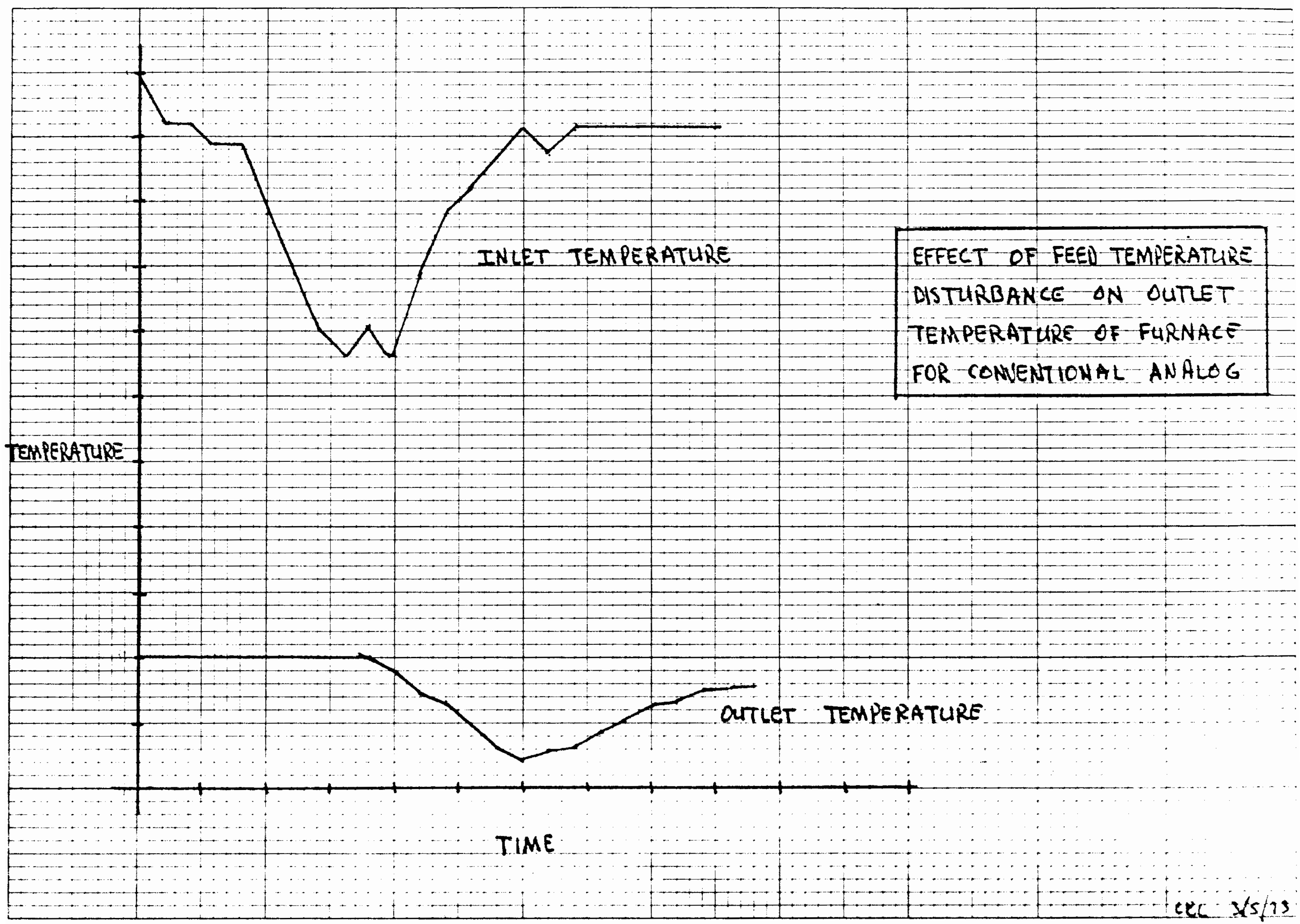
The data may be presented in dimensionless terms to avoided any association with the actual process or levels of operation. Attached are the data presented in graphical terms, that I would use.

The theory to which I have referred is familiar to you, Egon Doering, Charles Gillard, and Stan Marple in Head Office. However, for others who may read this letter, I have attached a copy of the original research proposal I gave my professor. The technique used on the CO Furnace is the least square approach to reducing the error described in the proposal.

Your consideration of this matter will be appreciated.

C. R. Cutler

Attachment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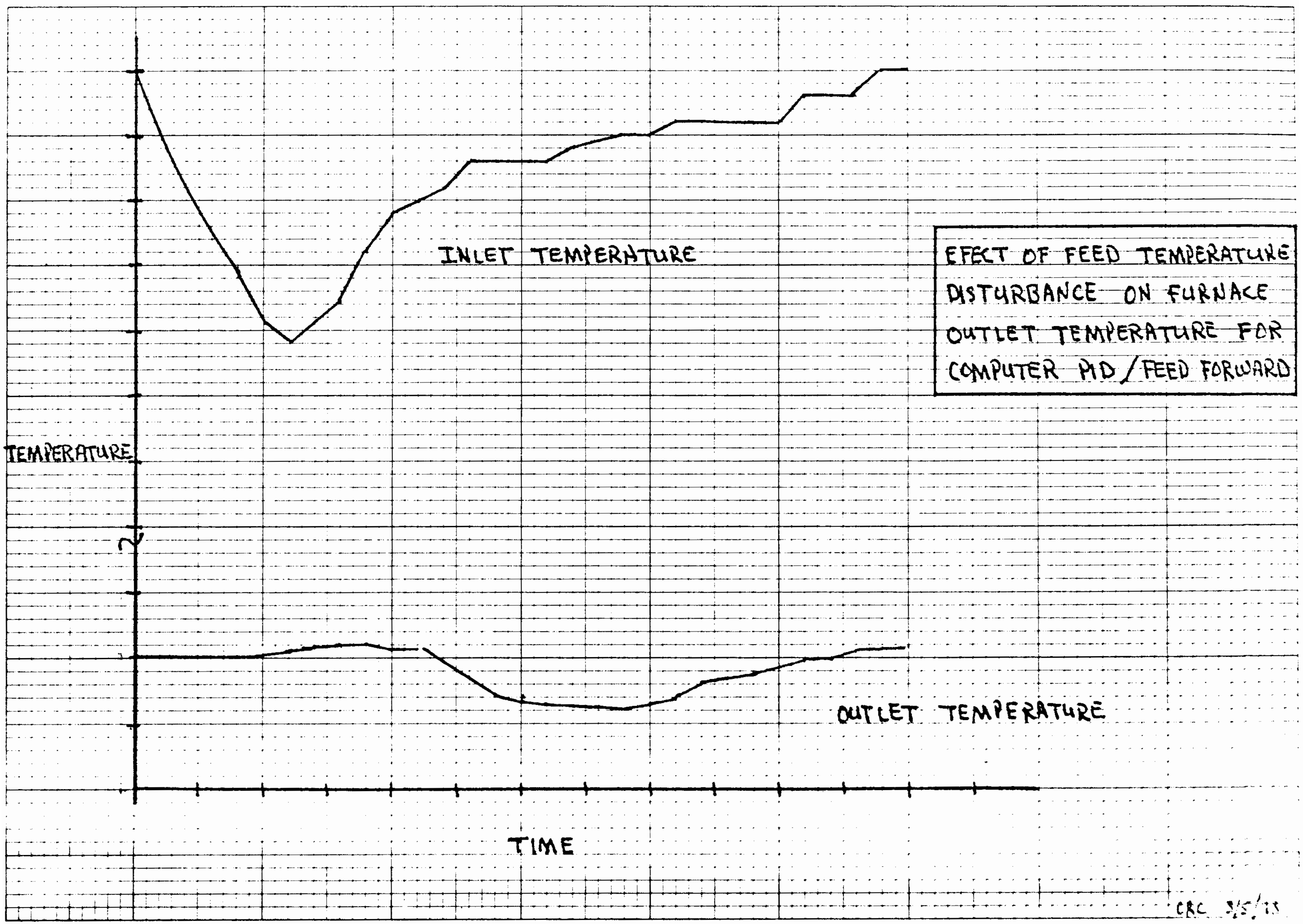
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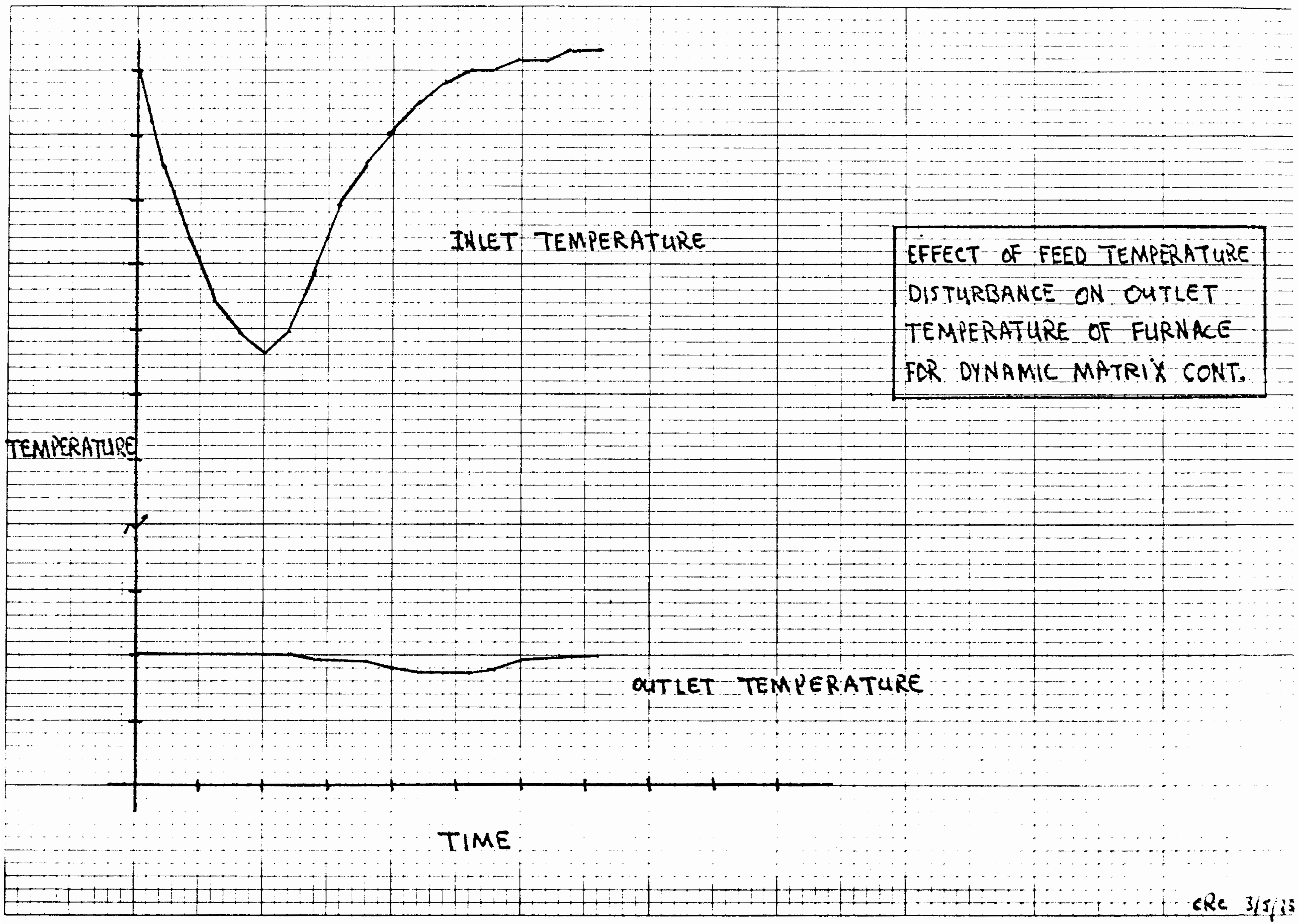
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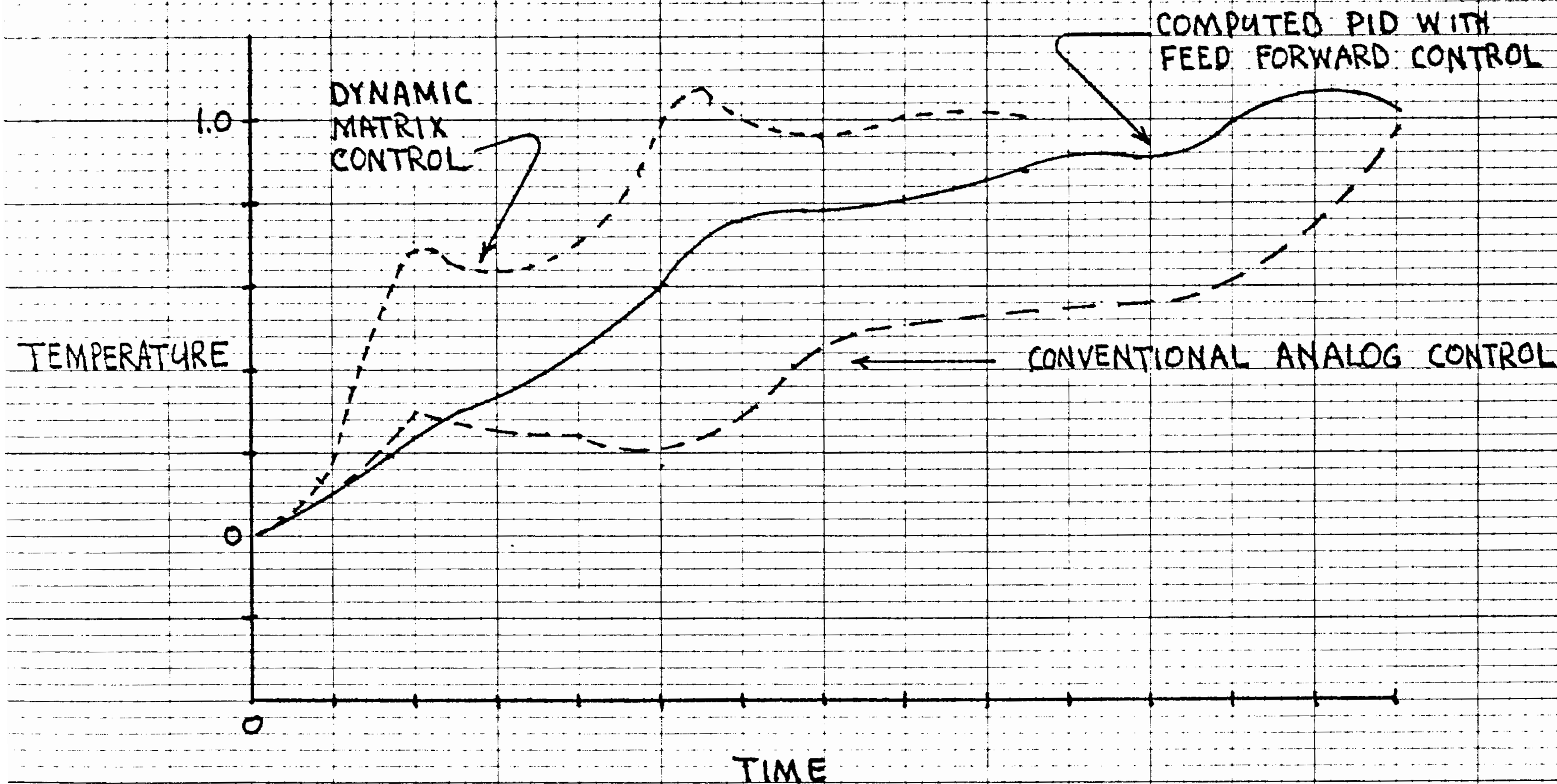
OUTLET TEMPERATURE
TEMPERATURE
TIME
CRC 3/5/75

