Control of Transport PDE/Nonlinear ODE Cascades with State-Dependent Propagation Speed

Mamadou Diagne, Nikolaos Bekiaris-Liberis, Andreas Otto, and Miroslav Krstic

Abstract—In this paper, we deal with the control of a transport PDE/nonlinear ODE cascade system in which the transport coefficient depends on the ODE state. We develop a PDE-based predictor-feedback boundary control law, which compensates the transport dynamics of the actuator and guarantees global asymptotic stability of the closed-loop system. The stability proof is based on an infinite-dimensional backstepping transformation and a Lyapunov-like argument. The relation of the PDE-ODE cascade with a state-dependent propagation speed to an ODE system with a state-dependent input delay, which is defined implicitly via an integral of past values of the ODE state, is also highlighted and the corresponding equivalent predictorfeedback design is presented together with an alternative proof of global asymptotic stability of the closed-loop system based on the construction of a Lyapunov functional. The practical relevance of our control framework is illustrated in an example that is concerned with the control of a metal rolling process.

I. INTRODUCTION

The problem of stabilization of coupled transport PDE/ODE systems in which the transport coefficient or the boundary of the PDE domain varies with time is currently attracting considerable attention. This is attributed to the fact that such systems occur in a large number of challenging engineering problems, typically when sensors and actuators are not colocated and, particularly, in systems involving transport of materials. Among several other applications, such systems are utilized to describe the dynamics of screw extrusion processes for additive manufacturing [1], metal cutting processes [2], moisture in convective flows [3], populations [4], transport phenomena in gasoline engines [5], [6], [7], [8], [9], crushingmills [10], production of commercial fuels by blending [11] and of stick-slip instabilities during oil drilling [12], [13], [14], [15].

In this paper, we consider a particular class of implicitly defined state-dependent delays, which appear in numerous applications and which are expressed as transport, with a variable velocity (that may depend on the state of the ODE system), over a constant distance [16]. In engineering, such delays are sometimes called variable transport delays [17] and

can be found, for example, in material flows in reactors [18], whereas the same type of delays can be even found in biology, typically known as threshold delays [4], [19].

Predictor-feedback control laws are often employed for compensation of constant input delays, which appear in numerous linear [20], [21] and nonlinear [22], [23] physical systems. In recent years, the extension of the predictor-feedback concept to the case of nonlinear systems with input delays that vary with time has been developed in [24], [25], [26] (see also [27], [28] for other prediction-based approaches for linear systems). Such predictor feedbacks are employed for stabilization of PDE-ODE cascades in which the PDE part describes the actuator dynamics of the ODE system, exploiting an alternative representation of the PDE-ODE system via a nonlinear system with input delay. In particular, [1] is dealing with the control of the nozzle flow rate of screw extruders in additive manufacturing utilizing a transport PDE/ODE cascade model in which the length of the PDE domain depends on the ODE state and [12], [13] with the stabilization of nonlinear systems with actuator dynamics governed by a wave PDE with moving boundary that depends on the ODE state as well. Predictor-based control designs are also developed for stabilization of transport PDE-ODE cascades with inputdependent transport coefficient [9].

In this paper, we develop a PDE-based predictor-feedback law for stabilization of a transport PDE/nonlinear ODE cascade with state-dependent propagation speed. We prove global asymptotic stability of the closed-loop system with the aid of a Lyapunov functional that is constructed by introducing a novel infinite-dimensional backstepping transformation. An alternative representation of the PDE/ODE cascade as a nonlinear system with state-dependent input delay defined implicitly through an integral of the ODE state, is derived, computing the PDE solution with the method of characteristics. The equivalent predictor-feedback design for the delay system is also presented. We prove global asymptotic stability of the closed-loop system in the new representation providing an alternative proof.

The problem in this paper differs than a problem with a paststate-dependent delay [29] in that the different (in comparison to [29]) definition of the delay in the current case gives rise to a different prediction horizon, which is defined implicitly through an integral equation that incorporates the future values of the state over the entire prediction window (and not just as an explicit function of the current state as in the case of a past-state-dependent delay). This results in a different definition of the predictor in comparison to [29]. In addition, unlike the contributions [25], [29], the present work offers a

Mamadou Diagne is with the Department of Mechanical Aerospace and Nuclear Engineering, Rensselaer Polytechnic Institute, Troy, NY 12180, USA, diagnm@rpi.edu

Nikolaos Bekiaris-Liberis is with the Department of Production Engineering and Management, Technical University of Crete, Chania, 73100, Greece, nikos.bekiaris@dssl.tuc.gr

as Otto is with the Institute of Physics, Chem-
University of Technology, Chemnitz, Germany, nitz University of Technology, andreas.otto@physik.tu-chemnitz.de

Miroslav Krstic is with the Department of Mechanical & Aerospace Engineering, University of California, San Diego, La Jolla, CA 92093-0411 krstic@ucsd.edu

global stability result. This is due to the fact that the feasibility condition that the delay rate is less than one is satisfied a priori (irrespective of the values of the state and input). This is guaranteed by the assumption of the uniform (with respect to the state) strict positiveness of the transport speed made here, which imposes a single direction of propagation of the control signal along the actuation path (i.e., the control signal never propagates in the opposite direction).

The effectiveness of the proposed control approach is illustrated in a simulation of a model for the control of a metal rolling process [30], [31], [32], where a state-dependent delay due to a state-dependent transport velocity occurs [33], [34].

This paper is organized as follows: In Section II, the PDE/nonlinear ODE cascade system and the controller design are presented. The statement of the main result and the stability proof via PDE representation are introduced in Section III. Section IV discusses the alternative representation of the PDE/nonlinear ODE cascade system as an implicit statedependent input delay system. The design of an equivalent controller for the delay system is established in Section V. The stability analysis via delay system representation is presented in Section VI. The paper ends with simulation results, which illustrate the practical relevance of the proposed framework via an application to metal rolling processes in Section VII. Final remarks and future directions are provided in Section VIII.

Notation: We use the common definition of class K, K_{∞} and \mathcal{KL}_{∞} from [35]. For an *n*-vector, the norm |.| denotes the usual Euclidean norm. We denote by $C^{j}(A)$ the space of functions that have continuous derivatives of order j on A .

II. PROBLEM STATEMENT AND CONTROLLER DESIGN

We consider the transport PDE/nonlinear ODE cascade system with state-dependent propagation speed defined as

$$
\dot{X}(t) = f(X(t), u(0, t)),
$$
\n(1)

where $X \in \mathbb{R}^n$ and $f : \mathbb{R}^n \times \mathbb{R} \to \mathbb{R}^n$ is continuously differentiable with $f(0, 0) = 0$. The plant is located at the boundary $x = 0$ of a transport device (e.g., a pipe, which represents the actuation path) and controlled through a transport equation given by

$$
\partial_t u(x,t) - v\left(X(t)\right)\partial_x u(x,t) = 0,\t(2)
$$

where $v : \mathbb{R}^n \to \mathbb{R}_+$ is continuously differentiable with respect to X. The actuation $U(t)$ at the boundary $x = D$ of the PDE is written as

$$
u(D, t) = U(t). \tag{3}
$$

The initial condition along the actuation path is defined as

$$
u(x,0) = u_0(x). \t\t(4)
$$

Assumption 1: The state-dependent propagation speed v : $\mathbb{R}^n \to \overline{\mathbb{R}}_+$ is continuously differentiable and there exists a positive constant v_* such that

$$
v(X) \ge v_\star, \quad \text{for all } X \in \mathbb{R}^n. \tag{5}
$$

Assumption 2: There exist a smooth positive definite function C and class \mathcal{K}_{∞} functions μ_1 , μ_2 and μ_3 such that for the plant $X = f(X, w)$, the following hold

$$
\mu_1(|X|) \le C(X) \le \mu_2(|X|) \tag{6}
$$

$$
\frac{\partial C(X)}{\partial X} f(X,\omega) \le C(X) + \mu_3(|\omega|),\tag{7}
$$

for all $(X, \omega)^T \in \mathbb{R}^{n+1}$.

Assumption 2 guarantees that system $\dot{X} = f(X, \omega)$ is strongly forward complete with respect to ω .

Assumption 3: System $\dot{X} = f(X, \kappa(X) + \omega)$ is input-tostate stable (ISS) with respect to ω . Moreover, the feedback law $\kappa : \mathbb{R}^n \to \mathbb{R}$ is continuously differentiable with $\kappa(0) = 0$.

The definitions of strong forward completeness and inputto-state stability are those from [36] and [37], respectively.

The predictor-feedback controller for system (1) – (3) is given by

$$
u(D,t) = \kappa(p(D,t))
$$
\n(8)

$$
p(x,t) = X(t) + \int_0^x \frac{1}{v(p(y,t))} f(p(y,t), u(y,t)) dy,
$$
 (9)

for all $x \in [0, D]$. We emphasize that for implementing control law (8), (9), one needs to measure the ODE state $X(t)$ and the PDE state $u(x, t)$, $x \in [0, D]$.

Fig. 1. Schematic of the closed-loop system

III. MAIN RESULT AND ITS PROOF VIA PDE **REPRESENTATION**

Theorem 1: Consider the closed-loop system consisting of the plant (1) – (3) and the control law (8) , (9) under Assumptions 1, 2, and 3. For all initial conditions for which $u_0(x)$ is locally Lipschitz on $[0, D]$ and which satisfy the compatibility condition $u_0(D) = \kappa (p(D, 0))$, there exists a unique solution to the closed-loop system with $X(t) \in C^1[0,\infty)$ and $u(x,t)$ locally Lipschitz on $[0, D] \times [0, \infty)$. Moreover, there exists a class $K\mathcal{L}$ function Γ such that the following holds for all $t \geq 0$

$$
|X(t)| + \sup_{x \in [0,D]} |u(x,t)| \le \Gamma\left(|X(0)| + \sup_{x \in [0,D]} |u_0(x)|, t\right).
$$
\n(10)

The Lipschitzness of the initial condition $u_0(x)$ and the compatibility condition guarantee that the closed-loop system is well-posed.

The proof of Theorem 1 is based on the following lemmas whose proof can be found in the Appendix (Section A).

Using the predictor state defined in (9), we introduce in the first two lemmas a novel backstepping transformation (and its inverse) that allows one to convert the original system to a suitable "target system" whose stability is easier to establish compared to the original closed-loop system (1) – (3) , (8) , (9) .

Lemma 1: The control law defined in (8), (9), together with the infinite-dimensional backstepping transformation

$$
w(x,t) = u(x,t) - \kappa (p(x,t)), \qquad (11)
$$

where $p(x, t)$ is defined in (9), maps the system (1), (2) with the boundary condition (3) into the following target system

$$
\dot{X}(t) = f(X(t), \kappa(X(t)) + w(0, t)), \quad (12)
$$

$$
\partial_t w(x,t) = v(X(t))\partial_x w(x,t), \quad x \in [0,D] \quad (13)
$$

$$
w(D,t) = 0. \t(14)
$$

Lemma 2: The inverse of the infinite-dimentional backstepping transformation (11) is given by

$$
u(x,t) = w(x,t) + \kappa (\pi(x,t)), \qquad (15)
$$

where π is defined as

$$
\pi(x,t) = X(t) + \int_0^x \left[\frac{1}{v(\pi(y,t))} \times f\left(\pi(y,t), \kappa(\pi(y,t)) + w(y,t)\right) \right] dy.
$$
 (16)

In the next lemma we show that the target system (12) – (14) is globally asymptotically stable employing a Lyapunov-like argument.

