



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



Issue No. 01	Rev. No: 00	Effective Date: 01.07.2013	WI-23 (SP-8; AM-7)
Issued By: M.R		Approved By: HOD-INSTRUMENTATION	
CALIBRATION PROCEDURE OF BIN WEIGHING SYSTEM			

The Instrument engineer takes action as follows for calibration:

## **1 ZERO CALIBRATION**

- 1.1. Ensure the Bin weighing system in feed circuit is in stopped condition.
- 1.2. Inspect the Bin top and inside the bin in clean condition.
- 1.3. Ensure all the Connecting chute to bin free from the Point contact.
- 1.4. Check the CCR as well as LAPTOP reading and ensure Zero.
- 1.5. If it is not Zero, Press the TARE button for zeroing.
- 1.6. Place then Standard weight (one Ton) on Bin top and Ensure the bin weight in the CCR.
- 1.7. Remove the Standard weight and check the repeatability.
- 1.8. If there is any differences in Repeatability repeat the steps from 1.2 to 1.3

## **2. SPAN CALIBRATIONS:**

- 2.1. Ensure the Bin weight is ZERO.
- 2.2. Feed the material around 25 % of the Bin capacity and note down the reading.
- 2.3. Place the one Ton Standard weight on the Bin and ensure the weight increment of one Ton.
- 2.4. Remove the Standard weight and check the repeatability
- 2.5. Check the CCR as well as LAPTOP reading and ensure filled weight.
- 2.6. If there is any differences in Repeatability. Empty out the material and repeat the steps from  
1.2 to 1.3



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



Issue No. 01	Rev. No: 00	Effective Date: 01.07.2013	WI-23 (SP-8; AM-7)
Issued By: M.R		Approved By: HOD-INSTRUMENTATION	
CALIBRATION PROCEDURE OF BIN WEIGHING SYSTEM			

- 2.7. Feed the material around 50 % of the Bin capacity and note down the reading.
- 2.8. Place the one Ton Standard weight on the Bin and ensure the weight increment of one Ton.
- 2.9. Remove the Standard weight and check the repeatability.
- 2.10. Check the CCR as well as LAPTOP reading and ensure filled weight.
- 2.11. If there is any differences in Repeatability. Empty out the material and repeat the steps from 1.2 to 1.3