UNIVERSITI TEKNIKAL MALAYSIA MELAKA

Faculty of Manufacturing Engineering

N-PID CONTROLLER WITH FEEDFORWARD OF GENERALIZED MAXWELL-SLIP AND STATIC FRICTION MODEL FOR FRICTION COMPENSATION IN MACHINE TOOLS

Chiew Tsung Heng

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CHIEW TSUNG HENG

A thesis submitted
in fulfillment of the requirements for the degree of Master of Science in Manufacturing Engineering

Faculty of Manufacturing Engineering

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DECLARATION

I declare that this thesis entitled "N-PID Controller with Feedforward of Generalized Maxwell-Slip and Static Friction Model for Friction Compensation in Machine Tools" is the result of my own research except as cited in the references. The thesis has not been accepted for any degree and is not concurrently submitted in candidature of any other degree.

Signature : ....
Name : CHIEW TSUNG HENG
Date : ....

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APPROVAL

I hereby declare that I have read this thesis and in my opinion this thesis is sufficient in terms of scope and quality for the award of Master of Science in Manufacturing Engineering.

Signature : ....

Name : DR. ZAMBERI JAMALUDIN

Date : ....

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DEDICATION

For my beloved father and mother
Their loving and unconditional support throughout my life

To my brothers,
Without whose love and assistance this may not be completed

And also for those I love very much.

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ABSTRACT

Increasing demand for accuracy and precision in machine tools application has placed greater pressure on researchers and machine developers for better products performance. Several factors that have been identified in literature that could affect machine performance are the active presence of disturbance forces such as cutting forces and friction forces. This research focuses only on the effect of friction forces as disturbance in a positioning system. “Spikes” on milled surface are normally observed in computer numerical control machine based on recent research and analysis. These “spikes” are known as quadrant glitches and is mainly due to the friction forces, which is an undesirable and nonlinear phenomenon that cannot be avoided during positioning process. The main objective of this research is the compensation of these friction forces to improve tracking performance of system by utilizing two different approaches, namely; non-model based method and friction model-based feedforward method. Two controllers, namely, proportional-integral-derivative (PID) controller and nonlinear PID (N-PID) controller, were designed, implemented and validated as non-model based technique to compensate friction forces on a XYZ-Stage, which is a fundamental block of a milling machine. In friction model-based method, two friction models, namely; static friction model and Generalized Maxwell-slip (GMS) model, were identified, modeled and applied as friction model-based feedforward. The system frequency response function was identified using a data acquisition unit, dSPACE 1104 with MATLAB software and H1 estimator, a nonlinear least square frequency domain identification method. Parameters for static friction and GMS model were identified using heuristic method and virgin curve respectively. PID and N-PID controllers were designed based on traditional loop shaping frequency domain approach and Popov stability criterion respectively. Numerical simulation and experimental validation for non-model based method showed that N-PID controller provided 25.0% improved performance in terms of quadrant glitches magnitude reduction than the PID controller. This is due to its automatic gain adjustment based on the chosen nonlinear function. For friction model-based feedforward method, the static friction model produced 95.9% reduction in tracking errors using PID controller and 95.8% reduction using the N-PID controller. For GMS friction model feedforward, the quadrant glitches magnitude was reduced by 33.3% using PID controller and 30.0% while using the N-PID controller. Finally, a combined feedforward of static and GMS friction models with the N-PID controller has resulted in the best performance that was a 96.5% reduction in tracking errors, and a 50.0% reduction in quadrant glitches magnitude. It is concluded that this combined approach would benefits to machine tools manufacturers and users as it improves the tracking performance as well as precision especially during circular motion and low tracking velocity.