Lemma 3: There exists a function $\nu \in \mathcal{KL}$ such that

$$
|X(t)| + ||w(t)||_{\infty} \le \nu\bigg(|X(0)| + ||w(0)||_{\infty}, t\bigg), \qquad (17)
$$

for all $t > 0$.

Lemmas 4 and 5 show the equivalence between the norm of the original system and the norm of the transformed system based on Assumptions 1–3.

Lemma 4: There exists a class \mathcal{K}_{∞} function $\bar{\omega}$ such that

$$
\sup_{x \in [0,D]} |p(x,t)| \le \bar{\omega} \bigg(|X(t)| + \sup_{x \in [0,D]} |u(x,t)| \bigg) \quad t \ge 0.
$$
\n(18)

Lemma 5: There exists a class K_{∞} function ω such that

$$
\sup_{x \in [0,D]} |\pi(x,t)| \le \underline{\omega} \bigg(|X(t)| + \sup_{x \in [0,D]} |w(x,t)| \bigg), \quad t \ge 0.
$$
\n(19)

Proof of Theorem 1: Assumption 3 implies the existence of a class \mathcal{K}_{∞} function Ω such that

$$
\kappa(|\xi|) \le \Omega(|\xi|). \tag{20}
$$

From the backstepping transformation (11) defined in Lemma 1 we deduce the following inequalities

$$
\sup_{x \in [0,D]} |w(x,t)| \le \sup_{x \in [0,D]} \bigg(|u(x,t)| + \Omega(|p(x,t)|) \bigg), \quad (21)
$$

$$
\sup_{x \in [0,D]} |u(x,t)| \le \sup_{x \in [0,D]} \left(|w(x,t)| + \Omega(|\pi(x,t)|) \right). \tag{22}
$$

Then, from (18) and (19), we obtain

$$
\sup_{x \in [0,D]} |w(x,t)| \leq \sup_{x \in [0,D]} |u(x,t)|
$$

+ $\Omega \circ \bar{\omega} \Big(|X(t)| + \sup_{x \in [0,D]} |u(x,t)| \Big),$

$$
\sup_{x \in [0,D]} |u(x,t)| \leq \sup_{x \in [0,D]} |w(x,t)|
$$

+ $\Omega \circ \underline{\omega} \Big(|X(t)| + \sup_{x \in [0,D]} |w(x,t)| \Big).$
(23)

From (23) and (24), there exist some class \mathcal{K}_{∞} functions $\bar{\lambda}$ and λ such that

$$
|X(t)| + \sup_{x \in [0,D]} |w(x,t)| \leq \bar{\lambda} \bigg(|X(t)| + \sup_{x \in [0,D]} |u(x,t)| \bigg),
$$
\n(25)
\n
$$
|X(t)| + \sup_{x \in [0,D]} |u(x,t)| \leq \bar{\lambda} \bigg(|X(t)| + \sup_{x \in [0,D]} |w(x,t)| \bigg).
$$
\n(26)

Combining (17) and (26) we conclude that

$$
|X(t)| + \sup_{x \in [0,D]} |u(x,t)|
$$

\n
$$
\leq \underline{\lambda} \left(\nu \left(|X(0)| + \sup_{x \in [0,D]} |w_0(x)|, t \right) \right).
$$
 (27)

Using (25) we recover (10) with $\Gamma(s) = \lambda \left(\nu(\bar{\lambda}(s))\right)$.

In order to prove the well-posedness of the closed-loop system consisting of (1) – (3) with the controller (8) , (9) , we first compute the solution to (13) , (14) with respect to a given initial condition $(X(0), w_0(x))$. We denote by $w(x(s), t(s))$ the characteristic curve passing through the point $(x, t) \in$ $[0, D] \times [0, \infty)$, i.e.,

$$
\frac{dt(s)}{ds} = 1,\t(28)
$$

$$
\frac{dx(s)}{ds} = -v(X(t(s))),\tag{29}
$$

$$
\frac{dw(s)}{ds} = 0,\t\t(30)
$$

with the initial conditions $t(0) = 0$, $x(0) = x_0$, and $w(0) = w_0(x_0)$, respectively. Integrating (28)–(30) along the characteristic lines one deduces the solution of (13), (14) as

$$
w(x,t) = w_0(x + \Phi(t)), \text{ for all } 0 \le x + \Phi(t) \le D \quad (31)
$$

$$
w(x,t) = 0, \quad \text{for all } x + \Phi(t) \ge D,\tag{32}
$$

$$
\Phi(t) = \int_0^t v(X(\lambda))d\lambda.
$$
\n(33)

Thus, for $t < \Phi^{-1}(D)$ system (12) is written as

$$
\dot{X}(t) = f\left(X(t), \kappa\left(X(t)\right) + w_0\big(\Phi(t)\big)\right),\tag{34}
$$

$$
\dot{\Phi}(t) = v(X(t)),\tag{35}
$$

$$
\Phi(0) = 0.\tag{36}
$$

From the backstepping transformation (11), we obtain

$$
w_0(x) = u_0(x) - \kappa (p_0(x)), \qquad (37)
$$

where $p_0(x)$ is given by

$$
p_0(x) = X(0) + \int_0^x \frac{1}{v(p_0(y))} f(p_0(y), u_0(y)) dy.
$$
 (38)

Since κ , f, U, and v are continuously differentiable, we deduce the local Lipschitzness of $w_0(x)$ from the Lipschitzness of $u_0(x)$ stated in Theorem 1 and (38). Then, relations (34)– (36) imply the local Lipschitzness of the right-hand side of the (X, Φ) system, which in turn ensures the existence and uniqueness of $(X(t), \Phi(t)) \in C^1[0, \Phi^{-1}(D))$ where $\Phi^{-1}(D)$ satisfies

$$
D = \int_0^{\Phi^{-1}(D)} v(X(\tau))d\tau.
$$
 (39)

For $t > \Phi^{-1}(D)$, $w(0,t) = 0$ and the dynamics of X in (34) are reduced to $\dot{X} = f(X, \kappa(X))$. The Lipschitzness of f and κ guarantee the existence and uniqueness of $X(t) \in C^1(\Phi^{-1}(D), \infty)$ and the compatibility condition guarantees that X is differentiable at $\Phi^{-1}(D)$, and thus, $X(t) \in C^1[0,\infty).$

From (31), (32) and (13), (14) the well-posedness of X together with the continuous differentiability and the strict positiveness of the transport speed $v(X)$ imply the existence and uniqueness of $w(x, t)$ which is locally Lipschitz on (x, t) , for all $(x, t) \in [0, D] \times [0, \infty)$. Using the equivalence between the signals $p(x, t)$ and $\pi(x, t)$ stated in (104), it can be deduced from (100) that the π -system satisfies the following PDE

$$
\partial_t \pi(x, t) = v(X(t)) \partial_x \pi(x, t), \tag{40}
$$

$$
\pi(0,t) = X(t). \tag{41}
$$

Defining the characteristic curves parameterized by some variable τ and expressing the total derivative of $\pi(x(\tau), t(\tau))$ in order to derive the equivalent set of ODE for the system (40) along the characteristic lines, the solution of the transport PDE (40), compatible with the boundary condition (41) is written $as¹$

$$
\pi(x,t) = X(\Phi^{-1}(x + \Phi(t))).
$$
 (42)

The existence and uniqueness of $(X(t), \Phi(t)) \in C^1[0, \infty)$ ensures that $\pi(x, t)$ is continuously differentiable on $[0, D] \times$ $[0, \infty)$, and thus, from the inverse backstepping transformation (15) and the local Lipschitzness of $w(x, t)$ we get the local Lipschitzness of $u(x, t)$ on $[0, D] \times [0, \infty)$.

IV. LINKING THE PDE-ODE CASCADE TO AN IMPLICIT STATE-DEPENDENT INPUT DELAY SYSTEM

In this section we present an alternative state-dependent delay system represention of the transport PDE/nonlinear ODE cascade system (1) – (3) . The method of characteristics is used first in order to solve the transport PDE equation (2). Defining the characteristic curves parameterized by some variable τ , the state of the PDE can be described by $u(x(\tau), t(\tau))$ whose total derivative is written as

$$
\frac{du(x(\tau),t(\tau))}{d\tau} = \frac{\partial u}{\partial t}\frac{dt}{d\tau} + \frac{\partial u}{\partial \tau}\frac{dx}{d\tau}.
$$
 (43)

By comparing the total derivative and the transport equation (2) we deduce the following ODEs system

$$
\frac{dt(\tau)}{d\tau} = 1,\t\t(44)
$$

$$
\frac{dx(\tau)}{d\tau} = -v\left(X(t(\tau))\right),\tag{45}
$$

$$
\frac{du(\tau)}{d\tau} = 0.\t\t(46)
$$

Integration of the ODEs (44) and (45) yields the characteristic curves of the PDE (2) given as

$$
t(\tau) = t_0 + \tau, \quad t(0) = t_0 \tag{47}
$$

$$
x(\tau) = \int_0^{\tau} \frac{dx(\lambda)}{d\lambda} d\lambda + x(0)
$$
 (48)

$$
= -\int_0^{\tau} v(X(t_0 + \lambda)) d\lambda + D, \quad x(0) = D \quad (49)
$$

Now, we define the primitive function of the variable transport velocity as

$$
\Phi_X(t) = \int_0^t v(X(\lambda)) d\lambda.
$$
 (50)

Since the transport velocity v is assumed to be strictly positive, the function $\Phi_X(t)$ is a monotonically increasing function and defines a bijective mapping between time and space. The subscript $_X$ denotes the state-dependence of the function</sub> $\Phi_X(t)$. By combining (49) and (50), we derive the following relation

$$
x(\tau) = \Phi_X(t_0) - \Phi_X(t_0 + \tau) + D. \tag{51}
$$

We next reduce the PDE-ODE system to a state-dependent delay system (see Fig. 2). We consider the characteristic curves with $x(\tau) = 0$ at time $t = t_0 + \tau$ as illustrated in Fig. 2 and define the time delay $R_X(t) = t - t_0$. According to (51) the state-dependent input delay is implicitly given as

$$
D = \Phi_X(t) - \Phi_X(t - R_X(t)).
$$
\n(52)

Since the function $\Phi_X(t)$ depends on the state X of the plant, the delay $R_X(t)$ is also state-dependent. From (46) we know that the solution of the transport PDE (2) is constant along the characteristic curves. Thus,

$$
u(0,t) = u(D, t - R_X(t)) = U(t - R_X(t)).
$$
 (53)

Consequently, using (52) and (53), the original cascade system (1) – (3) is reduced to a nonlinear system with an implicit statedependent input delay, which is written as

$$
\dot{X}(t) = f(X(t), U(\phi(t)))\tag{54}
$$

$$
\phi(t) = t - R_X(t) \tag{55}
$$

$$
D = \int_{\phi(t)}^{t} v(X(\lambda))d\lambda.
$$
 (56)

We are not aware of a result dealing with the delay compensation of general nonlinear systems (54) with input delay of the

¹The explicit derivation of such solutions is given in detail later on in Section IV and is similar to the procedure employed for the derivation of $(31)–(33)$.

