



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



Issue No. 01	Rev. No: 00	Effective Date: 01.11.2010	WI-18 (SP-8; AM-7)
Issued By: M.R		Approved By: HOD-INSTRUMENTATION	
CALIBRATION PROCEDURE OF ROTOR SCALE			

The Instrument engineer takes action as follows for calibration:

1.1 STATIC CALIBRATION

- 1.1.1 Feeder must be completely empty
- 1.1.2 Feeder should be in stop condition
- 1.1.3 Slide gate above rotor should be in close condition
- 1.1.4 Put the Rotor scale in Local mode

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 weigh feed 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 Scroll down until check weight being displayed The Check weight input must match the Actual check weight, scroll down calibration is displayed



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- 1.2.2 Put the check weight in the eye bolt area, Press 3 and enter key to carry out span calibration now display will show pre calculated figure as per the chart.
- 1.2.3 To check the calibration, Press Ctrl A to enter main menu, Press down arrow key until display 1 parameter then Enter and press Down arrow key the load is displayed in Kg/Revolution Press down arrow key load will be displayed in Percentage (%)
- 1.2.4 Remove the test weight indication must go to 0.00 this finishes the calibration
- 1.3 Record the observations in the Instrument calibration format F-1/WI-18(SP-8; AM-7)

2.0 CONNECTED DOCUMENTS:

F-1/WI-18(SP-8; AM-7) CALIBRATION OF ROTOR SCALE
CALIBRATION OF ROTOR SCALE CALCINER FIRING
CALIBRATION OF ROTOR SCALE KILN FEED
KILN FIRING CAPACITY 16.6 TPH

TEST WEIGHTS
7.41 Kg

CALIBRATION SET POINT
22.68 Kg/u

CALCINER FIRING
TEST WEIGHTS
19.58 Kg

CAPACITY 23.8 TPH
CALIBRATION SET POINT
62.51Kg/u

KILN FEED
TEST WEIGHTS
60.14 Kg

CAPACITY 397 TPH
CALIBRATION SET POINT
220.33 Kg/u