OUTLET TEMPERATURE RESPONSE TO UNIT SET POINT CHANGE FOR FURNACE



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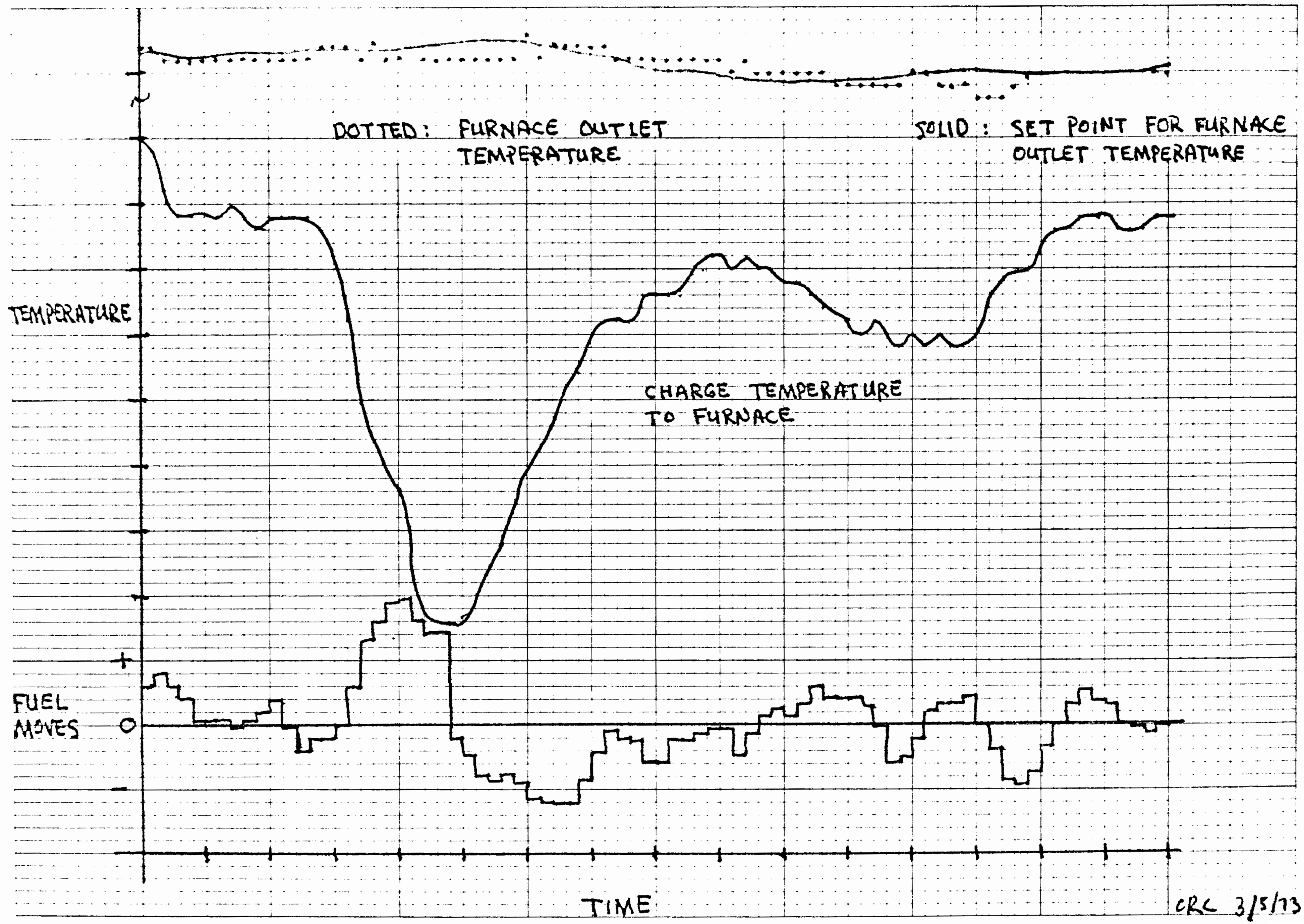


CRC 3/5/73

August 24, 1969

Dr. C. J. Huang
Chemical Engineering Department
University of Houston
Houston, Texas

Dear Dr. Huang:

I have outlined in the following pages my proposal for a multivariable control algorithm to fulfil my dissertation requirement. I believe this is an original approach in a number of ways that will become evident as the algorithm is developed. I would like to apply it to the control of a complex distillation column that has several reflux systems and draw streams. Preferably this would be an actual column, but if I cannot get Shell Oil to let me try it on an actual column, then I would use a computer simulation of a column to test the control algorithm.

The algorithm was formulated to satisfy the following criterion:

1. The manipulated variables should be moved on the basis of a profit criterion, rather than some type of minimum error criterion that most optimal control systems are based.

2. The algorithm should recognize its ability to move the manipulated variables at future times. Prior knowledge of the overall system dynamics should

permit the calculation of the trajectory of the manipulated variable as well as the controlled variable.

3. The algorithm should include feedback to compensate for prediction errors in the dynamics and for disturbances that enter the system.

4. The control algorithm should recognize that control variables are many times set at their maximum or minimum values by an overall process optimization. This means the set point for the control variable must be approached asymptotically and must not be exceeded.

5. The algorithm should recognize that the manipulated variable has a limited range over which to operate before the valve, compressor, etc., reaches saturation.

6. The algorithm should be capable of controlling D^n variables with I^k manipulated variables where $n \neq k$.

The explanation of the proposed algorithm is presented in the following manner. First, I will demonstrate how a set of linear algerbraic equations can be used to describe the dynamic response of a dependent variable D to the change in a number of independent variables I_k. Then I will show how the system can be expanded to describe the dynamic response of more than one dependent variable D_j with the same independent variables I_k.

By changing from absolute values to differences for the independent and the dependent variables, the dependent variable may be described in terms of an error relative to a set point.

At this point in the development of the algorithm, I will have demonstrated how to calculate the change in error in time for n dependent control variables with a change in M independent manipulated variables. The complete response will be calculated by solving a system of linear algerbraic equations. The next degree of sophistication will demonstrate how previous calculated moves in the independent variables and the resulting transient condition may be incorporated into current calculations. Also the feedback corrections for the errors generated by dynamic responses predictions and disturbances will be added at this point in the algorithm development. I shall discuss and show how a least square solution of the equations developed would lead to a workable multivariable control system. This will be helpful in visualizing the subsequent steps in the algorithm development. The next step is to show how the linear programming algorithm may be used to solve the dynamic equations and guarantee stability and convergence. The last step in development will be to show how steady state calculations on the process economics can be incorporated with dynamic control equations to obtain the most profitable set of control moves.

<u>Description of System Dynamics By A Set Of Linear Algebraic Equations</u>

The following analysis is based on the assumption that the process dynamics can be described by a set of linear differential equations. This is not a serious limitation since the non-linear systems may be linearized in the region of interest. For a linear system the magnitude of the scale factor is proserved. This principle is demonstrated in Figure 1 where the response of the dependent variable D is shown for a unit change in independent variable I.

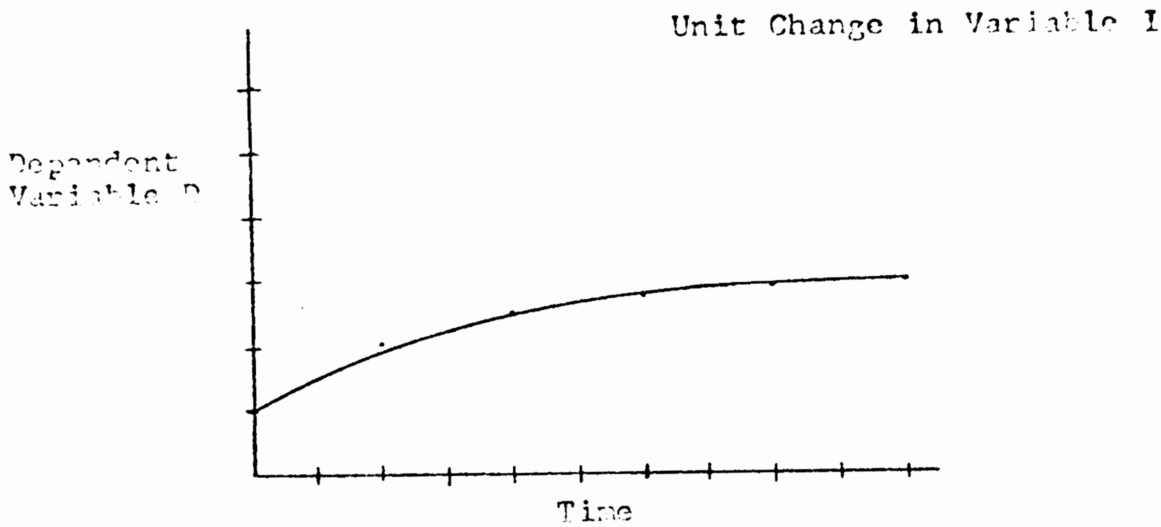


Figure 1

If a two unit change is made in independent variable I, then the same response is obtained from D except that the change in amplitude is multiplied by 2. This is demonstrated in figure 2.

