DALMIA CEMENT (B) LIMITED – CEMENT PLANT ARIYALUR INSTRUMENTATION DEPARTMENT			
Issue No. 02	**Rev. No: 00**	**Effective Date: 01.11.2019**	**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

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