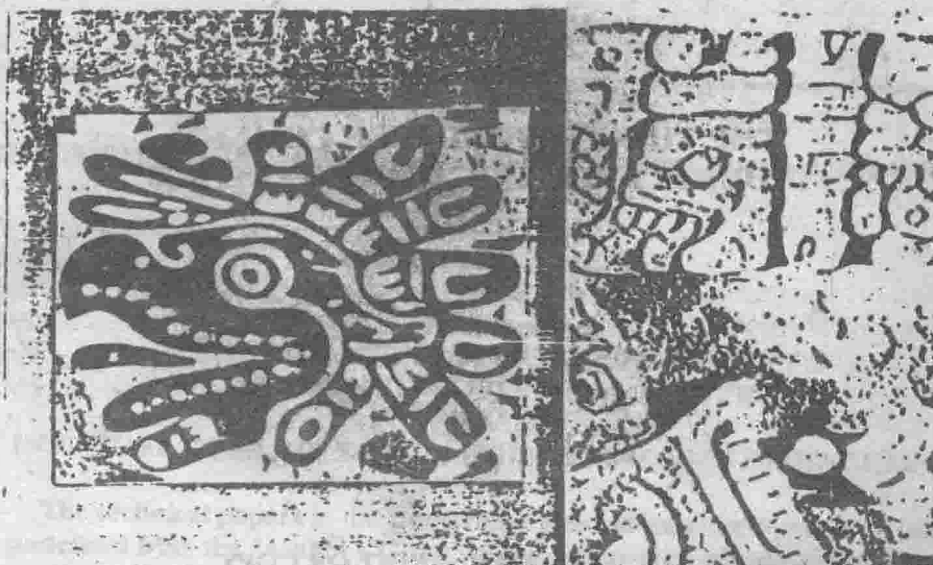


RECORD OF CONFERENCE PAPERS



IEEE Cement Industry Technical Conference XXXIII

Mexico City, Mexico May 21-23, 1991



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THE THIRTY-THIRD IEEE CEMENT INDUSTRY TECHNICAL CONFERENCE

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FOREWORD

THE THIRTY-THIRD IEEE CEMENT INDUSTRY TECHNICAL CONFERENCE

May 21-23, 1991
MEXICO CITY, MEXICO.

Sponsored by
THE INDUSTRY APPLICATIONS SOCIETY'S
CEMENT INDUSTRY COMMITTEE
OF THE
INSTITUTE OF ELECTRICAL AND ELECTRONICS ENGINEERS, INC.

The technical papers in the Conference Record have been prepared using guidelines from the "Author's Guide" of the Industry Applications Society (IAS) modified by the Cement Industry Committee. The IAS is comprised of twenty-eight Technical Committees including the Cement Industry Committee.

This year's Annual IEEE Cement Industry Technical Conference completes thirty-three years of such Conferences. This is the second time that Mexico has been selected as the site, the first being in 1974.

The papers included in this Record are written and are presented to comply with the scope for the Cement Industry Committee which has been established by the IEEE Industry Applications Society. In substance, this scope is:

"The development and application of electrical systems, apparatus, devices, and controls to the processes and equipment for which the emphases or dominant factors specifically relate to the cement manufacturing industry; the promotion of safe, reliable, and economic installations; the encouragement of energy conservation; and the creation of voluntary engineering standards and recommended practices."

The dedicated work by many Cement Industry Members supporting the activities of the Institute (IEEE) is appreciated. Thanks also to the many cement industry related firms & employees and others who attend this Thirty-third IEEE Cement Industry Technical Conference.