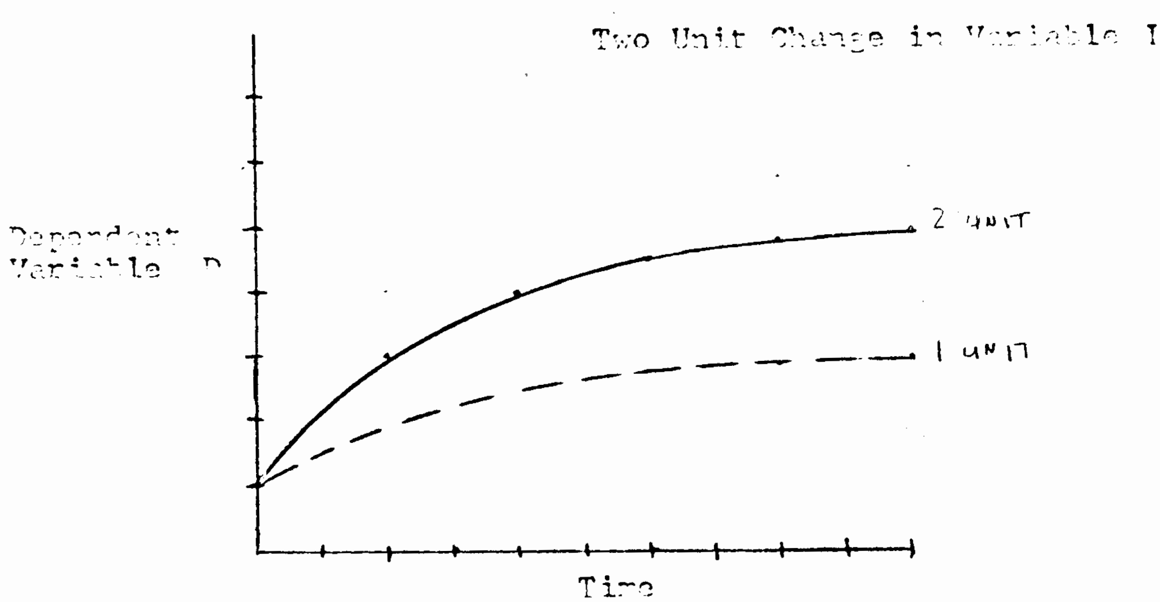


Figure 2

For a linear system the principle of superposition applies and this is demonstrated in Figure 3.

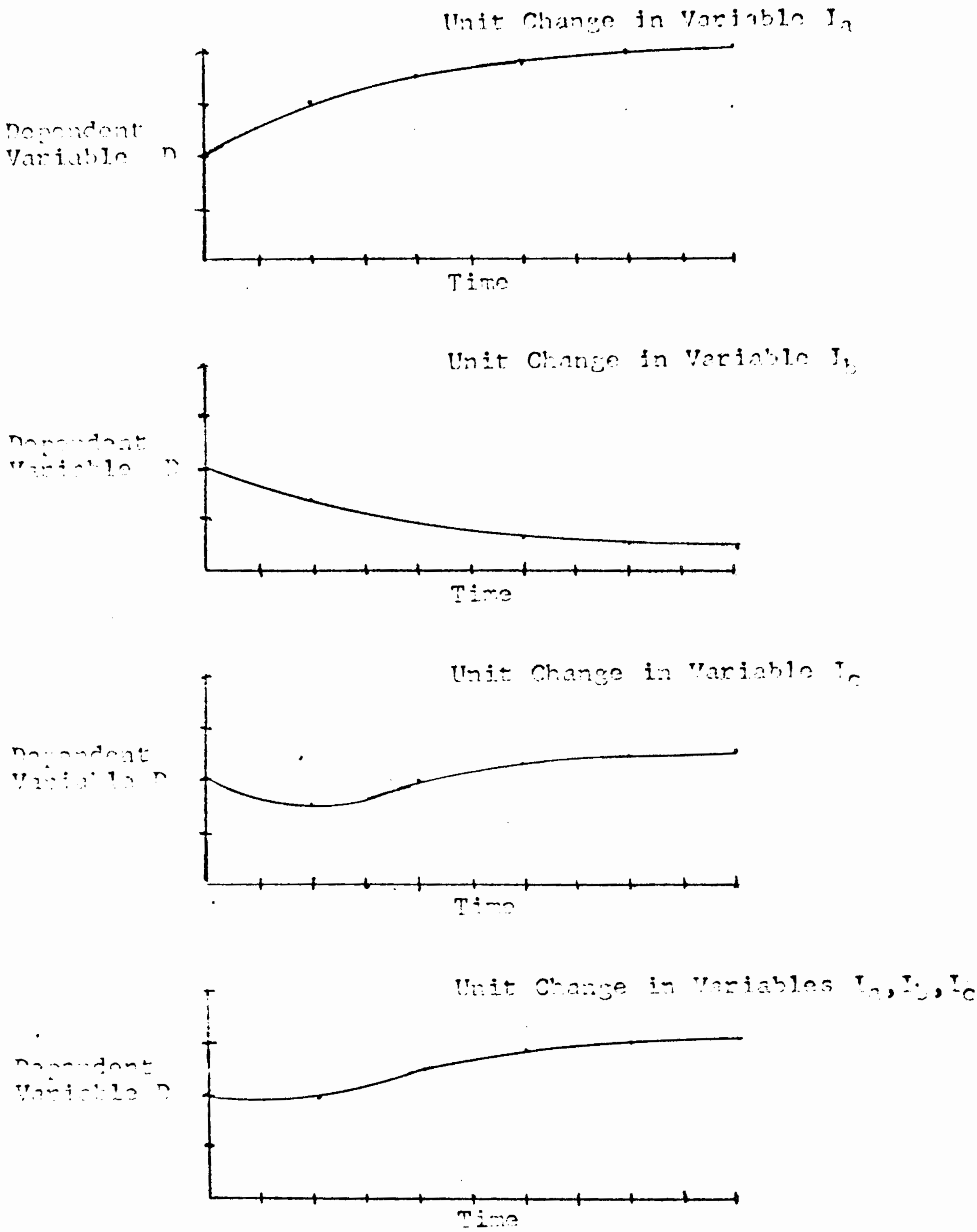


Figure 3

Let the numerical subscription on the dependent variable D represent the value of D at some discrete time interval after the change in the independent variables. The change in value of D at any time interval may be determined by a set of linear algerbraic equations if the change in the independent variables are known.

$$
\begin{aligned}
D_1 &= A_{11} I_a + A_{12} I_b + A_{13} I_c \\
D_2 &= A_{21} I_a + A_{22} I_b + A_{23} I_c \\
D_3 &= A_{31} I_a + A_{32} I_b + A_{33} I_c \\
D_4 &= A_{41} I_a + A_{42} I_b + A_{43} I_c \\
D_5 &= A_{51} I_a + A_{52} I_b + A_{53} I_c \\
D_6 &= A_{61} I_a + A_{62} I_b + A_{63} I_c \\
&\vdots
\end{aligned}
$$

Equation Set 1

where D_1, D_2, D_3, etc. are for time intervals 1,2,3, etc. respectively and represent the change in D that results from the change in I_a, I_b, and I_c. The coefficients Aij describe the system dynamics and may be determined experimentally by a number of published techniques. The relationship between this approach to describing systems dynamics and finite difference differential equations is obvious. The coefficients Aij in the matrix are nothing more than the solution of the differential difference equations. It is a simple matter to extend this calculational procedure to more than one dependent variable. For example two dependent variables D_a and D_b.

$$
\begin{aligned}
D_{a1} &= A_{11} I_a + A_{12} I_b + A_{13} I_c \\
D_{a2} &= A_{21} I_a + A_{22} I_b + A_{23} I_c \\
D_{a3} &= A_{31} I_a + A_{32} I_b + A_{33} I_c \\
&\vdots \\
D_{b1} &= B_{11} I_a + B_{12} I_b + B_{13} I_c \\
D_{b2} &= B_{21} I_a + B_{22} I_b + B_{23} I_c \\
D_{b3} &= B_{31} I_a + B_{32} I_b + B_{33} I_c \\
&\vdots
\end{aligned}
$$

Equation Set 2

The Change In A Dependent Variable Can Be Expressed As A Change In The Error And A Control Scheme Developed Using The Least Square Method To Solve For The Control Moves

The change in the dependent variable D_a and D_b can be expressed as a change in the error when the set point for each variable is known.

$$D_{a1} = D_a(\text{At Time} = 1) - D_a(\text{At Time} = 0)$$

$$D_{a1} = (D_a \text{ Set Point} - D_a \text{ at time} = 0) - (D_a \text{ Set Point} - D_a \text{ At Time} = 1)$$

$$D_{a1} = \text{Error At Time} = 0 - \text{Error At Time} = 1 = E_{a1}$$

Equation Set 3

For illustration, assume that a steady state error exists in one of the dependent variables D_a. It is also assumed that the most desirable path for the variable to return to the set point is known. This is illustrated in Figure 4.

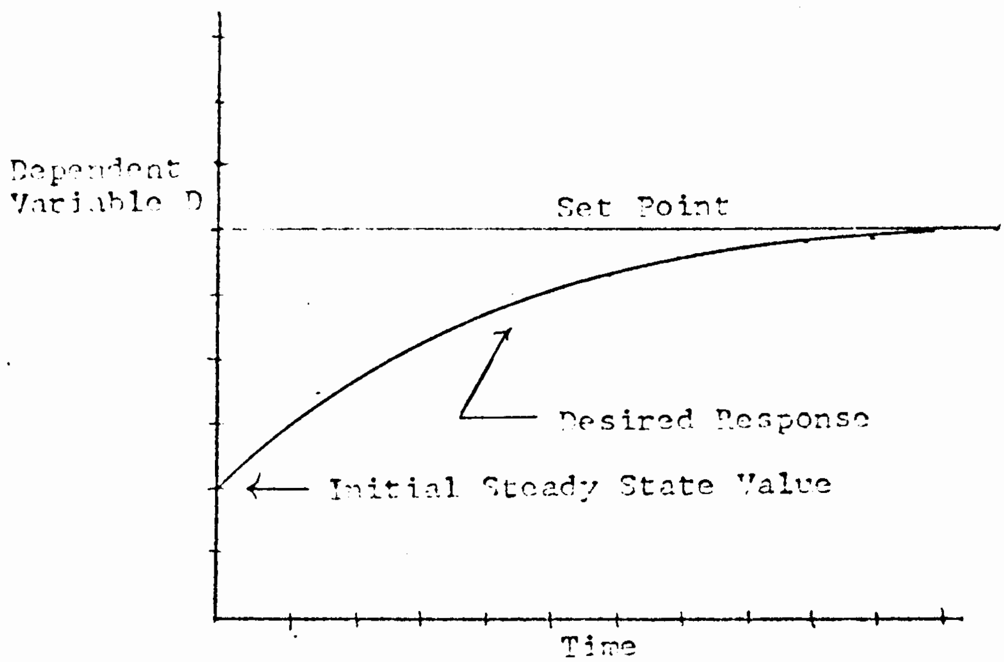


Figure 4

Since the desired change in D_a is now known and the coefficients Aij in the dynamic response matrix are known, the best set of moves in the independent variables to accomplish this control reponse can be determined by the method of least squares. The concept is easily extended to multivariable control since the change in independent variables determined may influence a number of dependent control variables.