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ABSTRAK

Peningkatan permintaan terhadap ketepatan dan kepersisan dalam aplikasi perkakasan mesin sering membebankan para penyelidik dan pengeluar mesin untuk mendapatkan prestasi produk yang lebih baik. Antara faktor-faktor yang dikenalpastikan dapat mempengaruhi prestasi mesin dalam hasil-hasil kajian lepas ialah kewujudan daya-daya gangguan seperti daya pemotongan dan daya geseran. Penyelidikan ini hanya fokus terhadap kesan-kesan daya geseran sebagai gangguan dalam sistem keposisian. Berdasarkan kajian and analisa baru-baru ini,"spikes" atas permukaan kisaran hasil mesin kawalan berangka computer biasanya dapat diperhatikan. "Spikes" ini adalah dikenali sebagai "glic" sukuan dan diakibatkan oleh suatu situasi yang tidak sekata, tidak diinginkan dan tidak dapat dielakkan ketika proses keposisian, iaitu daya geseran. Objektif utama penyelidikan ini ialah pengurangan daya geseran ini untuk meningkatkan prestasi sistem melalui penggunaan dua pendekatan yang berbeza, iaitu kaedah bukan berasaskan model dan kaedah suap depan model geseran. Dua jenis pengawal, iaitu pengawal "proportional-integral-derivative" (PID) dan pengawal PID tidak linear (N-PID) direka, dilaksanakan dan disahkan sebagai teknik bukan berasaskan model untuk mengimbangi daya geseran di XYZ-Stage yang merupakan blok asas mesin pengisaran. Dua jenis model geseran, iaitu model geseran statik dan model "Generalized Maxwell-slip" (GMS) telah dikenalpastikan, dimodelkan dan digunakan sebagai teknik model geseran suap depan. Fungsi respon frekuensi sistem dikenalpastikan dengan menggunakan unit perolehan data, iaitu dSPACE 1104 bersama MATLAB dan anggaran H1, iaitu teknik "nonlinear least square frequency domain". Parameter-parameter model geseran statik dan model GMS telah dikenalpastikan menggunakan kaedah heuristik manakala parameter-parameter model GMS dikenalpastikan melalui "virgin curve". Pengawal PID telah direka berdasarkan "loop shaping" dalam domain frekuensi manakala pengawal N-PID telah direka berdassarkan kriteria kestabilan Popov. Simulasi dan pengesahan eksperimen menunjukkan bahawa kawalan N-PID memberi 25.0% prestasi yang lebih baik dari segi pengurangan sukuan glic kerana pelarasan gandaan secara automatik berdasarkan fungsi tidak linear yang terpilih. Untuk teknik suap depan model geseran pula, model geseran statik telah mengurangkan 95.9% ralat apabila menggunakan pengawal PID dan 95.8% ketika menggunakan pengawal N-PID. Dalam kes suap depan model GMS, sukuan "glic" dikurangkan sebanyak 33.3% dengnan menggunakan pengawal PID manakala 30.0% ketika menggunakan pengawal N-PID. Akhirnya, suap depan kombinasi kedua-dua model geseran bersama pengawal N-PID menghasilkan prestasi yang terbaik iaitu pengurangan ralat sebanyak 96.5% dan pengurangan sukuan "glic" sebanyak 50.0%. Kesimpulannya, kaedah kombinasi antara pengawal N-PID dan suap depan model-model geseran akan membawa faedah-faedah kepada para pembuat and pengguna perkakasan mesin kerana kemampuannya dalam meningkantkan prestasi dan kepersisan ketika pergerakan dalam bentuk bulatan dan halaju yang rendah.

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TABLE OF CONTENT

PAGE

DECLARATION
DEDICATION
ABSTRACT i
ABSTRAK ii
ACKNOWLEDGEMENT iii
TABLE OF CONTENT iv
LIST OF TABLES vii
LIST OF FIGURES x
LIST OF SYMBOLS xv
LIST OF ABBREVIATION xvii
LIST OF APPENDICES xviii
LIST OF PUBLICATIONS xix

CHAPTER
1. INTRODUCTION **1**
- 1.1 Background 1
- 1.2 Problem Statement 1
- 1.3 Objectives 2
- 1.4 Scopes 3
- 1.5 Significance of Study 3
- 1.6 Overview of Thesis 4