J.R. Treviño Salinas
Conference Chairman

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IEEE CEMENT INDUSTRY TECHNICAL CONFERENCE HISTORY

	YEAR	WHEN	WHERE	NATIONAL CHAIRMAN	PROGRAM COMMITTEE CHAIRMAN	APPROX. REG.
1st	1959	4/15-16/59	Allentown, PA	W.A. Allan	A.H. Huelsman	298
2nd	1960	5/17-19/60	Milwaukee, WI	W.A. Allan	V.B. Murdock	316
3rd	1961	4/18-20/61	Detroit, MI	J.F. Hlower	L.E. Swanson	307
4th	1962	4/3-5/62	St. Louis, MO	J.F. Hlower	J.B. Woodward	437
5th	1963	4/23-25/63	Cleveland, OH	R.J. Jager	G.E. MacDonald	304
6th	1964	4/14-17/64	Pasadena, CA	R.J. Jager	D.B. Carson	433
7th	1965	5/11-13/65	Allentown, PA	H.P. Cassel	C.A. Zimmerman	601
8th	1966	5/17-19/66	Denver, CO	H.P. Cassel	W.A. Walking	436
9th	1967	5/16-19/67	Albany, NY	L.E. Swanson	J.R. Kelley, Jr.	479
10th	1968	5/20-24/68	St. Louis, MO	L.E. Swanson	A.C. Lordi	515
11th	1969	5/13-15/69	Toronto, Ontario	A.C. Lordi	J.A. Allan	501
12th	1970	5/12-14/70	Indianapolis, IN	A.C. Lordi	G.F. Messinger	453
13th	1971	5/10-13/71	Seattle, WA	J.A. Allan	F.J. Bauer	370
14th	1972	5/16-18/72	Detroit, MI	J.A. Allan	L.E. Swanson	464
15th	1973	4/30-5/3/73	Miami, FL	R.P. Kistler	L.W. Copple	503
16th	1974	5/13-16/74	Mexico City, Mexico	R.P. Kistler	R.J. Plass	676
17th	1975	5/5-8/75	Montreal, Quebec	F.J. Bauer	M.S. Jackson	583
18th	1976	5/17-20/76	Tucson, AZ	F.J. Bauer	J.A. Vidergar	587
19th	1977	5/16-19/77	Omaha, NE	R.C. White	F.E. Staples & R.F. Palmer	570
20th	1978	5/15-18/78	Roanoke, VA	R.C. White	K.C. Wiles	677
21st	1979	5/20-24/79	Tarpon Springs, FL	Jay Warshawsky	F.W. Cohrs	829
22nd	1980	5/19-22/80	Toronto, Ontario	Jay Warshawsky	M.E. Wrinkle	839
23rd	1981	5/12-14/81	Lancaster, PA	L.L. Warner	N.W. Biege	841
24th	1982	5/24-26/82	Vancouver, BC	L.L. Warner	B.T. Price	595
25th	1983	5/22-27/83	San Antonio, TX	N. Roistacher	U. Alsguth	622
26th	1984	5/22-24/84	Anahemim, CA	N. Roistacher	J.A. Vidergar	563
27th	1985	5/20-22/85	New Orleans, LA	R.J. Kregel	L.C. Cockrell	595
28th	1986	5/19-22/86	Salt Lake City, UT	R.J. Kregel	R.W. Riegel	490
29th	1987	5/26-28/87	San Francisco, CA	R.F. Palmer	C.D. Maars	557
30th	1988	5/24-26/88	Quebec City, Quebec	R.F. Palmer	A. Morneau	560
31st	1989	5/15-17/89	Denver, CO	Ib Bentzen-Bilkvist	Ed Parker	546
32nd	1990	5/22-24/90	Tarpon Springs, FL	Ib Bentzen-Bilkvist	E.A. Buehler	
33rd	1991	5/21-23/91	Mexico City, Mexico	N.W. Biege	Jose R. Treviño S	
34th	1992		Dallas, Tx	N.W. Biege	Patton Caldwell	

TABLE OF CONTENTS

AUTOMATION

AUTOMATION SYSTEMS AND INTEGRATED CONTROLS USED AT DAVENPORT CEMENT COMPANY BUFFALO PLANT Steve Bassler, and George Fergades, Davenport Cement	13
--	----

ROBOTICS-AN EFFICIENT TOOL FOR LABORATORY AUTOMATION Steen Pedersen, F.L. Smidth & Co. A/S Wilfred Gecks, Dyckerhoff Cement	39
--	----

CENTRAL CONTROL SYSTEMS - DEALING WITH THE OPTIONS Jeffrey P. Kemmerer, Fuller Company	49
--	----

SELECTING A MAN/MACHINE INTERFACE FOR A PLC BASED PROCESS CONTROL SYSTEM Leroy Cockrell, Holnam Inc. Denver, Colorado Tom Sanders, Holnam Inc. Dundee, Mich.	65
---	----

DRIVES AND RELATED PRODUCTS

DEVELOPMENT OF MILL DRIVES FOR THE CEMENT INDUSTRY Peter Thomas, General Electric	101
---	-----

COOLER HYDRAULIC DRIVE MODIFICATION AT CEMENTOS MEXICANOS C. Cohrs and K. Pater, Claudius Peter Inc. M.O. Morales, Cementos Mexicanos	119
--	-----