$$
\begin{array}{lcllllll}
D_{a1} & = & A_{11} I_a & + & A_{12} I_b & + & --- & A_{ij} I_k \\
D_{a2} & = & A_{21} I_a & + & A_{22} I_b & + & --- & A_{2j} I_k \\
D_{a3} & = & A_{31} I_a & + & A_{32} I_b & + & --- & A_{3j} I_k \\
D_{a4} & = & A_{41} I_a & + & A_{42} I_b & + & --- & A_{4j} I_k \\
\vdots & & \vdots & & \vdots & & & \vdots \\
D_{ai} & = & A_{i1} I_a & + & A_{i2} I_b & + & --- & A_{ij} I_k \\
D_{b1} & = & B_{11} I_a & + & B_{12} I_b & + & --- & B_{1j} I_k \\
D_{b2} & = & B_{21} I_a & + & B_{22} I_b & + & --- & B_{2j} I_k \\
D_{b3} & = & B_{31} I_a & + & B_{32} I_b & + & --- & B_{3j} I_k \\
D_{b4} & = & B_{41} I_a & + & B_{42} I_b & + & --- & B_{4j} I_k \\
\vdots & & \vdots & & \vdots & & & \vdots \\
D_{bi} & = & B_{i1} I_a & + & B_{i2} I_b & + & --- & B_{ij} I_k \\
D_{c1} & = & C_{11} I_a & + & C_{12} I_b & + & --- & C_{1j} I_k \\
D_{c2} & = & C_{21} I_a & + & C_{22} I_b & + & --- & C_{2j} I_k \\
D_{c3} & = & C_{31} I_a & + & C_{32} I_b & + & --- & C_{3j} I_k \\
D_{c4} & = & C_{41} I_a & + & C_{42} I_b & + & --- & C_{4j} I_k \\
\vdots & & \vdots & & \vdots & & & \vdots \\
D_{ci} & = & C_{i1} I_a & + & C_{i2} I_b & + & --- & C_{ij} I_k
\end{array}
$$

where $j \geq i$

Equation Set 4

The number of of independent variables fix the size of the matrix to be inverted, therefore any degree of accuracy can be achieved in discribing the dynamic response by reducing the length of the time interval.

Time Dependent Moves In The Independent Variables May Be Incorporated Into The Control Algorithm

An additional improvement can be achieved by permitting the independent variable to move in each time interval in the future. For example I_{a0}, I_{a1}, I_{a2}, etc. are moves in the independable variable I_a at times 0,1,2 respectively.

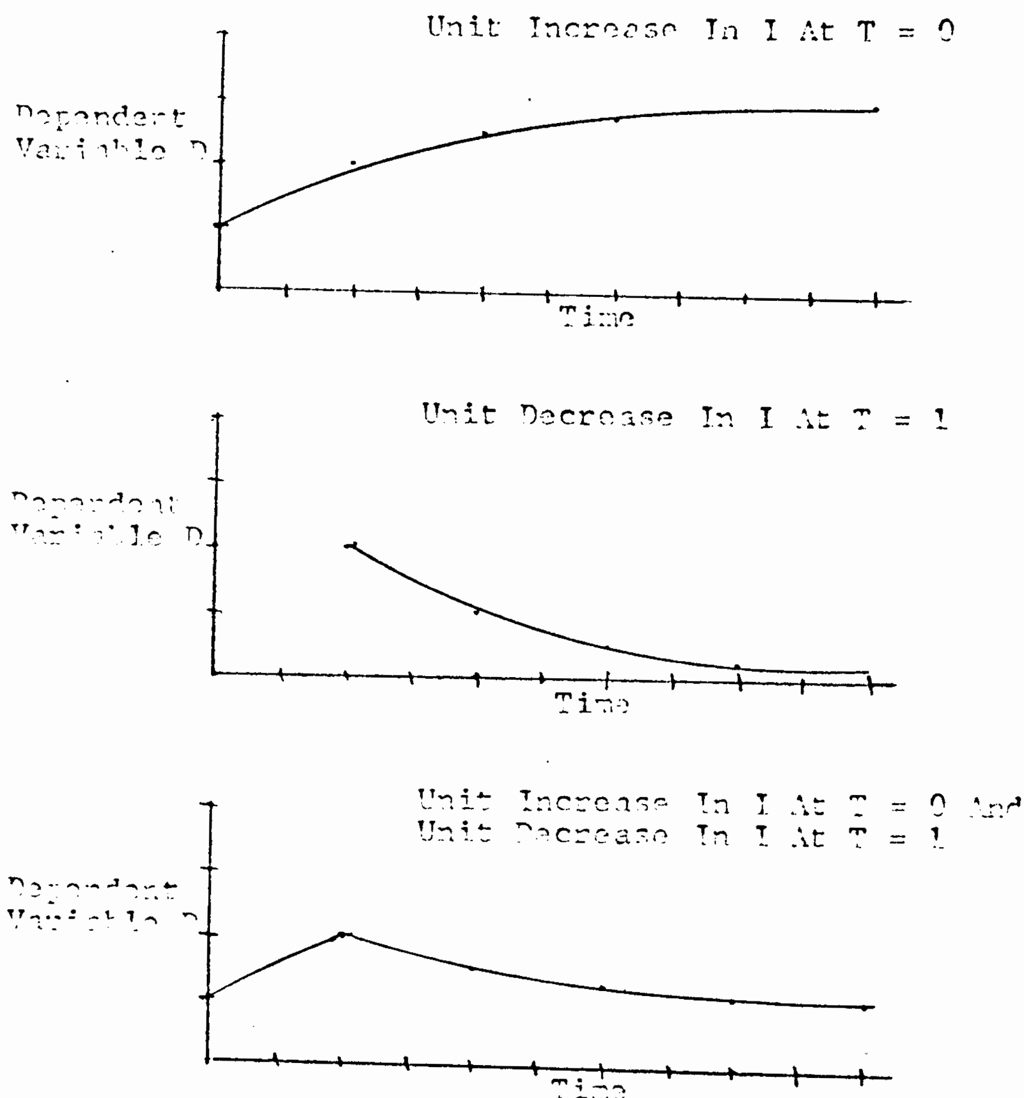


Figure 5

The response of the dependent variable D_a to changes in one variable I_a is shown in Figure 5. The changes in I_a are made at time 0 and time 1 and represent a unit increase and decrease respectively. The addition of this concept to the algorithm adds another dimension to the control since it allows the "planning" of future moves of the manipulated variable. There isn't any additional dynamic information required to extend the algorithm to time dependent moves in the independent variable since the dynamic matrix repeats itself. This is illustrated below for 2 independent variables.

$$
\begin{array}{lllllllllll}
D_{a1} & = & A_{11} I_{ao} & + & A_{12} I_{bo} & + & A_{01} I_{a1} & + & A_{02} I_{b1} & + & --- \\
D_{a2} & = & A_{21} I_{ao} & + & A_{22} I_{bo} & + & A_{11} I_{a1} & + & A_{12} I_{b1} & + & --- \\
D_{a3} & = & A_{31} I_{ao} & + & A_{32} I_{bo} & + & A_{21} I_{a1} & + & A_{22} I_{b1} & + & --- \\
D_{a4} & = & A_{41} I_{ao} & + & A_{42} I_{bo} & + & A_{31} I_{a1} & + & A_{32} I_{b1} & & --- \\
\cdot & & \cdot & & \cdot & & \cdot & & \cdot & & \\
\cdot & & \cdot & & \cdot & & \cdot & & \cdot & & \\
\cdot & & \cdot & & \cdot & & \cdot & & \cdot & &
\end{array}
$$

Equation Set 5

The concept of time varying independent variables is easily extended to more than one dependent variable by analogy to equations Set 2 where only one move in each of the independent variables at time zero was shown. For clarafication this situation is illustrated below:

(Illustration is listed on next page (page 12)

$$
\begin{array}{lllll}
D_{a1} = & A_{11} I_{ao} & + A_{12} I_{bo} & + \overset{0}{\cancel{A_{11}}} I_{a1} & + \overset{0}{\cancel{A_{12}}} I_{b1} \\
D_{a2} = & A_{21} I_{ao} & + A_{22} I_{bo} & + A_{11} I_{a1} & + A_{12} I_{b1} \\
D_{a3} = & A_{31} I_{ao} & + A_{31} I_{bo} & + A_{21} I_{a1} & + A_{22} I_{b1} \\
\vdots & \vdots & \vdots & \vdots & \vdots \\
D_{b1} = & B_{11} I_{ao} & + B_{12} I_{bo} & + \overset{0}{\cancel{B_{11}}} I_{a1} & + \overset{0}{\cancel{B_{12}}} I_{b1} \\
D_{b2} = & B_{21} I_{ao} & + B_{22} I_{bo} & + B_{11} I_{a1} & + B_{12} I_{b1} \\
D_{b3} = & B_{31} I_{ao} & + B_{32} I_{bo} & + B_{21} I_{a1} & + B_{22} I_{b1} \\
\vdots & \vdots & \vdots & \vdots & \vdots
\end{array}
$$

Equation Set 6

Correction For Errors In The Dynamic Model And Disturbances To The System

The correction in the algorithm for errors in the dynamic predictions and disturbances would be made by comparing the predicted error against the actual error. If the actual error is less than the predicted error then there would not be any corrections made in the independent variables. If on the other hand the actual error is greater than the predicted error, then the descrepancy between the errors would be corrected by moving the independent variables. The use of the least square method of solution in conjuction with the specification of a desired system response represents a practical control algorithm for a multivariable control system. The algorithm would satisfy four of the six desired criterion listed on the first two pages of this letter. The profit criterion is not covered directly with this type of approach; however if the set points were the result of an optimization, this would not be a serious limitation.

The method does not provide a technique for recognizing the physical limitations on the independent (manipulated) variables. Although this problem can probably be circumvented by an iteration process, there appears to be a simplier alternative that will be considered next.

Use Of The Linear Programming Algorithm To Solve The Dynamic Equations

The sum of the moves in each of the independent variable determines the final steady state position of the process. The most desirable steady state is the one which is optimum from the standpoint of a profit function. On this basis the best set of control moves is the set that culminates in an optimum steady state operation. The linear programming algorithm provides the basis for finding the steady state optimum and also provides a means of constraining the response of the process being optimized when the dynamics are described in the manner presented in the preceding paragraphs. The beauty of this approach is that by adjusting the allowable error at each interval of time the convergence of the system can be guaranteed. In addition the controlled variable can be allowed to converge in a cyclic manner or in an over damped manner depending on how the limits are set at each time interval. This characteristic permits the control of a system adjacent to the constraints of the process, which is essential if the maximum benefits are to be derived from the control. This principal is illustrated in the next figure.

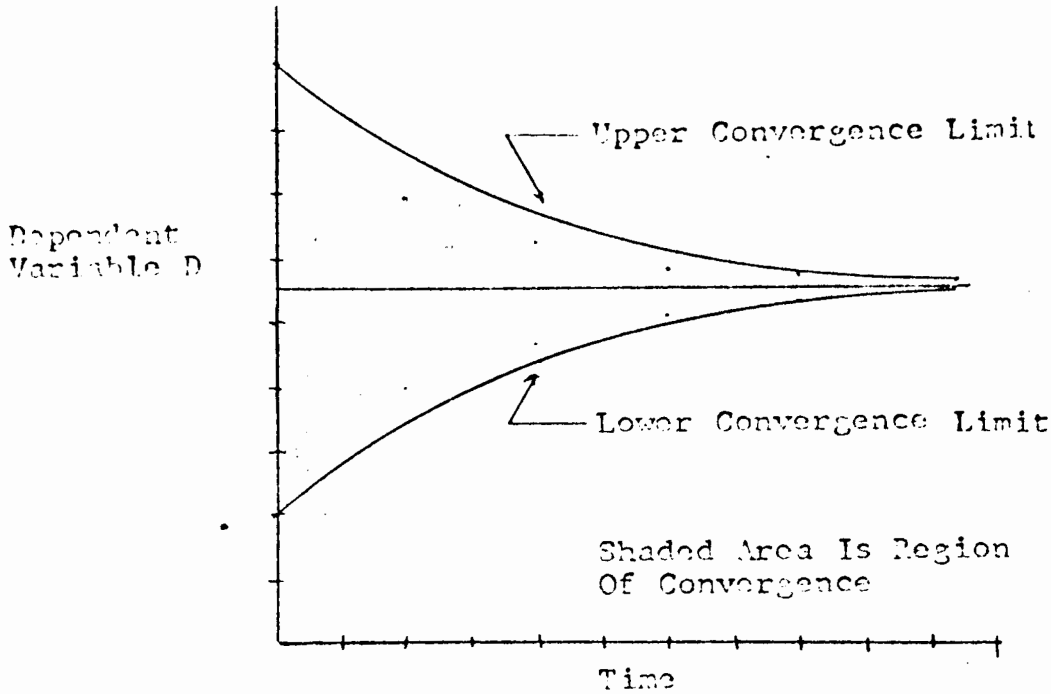


Figure 6

An optimization by its definition forces a process to some set of constraints, therefore an algorithm that has an economic motivation must be capable of approaching while not exceeding a constraint or control variable.