2. LITERATURE REVIEW **5**
- 2.1 Introduction 5
- 2.2 Machine Tools Technology 5
- 2.3 Mechanical Drive Systems 8
  - 2.3.1 Rack and Pinion Drive 8
  - 2.3.2 Ball Screw Drive 9
  - 2.3.3 Direct Drive 10
- 2.4 Disturbances in Drive System 11
  - 2.4.1 Cutting Forces 12
  - 2.4.2 Friction Forces 13
- 2.5 Characteristic of Friction Forces 14
  - 2.5.1 Pre-sliding Behavior 16
  - 2.5.2 Sliding Behavior 18
- 2.6 Friction Compensation Methods 19
  - 2.6.1 Non-model Based Techniques 21
    - 2.6.1.1 PID Controller 21
    - 2.6.1.2 N-PID Controller 25

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2.6.2 Friction Model-based Techniques 27
- 2.6.2.1 Static Friction Model 27
- 2.6.2.2 Dahl Model 28
- 2.6.2.3 LuGre Model 29
- 2.6.2.4 GMS Model 30

2.7 Summary 32

3. METHODOLOGY 34
- 3.1 Introduction 34
- 3.2 Experimental Setup 36
- 3.3 System Identification and Modeling 38
- 3.4 Motor Constant Identification 40
- 3.5 Friction Model Identification 41
  - 3.5.1 Static Friction Model Identification 41
  - 3.5.2 GMS Friction Model Identification 44
- 3.6 Constructing Plant Model with Identified Friction Model 47
- 3.7 Summary 52

4. DESIGN OF CONTROLLER 54
- 4.1 Introduction 54
- 4.2 Design of PID Controller 54
- 4.3 Design of N-PID Controller 60
- 4.4 Data Properties of Simulation and Experimental Validation 64
- 4.5 Summary 68

5. RESULTS AND DISCUSSION 69
- 5.1 Introduction 69
- 5.2 Tracking Performance of PID Controller 69
- 5.3 Tracking Performance of N-PID Controller 71
- 5.4 Discussion on Tracking Performance between PID and N-PID Controller 72
- 5.5 Tracking Performance of PID Controller with Friction Model Feedforward 75
- 5.6 Tracking Performance of N-PID Controller with Friction Model Feedforward 81
- 5.7 Discussion on Tracking Performance Between Non-model and Model-based Approach 88
- 5.8 Summary 97

6. CONCLUSION AND FUTURE STUDY 99
- 6.1 Conclusion 99
- 6.2 Contribution 100
- 6.3 Future Study 101

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REFERENCES **102**
APPENDICES **107**

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LIST OF TABLES

TABLE	TITLE	PAGE
3.1	System model parameters for x-axis	40
3.2	Parameters of static friction model for x-axis	44
3.3	GMS slip-blocks model parameters of x-axis	47
3.4	Original and revised parameters of system transfer function	52
4.1	Gain values of Kp, Ki, and Kd for PID controller in x-axis	56
4.2	Time domain properties of designed PID controller	60
4.3	Time domain properties of designed N-PID controller	64
4.4	Data properties for simulation and experimental validation	67
5.1	Numerical and experimental tracking error of system with PID controller for tested tracking velocities	71
5.2	Numerical and experimental tracking error of system with N-PID controller for tested tracking velocities	72
5.3	Measured tracking errors of PID and N-PID control system for tracking velocity of 5 mm/s, 10 mm/s, and 15 mm/s	74
5.4	Measured quadrant glitches of PID and N-PID control system for velocity of 5 mm/s, 10 mm/s, and 15 mm/s	74
5.5	Friction compensation performance (in terms of tracking error) for a simulated reference sinusoidal signal with amplitude 30 mm and tracking velocity of 5 mm/s, 10 mm/s and 15 mm/s	79
5.6	Measured tracking error of PID control system with friction model feedforward for tracking velocity of 5 mm/s, 10 mm/s and 15 mm/s	80

