



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

Issue No. 02	Rev. No: 00	Effective Date: 01.11.2019	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	CALIBRATION SET POINT
7.41 Kg	22.68 Kg/u

CALCINER FIRING	CAPACITY 23.8 TPH
TEST WEIGHTS	CALIBRATION SET POINT
19.58 Kg	62.51Kg/u

KILN FEED	CAPACITY 397 TPH
TEST WEIGHTS	CALIBRATION SET POINT
60.14 Kg	220.33 Kg/u