The elements in the profit row of the linear program matrix would be derived from a steady state model of the process as reported by a number of writers in the literature.

The control algorithm proposed in this letter is the result of a number of years of studying and searching for a practical method of controlling a multivariable system. The criterion listed for the control algorithm are not just desirable but necessary if a computer is to successfully control a chemical process at an optimum condition. The conventional control theory presented in text books falls miserable short of these criterion, therefore I believe this proposal of mine is worth pursuing. To the best of my knowledge the approach has not been proposed or attempted before and although my experience with process control at Shell cannot be disassociated from my technical background, I can say without hesitation that it does not resemble any techniques now being used by Shell or under development by Shell.

Your comments, even if you do not agree with my view points would be appreciated.

Respectfully yours,

Charles R. Cutler

Charles R. Cutler
1504 Mason Smith
Metairie, La. 70003

CRC/jc

SM-32 (Rev. 9-57)

REFERENCE

SHELL OIL COMPANY

DATE MARCH 6, 1973

TO HEAD OFFICE
MANUFACTURING TECHNOLOGICAL
D. C. MC CORMACK

FROM CHIEF TECHNOLOGIST
NORCO REFINERY

SUBJECT C. R. CUTLER PhD
DISSERTATION MATERIAL

Some time ago we discussed with you the possibility of C. R. Cutler - Process Manager Catalytic Cracking, testing certain process control configurations on the Norco Cat. Cracker, that he planned on making a part of his Dissertation for his PhD Degree in Chemical Engineering from the University of Houston. In incorporating the test data and control schemes in the Dissertation, Cutler proposed that it be presented in such a way that it would not be identified with Shell Oil or the Norco Refinery.

In recent weeks he has been able to implement one of the techniques on the CO furnace transfer temperature control and has shown that it performs better than the conventional methods. Curves are attached as well as a copy of his original proposal to Dr. C. J. Huang of the University of Houston.

We recommend that Cutler be given permission to publish these data as a part of his Dissertation with no reference to Shell Oil and solicit your concurrence.

Original Signed By
S. J. OERTLING

SJO:mfl

S. J. Oertling

Attachments

bc - Norco - Circulate: RAW - RKH
Manager Technological
Process Manager Cat. Cracking THIS COPY FOR

SM-32 (Rev. 9-57)

REFERENCE

SHELL OIL COMPANY

DATE MAY 4, 1973

TO PROCESS MANAGER - CATALYTIC CRACKING - C. R. CUTLER

FROM CHIEF TECHNOLOGIST NORCO REFINERY

SUBJECT PUBLISHING OF CO FURNACE CONTROL DATA

Your subject memorandum of March 4, 1973 to Mr. Hartig requested permission to publish as a part of your PhD dissertation certain CO furnace control data.

The information attached to your memorandum was forwarded to Head Office - Manufacturing Technological on March 6, 1973 with a recommendation that you be permitted to use this information.

Head Office - Manufacturing Technological has advised in a memorandum dated May 1, 1973 that the preliminary dimensionless data shown in your memorandum with no reference to Shell Oil Company are satisfactory for release as a part of your PhD dissertation. Head Office has asked that you supply them with a copy of the final draft for their review.

S. J. Oertling

SJO:mfl

cc - R. K. Hartig
S. J. Oertling

SM-32 (Rev. 9-57)

REFERENCE T-9113

SHELL OIL COMPANY

DATE DECEMBER 29, 1975

TO HEAD OFFICE - ENGINEERING PRODUCTS -
PROCESS ENGINEERING-REFINING - MANAGER

FROM TECHNICAL SUPERINTENDENT
NORCO REFINERY

SUBJECT PUBLICATION OF DYNAMIC CONTROL MATRIX

Attached for your inspection is a proposed paper for publication by C. R. Cutler on the Dynamic Control Matrix technique. Basic approval to publish this information as part of his dissertation was obtained earlier subject to your review. Earlier correspondence is also attached for your convenience. The present request is to publish the information in the literature, which should not be different in principle from the earlier request.

Your consideration of the matter will be appreciated.

ORIGINAL SIGNED BY:
R. H. BROWN

CRC:kgp

R. H. Brown

Attachment

SM 32 (Rev. 9-57)

REFERENCE

SHELL OIL COMPANY

DATE JANUARY 6, 1976

TO HEAD OFFICE - GENERAL MANAGER REFINING

FROM COMPLEX MANAGER
NORCO MANUFACTURING COMPLEX

SUBJECT REQUEST TO PUBLISH IN LITERATURE

In 1973 your technical organization gave C. R. Cutler permission to publish computer control data from the CO furnace in his dissertation. He has expanded this request to include publication in a technical periodical such as Chemical Engineering or the AIChE Journal. Attached is a rough draft of the proposed paper for your review. The earlier correspondence is also attached for your convenience.

Your consideration of this matter will be appreciated.

ORIGINAL SIGNED BY
J. D. RAMSEY

CRC:jco

J. D. Ramsey

Attachments

bc - Norco - Circulation Copy: Messrs. J. A. Byerly
R. H. Brown
A. W. Clark
J. R. Nieman
C. R. Cutler

A COMPUTER CONTROL ALGORITHM FOR COMPLEX CONTROL PROBLEMS

BY

DR. C. J. HUANG & C. R. CUTLER

A Control Algorithm for digital computers has been developed which permits the solution of control problems that are not handled adequately by conventional feed back control. The principles were developed at the University of Houston and the Control Algorithm was tested at Shell Oil Companies Norco Refinery. The Algorithm evolved from a technique of representing process dynamics with a set of numerical coefficients. The numerical technique, in conjunction with a least square formulation to minimize the integral of the error/time curve, make it possible to solve complex control problems in a unique manner. The control problem on which the Algorithm was tested was a preheat furnace. The furnace is located downstream of a number of other process units that at times introduce significant distrubances in the inlet temperature. The control problem is further enhanced by a dead time and a large time constant for the response of the outlet temperature to a change in the fuel. These response curves are shown in Figure 1.

The Algorithm which was named the ''Dynamic Matrix Control'' is compared against the conventional Analog Control of the furnace in Figure 2. As can be observed, the Dynamic Matrix Control of the outlet temperature of the furnace for a unit change in the set point is substantially better than the Analog Control. Another comparison is made in Figures 3A and 3B between the Dynamic Matrix and a computer implemented PID Algorithm for a distrubance in the feed inlet temperature. The Computer PID control has a feed forward feature that is a significant improvement over the feedback Analog Control which is shown in Figure 3C. However the Dynamic Matrix Control is substantially better than either of these modes of control.

Any system which can be described or approximated by a system of linear differential equations can utilize the Dynamic Matrix Control technique. The technique is based upon the numerical representation of the system dynamics. Two properties of linear systems makes the numerical representation possible. The first of these principles is the preservation of the scale factor. It is illustrated in Figure 4 where the response of the dependent variable D is shown for a change in the independent variable I. The solid line represents the response of the dependent variable to a unit change in the independent variable and the dashed line illustrates the response for a two-unit change in the independent variable. Note the response of the two-unit change has twice the amplitude of the one-unit change. For a linear system, the response of the dependent variable for any size change in the independent variable may be obtained by multiplying the scalar value of the independent variable times the unit response curve for the dependent variable. Further, note on Figure 4 that the unit response curve can be approximated by a set of numbers if the curve is broken into discrete intervals of time. The two-unit response curve in Figure 4 can be obtained by multiplying the set of numbers for the unit response by 2. The second charateristic of a linear system is the principle of superposition. This principle is illustrated in Figure 5 where the response of a dependent variable is shown for a unit change in two independent variables. Also, the response of the dependent variable to a simultaneous unit change in both independent variables is shown. The response for this curve was obtained by summing the responses for the unit response curves for the independent variables.

Mathematically the change in the dependent variable with time for the change in N independent variables is given by:

$$\Delta D_1 = \sum_{j=1}^{N} A_{1j} \quad \Delta I_j$$

$$\Delta D_2 = \sum_{j=1}^{N} A_{2j} \quad \Delta I_j \qquad (1)$$

'' '' '' ''
'' '' '' ''

$$\Delta D_i = \sum_{j=1}^{N} A_{ij} \quad \Delta I_j$$

Where the ΔD_i are the changes in the dependent variable from its initial value to its value at time interval i and the ΔI_j are the changes in the independent variables from their initial value at time equal to zero. The A_{ij} are the numerical coefficients referred to in the proceeding paragraphs.

The concept of describing process dynamics with numerical coefficients is easily expanded to more than one dependent variable by providing a set of equations similiar to Equation Set (1) for each dependent variable. Inasmuch as the independent variables affect the response of all dependent variables for an interacting system, the complete system response is determined when the changes in the independent variables are known. The following set of equations demonstrate this relationship:

$$\Delta D_{i^1} \Big|_{i=1}^{M} = \sum_{j=1}^{N} A^1_{ij} \quad \Delta I_j \Big|_{i=1}^{M}$$

$$\Delta D_{i^2} \Big|_{i=1}^{M} = \sum_{j=1}^{N} A^2_{ij} \quad \Delta I_j \Big|_{i=1}^{M} \qquad (2)$$

'' '' '' '' '' ''
'' '' '' '' '' ''

$$\Delta D_{ik} \Big|_{i=1}^{M} = \sum_{j=1}^{N} A_{ij}^{k} \Delta I_j \Big|_{i=1}^{M}$$

Where M is the number of time intervals, N is the number of independent variables, k is the number of dependent variables, i is the index on the time intervals, j is the index on the independent variables, and the superscript carried on the A_{ij} indicates a different set of numerical coefficients for each dependent variable. The notation $\Big|_{i=1}^{M}$ implies the vector ΔD_{ik} takes on values form i equal 1 to M for each value of k. Further, note that the ΔI_j are common to all equation sets.

The idea of introducing the movement of the independent variables in future intervals is accomplished by shifting the vector of dynamic coefficients down one time interval, filling the vacated element with a zero, and adding a movement column for each independent variable for that interval of time. Expanding Equation Set (2) to include this concept yields the following:

$$\Delta D_{i1} \Big|_{i=1}^{M} = \sum_{j=1}^{N} A_{ij}^{1} \Delta I_{1j} + \sum_{j=1}^{N} B_{ij}^{1} \Delta I_{2j} + \ldots \Big|_{i=1}^{M}$$

$$\Delta D_{i2} \Big|_{i=1}^{M} = \sum_{j=1}^{N} A_{ij}^{2} \Delta I_{1j} + \sum_{j=1}^{N} B_{ij}^{2} \Delta I_{2j} + \ldots \Big|_{i=1}^{M}$$

$$\vdots \qquad \vdots \qquad \vdots \qquad \vdots \qquad \vdots \qquad \vdots \qquad \vdots \qquad (3)$$

$$\Delta D_{ik} \Big|_{i=1}^{M} = \sum_{j=1}^{N} A_{ij}^{k} \Delta I_{1j} + \sum_{j=1}^{N} B_{ij}^{k} \Delta I_{2j} + \ldots \Big|_{i=1}^{M}$$

Where M is the number of time intervals, N is the number of independent variables, k is the number of dependent variables, i is the index on the time intervals, j is the index on the independent variables, and the superscript on the A_{ij} and B_{ij} indicate a different set of numerical coefficients for each dependent variable. The B_{ij} matrix has the same set of numerical coefficients as appear in the A_{ij} matrix except the first row is all zeros in the B matrix and the i+1 row of the B matrix is equal to the i row of the A matrix.

