



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



Issue No. 01	Rev. No: 00	Effective Date: 01.11.2010	WI-10 (SP-8; AM-7)
Issued By: M.R		Approved By: HOD-INSTRUMENTATION	
CALIBRATION PROCEDURE FOR THERMOCOUPLE TRANSMITTER			

CALIBRATION PROCEDURE FOR THERMOCOUPLE TRANSMITTER:

- 1.1 The Instrument engineer takes action as follows, for calibration:
Connect the transmitter to DTM through ABB DCS.
 - 1.2 Connect the calibrator to the input terminals of the temperature transmitter.
 - 1.3 Apply milli volt corresponding to the desired full scale temperature by considering ambient temperature correction the CCR indication should show full scale temperature.
 - 1.4 If not, adjust it by desired offset in DTM.
 - 1.5 Observations are recorded in the instrument calibration format F-1/WI-10(SP-8;AM-7)
- 2.0 CONNECTED DOCUMENT:**
F-1/WI-10(SP-8; AM-7)

Calibration of Thermocouple Transmitter

Calibration of Coal Mill inlet temperature transmitter
Calibration of PH fan inlet temperature transmitter.
Calibration of PH Calciner Inlet temperature transmitter.
Calibration of RABH inlet Temperature Transmitter.
Calibration of Cooler ESP inlet Temperature Transmitter.
Calibration of Kiln Hood Temperature transmitter (SEC. AIR)
Calibration of Cement Mill Inlet Temperature Transmitter.

Raw Mill Inlet Temperature

RANGE 0- 400 Deg

Applied Value In mv.

Calculated value in DEG.

0.0
8.138
16.397

0.0
200.0
400.0



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COALMILL INLET TEMPRATURE

RANGE 0- 400 Deg

Applied Value In mv.

Calculated value in DEG.

0.0

0.0

8.138

200.0

16.397

400.0

PREHEATER FAN INLET TEMPRATURE

RANGE 0- 600 Deg

Applied Value In mv.

Calculated value in DEG.

0.0

0.0

12.209

300.0

24.905

600.0

CALCINER INLET TEMPRATURE

RANGE 0- 1000 Deg

Applied Value In mv.

Calculated value in DEG.

0.0

0.0

20.644

500.0

41.276

1000.0

RABH INLET TEMPRATURE

RANGE 0- 500 Deg

Applied Value In mv.

Calculated value in DEG.

0.0

0.0

10.153

250.0

20.644

500.0

KILN HOOD (SEC.AIR) TEMPRATURE

RANGE 0- 1200 Deg

Applied Value In mv.

Calculated value in DEG.

0.0

0.0

24.905

600.0

48.838

1200.0



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CALIBRATION PROCEDURE FOR THERMOCOUPLE TRANSMITTER			

CEMENT MILL INLET TEMPRATURE

RANGE 0- 850 Deg

Applied Value In mv.

Calculated value in DEG.

0.0

0.0

17.667

430.0

35.313

850.0

COOLER ESP INLET TEMPRATURE

RANGE 0- 500 Deg

Applied Value In mv.

Calculated value in DEG.

0.0

0.0

10.153

250.0

20.644

500.0