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Design and Assessment of a Six-DOF Micro-/Nanopositioning System

Defu Zhang, Pengzhi Li, Jianguo Zhang, Huanan Chen, Kang Guo, Mingyang Ni

Abstract— A six degree-of-freedom (six-DOF) parallel positioning system with high resolution, high repeatability and low parasitic motions was proposed. It mainly consists of three identical limbs. Each limb consists of two symmetrical six prismatic-universal-spherical (6-PUS) branches. Firstly, the design process for a novel six-DOF limb with input displacement reduction was introduced. By applying bipods and linear displacement output mechanisms, these novel limbs with symmetric configurations were designed. Moreover, a numerical compliance/stiffness model of the proposed mechanism was built based on the matrix method. This numerical model was verified by ANSYS finite element analysis (FEA) software package. Hence, the input stiffness, the output compliance and the stroke of the mechanism can be theoretically estimated. Furthermore, a prototype made of stainless steel 431 was successfully manufactured by wire electrical discharge machining (WEDM) process. It is actuated and sensed by piezo actuators and capacitive displacement sensors respectively. Finally, the working performances of this proposed mechanism were experimentally investigated. It shows that the spatial resolution can be achieved in 10nm × 10nm × 5nm × 100nrad × 100nrad × 200nrad in open-loop control. The closed-loop positioning accuracy in σ (standard error) can reach 30nm × 30nm × 15nm × 150nrad × 150nrad × 300nrad. The experimental results not only validate the effectiveness of the proposed positioning system but also verify the nanometer-scale spatial positioning accuracy within several tens of micrometers stroke range. The proposed micro-/nanopositioning system maybe expand the actual application of alignment optical elements in projection lenses of 193nm immersion lithography.

Index Terms— Six-DOF, Parallel positioning system, Mechanical design, Micro-/nanopositioning, Flexure mechanisms

I. INTRODUCTION

MICRO-/NANOPositionING technology becomes much more essential in precision engineering, such as atomic force microscope system[1], microelectromechanical system[2], lithography[3], ultra-precision machining[4], and so on. In general, compliant mechanism can transmit some accurate relative motions in micro/nanometer scale through elastic deformation[5][6]. This kind of mechanism has so many advantages, such as avoiding energy losses caused by friction, unnecessary of lubrication, absence of hysteresis, compactness, easy to be fabricated, position resolution in micro/nanometer scale, and so on. Hence, compliant mechanism becomes much more suitable for high-precision positioning applications than conventional mechanism named.

There are two types of compliant mechanisms named as serial and parallel mechanism respectively. On one hand, the serial mechanism connects multiple lower-mobility mechanisms in a nested or stacked manner[7-9]. Although the structure scheme and control strategy are simple in serial mechanism, it has low natural frequency, large inertia, error accumulation, and huge differences in dynamic characteristics of each motion element. The inconsistent performance of each motion axis in the workspace can not be negligible. On the other hand, parallel mechanism connects an end effector by a series of individual limbs[10-12]. It is advantageous in high load capacity, small inertia, and especially negligible differences in dynamic characteristics of each motion axis with high motion accuracy[13-15]. Therefore, the parallel mechanism is more suitable and applicable for micro-/nanopositioning system. However, the end effector of parallel mechanism is directly connected with several limbs, resulting in the parasitic motions. Parasitic motion produces more than one direction of displacement, which is a typical character of parallel mechanism[16][17]. Therefore, it is worth to pay much more attention to the compliant mechanism design to reduce the parasitic motion.

In the past few decades, several piezoelectrically-driven compliant parallel mechanisms have been reported[18-21]. Some successful commercial applications have emerged in market (e.g., the multi-axis positioners fabricated by Physik Instrumente GmbH and Company). Recently, more and more precision positioning systems with six-DOFs, i.e., three linear
and three rotational axes, are demanded in some special applications. The six-DOF positioners make motion possible on the basis of complex trajectories in arbitrary workspace. For example, Cai et al. [22] proposed a six-DOF positioning system assembled by two three-DOF positioning platforms in series. The working space was 8.2μm × 10.5μm × 13.0μm × 224μrad × 105μrad × 97μrad along three linear and three rotational axes. Shin and Moon reported a six-DOF positioning system with double triangular parallel positioning mechanisms[23]. Three piezoelectric ceramic transducers(PZTs) were utilized in the inner triangle as in-plane positioning. The other three PZTs were mounted in the external triangle as out-of-plane positioning. The stroke of this mechanism exceeded 50μm × 50μm × 150μm × 733μrad × 733μrad × 244μrad. The translational and rotational resolutions were 0.1μm and 1μrad respectively.  