The representation of the response of a dynamic system by a set of linear equations as outlined in the preceeding paragraphs permits the prediction of a systems response if the changes in the independent variables are known. The Control Algorithm substracts the predicted system response from the set point for each dependent variable. The vector of projected errors are set equal to the matrix of dynamic coefficients. A least square fit of the data yields the best set of moves in the independent variables to minimize the projected error. The obvious difficulty with the use of the least square method to calculate the movement of the manipulated variable is the unconstrained nature of the solution. The method without constraint will yield very large changes in the manipulated variables that would not be physically realizable.

One technique for suppressing the change in the manipulate variable is to multiply by a number greater than one, the main diagonal elements of the square matrix that evolves from the least square formulation. The effectiveness of such a multiplier is illustrated in Figure 6 where a square wave change in set point was made. The unconstrained least square reduction in the error resulted in a total change in the absolute value of the manipulated variable moves of 37.57 taken over 10 intervals of time. With a multiplier of 1.005 the total moves where 4.91 and with 1.010 the moves were 3.42. The multiplier effectively adds another row to the original data for each independent variable for each interval in which it is allowed to move. All elements in the row are zero except for the specific independent variable which has a coefficient related to the size of the multiplier. As can be seen from Figure 6, the suppression of the independent variable moves by an order of magnitude did not significantly impair the reduction in the projected error.

The matrix of coefficients which describe the dynamics of the system are the basis for the Dynamic Matrix Control Algorithm. For the furnace control problem the response of the dependent variable was considered for 30 intervals of time and the movement of the fuel gas was considered for 10 intervals. Thirty intervals of time represents about 4 1/2 time constants for the response of the outlet temperature to a change in the fuel. At the tenth time interval, the outlet temperature has 3 times constants to settle from the last change in the fuel. This choice of time intervals results in a matrix with 10 columns and 30 rows. To initialize the Algorithm, the measured outlet temparature is stored into the 30 element vector that represents predicted values of the dependent variable. This assumes the system is at steady state, but is not a necessary criterion. An error is then calculated from the expected value of the variable and the set point for the 30 intervals of time. This vector of errors become the right hand side for the 10 by 30 matrix. The least square fit of these data yields the best set of fuel moves to eliminate the projected errors for 30 time intervals. The projected set of fuel moves are used to calculate the outlet temperature change for the forthcoming 30 intervals of time, and the temperature changes are then added into the 30 element vector for the predicted value of the dependent variable. The first fuel move is implemented and the entire vector of predicted dependent variable values is shifted forwared one interval of time. At the start of the next interval of time the predicted value of the dependent variable is compared with the measured value. The error in the projection is used to adjust all 30 values in the predicted dependent variable vector. This adjustment in the prediction provides the feedback to compensate for distrubances and errors in the dynamic prediction. At the next interval the set of errors between the set point and the predicted values of the dependent variable is used to solve for another set of 10 fuel moves. The 9 remaining fuel moves from the previous calculations are summed with newly calculated fuel moves and the current fuel move is implemented. The pattern is repeated at each successive interval of time.

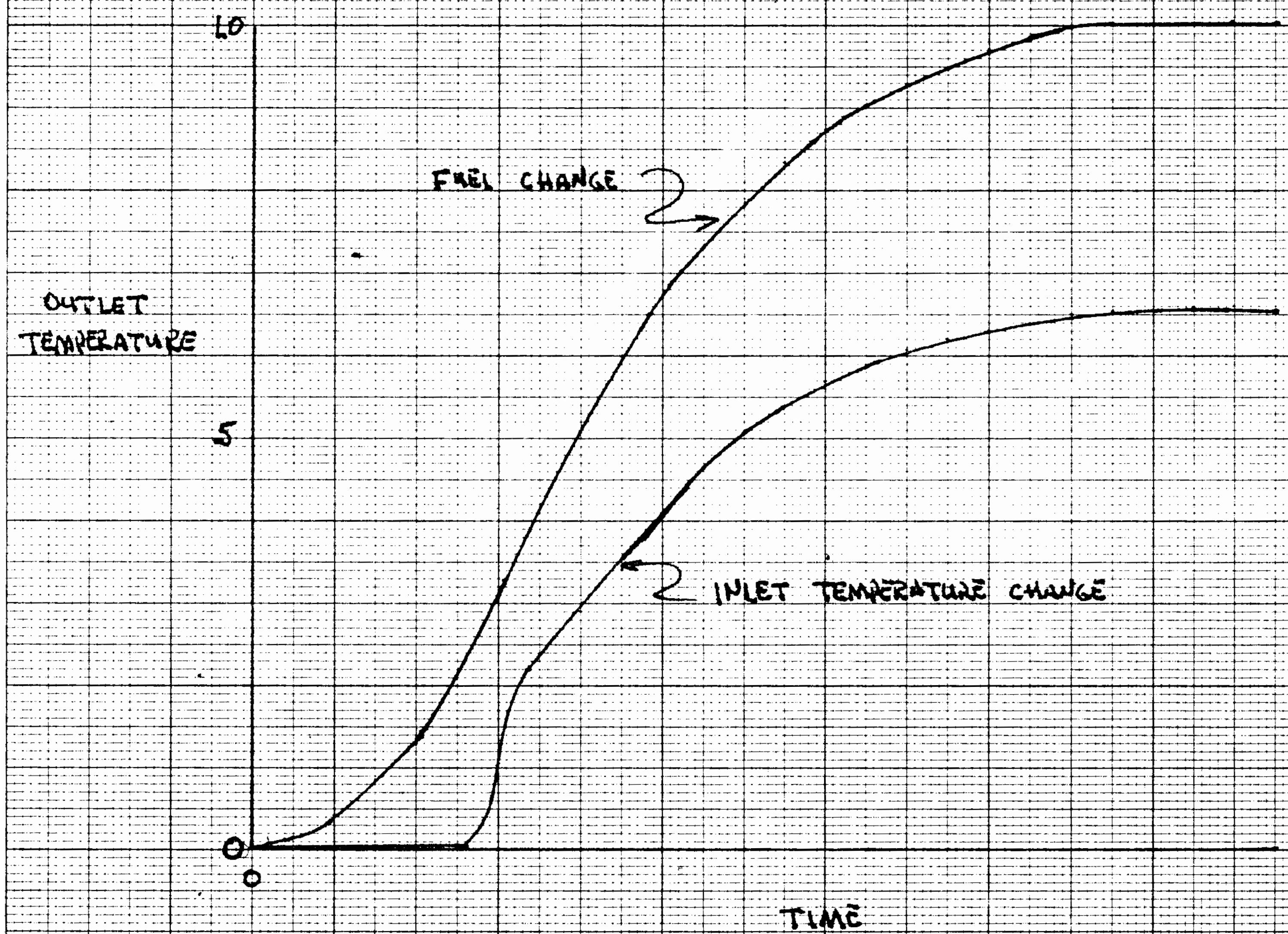
Feed forward control is implemented by measuring the change in the feed inlet temperature between time intervals, multiplying by the numerical coefficient for the effect of the inlet temperature on the outlet, and summing this response of the outlet temperature into the vector of predicted values for the dependent variables.

The description of the technique for the Dynamic Matrix was given in some detail to foster understanding. The actual calculations involved in the technique are at least two orders of magnitude less than would be required by the outlined procedure. The first simplification is to recognize that the matrix of coefficients representing the dynamics are fixed and only the right hand side changes from one time interval to the next. Furthermore, the square matrix that results from the formulation of the least square procedure does not change, which also means the inverse matrix does not change. The errors between the projected vector of dependent variable and the set point, appear in the calculation of the right hand side for the least square formulation.

Consequently the inverse matrix multiplied times the right hand sides yields the set of projected moves in the independent variable. Further it can be shown that only the first row of the inverse matrix and the right hand sides are needed to solve the control program. This calculation yields the control move to make at the present interval of time. The other control moves in the independent variables are imbeded in the first row of the inverse matrix, in the successive updating of the right hand sides and by the coupling of time intervals from adding in the projected response from the fuel moves in each interval of time. In the case of the furnace control discussed earlier the calculations for the Dynamic Matrix Algortithm reduced to the multiplication of the 10 elements in the first row of the inverse matrix times the right hand sides calculated for the least square formulation.

In summary, the Dynamic Matrix Control Algoithm has proven to be a valuable technique for computer control of difficult problems. The opportunity for solution of multivariable problems was not emphasized, but is one of the real attributes of the Algorithm. The least square procedure was used to solve the Dynamic Matrix, however, the Linear Programming Technique is an effective tool for solving the same type problem and has many interesting features.

FURNACE OUTLET TEMPERATURE RESPONSE TO FUEL AND INLET TEMPERATURE



FUEL COEFFICIENTS	INLET TEMPERATURE COEFFICIENTS
.014	ST 0.0
.043	.107
.086	.240
.143	.290
.214	.340
.307	.410
.414	.465
.507	.508
.600	.540
.676	.570
.736	.590
.786	.609
.836	.622
.874	.632
.904	.640
.929	.651
.949	.653
.972	.656
.986	.658
1.000	.659

FIGURE 1

LK

10 X 10 PER INCH

EUGENE DIETZGEN CO.
MADE IN U. S. A.