Fig. 2. Equivalence between the PDE/ODE cascade system and the delay system.

form (55), (56). A relevant result can be found in [9]. However, the results in [9] are dealing with linear ODE systems and the delay is defined implicitly through an integral of past input values rather than past state values (as in (56)). In addition the result in [9] does not aim at completely compensating the input delay. A possible next step would be to consider the problem of delay compensation for general nonlinear ODE systems with input-dependent input delay of an integral type as the one considered in [9].

In the following, we design the predictor-feedback control law for the delay system (54)–(56) and present a stability analysis for the closed-loop system in delay system representation.

V. PREDICTOR FEEDBACK CONTROL DESIGN FOR THE EQUIVALENT DELAY SYSTEM

Let us define $\kappa(X)$ to be the nominal stabilizing feedback control law for the delay free plant $X(t) = f(X(t), U(t))$. The predictor feedback control law for system (54) is

$$
U(t) = \kappa(P(t)), \tag{57}
$$

where

$$
P(t) = X(t) + \int_{\phi(t)}^{t} \frac{v(X(\theta))}{v(P(\theta))} f(P(\theta), U(\theta)) d\theta, \quad (58)
$$

with the initial condition

$$
P(\theta) = X(0) + \int_{\phi(0)}^{\theta} \frac{v(X(s))}{v(P(s))} f(P(s), U(s)) ds, \quad (59)
$$

for all $\phi(0) \le \theta \le 0$. The fact that the predictor is given by (58) with the delay being defined by (56) can be seen as follows. Defining the prediction time

$$
\sigma(t) = \phi^{-1}(t) \tag{60}
$$

we derive the following implicit relation with respect to σ

$$
D = \int_{t}^{\sigma(t)} v(X(\lambda))d\lambda.
$$
 (61)

Taking the time derivative of (61), we get

$$
\dot{\sigma}(t)v\left(X(\sigma(t))\right) - v\left(X(t)\right) = 0,\tag{62}
$$

that is,

$$
\dot{\sigma}(t) = \frac{v(X(t))}{v(X(\sigma(t)))}.
$$
\n(63)

Substitution of $t = \sigma(\theta)$, $\theta \in [\phi(t), t]$, in (54) leads to

$$
\dot{X}(\sigma(\theta)) = \dot{\sigma}(\theta) f(X(\sigma(\theta)), U(\theta)).
$$
 (64)

Hence,

$$
\dot{X}(\sigma(\theta)) = \frac{v(X(\theta))}{v(X(\sigma(\theta)))} f(X(\sigma(\theta)), U(\theta)).
$$
 (65)

Integrating (65) over $[\phi(t), t]$ and using definition

$$
P(t) = X(\sigma(t)), \tag{66}
$$

we derive the predictor (58) with initial condition (59).

To implement numerically the predictor feedback control law (57)–(59), one needs to compute at each time step $\phi(t)$ using (56) and employing the history of the state X. An example of computing numerically $\phi(t)$ is presented in the next section. Relevant numerical schemes for computation of a delay defined implicitly via an integral equation of the control input are presented in [9], [38]. Moreover, one then needs to numerically compute the predictor $P(t)$ using (58) employing, in addition, the history of the input U . We emphasize that in the recent papers [39], [40], the implementation issue of predictor feedback is discussed in detail and various numerical schemes are developed for computation of predictor feedback laws.

VI. STABILITY ANALYSIS VIA DELAY SYSTEM REPRESENTATION

Theorem 2: Consider the closed-loop system consisting of the plant (54)–(56) and the control law (57), (58) under Assumptions 1, 2, and 3. For all initial conditions for which U and X are locally Lipschitz on the interval $[\phi(0), 0]$ and which satisfy the compatibility condition $U(0) = \kappa(P(0)),$ there exists a unique solution to the closed-loop system with $X(t) \in C^1[0,\infty)$ and $U(t) \in C^1(0,\infty)$. Moreover, there exists a class $K\mathcal{L}$ function Λ such that the following holds

$$
\Omega(t) \le \Lambda(\Omega(0), t), \quad t \ge 0,\tag{67}
$$

where,

$$
\Omega(t) = \sup_{\phi(t) \le \theta \le t} |X(t)| + \sup_{\phi(t) \le \theta \le t} |U(\theta)|.
$$
 (68)

In order to prove Theorem 2 we state the following lemmas whose proofs are provided in the Appendix (Section B).

Lemma 6: The infinite-dimensional backstepping transformation of the actuator state given by

$$
W(\theta) = U(\theta) - \kappa(P(\theta)), \tag{69}
$$

for all $\phi(t) \leq \theta \leq t$, together with the controller (57), (58) transform system (54)–(56) into the following target system

$$
\dot{X}(t) = f(X(t), \kappa(X(t)) + W(\phi(t)))\tag{70}
$$

$$
W(t) = 0.\t\t(71)
$$

Lemma 7: The inverse of the infinite-dimensional backstepping transormation (69) is defined for all $\phi(t) \leq \theta \leq t$ by

$$
U(\theta) = W(\theta) + \kappa(\Pi(\theta)), \qquad (72)
$$

with

$$
\Pi(\theta) = X(t) + \int_{t-R_X(t)}^{\theta} \left(\frac{v(X(\lambda))}{v(\Pi(\lambda))} \times f(\Pi(\lambda), \kappa(\Pi(\lambda)) + W(\lambda)) \right) d\lambda \tag{73}
$$

In the next lemma we show that the target system (70) – (71) is globally asymptotically stable constructing a Lyapunov functional. Note that the presented proof argument is different from the one used in the proof of Lemma 3.

Lemma 8: There exists a class KL function β such that the following holds

$$
\Xi(t) \leq \beta \left(\Xi(0), t \right), \quad t \geq 0 \tag{74}
$$

$$
\Xi(t) = \sup_{\phi(t) \le \theta \le t} |X(\theta)| + \sup_{\phi(t) \le \theta \le t} |W(\theta)|. \quad (75)
$$

Lemma 9: There exists a class K_{∞} function ρ such that the following holds for all $\phi(t) \leq \theta \leq t$

$$
|P(\theta)| \le \rho \left(|X(t)| + \sup_{t - R_X(t) \le s \le t} |U(s)| \right). \tag{76}
$$

Lemma 10: There exists a class K function ψ such that the following holds

$$
|\Pi(\theta)| \le \psi\left(|X(t)| + \sup_{t - R_X(t) \le s \le t} |W(s)|\right),\tag{77}
$$

for all $t - R_X(t) \leq \theta \leq t$.

Lemma 11: There exist class K_{∞} functions ρ_1 and μ_4 such that the following hold

$$
\Omega(t) \leq \mu_4(\Xi(t)), \tag{78}
$$

$$
\Xi(t) \leq \rho_1(\Omega(t)), \tag{79}
$$

where Ω and Ξ are defined in (67) and (75), respectively. Proof of Theorem 2: Combining (78), (79) with (74), we deduce that inequality (67) is satisfied with

$$
\Lambda(s) = \mu_4^{-1}(\beta(\rho_1(s)), t). \tag{80}
$$

We prove next, existence and uniqueness of solutions. We consider the system (X, ϕ) defined as

$$
\dot{X}(t) = f\left(X(t), U(\phi(t))\right),\tag{81}
$$

$$
\dot{\phi}(t) = \frac{v(X(t))}{v(X(\phi(t)))},\tag{82}
$$

where the initial condition $\phi(0)$ satisfies the following relation

$$
D = \int_{\phi(0)}^{0} v(X(\lambda))d\lambda.
$$
 (83)

For all $0 \le t < \sigma(0)$, it holds that $\phi(0) \le \phi(t) < 0$, and thus, since the initial conditions $X(s)$ and $U(s)$, $\phi(0) \leq s < 0$, are Lipschitz the right-hand side of the (X, ϕ) system (81),

(82) is Lipschitz with respect to (X, ϕ) . Thus, existence and uniqueness of $(X(t), \phi(t)) \in C^1[0, \sigma(0))$ follows.

Then, for $t > \sigma(0)$, from the target system $X =$ $f(X, \kappa(X))$ and the continuous differentiability of f and κ we get existence and uniqueness of $X(t) \in C^1(\sigma(0), \infty)$. With the compatibility condition we get that X is differentiable also at $\sigma(0)$, and thus, $X(t) \in C^1[0,\infty)$.

Differentiating (73) with respect to t we have

$$
\dot{\Pi}(t) = \frac{v(X(t))}{v(\Pi(t))} f(\Pi(t)), \kappa(\Pi(t))), \quad \text{for all } t \ge 0. \tag{84}
$$

Introducing the change of variables $\tau = \Phi_X(t)$ we rewrite system (84) as

$$
\dot{\overline{\Pi}}(\tau) = \frac{1}{v(\overline{\Pi}(\tau))} f(\overline{\Pi}(\tau)), \kappa(\overline{\Pi}(\tau))) , \text{ for all } \tau \ge 0, (85)
$$

where $\Pi(\tau) = \Pi(\Phi_X^{-1}(\tau))$. Since κ , v and f are continuously differentiable, it follows that there exists a unique solution $\Pi(\tau) \in C^1[0,\infty)$. Thus, $\Pi(\Phi_X(t))$ is continuously differentiable with respect to t for all $\Phi_X(t) \ge 0$, i.e., $t \ge \Phi_X^{-1}(0) =$ 0, since $X(t) \in C^1[0,\infty)$ and $\dot{\Phi}_X(t) = v(X(t))$. Hence, since $\Pi(t) = \overline{\Pi}(\Phi_X(t))$ we deduce that $\Pi(t) \in C^1[0, \infty)$, and thus, we get that $U(t) \in C^1(0, \infty)$, which concludes the proof.

VII. APPLICATION TO METAL ROLLING PROCESSES

The metal rolling process is a common industrial process where, in essence, a deformation of a workpiece takes place between two rolls with parallel axes revolving in opposite directions as shown in Fig. 3 [41]. In industry, the initial breakdown of ingots is generally performed using hot rolling while the cold rolling is crucial for the production of sheet or strip with good surface finishes and increased mechanical strength. However, in practice often undesired self-excited vibrations occur, which are known as chatter [32] and are closely related to the machine tool vibrations in metal cutting [2]. In general, the reason for chatter vibrations are the interaction between the structural dynamics of the mill stand and the rolling process, where for unstable situations energy from the machine drives is captured by the process and transformed into vibration energy of the structure. In these systems, time delays occur due to the material transport between two passes or between two stands of the mill [32], [42]. These delays are state-dependent due to their dependency on the statedependent velocity of the metal strip [33], [43], but these are often approximated by constant delays [44]. There are several strategies to control the strip thickness in metal rolling [30], [31], [41], [45], but the effect of state-dependent delays on the dynamics of metal rolling is only rarely studied in the literature [34]. In this section, the compensation of the statedependent delay in metal rolling via the predictor feedback control design from Section V is illustrated. In an industrial application of cold rolling the control task is very complex including, for example, the control of interstand tension and interstand strip thickness between multiple mill stands as well as eccentricity control of the rolls. In the present contribution, we consider only strip thickness control at a single mill stand to focus on the compensation of the state-dependent delays, which are generic for these type of processes.

Fig. 3. Metal rolling schematic.