Moreover, a six-DOF prismatic-spherical-spherical parallel compliant nanopositioner was introduced by Wu et al.[24]. This nanopositioner has a stroke of 7.49μm × 8.22μm × 8.79μm × 205μrad × 245μrad × 202μrad with a translational resolution of 5nm and a rotational resolution of 0.7μrad respectively. Kang and Gweon proposed a large-stroke six-DOF micro-positioning mechanism applied for optical alignment[25]. The workspace was ±2mm × ±2mm × ±2mm × ±35μrad × ±35μrad × ±35μrad with a high translation resolution of 15nm and a rotational resolution of 0.68μrad. Furthermore, based on the kinematic coupling principle, a six-DOF micropositioning mechanism was designed in by Varadarajan and Culpepper[26, 27]. Although the designed stage can demonstrate a position resolution of 4nm within a single-axis stroke, the resultant parasitic motion can not be ignored. The z-axis parasitic motion exceeded 1μm while driving the x-axis stroke of ±25μm or rotating the θx-axis with 200μrad. A six-DOF parallel micromanipulator with an alternative type of Stewart mechanism was also introduced by Yue et al.[28]. Its maximum translation and rotation errors reached 12.8% and 9.6% of the target motion respectively. Hence, it is worth to develop a six-DOF precision positioning system with high motion accuracy and low parasitic motion.

The main contribution of this paper is that a novel six-DOF micro/nano-positioning system which is featured with high resolution, high repeatability and low parasitic motion has been proposed. This paper includes the following sections. At first, mechanical design and assembly are outlined in Section II. As following, an analytical model which can be used to predict the stroke range and stiffness of the designed mechanism is established in detail in Sections III. Furthermore, the numerical design of the positioning system is verified by applying ANSYS FEA in Section IV. Moreover, the static performances of the proposed mechanism are tested with a self-fabricated prototype in Section V. A series of experimental investigations are carried out in Section VI in order to clarify the positioning accuracy and repeatability of the proposed mechanism. Finally, Section VII concludes this research paper.

II. MECHANISM DESIGN

A. Configuration Design

To begin with, the DOFs of a limb in a flexure parallel mechanism are introduced. Gao et al. pointed out that if a parallel mechanism has a certain DOFs ($s$, the limbs ($1, 2, ..., n$) connecting the end effector and the base need to satisfy the following equation:[29]

$$s = s_1 \cap s_2 \ldots \cap s_n$$

where $s_n$ is the DOFs of the $n$th limb. As known, Plücker coordinates are adopted as an effective way to assign six homogeneous coordinates to each line in projective 3D-space. $s$ can be considered as the special Plücker coordinates in characterizing the output displacement of a limb. Eq. (1) indicates that the special Plücker coordinates of the stage motion equal to the intersection of the special Plücker coordinates of all limbs in the parallel mechanism.

Gao et al. reported that a six-DOF parallel mechanism can be actualized by three or six limbs, where each limb should have six DOFs[29]. Parallel mechanisms with six limbs have commonly been used so far, such as the Stewart platform. These configurations usually include 6-SPS, 6-RSS, 6-PUS or 6-RUS, where $P$, $R$, $U$, $S$ is denoted as the prismatic, revolute, universal, and spherical joints, respectively. With considering that fewer limbs can achieve low cost, easy installation, high integration and light weight, a novel 6/3-PUS flexure parallel mechanism with six DOFs is proposed in this paper.