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5.7 Measured magnitude of quadrant glitch for PID control system with friction model feedforward at tracking velocity of 5 mm/s 80
5.8 Measured magnitude of quadrant glitch for PID control system with friction model feedforward at tracking velocity of 10 mm/s 81
5.9 Measured magnitude of quadrant glitch for PID control system with friction model feedforward at tracking velocity of 15 mm/s 81
5.10 Friction compensation performance (in terms of tracking error) for a simulated reference sinusoidal signal with amplitude 30 mm and tracking velocity of 5 mm/s, 10 mm/s and 15 mm/s 86
5.11 Measured tracking error of N-PID control system with friction model feedforward for tracking velocity of 5 mm/s, 10 mm/s and 15 mm/s 87
5.12 Measured magnitude of quadrant glitch for N-PID control system with friction model feedforward at tracking velocity of 5 mm/s 87
5.13 Measured magnitude of quadrant glitch for N-PID control system with friction model feedforward at tracking velocity of 10 mm/s 88
5.14 Measured magnitude of quadrant glitch for N-PID control system with friction model feedforward at tracking velocity of 15 mm/s 88
5.15 Comparison of measured magnitude quadrant glitch in friction model feedforward with PID and N-PID controllers at tracking velocity of 5 mm/s 90
5.16 Comparison of measured magnitude of quadrant glitch in friction model feedforward with PID and N-PID controllers at tracking velocity of 10 mm/s 91
5.17 Comparison of measured magnitude of quadrant glitch in friction model feedforward with PID and N-PID controllers at tracking velocity of 15 mm/s 91
5.18 Comparison of measured tracking errors in friction model feedforward with PID and N-PID controller for tracking velocity of 5 mm/s 92
5.19 Comparison of measured tracking errors in friction model feedforward with PID and N-PID controller for tracking velocity of 10 mm/s 92
5.20 Comparison of measured tracking errors in friction model feedforward with PID and N-PID controller for tracking velocity of 15 mm/s 93

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5.21 Comparison of measured tracking errors in friction model feedforward and without feedforward with different amplitude of reference signal 95
5.22 Comparison for measured magnitude of quadrant glitches in friction model feedforward and without feedforward with different amplitude of reference signal 96

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LIST OF FIGURES

FIGURE	TITLE	PAGE
2.1	Rack and pinion system (reproduced from Anonymous, 2010)	9
2.2	Ball screw drive system (reproduced from Altintas et al., 2011)	10
2.3	Direct drive system (reproduced from Anonymous, 2011)	10
2.4	Force circle acting in the cutting zone (Kalpakjian and Schmid, 2013)	12
2.5	The quadrant glitches formed during milling process (Jamaludin, 2008)	13
2.6	The pre-sliding and sliding regime of friction force (Tjahjowidodo, 2013)	14
2.7	Life cycle of one asperity contact: (i) no contact, (ii) contact, and (iii) loss of contact; and spring force behavior as a function of the spring extension during a life cycle of an asperity contact: (iia) during stick, (iib) during slip, and (iic) when loosing contact (Al-Bender et al., 2004)	16
2.8	Possible trajectories of hysteresis function with non-local memory (reproduced from Vo-Minh et al., 2011)	17
2.9	Summary of various friction compensation techniques (Jamaludin, 2008)	19
2.10	Block diagram of basic feedback control system	22
2.11	Block diagram of N-PID controller in feedback system	26
2.12	Different friction components in static friction model (Jamaludin, 2008)	28
2.13	Parallel N- elementary in Maxwell-slip structure (Jamaludin, 2008)	31
3.1	Flow chart of overall research	35
3.2	XYZ-Stage used in experimental setup	36
3.3	Schematic diagram of overall experimental setup	37
3.4	Simulink diagram for FRF measurement	38
3.5	Measured FRFs of x-axis	39
3.6	FRF measurement and proposed model for x-axis	39

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3.7 Block diagram of open loop system for estimation of force constant (Jamaludin, 2008) 40

