



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

Issue No. 02	Rev. No: 00	Effective Date: 01.11.2019	WI-19 (SP-8; AM-7)
Issued By: M.R		Approved By: HOD-INSTRUMENTATION	
CALIBRATION PROCEDURE OF ROTOR SCALE CHECK BIN			

The Instrument engineer takes action as follows for calibration:

**1.1 STATIC CALIBRATION**

1.1.1 Feeder and pre bin must be completely empty

1.1.2 Feeder should be in stop condition

1.1.3 Put the Rotor scale in Local mode

1.1.4 Prebin aeration must be off.

**1.2. ZERO CALIBRATION:**

1.2.1 Connect PHT to local panel

1.2.2 When PHT is connected Ctrl Y is displayed. and go to the parameter 3 CPI server press enter to get into CSC menu

1.2.3 Now PHT will show main menu, go to configuration menu and enter. Then it will show system parameter menu and enter

1.2.4 System would ask for free entry, enter yes, then come out, Scroll down to check weigher menu and enter, go to Calibrate menu and enter.

1.2.5 Scroll Down until the dead load setting is displayed press 2 and enter key to set the scale to zero.

1.2.6 Now display will show Zero value.

**1.2 SPAN CALIBRATION:**

1.2.1 Press down arrow key Calib.Setpoint is displayed

1.2.2 Place the weights evenly on the Rotor frame; the weight indication will start increasing.



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- 1.2.3 Enter the applied weight value and enter, calibrate is displayed
- 1.2.4 Calibration can be carried when the indication is more than the weights placed on the rotor frame. Else the parameters are to be checked.
- 1.2.5 Press 3 and Enter for span calibration. After calibration indication will display the exact weight placed on the rotor frame
- 1.2.6 As the weight is removed indication must read zero. This ends the calibration of Pre bin.
- 1.3 Record the observations in the Instrument calibration format F-1/WI-19(SP-8; AM-7)

**2.0 CONNECTED DOCUMENTS:**

F-1/WI-19(SP-8; AM-7)

CALIBRATION OF ROTOR SCALE PRE BIN  
CALIBRATION OF ROTOR SCALE CHECK BIN CALCINER FIRING

KILN FIRING BIN	CAPACITY 2.1 Ton
TEST WEIGHTS (TON)	TON (DISPLAY)
0.2	0.2
0.6	0.6
1.0	1.0
CALCINER FIRING BIN	CAPACITY 2.8 Ton
TEST WEIGHTS (TON)	TON (DISPLAY)
0.2	0.2
0.6	0.6
1.0	1.0