Hence, flexure hinges used in each limb are designed at first. In a flexure mechanism, hinges usually include revolute joints (R), prismatic joints (P) and universal joints (U), as shown in Fig. 1. The rotation hinge has only one DOF of y-axis rotation(ry), as shown in Fig. 1(a). Hinges with parallel rotation joints have three DOFs, which are x-axis translation(tx), Ry and z-axis rotation(rz), as shown in Fig. 1(b). Two rotating hinges are orthogonal to each other can be considered as a universal joint. It has three DOFs of x-axis rotation(rx), Ry and Rz, as shown in Fig. 1(c). Two universal joints which are connected in series have five DOFs, i.e., Tx, y-axis translation(ty), Rx, Ry, and Rz, as shown in Fig. 1(d).

The limbs in Fig.1(b), (c) and (d) can be obtained by series connection of multiple joints shown in Fig.1(a), respectively. The limb as shown in Fig. 1 (e) and (f) can be obtained by connecting two identical hinges in parallel as introduced in Fig. 1(d). Although the single branch along z-direction in Fig. 1(e) has five DOFs, i.e., Tx, Ty, Rx, Ry, and Rz, it is constrained by the horizontal branch along x-direction. Hence, due to the constrained Tx, the limb has only four DOFs of Ty, Rx, Ry, and Rz. Similarly, horizontal branch along x-direction also has four DOFs of Ty, Rx, Ry, and Rz. These two combined hinges constraint two DOFs of Tx and z-axis translation(Tz). This structure is well known as BIPOD[30]. Moreover, the stability of the mechanism shown in Fig. 1(f) is better than that shown in Fig. 1(e) when considering the load capacity of the end effector. However, the mechanisms shown in Fig. 1(e) and (f) require at least three times threading from three different directions with
WEDM process. The manufacture process becomes complex and time consuming. Although it just needs twice threading from two vertical directions with optimizing the structure as Fig. 1(g) shows, the rotational axis drift is increased due to the diamond shape of rotation hinge. Therefore, the structure was optimized as shown in Fig. 1(h) to obtain not only simple manufacturing process but also tiny rotational axis drift. Furthermore, if the driving motor is mounted at the bottom of each branch as shown in Fig. 1(h), the output displacement of Tx and Tz can also achieve. The DOFs of Tx and Tz of the limb are not being constrained any more. Hence, a six-DOF limb that satisfies equation (1) can be obtained.

B. Mechanism Assembly

In order to decrease the resolution requirement for a motor, a displacement reduction lever was also adopted to achieve tens of nanometers output resolution. As shown in Fig. 1(i), a six-DOF limb with a bipod and two levers (LBL) is proposed. The output ends of levers are connected with the two fixed ends of the branch as Fig. 1(h) shows. A reduced Tz displacement of the output end is generated when two linear actuators move in the same direction. A reduced Tx displacement is obtained when two linear actuators move in the opposite direction. When only one actuator moves, a reduced translation in xz plane is obtained.

In order to reduce the input parasitic motion, a hook joint is mounted between the motor and the lever. It transmits only the axial force and protects the motor from undesired shear forces and bending moments. It should be noted that the LBL limb can also be changed into other forms. For example, both the output direction and displacement can be changed by substituting a Scott-Russell mechanism or a four-bar mechanism for levers.

The designed six-DOF parallel positioning system is shown in Fig. 2(a) where three identical six-DOF limbs are uniformly distributed around the z-axis with 120° intervals. By controlling the input displacement of the six linear actuators, these three limbs can do the synchronous motion. Hence, the end effector can achieve the posture adjustments with six-DOF in 3D-space. The maximum diameter and height of the six-DOF mechanism are 264mm and 148.4mm respectively. The CAD model and the assembly process of the proposed mechanism are illustrated in Fig. 2(b).

III. MECHANISM MODELING

There are several methods that can be used for modeling the elastic deformation of flexure mechanisms. The commonly used methods are pseudo-rigid-body (PRB) model[31] and Castigliano’s second theorem[32]. The PRB model is suitable for planar structure while Castigliano’s second theorem requires complex mechanical analysis in a linearly elastic structure. As compared with the above-mentioned methods, the compliance matrix method (CMM) which is derived from the linear Hooke’s law[11,19,33] is much more efficient in modelling the complex space flexure mechanism. Hence, the CMM method was adopted to establish the stiffness/compliance model of the proposed mechanism in this paper.