3.8 Measured input voltage at constant velocity of 2.0 mm/s for x-axis 42

3.9 Measured friction-velocity mapping 43

3.10 Measured friction-velocity mapping (solid line) and fitted static friction model (dash line) 43

3.11 Measured friction force and position for sinusoidal signal of 0.1 Hz and amplitude of 0.010 mm 45

3.12 Virgin curve with selected knots and slopes 46

3.13 GMS model parameters identification of x-axis 47

3.14 Block diagram of original plant model transfer function 48

3.15 Block diagram of system transfer function with identified friction model 48

3.16 Comparison between measured FRF, FRF of identified system transfer function and FRF of combined model (static friction + identified system transfer function) 49

3.17 Comparison between measured FRF, FRF of identified system transfer function and FRF of revised model (static friction + identified system transfer function with revised parameters) 49

3.18 Comparison between measured FRF, FRF of identified system transfer function and FRF of combined model (GMS model + identified system transfer function) 50

3.19 Comparison between measured FRF, FRF of identified system transfer function and FRF of revised model (GMS model + identified system transfer function with revised parameters) 50

3.20 Comparison between measured FRF, FRF of identified system transfer function and FRF of combined model (static friction + GMS model + identified system transfer function) 51

3.21 Comparison between measured FRF, FRF of identified system transfer function and FRF of revised model (static friction + GMS model + identified system transfer function with revised parameters) 51

4.1 Block diagram of PID controller in controlling the ball-screw drive system 55

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4.2 Bode diagram of open loop transfer function with gain margin of 9.9 dB at 194 Hz and phase margin of 54.2 degree at 64.9 Hz 56
4.3 Nyquist diagram of open loop transfer function 57
4.4 Close loop transfer function of system for x-axis 57
4.5 Sensitivity function of system for x-axis 58
4.6 Close loop transfer function with peak absolute value of 1.25 at frequency 108 Hz 59
4.7 Sensitivity function with peak absolute value of 1.76 at frequency 124 Hz 59
4.8 Step response graph of designed PID controller 60
4.9 Popov plot for N-PID control system 62
4.10 Graph of nonlinear gain, k(e) against error, e 63
4.11 Step response graph of designed N-PID controller 64
4.12 Control scheme of system with PID controller for simulation 65
4.13 Control scheme of system with N-PID controller for simulation 65
4.14 Control scheme of friction compensation using friction model-based feedforward for simulation 65
4.15 Control scheme of system with PID controller for experimental validation 66
4.16 Control scheme of system with N-PID controller for experimental validation 66
4.17 Control scheme of friction compensation using PID controller with friction model-based feedforward 66
4.18 Control scheme of friction compensation using N-PID controller with friction model-based feedforwar 67
5.1 Simulated tracking error of system with PID controller for tracking velocity (a) 5 mm/s, (b) 10 mm/s, and (c) 15 mm/s 70
5.2 Measured tracking error of system with PID controller for tracking velocity (a) 5 mm/s, (b) 10 mm/s, and (c) 15 mm/s 70
5.3 Simulated tracking error of system with N-PID controller for tracking velocity (a) 5 mm/s, (b) 10 mm/s, and (c) 15 mm/s 71
5.4 Measured tracking error of system with N-PID controller for velocity (a) 5 mm/s, (b) 10 mm/s, and (c) 15 mm/s 72

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5.5 Quadrant glitches of both PID and N-PID controllers at velocity of 5 mm/s (a-i and a-ii), velocity of 10 mm/s (b-i and b-ii), and velocity of 15 mm/s (c-i and c-ii) 73

5.6 Simulated reference velocity of 5 mm/s and tracking errors for (a) no friction feedforward (PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with both friction models together 76

5.7 Simulated reference velocity of 10 mm/s and tracking errors for (a) no friction feedforward (PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with both friction models together 76

5.8 Simulated reference velocity of 15 mm/s and tracking errors for (a) no friction feedforward (PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with both friction models together 77

5.9 Reference velocity of 5 mm/s and measured tracking errors for (a) no friction feedforward (PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with both friction models together 77