A. Modeling of metal rolling.

The physical layout of the mill stand is illustrated in Fig. 3. It is closely related to the rolling model from [30], [31], [41]. The bottom roll is assumed to be rigid, whereas the position of the upper roll is adjustable. The flexible roll with lumped mass m_2 is connected via a spring with stiffness k to a roll gap adjusting mechanism with lumped mass m_1 . Both ends of the spring are movable and the equation of motion can be given by

$$
m_1 \ddot{y}(t) + d(\dot{y}(t) - \dot{h}_o(t)) + k(y(t) - h_o(t)) = F_c
$$

\n
$$
m_2 \ddot{h}_o(t) + d(\dot{h}_o(t) - \dot{y}(t)) + k(h_o(t) - y(t)) = F_r,
$$
 (86)

where $y(t)$ and $h_o(t)$ specify the positions of the upper and the lower end of the spring, respectively. In particular, $h_o(t)$ is equivalent to the roll gap and the upper position $y(t)$ is defined in such a way that it is equivalent to the roll gap if the spring is not compressed. In contrast to [30], [31], [41], we do not neglect the inertial force of the roll $(m_2 > 0)$ and we consider a damping term with damping coefficient d . We assume that damping is proportional to the derivative of the relative displacement of the spring. The variables $F_c(t)$ and $F_r(t)$ denote the control and the process forces that act on the upper and the lower end of the spring, respectively. The process force F_r in metal rolling depends in a nonlinear way on the difference between the input thickness h_i and the output thickness $h_o(t)$ of the metal

$$
F_r = F(h_o(t)) = k_f \sqrt{h_i - h_o(t)},
$$
 (87)

where the input thickness h_i is assumed to be constant and k_f specifies the force coefficient. Details on the derivation of the force law and the determination of the force coefficient k_f in metal rolling can be found in [32], [42], [45], [46].

A feedback controller is used to keep the output thickness $h_o(t)$ at a desired reference value h_r by controlling the force F_c on the upper end of the spring. A PD controller is considered for the stabilization of the output thickness. In particular, the nominal controller is given by

$$
F_c(t) = U(t) = K_p(h_r - h_o(t)) - K_d \dot{h}_o(t) - F_0, \quad (88)
$$

where K_p and K_d are the gains for the proportional and the derivative terms, respectively. The constant part $F_0 =$ $k_f\sqrt{h_i-h_r}$ is necessary to provide the constant rolling force for keeping the output thickness at the desired reference value h_r . In practice, the measurement point for the output strip thickness is located a constant distance D away from the rolling mill. In an industrial mill stand, realistic values for D range from 1 m to 2 m, which implies that the delay cannot be neglected and significant delay variations are possible for lower speeds [44]. Hence, we assume that only a delayed version $U(\phi(t))$ of the feedback control input (88) can affect the plant. The delayed time $\phi(t)$ is given by (56), where $v(X(t))$ specifies the velocity of the metal strip over the constant distance D [33], [34], [43]. Due to mass conservation the velocity $v(X(t))$ can be specified by [32], [43], [45]

$$
v(h_o(t)) = \frac{h_i v_i}{h_o(t)},
$$
\n(89)

where the input velocity v_i of the metal is constant and where it is assumed that the width of the strip does not change during the process [43]. Thus, a state-dependent delay $R_X(t)$ appears [33], [34], [43]. We only consider the case $h_o > 0$ because (89) is not adequate to model a collapse with $h_o = 0$.

We now introduce the state variables of the system as follows

$$
X_1(t) = h_0(t), X_2(t) = \dot{h}_0(t), X_3(t) = y(t), X_4(t) = \dot{y}(t).
$$
\n(90)

The rolling example (86) with the force (87) and the statedependent transport velocity (89) can be written as a system of delay differential equations (DDEs) with state-dependent delay, in the form (54) – (56) , as

$$
\dot{X}_1(t) = X_2(t), \n\dot{X}_2(t) = \frac{k_f}{m_2} \sqrt{h_i - X_1(t)} + \frac{d}{m_2} (X_4(t) - X_2(t)) \n+ \frac{k}{m_2} (X_3(t) - X_1(t)), \n\dot{X}_3(t) = X_4(t), \n\dot{X}_4(t) = \frac{d}{m_1} (X_2(t) - X_4(t)) + \frac{k}{m_1} (X_1(t) - X_3(t)) \n+ \frac{1}{m_1} U(\phi(t)), \nD = \int_{\phi(t)}^t \frac{h_i v_i}{X_1(\theta)} d\theta,
$$
\n(91)

where we have dropped all trivial time dependencies t . Under the proposed control law (88) and realistic parameter values (namely, $h_i - h_r > 0$) the closed-loop system (91) has one equilibrium $X^* = (h_r, 0, y^*, 0)$, where $U = -F_0$ and

$$
y^* = h_r - \frac{k_f}{k} \sqrt{h_i - h_r}.\tag{92}
$$

The objective is to stabilize the equilibrium X^* .

B. Delay-free closed-loop system

The predictor feedback control compensates the statedependent delay $R_X(t) = t - \phi(t)$. Thus, ideally, the performance of the closed-loop system with delay under the predictor feedback control law would be equivalent to the performance of the closed-loop system without delay, and under the nominal delay-free feedback law, after a finite transient period (i.e., after the control signal reaches the plant). We briefly discuss the stability of the linearized delay-free closed-loop system. The characteristic equation of system (91) (linearized around the equilibrium X^*) without delay under the nominal control law (88) is given by

$$
m_1 m_2 s^4 + d(m_1 + m_2) s^3
$$

+ $(k_r m_1 + k m_1 + k m_2 + dK_d) s^2$
+ $(K_p d + K_d k + k_r d) s + k(K_p + k_r) = 0$, (93)

where $k_r = k_f/(2\sqrt{h_i - h_r})$ is the stiffness of the rolling process at the equilibrium. For the open-loop system, i.e., $K_p = 0$ and $K_d = 0$, it can be derived from the Routh-Hurwitz criterion that the equilibrium is always stable in the case of a physically meaningful choice of the parameters (all parameter values larger than zero and $h_i > h_r$). However, numerical simulations have shown that the open-loop system is only weakly stable, which means that potential transient oscillations decay very slowly. The maximum real part of the characteristic roots is calculated numerically from (93) for the plant parameter values from Table I and varying control parameters K_p and K_d . The result is presented in the contour plot in Fig. 4. In particular, for the open-loop system the real part of the dominant characteristic root is given by $-0.0035s^{-1}$, which means that a controller should be applied to suppress undesired long-lasting transient oscillations. The choice $K_p = 10^6 Nm^{-1}$, $K_d = 6500 Nsm^{-1}$ (labeled by 'x' in Fig. 4) leads to good nominal transient performance in the sense that the real part of the characteristic root is given by $-22.33s^{-1}$.

Fig. 4. Performance of the nominal control law for the system without delay

C. Simulation results for system with delay

Simulations of the rolling process were performed by integrating the equations of motion (91) with the MATLAB solver *ddesd* for DDEs with state-dependent delay. The MATLAB solver requires an explicit expression for the delayed time

TABLE I PHYSICAL DEFINITION OF THE PARAMETERS

Symbol and value	Units (S.I)	Definition
$m_1 = 50$	kg	Mass of adjusting mechanism
$m_2 = 100$	kq	Mass of flexible roll
$d = 3000$	N sm ^{-1}	Damping coefficient
$k = 10 \times 10^6$	Nm^{-1}	Stiffness
$K_F = 50000$	$N.m^{-0.5}$	Force constant
$h_i = 0.005$	m	Input thickness
$h_r = 0.003$	m	Desired output thickness
$v_i=5$	$m.s^{-1}$	Input velocity
$D = 0.1$	m	Distance between
		rolls and sensor
$K_p = 1 \times 10^6$	Nm^{-1}	Proportional gain
		of PD-Controller
$K_d = 6500$	N sm ^{-1}	Derivative gain
		of PD-Controller

 $\phi(t)$, which can be obtained by numerical integration of the time derivative of (56)

$$
\dot{\phi}(t) = \frac{v(X(t))}{v(X(\phi(t)))},\tag{94}
$$

with initial condition $\phi(0)$ obtained by numerically integrating (56) in the interval of the initial function. The predictor state $P(t)$ is obtained by a numerical integration of (58). We have used constant upper position $y(\theta) = h_i$ and constant output thickness $h_o(\theta) = h_i$ with $\phi(0) \le \theta \le 0$ as initial conditions, which means that for $t < 0$ the rolling force and the control force are zero. At $t = 0$ the first input, which is given by the constant initial condition $U(\theta) = -F_0$, $\phi(0) \le \theta \le 0$, arrives at the plant and the deformation of material starts. The initial condition of the predictor is obtained by numerical integration of (59).

Three different cases were studied. On the one hand, the uncompensated PD controller (88) with the nominal feedback law $\kappa(X(t))$ from (88) and the open-loop control law were employed. On the other hand, the predictor feedback law (57) for the nominal feedback law (88) was employed. The simulation reveals the necessity to compensate the delay in order to avoid collapse phenomena as it is shown in Fig. 5 and Fig. 6. More precisely, the uncompensated control action leads to a negative thickness, which is not admissible physically for the metal rolling dynamics. The simulation results also exhibit the limitation of the open-loop control with $F_c = -F_0$, which is not able to drive the system to the reference thickness value h_r fast enough as illustrated in Fig. 5 and Fig. 6. In addition, we have employed the nominal PD controller (88) in system (91) without delay ($D = 0$) to verify the equivalence between the response of the closed-loop system with delay $(D > 0)$ under the predictor feedback control law and the response of the delay-free system with the nominal control law $D = 0$. Fig. 7 shows that, in fact, practically no deviations occur between the response of the nominal controller of the delayfree system and the response of the predictor feedback control in the delayed system. Note that for the delay-free system we have used $U(t) = -F_0$ for the time interval $0 \le \theta \le \sigma(0)$ similar to the initial condition $U(t)$, $\phi(0) \leq t \leq 0$, for the input of the system with delay.

Fig. 5. Delay compensation: Upper position and implicit state-dependent delay evolution in time.

Fig. 6. Delay compensation: Strip thickness and input evolution in time.

Fig. 7. Delay compensation: Delay-free and compensated plants evolution in time .

VIII. CONCLUSIONS

In this paper, we present the predictor feedback control design for transport PDE/nonlinear ODE cascades in which the transport coefficient depends on the ODE state. The proof of stability of the closed-loop system is established by using a backstepping transformation which maps the original system into a suitable target system whose stability is proven using a Lyapunov-like argument. The equivalence between the stability of the target and the original systems is stated using the invertibility of the backstepping transformation. An alternative representation of the coupled PDE-ODE system with a nonlinear system with state-dependent input delay is presented. The equivalent predictor-feedback control design for the delay system is introduced and an alternative proof of global asymptotic stability of the closed-loop system is provided constructing a Lyapunov functional. Consistent simulation results are provided applying the proposed algorithm to a model of a metal rolling processes in which the control of the output thickness is a critical issue.