Fig. 1. The novel six-DOF limb. (a) revolute joint (R), (b) prismatic joint (P), (c) universal joint (U), (d) two universal joints, (e) bipod rotate 45° about y-axis, (f) standard bipod, (g) bipod easy fabricating type I, (h) bipod easy fabricating type II, (i) Output-displacement-reduced six-DOF limb.
A. Compliance of the LBL Limb

The system consists of three LBL limbs connected in parallel. Firstly, the output compliance of Limb1 in $B$-xy coordinate system as shown in Fig. 3 is investigated. The geometrical dimension of Limb1 is also shown in Fig. 3. Hook hinge $O_5O_3$ and hinge $O_1O_3$ are connected in parallel in the $O_3$-xy coordinate system. The compliance of position $O_6$ with respect to $O_1$ and $O_4$ is given by:

$$C_6 = \left( T_3^6 \cdot C_{hook} \cdot T_3^6 \right)^{-1} + \left( T_5^6 \cdot C_5 \cdot T_5^6 \right)^{-1}$$

where $C_{hook}$, $C_5$ is the local compliance of the hook hinge $O_2O_3$ and hinge $O_4O_5$, $T_3^6$, $T_5^6$ are the transformation matrices from coordinate system $O_1$-xy to $O_5$-xy.

Similarly, the hinges $O_5O_3$, $O_4O_5$, $O_0O_1$, and $O_12O_3$ are connected in series to the $B$-xy coordinate system and the compliance can be calculated by

$$C_B^6 = \sum_{i=3}^{6} T_{2i+1}^B \cdot C_{2i+1} \cdot \left( T_{2i+1}^B \right)^T$$

where $C_{2i+1}$ (for $i=3, 4, 5$ and $6$) are the local compliance and $T_{2i+1}^B$ are the transformation matrices.

The compliance of the left branch in the $B$-xy coordinate system is

$$C_B = C_B^6 + T_B^6 \cdot C_6 \cdot \left( T_6^B \right)^T$$

where $T_B^6$ is the transformation matrix.

And then, due to the Limb1 is left-right symmetric about the x-axis, there are two of the same branches as shown in Fig. 5 are connected in parallel at point $B$. Hence, the resultant compliance of the Limb1 in the $B$-xy coordinate system can be derived as

$$C_B = K_B^{-1} = \left( C_B^{-1} + T_r^T \cdot \left( C_B \cdot T_r \right)^{-1} \right)^{-1}$$

where the transformation matrix from the right to left branch can be expressed by

$$T_r = \begin{bmatrix} R_x & 0 \\ 0 & R_x \end{bmatrix}$$

where $R_x^\pi$ represents rotation matrix that rotates $\pi$ angle about x-axis.

B. Output Compliance of the End Effector

According to the system design in Fig. 2, the output compliance model of each limb is same at each respective output end. Those three limbs are connected in parallel at the centroid point $O$ of the output end. The output compliance of the limbs at the centroid point $O$ can be obtained as
\[
C_o = \left( \sum_{i=1}^{3} K_i^O \right)^{-1} = \left( \sum_{i=1}^{3} \left( T_i^O \cdot C_i \cdot (T_i^O)^T \right) \right)^{-1} \quad (7)
\]

where \( C_i \) (for \( i = 1, 2, \) and \( 3 \)) is the local compliance of each limb at its own output end and the transformation matrix \( T_i^O \) can be written as

\[
T_i^O = \begin{bmatrix}
R_i^O & R_i^O \cdot S(r_i^O) \\
0 & R_i^O
\end{bmatrix}
\]

where \( R_i^O \) is the rotation matrix of coordinate \( B_i \) with respect to \( O \), \( r_i^O \) is the position vector of point \( B_i \) expressed in reference frame \( O \), and \( S(r) \) represents the skew-symmetric operator for a vector \( r = [r_x, r_y, r_z]^T \) with the notation

\[
S(r) = \begin{bmatrix} 0 & -r_z & r_y \\
r_z & 0 & -r_x \\
-r_y & r_x & 0 \end{bmatrix}
\]

\[ \begin{align*}
C_i &= \left( T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \\
C_o &= \left( \sum_{i=1}^{3} \left( T_i^O \cdot C_i \cdot (T_i^O)^T \right) \right)^{-1} \quad (11)
\end{align*} \]

where \( T_i^O \) and \( T_i^O \) are the transformation matrices.