5.10 Reference velocity of 10 mm/s and measured tracking errors for (a) no friction feedforward (PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with both friction models together 78

5.11 Reference velocity of 15 mm/s and measured tracking errors for (a) no friction feedforward (PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with both friction models together 78

5.12 Simulated reference velocity of 5 mm/s and tracking errors for (a) no friction feedforward (N-PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with combining both friction models 82

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5.13 Simulated reference velocity of 10 mm/s and tracking errors for (a) no friction feedforward (N-PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with combining both friction models 83

5.14 Simulated reference velocity of 15 mm/s and tracking errors for (a) no friction feedforward (N-PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with combining both friction models 83

5.15 Reference velocity of 5 mm/s and measured tracking errors for (a) no friction feedforward (N-PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with combining both friction models 84

5.16 Reference velocity of 10 mm/s and measured tracking errors for (a) no friction feedforward (N-PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with combining both friction models 84

5.17 Reference velocity of 15 mm/s and measured tracking errors for (a) no friction feedforward (N-PID controller), (b) static friction model feedforward, (c) GMS model feedforward and (d) feedforward with combining both friction models 85

5.18 Tracking error of (a-i) without feedforward (N-PID only) and (a-ii) N-PID with feedforward of static and GMS model for reference signal with amplitude of 15 mm; tracking error of (b-i) without feedforward (N-PID only) and (b-ii) N-PID with feedforward of static and GMS model for reference signal with amplitude of 30 mm 95

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LIST OF SYMBOLS

Control:

$r(t)$ - Reference input signal

$y(t)$ - Output signal

$u(t)$ - Control input

$e(t)$ - Error

$G(s)$ - System

$G_m (s)$ - System model transfer function

$G_m'(s)$ - System model with friction term

$d(t)$ - Disturbances

$n(t)$ - Noises

$G_c (s)$ - Controller

L - Open loop transfer function

S - Sensitivity function

T - Close loop transfer function

w_c - Gain crossover frequency

w_B - Bandwidth from sensitivity function

w_{BT} - Bandwidth from close loop transfer function

$f(e)$ - Scaled error

T_d - Time delay

k_f - Motor constant

M - Mass

$k(e)$ - Nonlinear gain

k_o - Rate of variation of nonlinear gain

e_{max} - Range of variation of error

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Friction:

F_n - Compressive force
F_t - Tangential force
k_t - Tangential stiffness
k_n - Normal stiffness
F_f - Total friction force
F_s - Static friction force
F_c - Coulomb friction force
σ - Viscous friction force
δ - Stribeck shape factor
v - Velocity
V_s - Stribeck velocity
δ_d - Determinant of shape of hysteresis
σ_o - Asperity stiffness
σ_1 - Micro-viscous friction coefficient
σ_2 - Viscous friction coefficient
z - Average deflection of asperities
$s(v)$ - Stribeck curve
i - Elementary
k_i - Elementary stiffness
W_i - Maximum elementary Coulomb force
F_i - Friction output
z_i - Elementary displacement
C - Constant for rate of friction force followed Stribeck effect in sliding
α_i - Elementary normalized friction force
$\mathrm{\alpha}$ - Mean ratio of characteristic length between inactivity and activity
w - Randomly chosen wavelength
z - Randomly chosen height

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LIST OF ABBREVIATION

AC - Alternating current
CNC - Computer numerical control
D - Derivative
DSP - Digital signal processor
FRF - Frequency response function
GMS - Generalized Maxwell-slip
I - Integral
I/O - Input/output
NCTF - Nominal characteristic trajectory following
N-PID - Nonlinear proportional-integral-derivative
P - Proportional
PD - Proportional-derivative
PID - Proportional-integral-derivative
S-GMS - Smoothed Generalized Maxwell-slip
SISO - Single input single output
SMC - Sliding mode control
XGMS - Extended Generalized Maxwell-slip

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LIST OF APPENDICES

APPENDIX **TITLE** **PAGE**

A Specification of XY milling table 102

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LIST OF PUBLICATIONS

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