REFERENCES

- [1] M. Diagne and M. Krstic, "State-dependent input delay-compensated bang-bang control: Application to 3d printing based on screw-extruder, in *American Control Conference (ACC), Chicago, Illinois*, July 2015, pp. 5653–5658.
- [2] A. Otto and G. Radons, "Application of spindle speed variation for chatter suppression in turning," *CIRP J. Manuf. Sci. Technol.*, vol. 6, no. 2, pp. 102–109, 2013.
- [3] D. Bresch-Pietri and K. Coulon, "Prediction-based control of moisture in a convective flow," in *Control Conference (ECC), 2015 European*. IEEE, 2015, pp. 43–48.
- [4] H. L. Smith, "Reduction of structured population models to thresholdtype delay equations and functional differential equations: a case study," *Math. Bio.*, vol. 113, no. 1, pp. 1–23, 1993.
- [5] E. Detwiler *et al.*, "Exhaust oxygen sensor dynamic study," *Sensors and Actuators B: Chemical*, vol. 120, no. 1, pp. 200–206, 2006.
- [6] L. Guzzella and C. Onder, *Introduction to modeling and control of internal combustion engine systems*. Springer Science & amp; Business Media, 2009.
- [7] M. Jankovic and S. Magner, "Disturbance attenuation in time-delay systems—a case study on engine air-fuel ratio control," in *American Control Conference (ACC), 2011*. IEEE, 2011, pp. 3326–3331.
- [8] N. E. Kahveci and M. J. Jankovic, "Adaptive controller with delay compensation for air-fuel ratio regulation in si engines," in *American Control Conference (ACC), 2010*, 2010, pp. 2236–2241.
- [9] D. Bresch-Pietri, J. Chauvin, and N. Petit, "Prediction-based stabilization of linear systems subject to input-dependent input delay of integraltype," *IEEE Transactions on Automatic Control*, vol. 59, no. 9, pp. 2385– 2399, 2014.
- [10] J.-P. Richard, "Time-delay systems: an overview of some recent advances and open problems," *automatica*, vol. 39, no. 10, pp. 1667–1694, 2003.
- [11] M. Chebre, Y. Creff, and N. Petit, "Feedback control and optimization for the production of commercial fuels by blending," *Journal of Process Control*, vol. 20, no. 4, pp. 441–451, 2010.
- [12] X. Cai and M. Krstic, "Nonlinear control under wave actuator dynamics with time-and state-dependent moving boundary," *International Journal of Robust and Nonlinear Control*, vol. 25, no. 2, pp. 222–251, 2015.
- [13] -, "Nonlinear stabilization through wave pde dynamics with a moving uncontrolled boundary," *Automatica*, vol. 68, pp. 27–38, 2016.
- [14] M. Krstic, "Compensating a string pde in the actuation or sensing path of an unstable ode," *Automatic Control, IEEE Transactions on*, vol. 54, no. 6, pp. 1362–1368, 2009.
- [15] N. Bekiaris-Liberis and M. Krstic, "Compensation of wave actuator dynamics for nonlinear systems," *Automatic Control, IEEE Transactions on*, vol. 59, no. 6, pp. 1555–1570, 2014.
- [16] A. Otto and G. Radons, "Transformations from variable delays to constant delays with applications in engineering and biology," in *Advances in Delays and Dynamics*, T. Insperger, G. Orosz, and T. Ersal, Eds. Springer, accepted.
- [17] F. Zhang and M. Yeddanapudi, "Modeling and simulation of timevarying delays," in *Proc. of TMS/DEVS*. San Diego, CA, USA: SCS, 2012, pp. 34:1–34:8.
- [18] K. Zenger and A. Niemi, "Modelling and control of a class of timevarying continuous flow processes," *J Proc. Control*, vol. 19, no. 9, pp. 1511 – 1518, 2009.
- [19] J. Bélair, M. Mackey, and J. Mahaffy, "Age-structured and two-delay models for erythropoiesis," *Math. Biosci.*, vol. 128, no. 1–2, pp. 317 – 346, 1995.
- [20] Z. Artstein, "Linear systems with delayed controls: a reduction," *Automatic Control, IEEE Transactions on*, vol. 27, no. 4, pp. 869–879, 1982.
- [21] M. Krstic, "Lyapunov tools for predictor feedbacks for delay systems: Inverse optimality and robustness to delay mismatch," *Automatica*, vol. 44, no. 11, pp. 2930–2935, 2008.
- [22] ——, "Input delay compensation for forward complete and strictfeedforward nonlinear systems," *Automatic Control, IEEE Transactions on*, vol. 55, no. 2, pp. 287–303, 2010.
- [23] ——, "Lyapunov stability of linear predictor feedback for time-varying input delay," *Automatic Control, IEEE Transactions on*, vol. 55, no. 2, pp. 554–559, 2010.
- [24] N. Bekiaris-Liberis and M. Krstic, "Compensation of time-varying input and state delays for nonlinear systems," *Journal of Dynamic Systems, Measurement, and Control*, vol. 134, no. 1, p. 011009, 2012.
- [25] ——, "Compensation of state-dependent input delay for nonlinear systems," *IEEE Transactions on Automatic Control*, vol. 58, no. 2, pp. 275–289, 2013.
- [26] ——, "Robustness of nonlinear predictor feedback laws to time- and state-dependent delay perturbations," *Automatica*, vol. 49, no. 4, pp. 1576–1590, 2013.
- [27] D. Bresch-Pietri and N. Petit, "Robust compensation of a chattering time-varying input delay," in *Decision and Control (CDC), 2014 IEEE 53rd Annual Conference on*. IEEE, 2014, pp. 457–462.
- [28] F. Mazenc and M. Malisoff, "Reduction model approach for systems with a time-varying delay," in *54th IEEE Conference on Decision and Control*, 2015.
- [29] N. Bekiaris-Liberis and M. Krstic, "Nonlinear control under delays that depend on delayed states," *European Journal of Control*, vol. 19, no. 5, pp. 389–398, 2013.
- [30] S. Foda and P. Agathoklis, "Control of the metal rolling process: a multidimensional system approach," in *American Control Conference, Pittsburgh, PA,*. IEEE, 1989, pp. 2405–2410.
- [31] -, "Control of the metal rolling process: a multidimensional system approach," *Journal of the Franklin Institute*, vol. 329, no. 2, pp. 317 – 332, 1992.
- [32] I. Yun, W. Wilson, and K. Ehmann, "Review of chatter studies in cold rolling," *International Journal of Machine Tools and Manufacture*, vol. 38, no. 12, pp. 1499 – 1530, 1998.
- [33] G. Pin, V. Francesconi, F. Cuzzola, and T. Parisini, "Adaptive task-space metal strip-flatness control in cold multi-roll mill stands," *Journal of Process Control*, vol. 23, no. 2, pp. 108 – 119, 2013.
- [34] Q. Hu, "A model of cold metal rolling processes with state-dependent delay," *SIAM Journal on Applied Mathematics*, vol. 76, no. 3, pp. 1076– 1100, 2016.
- [35] H. Khalil, *Nonlinear systems*. Prentice hall, 2002, vol. 3.
- [36] M. Krstic, "Input delay compensation for forward complete and strictfeedforward nonlinear systems," *IEEE Transactions on Automatic Control*, vol. 55, no. 2, pp. 287–303, 2010.
- [37] E. Sontag, "On characterizations of the input-to-state stability property," *Systems & Control Letters*, vol. 24, no. 5, pp. 351–359, 1995.
- [38] D. Bresch-Pietri, T. Leroy, J. Chauvin, and N. Petit, "Practical delay modeling of externally recirculated burned gas fraction for spark-ignited engines," in *Delay Systems*, ser. Advances in Delays and Dynamics. Springer International Publishing, 2014, vol. 1, pp. 359–372.
- [39] I. Karafyllis and M. Krstic, "Numerical schemes for nonlinear predictor feedback," *Mathematics of Control, Signals, and Systems*, vol. 26, no. 4, pp. 519–546, 2014.
- [40] I. Karafyllis, "Stabilization by means of approximate predictors for systems with delayed input," *SIAM Journal on Control and Optimization*, vol. 49, no. 3, pp. 1100–1123, 2011.
- [41] E. Rogers, K. Galkowski, and D. Owens, *Control Systems Theory and Applications for Linear Repetitive Processes*, ser. Lecture Notes in Control and Information Sciences. Springer Berlin Heidelberg, 2009.
- [42] W. Roberts, *Cold Rolling of Steel*, ser. Manufacturing Engineering and Materials Processing. Taylor & Francis, 1978.
- [43] R. Johnson, "Functional equations, approximations, and dynamic response of systems with variable time delay," *IEEE Transactions on Automatic Control*, vol. 17, no. 3, pp. 398–401, 1972.
- [44] J. Pittner and M. A. Simaan, "Control of a continuous tandem cold metal rolling process," *Control Engineering Practice*, vol. 16, no. 11, pp. 1379–1390, 2008.
- [45] D. Sbarbaro-Hofer, D. Neumerkel, and K. Hunt, "Neural control of a steel rolling mill," *IEEE Control Systems*, vol. 13, no. 3, pp. 69–75, 1993.
- [46] D. R. Bland and H. Ford, "The calculation of roll force and torque in cold strip rolling with tensions," *Proceedings of the Institution of Mechanical Engineers*, vol. 159, no. 1, pp. 144–163, 1948.
- [47] L. Praly and Y. Wang, "Stabilization in spite of matched unmodeled dynamics and an equivalent definition of input-to-state stability," *Mathematics of Control, Signals and Systems*, vol. 9, no. 1, pp. 1–33, 1996.

APPENDIX A

PDE REPRESENTATION LEMMAS' PROOFS

A. Proof of Lemma 1

The proof of Lemma 1 is established in the following steps:

1) Differentiating (9) with respect to t , the following relation is deduced

$$
\partial_t p(x,t) = -\int_0^x \frac{1}{v(p(y,t))}
$$

\n
$$
\times \frac{\nabla v(p(y,t))}{v(p(y,t))} [f(p(y,t), u(y,t)) \partial_t p(y,t)]
$$

\n
$$
- \partial_p f(p(y,t), u(y,t)) \partial_t p(y,t)] dy
$$

\n
$$
+ \int_0^x \frac{1}{v(p(y,t))}
$$

\n
$$
\times \partial_u f(p(y,t), u(y,t)) \partial_t u(y,t) dy
$$

\n
$$
+ f(p(0,t), u(0,t)). \qquad (95)
$$

Next, differentiating (9) with respect to x we arrive at

$$
v(X(t))\partial_x p(x,t) = -\int_0^x \left(v(X(t)) \frac{\nabla v(p(y,t))}{v^2(p(y,t))} \times f(p(y,t), u(y,t)) \partial_y p(y,t) \right) dy
$$

$$
+ \int_0^x \frac{v(X(t))}{v(p(y,t))}
$$

$$
\times \partial_p f(p(y,t), u(y,t)) \partial_y p(y,t) dy
$$

$$
+ \int_0^x \frac{v(X(t))}{v(p(y,t))}
$$

$$
\times \partial_u f(p(y,t), u(y,t)) \partial_y u(y,t) dy
$$

$$
+ \frac{v(X(t))}{v(p(0,t))} f(p(0,t), u(0,t)).
$$
(96)

Combining (95) and (96), the following equality holds

$$
\partial_t p(x,t) - v(X(t))\partial_x p(x,t) = -\int_0^x \frac{1}{v(p(y,t))}
$$

\n
$$
\times \left[f(p(y,t), u(y,t)) \frac{\nabla v(p(y,t))}{v(p(y,t))} \right]
$$