Then, the above compliance and hook hinge \( O_2O_3 \) are connected in series at the input \( O_1 \)

\[ C_{in} = T_3^O \cdot C_6 \cdot (T_3^O)^T + C_{hook} \quad (12) \]

where \( T_3^O \) is the transformation matrix.

Finally, we can get the input stiffness

\[ k_{in} = [C_{in}(1,1)]^{-1} \quad (13) \]

\[ \begin{align*}
C_{in} &= \left( T_3^O \cdot C_6 \cdot (T_3^O)^T \right)^{-1} \\
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \quad (10)
\end{align*} \]

where \( T_3^O \) is the transformation matrix.

The compliance of position \( O_6 \) is connected in parallel with the hinge \( O_4O_5 \) in the coordinate system \( O_3-xy \)

\[ C_B = \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} + \left( T_3^O \cdot C_6 \cdot (T_3^O)^T \right) \quad (10) \]

where \( T_3^O \) is the transformation matrix.

The compliance of position \( O_6 \) is connected in parallel with the hinge \( O_4O_5 \) in the coordinate system \( O_3-xy \)

\[ C_{out} = \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \quad (10) \]

\[ \begin{align*}
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \\
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \quad (10)
\end{align*} \]

\[ \begin{align*}
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \\
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \quad (10)
\end{align*} \]

\[ \begin{align*}
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \\
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \quad (10)
\end{align*} \]

\[ \begin{align*}
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \\
C_{out} &= \left( \sum_{i=1}^{3} T_i^O \cdot C_i \cdot (T_i^O)^T \right)^{-1} \quad (10)
\end{align*} \]
the input stiffness, a certain force $F_{in}$ was applied to the input end of Limb1. And then, the corresponding input displacement was extracted from the FEA to obtain the input stiffness. In addition, by applying a certain force $F_{out}$ to the end effector, the output compliance can be evaluated by extracting the platform displacement, as shown in Fig. 5.

**TABLE I**

<table>
<thead>
<tr>
<th>$l_1$</th>
<th>$l_2$</th>
<th>$l_3$</th>
<th>$l_4$</th>
<th>$l_5$</th>
<th>$l_6$</th>
<th>$l_7$</th>
</tr>
</thead>
<tbody>
<tr>
<td>5.0</td>
<td>2.0</td>
<td>34.3</td>
<td>13.2</td>
<td>2.4</td>
<td>1.2</td>
<td>3.0</td>
</tr>
<tr>
<td>12.0</td>
<td>4.8</td>
<td>29.7</td>
<td>17.5</td>
<td>9.5</td>
<td>3.3</td>
<td>2.0</td>
</tr>
<tr>
<td>6.0</td>
<td>2.0</td>
<td>2.0</td>
<td>30.0</td>
<td>30.0</td>
<td>20.0</td>
<td>112.0</td>
</tr>
</tbody>
</table>

Units: mm.

**TABLE II**

<table>
<thead>
<tr>
<th>Materials</th>
<th>Young’s Modulus /GPa</th>
<th>Density /kg/m³</th>
<th>Poisson’s Ratio</th>
<th>Yield strength /MPa</th>
</tr>
</thead>
<tbody>
<tr>
<td>431</td>
<td>198.6</td>
<td>7.75×10³</td>
<td>0.27</td>
<td>655–1080</td>
</tr>
<tr>
<td>60Si2Mn</td>
<td>206</td>
<td>7.85×10³</td>
<td>0.27</td>
<td>1175</td>
</tr>
</tbody>
</table>

Based on Eq. (7) and Eq. (13), the output compliance and the input stiffness are predicted to be 8.479e-08m/N and 1.229 × 10¹⁷N/m, respectively by CMM models. By FEA simulation results the output compliance and the input stiffness are 7.436e-08m/N and 1.041 × 10¹⁷N/m. The model deviations are 14.02% and 18.06% according to an error equation (CMM-FEA)/FEA×100%. These deviations are mainly caused by some assumptions in the numerical analytical model, such as the accuracy of the compliance equations, the neglect of the links compliance between hinges, and so on. Moreover, the linear relationship between input force and input displacement indicates that stress stiffening does not happen in the proposed mechanism.