OUTLET TEMPERATURE RESPONSE TO UNIT SET POINT CHANGE FOR FURNACE

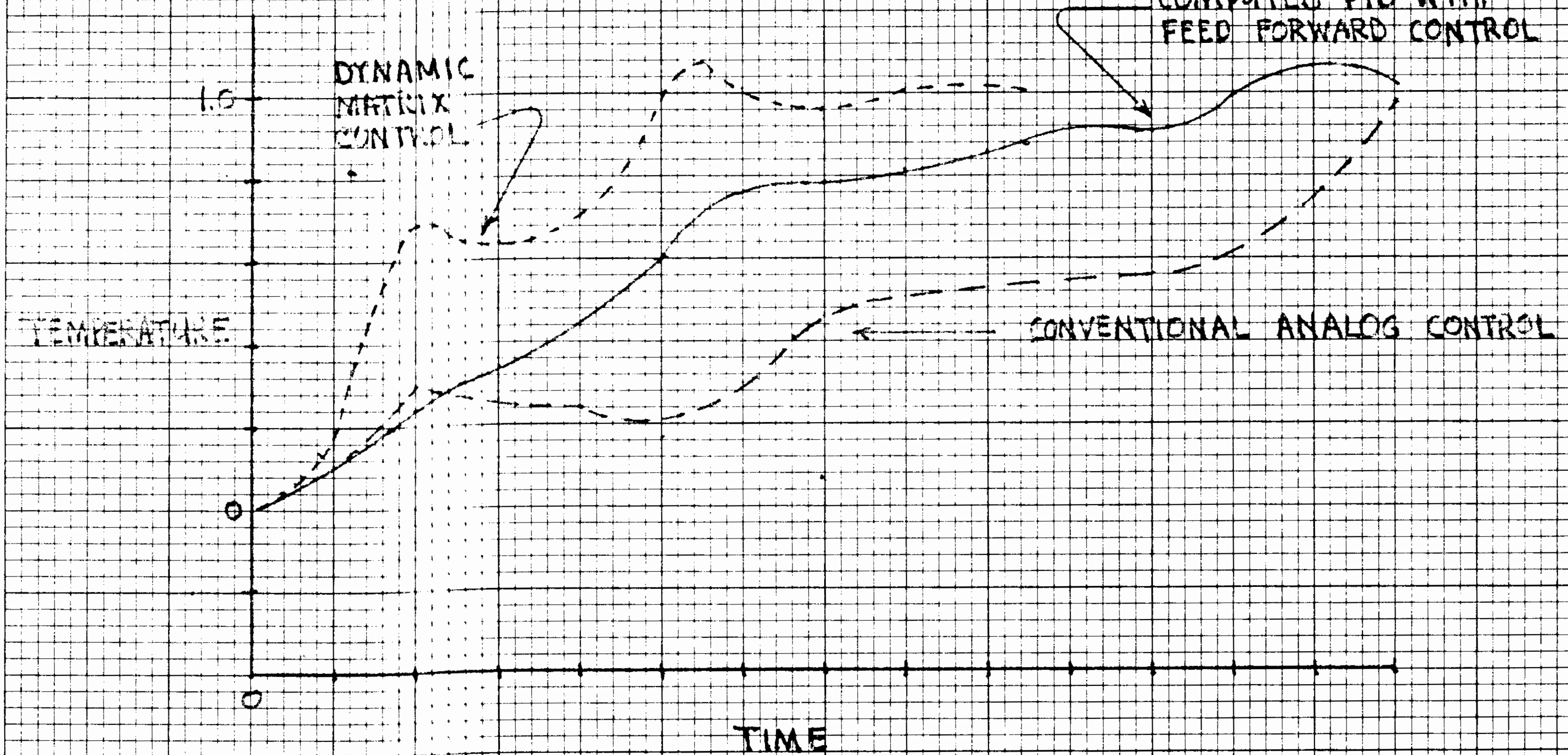


FIGURE 2

CRC
3/4/73

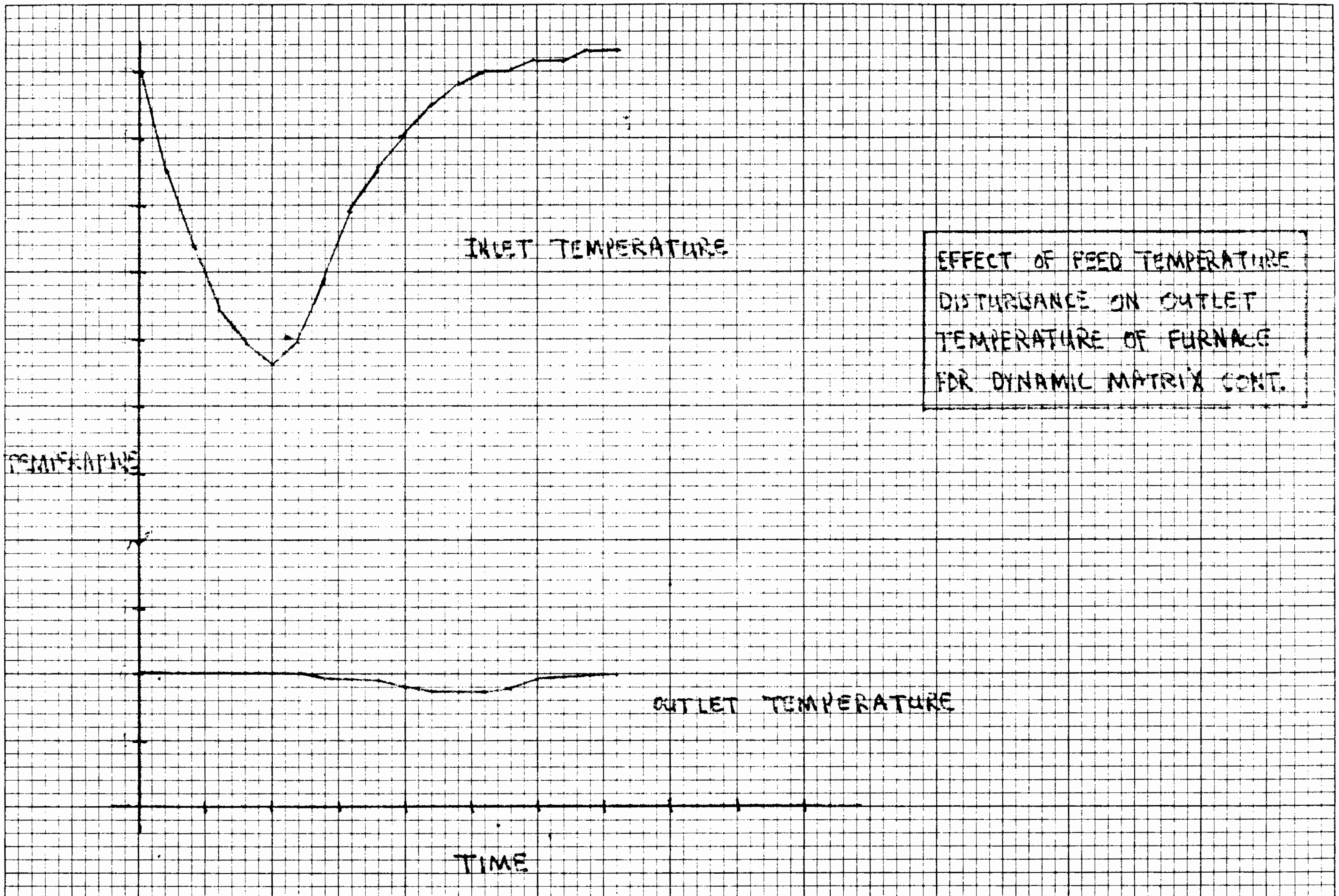

INLET TEMPERATURE
EFFECT OF FEED TEMPERATURE
DISTURBANCE ON OUTLET
TEMPERATURE OF FURNACE
FOR DYNAMIC MATRIX CONT.
TEMPERATURE
OUTLET TEMPERATURE
TIME