\n
$$
\times \left(\partial_t p(y,t) - v(X(t)) \partial_y p(y,t) \right) dy
$$

\n
$$
+ \int_0^x \frac{1}{v(p(y,t))} \partial_p f(p(y,t), u(y,t))
$$

\n
$$
\times \left(\partial_t p(y,t) - v(X(t)) \partial_y p(y,t) \right) dy.
$$
 (97)

Now, we define the function $G(x, t) = \partial_t p(x, t)$ – $v(X(t))\partial_x p(x,t)$, which satisfies

$$
\frac{dG(x,t)}{dx} = -\frac{1}{v(p(x,t))}
$$
\n
$$
\times \left[f(p(x,t), u(x,t)) \frac{\nabla v(p(x,t))}{v(p(x,t))} - \partial_p f(p(x,t), u(x,t)) \right] G(x,t) \tag{98}
$$
\n
$$
G(0,t) = 0. \tag{99}
$$

Hence, $G(x, t) = 0$ for all $x \in [0, D]$, which implies that

$$
\partial_t p(x,t) - v(X(t))\partial_x p(x,t) = 0. \quad (100)
$$

2) Taking the time and the spatial derivative of the backstepping transformation (11), we get

$$
\partial_t w(x,t) = \partial_t u(x,t) - \partial_p \kappa \left(p(x,t) \right) \partial_t p(x,t), \tag{101}
$$

and,

$$
\partial_x w(x,t) = \partial_x u(x,t) - \partial_p \kappa (p(x,t)) \partial_x p(x,t),
$$
 (102)

respectively, which leads to

$$
\partial_t w(x,t) - v(X(t))\partial_x w(x,t) = -\partial_p \kappa (p(x,t))
$$

$$
\times \left[\partial_t p(x,t) - v(X(t))\partial_x p(x,t)\right]
$$

$$
+\partial_t u(x,t) - v(X(t))\partial_x u(x,t).
$$
(103)

Using (2) and (100) , we derive (13) from (103) . The ODE dynamics (12) and the boundary condition (14) are obtained by direct verification from (11) for $x = 0$ and (8), respectively.

B. Proof of Lemma 2

The inverse transformation (15) maps $w \mapsto u$ and is associated to the target system predictor, namely, (16) whereas the direct transformation (11), which maps $u \mapsto w$, is associated to the plant predictor, namely, (9). Thus, even if the two predictor representations are driven by different input signals, it holds that

$$
p(x,t) = \pi(x,t), \quad \forall x \in [0, D].
$$
 (104)

C. Proof of Lemma 3

Consider the following family of parameterized Lyapunov functions candidates for the target system's transport PDE (14)

$$
L_{c,n}(t) = \int_0^D e^{2ncx} w^{2n}(x, t) dx,
$$
 (105)

for any $c > 0$ and positive integer n. The time derivative of $L_{c,n}(t)$ along (13) and (14) is written as

$$
\dot{L}_{c,n}(t) = \int_0^D e^{2ncx} \partial_t w(x,t)^{2n} dx,
$$

=2nv (X(t)) $\int_0^D e^{2ncx} w(x,t)^{2n-1} \partial_x w(x,t) dx$

$$
= -v(X(t)) \left[w(0,t)^{2n} + 2nc \int_0^D e^{2ncx} w(x,t)^{2n} dx \right]
$$
\n(106)

From Assumption 1 it holds that $v(X(t)) \geq v_{\star}$, for all $X \in \mathbb{R}$, and thus, we get from (105), (106) that

$$
\dot{L}_{c,n}(t) \le -2ncv_{\star}L_{c,n}(t). \tag{107}
$$

Moreover, from (105) it follows that

$$
\int_0^D |w(z,t)|^{2n} dz \le L_{c,n}(t) \le e^{2ncD} \int_0^D |w(z,t)|^{2n} dz,
$$
\n(108)

for all $t \geq 0$, $c > 0$, and $n \in \mathbb{N}_+$. Integrating (107) and using (108) we get

$$
\int_0^D |w(z,t)|^{2n} dz \le e^{-2ncv_*(t-s)} e^{2ncD} \int_0^D |w(z,s)|^{2n} dz,
$$
\n(109)

for all $t \geq 0$, $s \geq 0$. From (109) we get

$$
\left(\int_0^D |w(z,t)|^{2n} dz\right)^{\frac{1}{2n}} \leq e^{-cv_*(t-s)} e^{cD} \times \left(\int_0^D |w(z,s)|^{2n} dz\right)^{\frac{1}{2n}}.
$$
\n(110)

Taking the limit as $n \to \infty$ and using the fact that

$$
\lim_{n \to \infty} \left(\int_0^D |w(z, t)|^{2n} dz \right)^{\frac{1}{2n}} = \sup_{x \in [0, D]} |w(x, t)| \equiv ||w(t)||_{\infty}
$$
\n(111)

from (110) the following holds

$$
\sup_{x \in [0,D]} |w(x,t)| \le e^{-cv_*(t-s)} e^{cD} \left(\sup_{x \in [0,D]} |w(x,s)| \right),\tag{112}
$$

for all $t \geq s \geq 0$. Based on Assumption 3, there exist some $\bar{\nu} \in \mathcal{KL}$ and $\bar{\alpha} \in \mathcal{K}_{\infty}$ such that the solutions of (12) satisfy

$$
|X(t)| \leq \bar{\nu}\big(|X(s)|, t-s\big) + \bar{\alpha}\left(\sup_{\tau \in [s,t]} |w(0,\tau)|\right), \quad (113)
$$

for all $t \ge s \ge 0$. We perform the change of variables $s = \frac{t}{2}$ and rewrite (113) as

$$
|X(t)| \leq \bar{\nu}\bigg(\left|X\left(\frac{t}{2}\right)\right|, \frac{t}{2}\bigg) + \bar{\alpha}\left(\sup_{\tau \in \left[\frac{t}{2}, t\right]} |w(0, \tau)|\right). \tag{114}
$$

The estimate of $\left| X \left(\frac{t}{2} \right) \right|$ follows by setting $s = 0$ and substituting t by $\frac{t}{2}$ into (113). Hence, the following holds

$$
\left| X\left(\frac{t}{2}\right) \right| \leq \bar{\nu} \left(|X(0)|, \frac{t}{2} \right) + \bar{\alpha} \left(\sup_{\tau \in [0, \frac{t}{2}]} |w(0, \tau)| \right). \tag{115}
$$

 dx . From (112), we derive the estimates

$$
\sup_{\tau \in [0, \frac{t}{2}]} \|w(\tau)\|_{\infty} \le e^{cD} \sup_{x \in [0, D]} |w_0(x)|,
$$
\n(116)

$$
\sup_{\tau \in \left[\frac{t}{2}, t\right]} \|w(\tau)\|_{\infty} \le e^{-\frac{cv_{\star}}{2}t} e^{cD} \sup_{x \in [0, D]} |w_0(x)|. \tag{117}
$$

Substituting (115) through (117) into (114) and using the fact that

$$
|w(0,\tau)| \le \sup_{x \in [0,D]} |w(x,\tau)| \tag{118}
$$

leads to (17) with

$$
\nu(r,s) = \bar{\nu} \left(\bar{\nu} \left(r, \frac{s}{2} \right) + \bar{\alpha} \left(r e^{cD} \right), \frac{s}{2} \right) + \bar{\alpha} \left(e^{-\frac{cv_{*}}{2} s} r e^{cD} \right) + e^{-cv_{*} s} r e^{cD}.
$$
 (119)

D. Proof of Lemma 4

Taking the derivative of (9) with respect to x, we get

$$
\partial_x p(x,t) = \frac{1}{v(p(x,t))} f(p(x,t), u(x,t)) \quad (120)
$$

with the boundary condition

$$
p(0,t) = X(t). \t(121)
$$

Now, considering that $\frac{1}{v(p(x,t))} > 0$, we get the following relation with the help of (7)

$$
\frac{\partial C(p(x,t))}{\partial p} \frac{1}{v(p(x,t))} f(p(x,t), u(x,t))
$$

\n
$$
\leq \frac{1}{v(p(x,t))} \bigg(C(p(x,t)) + \mu_3(|u(x,t)|) \bigg). \tag{122}
$$

Using (120), we arrive at

$$
\frac{\partial C(p(x,t))}{\partial x}
$$

\n
$$
\leq \frac{1}{v(p(x,t))}C(p(x,t)) + \frac{1}{v(p(x,t))}\mu_3(|u(x,t)|). \quad (123)
$$

With the help of (5), inequality (123) yields

$$
\frac{\partial C(p(x,t))}{\partial x} \le \frac{1}{v_\star} C(p(x,t)) + \frac{1}{v_\star} \mu_3(|u(x,t)|). \tag{124}
$$

By the comparison principle and relation (121), we obtain

$$
C(p(x,t)) \le e^{\frac{x}{v_*}} C(X(t)) + \frac{1}{v_*} \int_0^x e^{\frac{x-y}{v_*}} \mu_3(|u(y,t)|) dy,
$$
\n(125)

which leads to

$$
C(p(x,t)) \le e^{\frac{D}{v_x}} C(X(t)) + \left(e^{\frac{D}{v_x}} - 1\right) \mu_3 \left(\sup_{x \in [0,D]} |u(x,t)|\right).
$$
\n(126)

Using (6) the following inequality holds

$$
|p(x,t)| \leq \mu_1^{-1} \left(e^{\frac{D}{v_*}} \mu_2(|X(t)|) + \left(e^{\frac{D}{v_*}} - 1 \right) \right)
$$

$$
\times \mu_3\left(\sup_{x \in [0,D]} |u(x,t)|\right)\right), \quad \text{for all } x \in [0,D]. \tag{127}
$$

Defining

$$
\bar{\omega}(s) = \mu_1^{-1} \left(e^{\frac{D}{v_*}} \mu_2(s) + \left(e^{\frac{D}{v_*}} - 1 \right) \mu_3(s) \right), \quad (128)
$$

the proof is complete.