**Fig. 5.** Mechanism deformation along z-axis with a force of 1800N on the end effector (Enlarged 110 times for a clear view).

**B. Stroke**

When a motor supplies a linear displacement of 0.5mm to the input end of each limb, the maximum stress of 181.87MPa subject to the axial load is generated at position $O_7$ of limbs of the proposed mechanism. Therefore, the safety factor can be calculated as $\sigma_r/\sigma_{max}$=655MPa/181.87MPa=3.6, where $\sigma_{max}$ is the maximum allowable stress of material. It indicates that the proposed mechanism can achieve reliably long-term running with the elastic deformation. The high-precision positioning repeatability can also be guaranteed. With a maximum input displacement no more than 0.5mm at input ends of three limbs, the six-DOF strokes of the end effector are also investigated by FEA. The $T_x$, $T_y$ and $T_z$ strokes are 59.441μm, 67.33μm and 37.796μm, respectively. The $R_x$, $R_y$ and $R_z$ strokes are 326.477μrad, 350.25μrad, and 512.801μrad, respectively.

**C. Modal Analysis**

The constraint modal analysis were performed. It demonstrates that the 1st and 2nd natural frequencies are 188.84Hz and 189.02Hz respectively. They are translational vibrations in the xy plane. The third mode is the rotation around the z axis which is 231.89Hz. The bending vibrations around Rx/Ry-axis and the translation vibrations along z-axis happen in the 4th, 5th, and 6th modes respectively. The 4th and 5th modes are close to each other with the vibration frequency of 331.53Hz and 331.66Hz, respectively. The 6th mode is a translation along the z-axis with a frequency of 364.22Hz.

**V. Prototype Fabrication and Tests**

In this section, the working performances of the proposed positioning system were experimentally investigated with a self-fabricated prototype.

**A. Experimental Setup**

The fabricated prototype and the experimental configurations are shown in Fig. 6. Capacitive displacement sensors are used to measure the postures of the end effector. The base of this system was fixed to a vibration isolation platform preventing the vibration from ground. Each limb was fabricated by WEDM process, and the material is stainless steel 431. The end effector was bolted to three limbs and then mounted on the base holistically. Each limb was actuated by two piezo actuators (LTC40 from PiezoMotor) with a stroke of ±1.5mm and a sub-micron/nanometer positioning resolution. The driving voltage of 0–48V can be obtained from a six-axis piezo amplifier and controller (Driver 206 from PiezoMotor). The piezoelectric actuator was connected with a hook hinge. There was no gap between the motor and the mechanism during operation. Hence, it becomes unnecessary to carry out the preloading springs. In order to measure the six motion DOFs of the proposed mechanism, six measuring blocks were mounted on the end effector. The output motion of the end effector was measured by six capacitive displacement sensors (CSH05FL from Micro-Epsilon) which have a linearity of ±0.05% in a full stroke of 500μm. The static and dynamic resolution are 0.38nm and 10nm under the sampling rate of 2Hz and 8.8kHz. The analog output voltage of the six sensors was changed into digital output by a data acquisition box. Then, the digital output was picked up by a computer through a RS232 interface with a sampling frequency of 10Hz. It should be noted that the measure direction of each sensor is the same as the motion direction of the measured target, which is beneficial for eliminating Abbe errors.

**B. Open-Loop Performance Testing**

In this section, the position resolution of the proposed mechanism was experimentally investigated by open-loop control. The $T_x$ response was studied by using a
continuous-step command with a position resolution of 0.01μm, as shown in Fig. 7(a). Because the response speed is slow, the position overshoot of this positioning system is negligible. It also shows that the steady-state error remains within the range of ±5nm, which verifies that the position resolution of Tx is about 10nm. Similarly, the position resolution of Ty is also about 10nm in the proposed mechanism, as shown in Fig. 7(b). In addition, the position resolution of Tz was also investigated. In Fig. 7(c), it shows that the position step of 5nm can be clearly identified, and the tracking steady-state error is also within ±2.5nm. It indicates that the position resolution of Tz can achieve about 5nm. Furthermore, the angular resolutions of Rx/Ry/Rz are measured as 100nrad, 100nrad and 200nrad, respectively, as shown in Fig. 7(d)-(f).

