



**DALMIA CEMENT (B) LIMITED – CEMENT PLANT  
ARIYALUR  
INSTRUMENTATION MANUAL**

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SOP for Sampling station(HR LKC) Synchronization procedure			

**Procedure:**

- Before Power ON the station, Please check air pressure is more than 5.5 BAR.
- If Air pressure is normal, Power ON the station
- Wait till it displays
  - “B04: Power was off press reset – button”**
  - “B01: Emergency –Stop activated”**
- Press **Reset** button
- Now it will display **“M01:No initial position press ‘SYN’ button”**
- Press **“K2(SYN)”** for synchronization
- Do not press any other button. This process will take 10minutes for complete
  - During process it will display as
  - “M03: Synchronization in operation”**
  - “M19: Cooling of Sample active”**
  - “M03: Synchronization in operation”**
- At the end you can see
  - “M08: Capsule not empty! Empty it or press RESET 3s”**
- Now press **“RESET”** button continuously for 10sec
- It will display as
  - “Capsule on the way or missing”** and **“Capsule not empty! Empty it or press RESET 3s”**
- After 10sec release the **Reset** button
- Now it will display as
  - “M04”Machine ready for manual operation”**
- Now press **“K1(AUT/MAN)”** button for put the station in Auto mode
- It will display as
  - “M01: Ready for operation auto mode”.**
- Now machine is ready for auto mode operation.