E. Proof of Lemma 5

Differentiating (16) with respect to x the following ODE is derived for all $x \in [0, D]$

$$
\partial_x \pi(x,t) = \frac{1}{v(\pi(x,t))} f\bigg(\pi(x,t), \kappa(\pi(x,t)) + w(x,t)\bigg),\tag{129}
$$

$$
\pi(0,t) = X(t).
$$

We introduce next the following change of variables

$$
y(x,t) = t + \int_0^x \frac{dr}{v(\pi(r,t))}, \quad x \in [0, D], \tag{131}
$$

where t acts as a parameter. Since the transport velocity v is assumed to be strictly positive, the function y is monotonically increasing with respect to x , for each t . Thus, it admits an inverse defined for each t as $x = \chi(y, t)$. Next, we rewrite the ODE (129), (130) as

$$
\frac{1}{v(\pi(\chi(y,t),t))} \partial_y \pi(\chi(y,t),t) = \frac{1}{v(\pi(\chi(y,t),t))}
$$

$$
f\left(\pi(\chi(y,t),t), \kappa(\pi(\chi(y,t),t)) + w(\chi(y,t),t)\right),
$$
(132)

$$
\pi(0,t) = X(t),\tag{133}
$$

for all $y \in \left[t, t + \int_0^D \frac{dr}{v(\pi(r,t))}\right]$. Defining the change of variables

$$
\psi(y,t) = \pi\bigg(\chi(y,t),t\bigg),\tag{134}
$$

$$
\omega(y,t) = w\bigg(\chi(y,t),t\bigg), \qquad (135)
$$

we rewrite (129), (130) in the new coordinates as

$$
\partial_y \psi(y, t) = f\bigg(\psi(y, t), \kappa(\psi(y, t)) + \omega(y, t)\bigg), \qquad (136)
$$

$$
\psi(t,t) = X(t). \tag{137}
$$

for all $y \in \left[t, t + \int_0^D \frac{dr}{v(\pi(r,t))} \right]$. Under Assumption 3, from (136) we deduce the existence of a class \mathcal{K}_{∞} function ν_3 and a class K function μ_6 such that

$$
|\psi(y,t)| \leq \nu_3 \left(|X(t)|, \int_0^D \frac{dr}{v(\pi(r,t))} \right)
$$

+ $\mu_6 \left(\sup_{y \in \left[t, t + \int_0^D \frac{dr}{v(\pi(r,t))} \right]} |\omega(y,t)| \right),$
for all $y \in \left[t, t + \int_0^D \frac{dr}{v(\pi(r,t))} \right].$ (138)

Then, with the help of $(131)–(135)$, the following inequality holds

$$
|\pi(x,t)| \leq \nu_3 \left(|X(t)|, \int_0^D \frac{dr}{v(\pi(r,t))} \right)
$$

$$
+ \mu_6 \left(\sup_{x \in [0,D]} |\omega(x,t)| \right), \tag{139}
$$

for all $x \in [0, D]$. Knowing that ν_3 decreases with respect to its second argument, using the fact that $y(D, t) - t =$ $\int_0^D \frac{dr}{v(\pi(r,t))} \geq 0$, the following holds

$$
\sup_{x \in [0,D]} |\pi(x,t)| \leq \nu_3 \bigg(|X(t)|, 0 \bigg) + \mu_6 \bigg(\sup_{x \in [0,D]} |\omega(x,t)| \bigg). \tag{140}
$$

Finally, using the properties of class \mathcal{K}_{∞} and \mathcal{KL} functions, we get the inequality (19).

APPENDIX B

DELAY SYSTEM REPRESENTATION LEMMAS' PROOFS

A. Proof of Lemma 6

The proof of Lemma 6 is based on a direct verification considering that $P(\phi(t)) = X(t)$.

B. Proof of Lemma 7

By direct verification considering that $P(\theta) \equiv \Pi(\theta)$ for all $\phi(t) \leq \theta \leq t.$

C. Proof of Lemma 8

Based on the input-to-state stability of \overline{X} $f(X, \kappa(X) + \omega)$ with respect to ω , namely, Assumption 3, from [47] there exist a smooth function $S(X) : \mathbb{R}^n \to \mathbb{R}_+$ and class \mathcal{K}_{∞} functions $\alpha_1, \alpha_2, \alpha_3$, such that for any $\mu > 0$

$$
\alpha_1(|X|) \le S(X) \le \alpha_2(|X|),
$$
\n
$$
\frac{\partial S(X)}{\partial X} f(X, \kappa(X) + \omega))
$$
\n
$$
\le -\mu S(X) + \alpha_3(|\omega|).
$$
\n(142)

Define next for any
$$
c > 0
$$
 and any positive integer *n* the

$$
\bar{L}_{c,n}(t) = \frac{1}{v_{\star}} \int_{\phi(t)}^{t} e^{2nc(\Phi_X(\theta) + D - \Phi_X(t))} W(\theta)^{2n} d\theta, \quad (143)
$$

where Φ_X is defined in (50).

functional

Taking the derivative of (143) and using (71) we get

$$
\dot{\bar{L}}_{c,n}(t) = -\frac{1}{v_{\star}} \frac{d\phi(t)}{dt} e^{2nc(\Phi_X(\phi(t)) + D - \Phi_X(t))} W(\phi(t))^{2n}
$$

$$
-\frac{2nc}{v_{\star}} \Phi'_X(t) \int_{\phi(t)}^t e^{2nc(\Phi_X(\theta) + D - \Phi_X(t))} W(\theta)^{2n} d\theta.
$$
(144)

From the implicit definition of the delay in (56), we decuce the following equality

$$
\dot{\phi}(t) = 1 - \frac{dR_X(t)}{dt}
$$

$$
=\frac{v(X(t))}{v(X(\phi(t)))},\tag{145}
$$

and thus, from Assumption 1 we get that $\dot{\phi}(t) > 0$, for all $t \geq 0$. Moreover, from (50) we get the following equality

$$
\Phi'_{X}(t) = v\left(X(t)\right). \tag{146}
$$

Therefore, Assumption 1 enables one to state the following inequality

$$
\dot{\bar{L}}_{c,n}(t) \le -2ncv_{\star}\bar{L}_{c,n}(t). \tag{147}
$$

Let us now define for any $c > 0$ the functional

$$
\bar{L}(t) = \frac{1}{v_{\star}} \int_{\phi(t)}^{t} e^{c(\Phi_X(\theta) + D - \Phi_X(t))} \gamma(|W(\theta)|) v(X(\theta)) d\theta,
$$
\n(148)

for any class \mathcal{K}_{∞} function γ . The derivative of \overline{L} with respect to time is written as

$$
\dot{L}(t) = -\frac{1}{v_{\star}} \frac{d\phi(t)}{dt} \times e^{c(\Phi_X(\phi(t))+D-\Phi_X(t))} \gamma (|W(\phi(t)|) v(X(\phi(t))) \n- \frac{c}{v_{\star}} \Phi'_X(\phi(t)) \times \int_{\phi(t)}^t e^{c(\Phi_X(\theta)+D-\Phi_X(t))} \gamma (|W(\theta)|) v(X(\theta)) d\theta,
$$
\n(149)

where we use (71) . Inserting (146) into (149) and using (145) we arrive at

$$
\bar{L}(t) = -\frac{v(X(t))}{v_{\star}} e^{c(\Phi_X(\phi(t)) + D - \Phi_X(t))} \gamma (|W(\phi(t)|)
$$

$$
-\frac{c}{v_{\star}} v(X(t)) \int_{\phi(t)}^t \left\{ e^{c(\Phi_X(\theta) + D - \Phi_X(t))} \right.
$$

$$
\times \gamma (|W(\theta)|) v(X(\theta)) \Big\} d\theta.
$$
(150)

From (5), (55) and (52) we get

$$
\dot{\bar{L}}(t) \le -\gamma \left(|W(\phi(t)|) - cv_{\star}\bar{L}(t). \right) \tag{151}
$$

Moreover, defining the functional

$$
V_1(t) = S(X(t)) + \bar{L}(t),
$$
\n(152)

whose time derivative along (70) is written as

$$
\dot{V}_1(t) = \frac{\partial S(X(t))}{\partial X} f(X(t), \kappa(X(t)) + W(\phi(t))) + \dot{\bar{L}}(t),\tag{153}
$$

and combining (142) with (143), from (151), we obtain the following inequality

$$
\dot{V}_1(t) \le -\mu S(X(t)) - cv_x \bar{L}(t) + \alpha_3(|W(\phi(t))|)
$$

- $\gamma (|W(\phi(t))|).$ (154)

Choosing γ such that $\gamma(s) \geq \alpha_3(s)$, for all $s \geq 0$, we get

$$
\dot{V}_1(t) \le -\lambda V_1(t),\tag{155}
$$

where

$$
\lambda = \min\{\mu, cv_\star\}.\tag{156}
$$

Let us define the Lyapunov function for the target system (70) and (71) as

$$
V_n(t) = V_1(t)^{2n} + \bar{L}_{c,n}(t).
$$
 (157)

Taking the derivative of V_n with the help of (149) and (155) we get

$$
\dot{V}_n(t) \le -2n\lambda V_n(t). \tag{158}
$$

Therefore,

$$
V_n(t)^{\frac{1}{2n}} \le e^{-\lambda t} V_n(0)^{\frac{1}{2n}}.
$$
 (159)

It then follows that

$$
V_1(t) + \bar{L}_{c,n}(t)^{\frac{1}{2n}} \le 2e^{-\lambda t} \left(V_1(0) + \bar{L}_{c,n}(0)^{\frac{1}{2n}} \right).
$$
 (160)

From (143), the following holds

$$
\bar{L}_{c,n}(t)^{\frac{1}{2n}} = \frac{1}{v_{\star}^{\frac{1}{2n}}} \left(\int_{\phi(t)}^{t} e^{2nc(\Phi_X(\theta) + D - \Phi_X(t))} W(\theta)^{2n} d\theta \right)^{\frac{1}{2n}}.
$$
\n(161)

Thus, taking the limit as $n \to \infty$ of (161) and using the fact that

$$
\lim_{n \to \infty} \bar{L}_{c,n}(t)^{\frac{1}{2n}} = \sup_{\phi(t) \le \theta \le t} \left| e^{c(\Phi_X(\theta) + D - \Phi_X(t))} W(\theta) \right|
$$

$$
\equiv \|W(t)\|_{c,\infty} \tag{162}
$$

we conclude that the following holds

$$
V_1(t) + ||W(t)||_{c,\infty} \le 2e^{-\lambda t} \bigg(V_1(0) + ||W(0)||_{c,\infty} \bigg). \tag{163}
$$

From Asumption 1 and (148) it follows that

$$
\bar{L}(t) \le \frac{1}{v_{\star}} \sup_{\phi(t) \le \theta \le t} \left| e^{c(\Phi_X(\theta) + D - \Phi_X(t))} \gamma(|W(\theta)|) \right|
$$

$$
\times \int_{\phi(t)}^t v(X(\theta)) d\theta.
$$
 (164)

Using relation (56) and the definition of the supremum norm

$$
||W(t)||_{\infty} = \sup_{\phi(t) \le \theta \le t} \left| W(\theta) \right|, \tag{165}
$$

with the fact that Φ_X is an increasing function (that follows from (50)) we deduce the following estimate

$$
\bar{L}(t) \le \frac{D}{v_\star} e^{cD} \gamma \left(\|W(t)\|_\infty \right). \tag{166}
$$

From the definition of V_1 in (152), using the facts that

$$
||W(t)||_{\infty} \le ||W(t)||_{c,\infty} \le e^{cD} ||W(t)||_{\infty}, \quad (167)
$$

and that $S(X(t)) \leq V_1(t)$, together with (141) and (166) we get

$$
\alpha_1(|X(t)|) + ||W(t)||_{\infty} \le 2e^{-\lambda t} \left(\alpha_2(|X(0)|) + \frac{D}{v_{\star}} e^{cD} \gamma \left(\sup_{\phi(0) \le \theta \le 0} |W(\theta)| \right) + e^{cD} \sup_{\phi(0) \le \theta \le 0} |W(\theta)| \right).
$$
 (168)

With the properties of comparison functions and the fact that $|X(0)| \leq \sup_{\phi(0) \leq s \leq 0} |X(s)|$, we conclude that there exists a class $K\mathcal{L}$ function β_2 such that

$$
|X(t)| + \sup_{\phi(t) \le s \le t} |W(s)| \le \beta_2 \left(\sup_{\phi(0) \le s \le 0} |X(s)| + \sup_{\phi(0) \le s \le 0} |W(s)|, t \right). \tag{169}
$$

Next, we upper bound $\sup_{\phi(t) \le s \le t} |X(s)|$. From (5) we deduce

$$
\dot{\sigma}(\theta) \le \frac{v(X(\theta))}{v_\star}.\tag{170}
$$

Integrating (170) on $[\phi(t), \theta]$ with $\sigma(\phi(t)) = t$, we derive the inequality

$$
\sigma(\theta) - t \le \frac{1}{v_\star} \int_{\phi(t)}^{\theta} v(X(\lambda)) d\lambda, \tag{171}
$$

for all $\phi(t) \leq \theta \leq t$. Since $v(X(t))$ is a positive function, it follows that $\int_{\phi(t)}^{\theta} v(X(\lambda))d\lambda$ is an increasing function of θ . Using the implicit definition of the delay in (56) we get

$$
\sigma(\theta) - t \le \frac{D}{v_{\star}}, \quad \forall \ \phi(t) \le \theta \le t. \tag{172}
$$

From inequality (172) the following holds

$$
\sigma(0) \leq \frac{D}{v_*}.\tag{173}
$$

Dividing the time domain into three different intervals the following estimates are then obtained.