Moreover, with a maximum actuators’ input displacement of 0.5mm, the stroke of the proposed mechanism was also investigated with open loop control. The stroke is about ±40μm × ±20μm × ±200μrad × ±200μrad × ±300μrad in the 3D space. Due to manufacturing errors and motor assembly tolerances, the actual two-direction travel range is not exactly symmetrical about the zero point.

And then, the parasitic motion of the end effector was investigated. Experiments were carried out with open-loop control. When controlling the end effector just move along the x-axis direction within ±40μm, the displacement of Tx and the other five parasitic motions (Ty, Tz, Rx, Ry and Rz) are simultaneously measured. Fig. 8(a) illustrated the experimental results. The maximum translational parasitic errors of Ty and Tz are 0.426μm and -0.139μm, respectively. The ratio of the parasitic error to the primary motion in Ty and Tz is about 1.064% and 0.348% respectively. Similarly, the maximum parasitic errors for Rx/Ry/Rz are measured as -0.915μrad, -2.521μrad and -7.748μrad respectively. So, the ratio of the parasitic error to the primary motion in Rx, Ry and Rz is 2.288%, 6.48% and 19.369% respectively. With the same investigation methods, the parasitic errors can also be obtained when just driving end effector along the Ty, Tz, Rx, Ry and Rz direction, as shown in Fig. 8(b)-(f).

It is considered that there are several reasons causing the parasitic motion generation in open-loop control, such as manufacturing error, misalignment of motors, assembly errors, mounting error of sensors, Abbe errors between the motion axes and the measurement point, and so on. The above-mentioned conditions also decrease the positioning accuracy of the proposed mechanism in open loop control. Parasitic errors may be reduced by adjusting the sensor installation with a coordinate measuring machine. In order to increase the positioning accuracy and decrease the parasitic motion, a closed-loop control was applied to the proposed positioning system.

VI. EXPERIMENTAL TESTS AND DISCUSSIONS

In the section, the positioning performance of the proposed system was experimentally investigated with a closed-loop
control.

\[
RMS_i = \sqrt{\frac{1}{N} \sum_{i=1}^{N} (X_i - \mu)^2}
\]  

(15)

where \( N \) is the number of samples, \( X \) is the variable.

The standard deviation(\( \sigma \)) of \( Tx/Ty/Tz/Rx/Ry/Rz \) are 0.0099, 0.0047, 0.0022, 0.0194, 0.0282 and 0.0632, which can be got by

\[
\sigma = \sqrt{\frac{1}{N} \sum_{i=1}^{N} (X_i - \mu)^2}
\]

The positioning repeatability in 3\( \sigma \) of the proposed positioning system is better than 30nm \( \times \) 30nm \( \times \) 15nm \( \times \) 150nrad \( \times \) 150nrad \( \times \) 300nrad in 3D space.

A. The positioning accuracy in six-axis control

The positioning accuracy was investigated by moving the end effector from an initial position (0, 0, 0, 0, 0, 0) to a target position (10\( \mu \)m, 10\( \mu \)m, 10\( \mu \)m, 100\( \mu \)rad, 100\( \mu \)rad, 100\( \mu \)rad) with controlling all the six motion axis simultaneously. The measurement results are shown in Fig. 9. It shows that the finally achieved position is (10.000\( \mu \)m, 10.005\( \mu \)m, 9.998\( \mu \)m, 99.973\( \mu \)rad, 99.961\( \mu \)rad, 99.937\( \mu \)rad). The positioning processes are shown in Fig. 9(a)-(f). The steady-state errors at the target position are enlarged view in Fig. 9(g)-(l), and the corresponding histograms of those steady-state errors are shown in Fig. 9(m)-(r). The 3\( \sigma \) positioning accuracy of \( Tx/Ty/Tz/Rx/Ry/Rz \) is 21.69nm, 18.92nm, 10.71nm, 86.43nrad, 87.78nrad, and 200.51nrad respectively.