FIGURE 3A

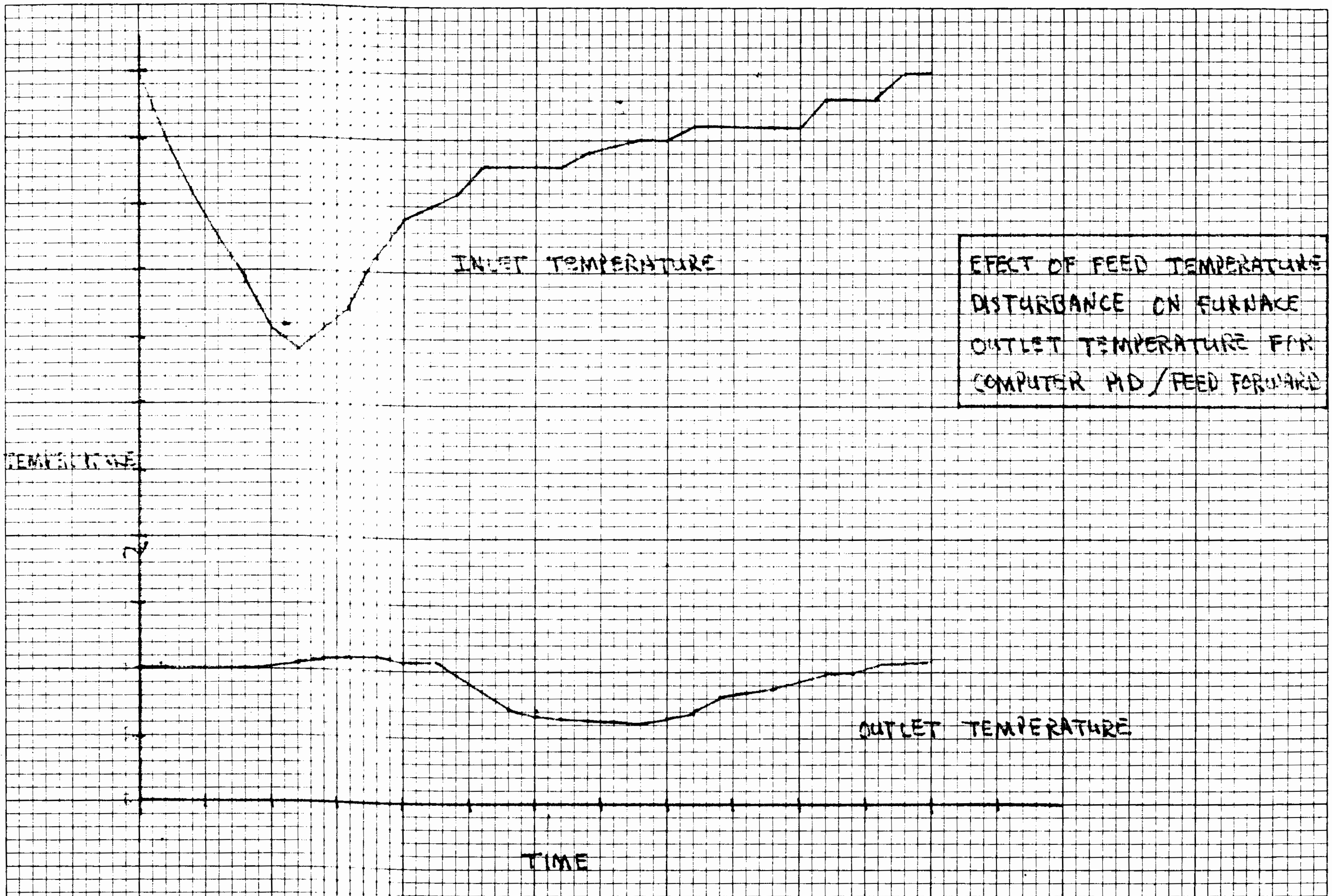


FIGURE 3B

CRC 3/5/73

FIGURE 4

ILLUSTRATION OF THE PRESERVATION OF SCALE FACTOR FOR A LINEAR SYSTEM

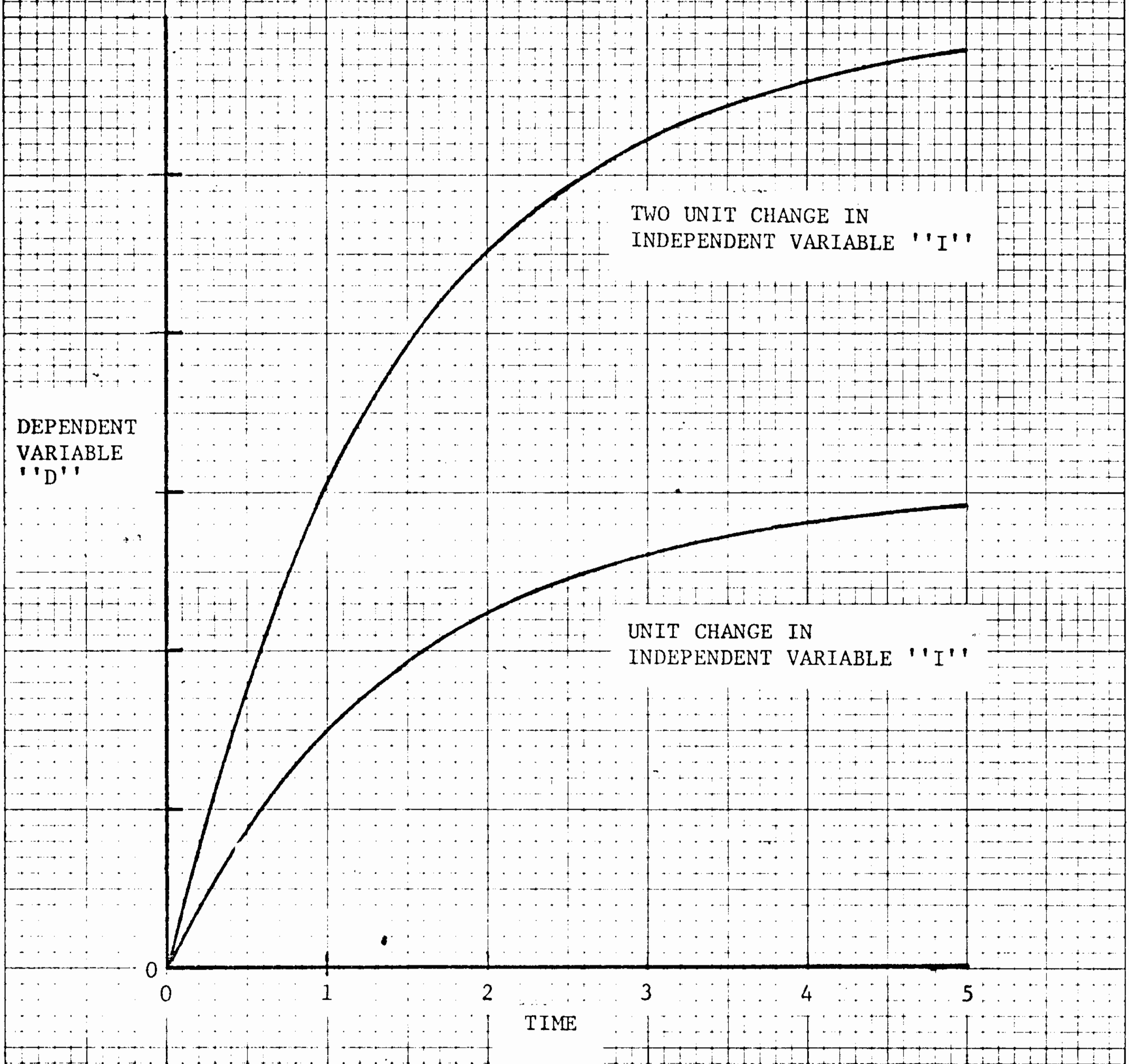
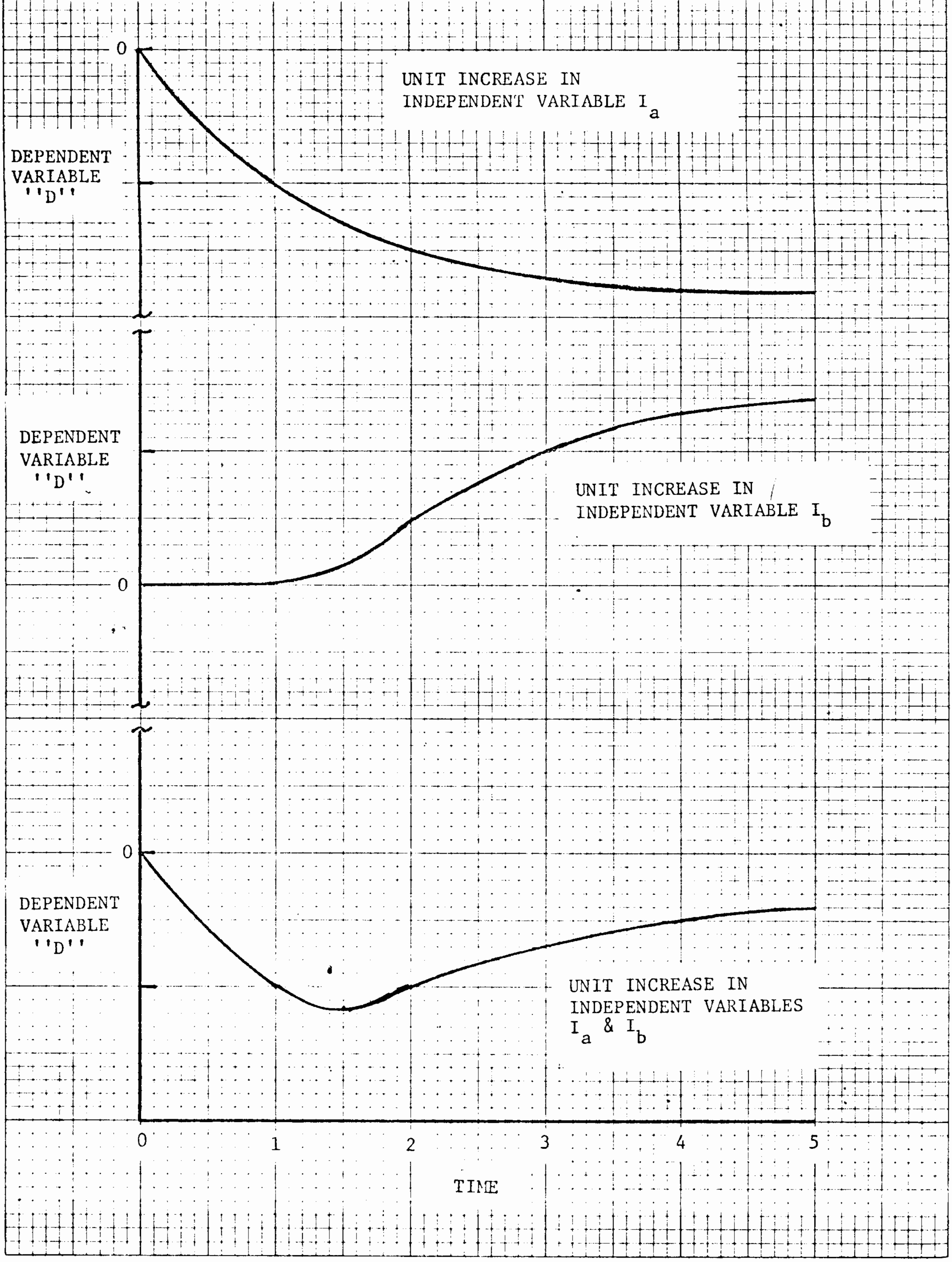


FIGURE 5

ILLUSTRATION OF THE PRINCIPLE OF SUPERPOSITION FOR A LINEAR SYSTEM



EFFECT OF SUPPRESSING FUEL MOVES ON OUTLET TEMPERATURE OF FURNACE

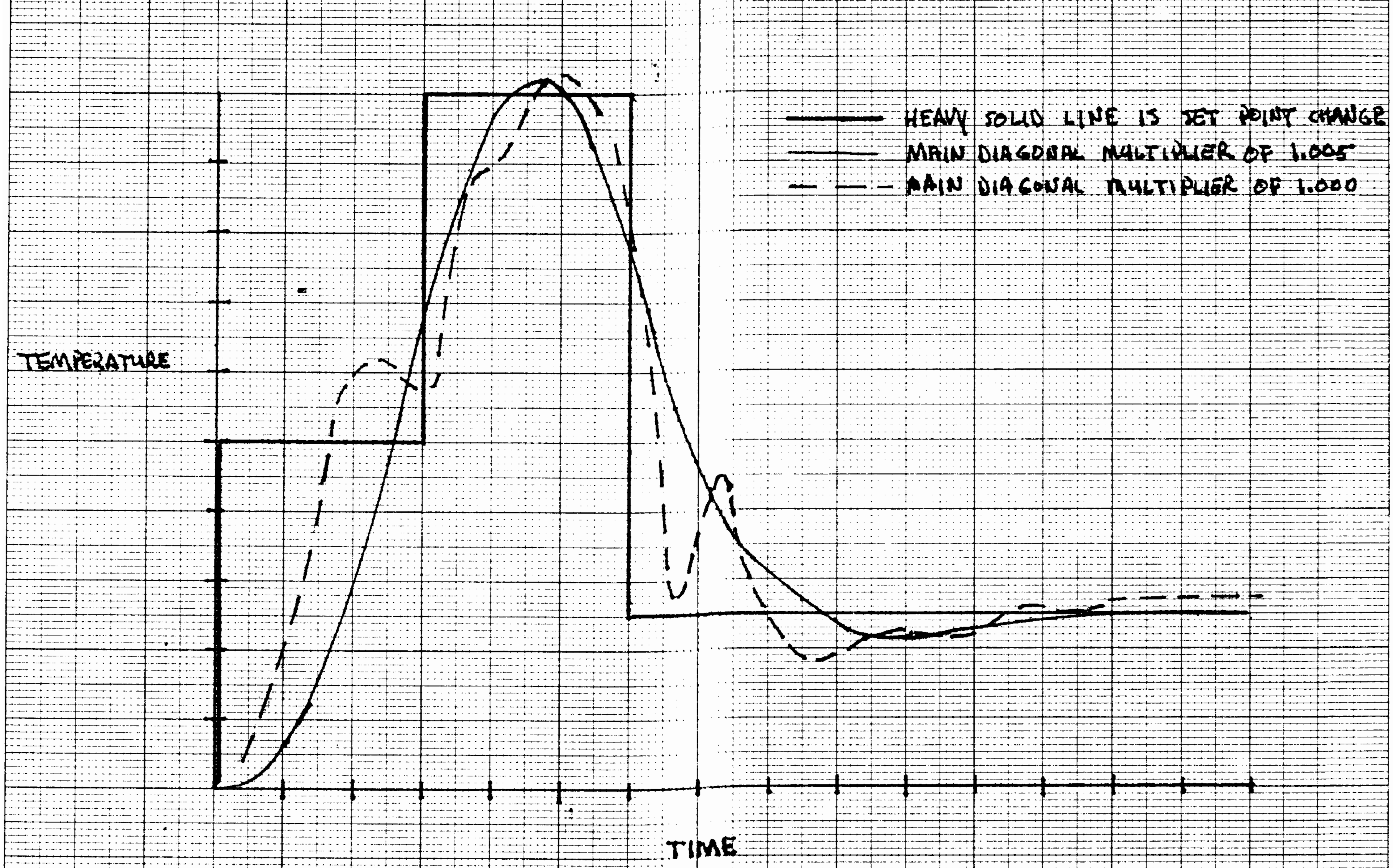


FIGURE 6

LPC

REGISTERED MAIL #76

SHELL OIL COMPANY

REFERENCE

DATE JANUARY 28, 1976

TO MANUFACTURING - PLANS & ANALYSIS - REFINING - MANAGER

FROM MANAGER PROCESS ENGINEERING- REFINING - ENGINEERING-PRODUCTS

SUBJECT REQUEST TO PUBLISH IN LITERATURE

As requested, we have reviewed the proposed publication by Dr. C. J. Huang of the University of Houston and Mr. C. R. Cutler of the Norco Manufacturing Complex on "A Computer Control Algorithm for Complex Control Problems". We recommend that permission to publish this article be granted.

The publication describes a control method for minimizing the effects of process disturbances upon a control loop. Specifically, the control technique is used for minimizing effects of feed rate, feed temperature, fuel gas heating value and soot blower operation upon a furnace outlet temperature control loop.

The information released in the article about the control technique is not sufficient to give other industries a competitive advantage. Publication would serve a useful purpose in that it may prevent others from obtaining patents in this area. Shell can not patent the control technique since it has been in commercial use for more than one calendar year.

Curtis C Williams, III

C. C. Williams, III

WS:fjt

cc - Norco Manufacturing Complex - Technical Superintendent
Engineering Products - Process Engineering - Manager
Shell Development Company - Oil Products - Patents & Licensing - Manager (W. V. Medlin)

Rec'd.	1/30/76
2	~~REFY.~~ MANAGER
3	~~REFY. SUPT.~~
4	~~TECH. SUPT.~~
	SUPT. OPER. - AWC
	SUPT. OPER. - JRN
	SUPT. PP-II
	REFY. CONTROLLER
	SUPT. CONST.
5	~~MGR. EMP.~~ REL.
4	Mgr Tech.
	MGR. FILE #

SM-32-(Rev. 9-57)

Reg. No. 134

SHELL OIL COMPANY

DATE JANUARY 29, 1976

TO NORCO MANUFACTURING COMPLEX - MANAGER

FROM MANAGER - MANUFACTURING-
PLANS & ANALYSIS - REFINING
HEAD OFFICE

SUBJECT REQUEST TO PUBLISH IN LITERATURE

There is agreement here that permission should be given to C. R. Cutler to publish his paper "A Computer Control Algorithm for Complex Control Problems".

T. R. Williams

SM-32 (Rev. 9-57)

REFERENCE T-9142

SHELL OIL COMPANY

DATE FEBRUARY 17, 1976

TO MANAGER TECHNOLOGICAL - REFINING
MR. C. R. CUTLER

FROM TECHNICAL SUPERINTENDENT - REFINING
NORCO MANUFACTURING COMPLEX

SUBJECT REQUEST TO PUBLISH IN LITERATURE

Your proposed paper "A Computer Control Algorithm for Complex Control Problems" has been reviewed by Head Office. I am pleased to inform you that they have granted you permission to publish the paper in the literature.

R. H. Brown

R. H. Brown

cc - Circulate: JDR - JAB - JRN - AWC - RHB