• For $0 \le t \le \sigma(0)$ we have that $\phi(0) \le \phi(t) \le 0$. Therefore,

$$
\sup_{\phi(t) \le s \le t} |X(s)| \le \sup_{\phi(0) \le s \le 0} |X(s)| + \sup_{0 \le s \le t} |X(s)|
$$

$$
\le \sup_{\phi(0) \le s \le 0} |X(s)|
$$

+ $\beta_2 \left(\sup_{\phi(0) \le s \le 0} |X(s)| + \sup_{\phi(0) \le s \le 0} |W(s)|, 0 \right)$. (174)

Thus, there exists a class \mathcal{K}_{∞} function μ_5 , such that

$$
\sup_{\phi(t)\leq s\leq t} |X(s)| \leq \mu_5 \left(\sup_{\phi(0)\leq s\leq 0} |X(s)| + \sup_{\phi(0)\leq s\leq 0} |W(s)| \right). \tag{175}
$$

• For $\sigma(0) \le t \le \frac{D}{v_*}$, we have $0 \le \phi(t) \le \phi\left(\frac{D}{v_*}\right)$. Thus,

$$
\sup_{\phi(t)\leq s\leq t} |X(s)| \leq \sup_{0\leq s\leq t} |X(s)| \tag{176}
$$

$$
\leq \beta_2 \left(\sup_{\phi(0)\leq s\leq 0} |X(s)| + \sup_{\phi(0)\leq s\leq 0} |W(s)|, 0 \right). \tag{177}
$$

• For $t \geq \frac{D}{v_*}$, we have from (173) that $\phi(t) \geq \phi\left(\frac{D}{v_*}\right) \geq 0$. Thus, using (169), we arrive at

$$
\sup_{\phi(t)\leq s\leq t} |X(s)| \leq \beta_2 \bigg(\sup_{\phi(0)\leq s\leq 0} |X(s)|
$$

$$
+\sup_{\phi(0)\leq s\leq 0}|W(s)|,\phi(t)\bigg). \qquad (178)
$$

and integrating (145) over $[t, \sigma(t)]$ with the help of (61) and (5), we get the following inequality

$$
R_X(t) \le \frac{D}{v_\star}, \quad \forall t \ge 0,\tag{179}
$$

we deduce that $t - R_X(t) \geq t - \frac{D}{2\epsilon}$, which leads to the existence of a class \mathcal{KL} function $\overline{\beta}_2^*$ such that

$$
\sup_{\phi(t)\leq s\leq t} |X(s)| \leq \bar{\beta}_2 \bigg(\sup_{\phi(0)\leq s\leq 0} |X(s)| + \sup_{\phi(0)\leq s\leq 0} |W(s)|, t - \frac{D}{v_*} \bigg). \tag{180}
$$

Combining estimates (175), (177), and (180) we deduce the existence of a class \mathcal{KL} function $\overline{\beta}$ such that, for all $t \ge 0$

$$
\sup_{\phi(t)\leq s\leq t} |X(s)| \leq \bar{\beta} \Big(\sup_{\phi(0)\leq s\leq 0} |X(s)| + \sup_{\phi(0)\leq s\leq 0} |W(s)|, t \Big).
$$
 (181)

D. Proof of Lemma 9

Differentiating (58) we deduce the following relation for all $\phi(t) \leq \theta \leq t$

$$
\frac{dP(\theta)}{d\theta} = \frac{v(X(\theta))}{v(P(\theta))} f(P(\theta), U(\theta)) d\theta.
$$
 (182)

Introducing the change of variables $y = \sigma(\theta)$, (182) may be rewritten as

$$
\frac{dP(\phi(y))}{dy} = f\bigg(P(\phi(y)), U(\phi(y))\bigg),\tag{183}
$$
\n
$$
t \le y \le \sigma(t).
$$

From Assumption 2, the following holds:

$$
\frac{\partial C(P(\phi(y)))}{\partial y} \le C(P(\phi(y))) + \mu_3 \bigg(|U(\phi(y))| \bigg). \tag{184}
$$

Using the comparison principle and the facts that $P(\phi(t)) =$ $X(t)$ and $y = \sigma(\theta)$ we derive the following inequality

$$
C(P(\theta)) \le e^{(\sigma(\theta)-t)} \bigg(C(X(t)) + \sup_{t \le s \le \sigma(t)} \mu_3(|U(\phi(s))|) \bigg),\tag{185}
$$

for all $\phi(t) \leq \theta \leq t$. Imposing $\theta = t$ in (171), we obtain

$$
\sigma(t) - t \le \frac{1}{v_\star} \int_{\phi(t)}^t v(X(\lambda)) d\lambda. \tag{186}
$$

Combining (186) with the implicit definition of the delay in (56) and using the fact that σ is increasing we get from (185) that

$$
C(P(\theta)) \le e^{\frac{D}{v_x}} \bigg(C(X(t)) + \sup_{\phi(t) \le \theta \le t} \mu_3(|U(s)|) \bigg), \quad (187)
$$

$$
\phi(t) \le \theta \le t.
$$

With standard properties of class K functions and using (6) we get (76) where the class \mathcal{K}_{∞} function ρ is written as

$$
\rho(s) = \mu_1^{-1} \left((\mu_2(s) + s) e^{\frac{D}{v_*}} \right).
$$
 (188)

E. Proof of Lemma 10

Consider the change of variables $y = \sigma(\theta)$ and write the predictor of the target system (73) as

$$
\frac{d\Pi(\phi(y))}{dy} = f(\Pi(\phi(y)), \kappa(\Pi(\phi(y))) + W(\phi(y))),
$$

$$
t \le y \le \sigma(t).
$$
 (189)

Under Assumption 3 there exist a class \mathcal{KL} function β_3 and a class K function ψ_1 such that

$$
\Pi(\phi(y)) \le \beta_3 \left(|X(t)|, y - t \right) + \psi_1 \left(\sup_{t \le s \le y} |W(\phi(s))| \right),
$$

 $t \le y \le \sigma(t).$ (190)

Using the fact that $y = \sigma(\theta)$ we get

$$
|\Pi(\theta)| \leq \psi_2(|X(t)|) + \psi_1\left(\sup_{t - R_X(t) \leq s \leq t} |W(s)|\right), \quad (191)
$$

for all $t - R_X(t) \le \theta \le t$ with $\psi_2(s) = \beta_3(s, 0)$. Using the properties of class K functions (77) is deduced with $\psi(s) =$ $\psi_1(s) + \psi_2(s)$.

F. Proof of Lemma 11

Due to the continuity of $\kappa(.)$ and the fact that $\kappa(0) = 0$, there exists $\hat{\rho} \in \mathcal{K}_{\infty}$ such that

$$
|\kappa(\xi)| \le \hat{\rho}(|\xi|). \tag{192}
$$

Using (192), the inverse transformation (72), and the bound (77) we derive (78) with

$$
\mu_4(s) = s + \hat{\rho}(\psi(s)).\tag{193}
$$

From the direct transformation (69) and the bound (76) we deduce (79) where ρ_1 is define as

$$
\rho_1(s) = s + \hat{\rho}(\rho(s)).\tag{194}
$$

Nikolaos Bekiaris-Liberis received the Ph.D. degree from the University of California, San Diego, in 2013. From 2013 to 2014 he was a postdoctoral researcher at the University of California, Berkeley. Dr. Bekiaris-Liberis is currently a postdoctoral researcher at the Dynamic Systems & Simulation Laboratory, Technical University of Crete, Greece. He has coauthored the SIAM book *Nonlinear Control under Nonconstant Delays*. His interests are in delay systems, distributed parameter systems, nonlinear control, and their applications.

Dr. Bekiaris-Liberis was a finalist for the student best paper award at the 2010 ASME Dynamic Systems and Control Conference and at the 2013 IEEE Conference on Decision and Control. He received the Chancellor's Dissertation Medal in Engineering from the University of California, San Diego, in 2014. Dr. Bekiaris-Liberis received the best paper award in the 2015 International Conference on Mobile Ubiquitous Computing, Systems, Services and Technologies.

Andreas Otto received the M.Sc. degree in computational science in 2008 and the Ph.D. degree in theoretical physics in 2016 from Chemnitz University of Technology, Germany. He is currently a postdoctoral researcher at the Institute of Physics at Chemnitz University of Technology. His research interests include numerical analysis, stability theory, nonlinear dynamics and mechanical vibrations. Currently, his work is focused on the analysis of time delay systems and machine tool vibrations.

Miroslav Krstic holds the Alspach endowed chair and is the founding director of the Cymer Center for Control Systems and Dynamics at UC San Diego. He also serves as Associate Vice Chancellor for Research at UCSD. As a graduate student, Krstic won the UC Santa Barbara best dissertation award and student best paper awards at CDC and ACC. Krstic is Fellow of IEEE, IFAC, ASME, SIAM, and IET (UK), Associate Fellow of AIAA, and foreign member of the Academy of Engineering of Serbia. He has received the PECASE, NSF Career, and ONR

Young Investigator awards, the Axelby and Schuck paper prizes, the Chestnut textbook prize, the ASME Nyquist Lecture Prize, and the first UCSD Research Award given to an engineer. Krstic has also been awarded the Springer Visiting Professorship at UC Berkeley, the Distinguished Visiting Fellowship of the Royal Academy of Engineering, the Invitation Fellowship of the Japan Society for the Promotion of Science, and the Honorary Professorships from the Northeastern University (Shenyang), Chongqing University, and Donghua University, China. He serves as Senior Editor in IEEE Transactions on Automatic Control and Automatica, as editor of two Springer book series, and has served as Vice President for Technical Activities of the IEEE Control Systems Society and as chair of the IEEE CSS Fellow Committee. Krstic has coauthored eleven books on adaptive, nonlinear, and stochastic control, extremum seeking, control of PDE systems including turbulent flows, and control of delay systems.

Mamadou Diagne received the Ph.D. degree in 2013 at Laboratoire d'Automatique et du Génie des Procédés, Université Claude Bernard Lyon I. He has been a postdoctoral fellow at the Cymer Center for Control Systems and Dynamics of University of California San Diego from 2013 to 2015 and at the Department of Mechanical Engineering of the University of Michigan from 2015 to 2016. He is currently an Assistant Professor at Rensselaer Polytechnic Institute. His research interests concern the

modeling and the control of heat and mass transport

phenomena, production/manufacturing systems and, additive manufacturing processes described by partial differential equations and delay systems.