With controlling the entire six-motion axis simultaneously in close-loop control, the positioning repeatability of the proposed system was also investigated. The positioning tests were repeated ten times to ensure reproducibility. The initial and target position in each test keep the same as above-mentioned. The measured target position and the calculated positioning accuracy (3\( \sigma \)) are concluded in Table III. The root-mean-square(RMS) of \( Tx/Ty/Tz/Rx/Ry/Rz \) are 10.0003\( \mu \)m, 10.0023\( \mu \)m, 9.9961\( \mu \)m, 100.0042\( \mu \)rad, 99.9593\( \mu \)rad and 99.9715\( \mu \)rad, which can be obtained by the equation (14)

\[
X_{RMS} = \sqrt{\frac{1}{N} \sum_{i=1}^{N} X_i^2} = \sqrt{\frac{X_1^2 + X_2^2 + ... + X_N^2}{N}}
\]  

(14)

Fig. 8. The parasitic errors of the end effector. (a)\( Tx \) primary motion, (b)\( Ty \) primary motion, (c)\( Tz \) primary motion, (d)\( Rx \) primary motion, (e)\( Ry \) primary motion, (f)\( Rz \) primary motion.

Fig. 9. The positioning results in the six axes. (a-f) Time history of positioning, (g-l) Steady-state error magnification diagram. (m-r) Histograms of steady-state errors of the positioning system.

B. Discussions on System Performance

In order to make a comparison with some already reported six-DOF systems, several typical performances of the present proposed system are summarized in Table IV.

With open-loop controlling, a large stroke of ±0.04mm \( \times \) ±0.04mm \( \times \) ±0.03mm \( \times \) ±0.02mrad \( \times \) ±0.2mrad \( \times \) ±0.3mrad can be achieved with the present proposed system. It should be
noted that the stroke of this presented system is conservative due to the installation errors and the limited working displacement of the driving motor. If a larger travel range is demanded, the stroke of the proposed system may be further increased by using a linear motor with a larger working displacement, such as voice coil motors (VCM).

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The performance comparison of the proposed system is shown in Table IV. The performance of optical elements in lithographic projection lenses[3][34]. Although commercial six-DOF positioning systems have enough workspace, the position resolution and positioning accuracy can not satisfy the requirements. Furthermore, the mechanism proposed in this paper is made of stainless steel 431. The thermal expansion coefficient of this material is close to that in optical glasses. The six-DOF positioning system proposed in this paper has a practical prospect in the above-mentioned ultra-precision optical engineering. The proposed system is more advantageous than present commercial ones in achieving the high-precision positioning accuracy. In order to improve the position tracking accuracy and the response speed of the system, a more compact six-DOF positioning system will be developed.
by optimizing the structural design in the future researches. Some advanced control strategies, i.e., discrete-time repetitive control[8], enhanced model-predictive control[14], sliding-mode control[35] and fuzzy adaptive control[36], will be adopted.

VII. CONCLUSIONS

This paper proposed a parallel six-DOF positioning system with high resolution, high repeatability and low parasitic motion. Lever-bipod-lever was adopted to design the limb with input displacement reduction, which improves the position resolution of the end effector. Based on the matrix method, a compliance model of the proposed mechanism was built. The output compliance, input stiffness and stroke of the proposed mechanism were theoretically calculated. As following, the feasibility of the proposed numerical model was also verified by a FEA simulation process. Furthermore, a prototype was manufactured for experimental investigations. The travel range of the proposed system can achieve $\pm 40 \mu m \times \pm 40 \mu m \times \pm 30 \mu m \times \pm 200 \mu m \times \pm 200 \mu m \times \pm 300 \mu m$ with the resolution of 10nm $\times$ 10nm $\times$ 5nm $\times$ 100nm $\times$ 100nm $\times$ 200nm in open-loop control. The positioning accuracy of the six-axis can achieve 30nm $\times$ 30nm $\times$ 15nm $\times$ 150nm $\times$ 150nm $\times$ 300nm in closed-loop control. The experimental results not only validate the effectiveness of the proposed positioning system but also verify the nanometer-scale spatial positioning accuracy within several tens of micrometers stroke range. The proposed micro-/nanopositioning system maybe expand the actual application of alignment optical elements in projection lenses of 193nm immersion lithography.

In the future, some researches can be carried out to improve the applicability of the proposed six-DOF positioning system: (1) High-performance control strategies will be carried and high-speed tracking performance will be investigated. (2) The geometrical dimension of the proposed mechanism will be optimized and miniaturized.

REFERENCES

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