



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

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SOP for Mill & Press (HP-MP) 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: PLC restarted! Press Quit”
- Press **Reset** button
- Now it will display **“M01Mill: Synchronization necessary”**
- Press **“SYN”** for synchronization
- Do not press any other button. During process it will display as
“M15 Press: Active”
“M25 Gripper: Active”
“M09 Mill: Synchronization active”
“M20 Press : Synchronization Active”
“M18 : External Transport active” (If Ring cleaning activated)”
- During Operation It will display as
“M40: Please remove ring”
- Remove ring from Mill & Press outlet
- At the end you can see
“M36: Machine Ready”
- Now press **“Mode”** 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.