



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



Issue No. 01	Rev. No: 01	Effective Date: 01.01.2016	WI-8 (SP-8; AM-7)
Issued By: M.R		Approved By: HOD-INSTRUMENTATION	
CALIBRATION PROCEDURE OF WEIGH FEEDER			

The Instrument engineer takes action as follows, for calibration:

1.1 STATIC CALIBRATION PROCEDURE:

1.1.1 Weigh feeder must be selected in Volumetric mode.

1.1.2 Belt should be Empty condition

1.1.3 TARE ADJUSTMENTS:

1.1.3.1 Start Weigh Feeder at full speed without weight.

Set point must be 100% (P value in TPH)

1.1.3.2 IF TPH indication will appear "zero", no need to TARE adjustment

1.1.3.3 IF TPH indication will not appear "zero"

1.1.3.4 Go to calibration mode.

1.1.3.5 Press Tare

1.1.3.6 TPH rate indication becomes zero.

If not zero, repeat step 1 to 5.

1.1.4 SPAN ADJUSTMENT:

1.1.4.1 Start Weigh Feeder at full speed; apply known weight (as per calibration chart). TPH indication should indicate the reading corresponding to the weight applied as per chart. If not, adjust the span.

1.1.4.2 Run belt empty.

1.1.4.3 Apply the known test weights on both sides of load cell freely

1.1.4.4 IF TPH indication will appear corresponding to the weights applied, no need to span adjustment



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1.1.4.5 IF TPH indication not match with applied weights

1.1.4.6 Adjust the span in D02

$$\text{TPH} = (\text{TEST WEIGHT} / \text{WEIGHING ZONE}) * \text{BELT SPEED} * 3.6.$$

1.1.4.7 TPH indication will appear corresponding to the weights applied.

1.1.4.8 IF not, repeat from step 1 to 6

1.1.4.9 Record the observations in the Instrument calibration format F-1/WI-8(SP-8; AM-7)

2.0 CONNECTED DOCUMENTS:

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

Calibration of Weigh feeder.

LIMESTONE WEIGH FEEDER-1	CAPACITY 600 TPH
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TEST WEIGHTS in Kg	TPH
20.0	45.9
30.0	68.9
40.0	91.9

SWEETNER WEIGH FEEDER	CAPACITY 600 TPH
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TEST WEIGHTS in Kg	TPH
20.0	45.9
30.0	68.9
40.0	91.9

LIME STONE WEIGH FEEDER-2	CAPACITY 500 TPH
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TEST WEIGHTS in Kg	TPH
20.0	12.1
30.0	18.1
40.0	91.9

FIRECLAY WEIGH FEEDER	CAPACITY 50 TPH
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TEST WEIGHTS in Kg

20.0

30.0

TPH

20.2

30.2

COAL WEIGH FEEDER-1

CAPACITY 60 TPH

TEST WEIGHTS in Kg

10.0

20.0

30.0

TPH

10.08

20.16

30.24

COAL WEIGH FEEDER-2

CAPACITY 60 TPH

TEST WEIGHTS in Kg

10.0

20.0

30.0

TPH

10.08

20.16

30.24

CLINKER APRON FEEDER

CAPACITY 400 TPH

TEST WEIGHTS in Kg

20.0

30.0

40.0

TPH

10.0

15.0

20.0

WET FLY ASH WEIGH FEEDER

CAPACITY 150 TPH

TEST WEIGHTS in Kg

20.0

30.0

40.0

TPH

30.2

45.4

60.5

GYPSUM WEIGH FEEDER

CAPACITY 40 TPH

TEST WEIGHTS in Kg

20.0

30.0

40.0

TPH

4.9

7.3

9.8



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COAL WEIGH FEEDER-3

CAPACITY 10 TPH

TEST WEIGHTS in Kg

TPH

15.0

7.75

10.0

5.2

5.0

2.5