INTEGRATED VARIABLE SPEED DRIVES - THE ENERGY SAVERS R.A. Errath, Asca Brown Boveri	135
---	-----

GENERAL PRACTICES AND PROCESS EQUIPMENT

BURNING WASTE FUELS IN CEMENT KILNS Edward Morton, Cemtech	153
NEW DESIGN CONCEPTS IN THE RECUPERATING ZONE OF GRATE CLINKER COOLERS Shane Alesi, Fuller Company	171
SO₂ EMISSIONS HISTORY AND SCRUBBING SYSTEM SANTA CRUZ PLANT CALIFORNIA Satish Sheth, RMC Lonestar	191
EFFECT OF EPA REGULATIONS ON PLANT DESIGN John Macfadyen, Penta Engineering	229
SELECTION AND APPLICATION OF ROLLER PRESS FOR RAW MEAL PREPARATION AT ALPENA Alan Kreisberg, Lafarge Canada	245
DOMES SILOS FOR CEMENT TERMINALS Armando García Segovia y Frans Van Der Linden, Cemex, S.A.	267
FAST TRACK PROJECT MANAGEMENT Frans Van Der Linden, Cemex, S.A.	293
HIGH EFFICIENCY CLASSIFIERS AS FLASH DRYERS FOR WET RAW MATERIALS Tom Gibbons, Phoenix Cement Ove Lars Jepsen, Fuller Company	323
PROBLEMAS WITH HIGH EFFICIENCY SEPARATORS Eric Dauphinee, Holderbank Consulting, Canada Kurt Brietschmid, Holderbank, Switzerland	339

POWER GENERATION, DISTRIBUTION AND RELATED PRODUCTS

DEVELOPMENT AND IMPLEMENTATION OF A HARMONIC EXPERT SYSTEM

M.S. Farahat, D.S. Shipp, L.M. Collins
E.C. Strycula, N.H. Woodley and D.A. Bauman
Westinghouse Electric Corp.

357

NETWORKING COMMUNICATION FOR POWER MONITORING PROTECTION AND CONTROL OF MILL POWER DISTRIBUTION

C.J. Krug and B.R. Quayle
Westinghouse Electric Corp.

375

A PLAN UPGRADING DISTRIBUTION POWER SYSTEMS AT SOUTH DAKOTA CEMENT

Mike Pendo, South Dakota Cement

385

THE ELECTRICAL POWER DISTRIBUTION SYSTEM FOR THE NON-ELECTRICAL ENGINEER

R.A. Haas and M. Klova, Lehigh Portland Cement

407

MAINTENANCE AND SAFETY

ELECTRO MAGNETIC RADIATION - ITS POSSIBLE HEALTH EFFECTS ON HUMAN BEINGS

Terry L. Tyson, Livingstone Graham Inc.

453

MODERN TUBE MILL DESIGN AND ITS INFLUENCE ON MAINTENANCE REQUIREMENTS

Johann Knecht, Krupp Polysius AG

471

CO-PROCESSING: - MORE THAN MEETS THE EYE

Arthur J. Helmstetter, Systech Environics Corp.

485

ENVIRONMENTAL TRENDS IN THE 1990'S

Douglas Mac Iver, Southwestern Portland Cement

503

AUTOMATION

FOR PRESENTATION AT THE
CEMENT INDUSTRY CONFERENCE
MAY 30 - 31, 1991
MEXICO CITY, MEXICO

**AUTOMATION SYSTEM AND INTEGRATED
CONTROLS USED AT DAVENPORT CEMENT COMPANY
BUFFALO PLANT**

ABSTRACT

**AUTOMATION SYSTEM AND INTEGRATED
CONTROLS USED AT DAVENPORT CEMENT COMPANY**

BUFFALO PLANT

by

**Steven L. Bassler
George J. Fergades**

DAVENPORT CEMENT COMPANY

INTRODUCTION

There are many computer based control systems available on the market today. Following the design of a new facility or the upgrading of an older one, selection of the control system is an important decision.

**FOR PRESENTATION AT THE
IEEE CEMENT INDUSTRY CONFERENCE
MAY 26 - 30, 1991
MEXICO CITY, MEXICO**

1. System reliability and performance history.
2. Control philosophy to be utilized at the facility.
3. System Master/Receive fail-over capability.
4. Type of operator interface.
5. Ease of system programming with flexibility to make changes with on-line.
6. Equipment environmental considerations.
7. Training and vendor support.

After comparing these initial hardware and software problems, the distributed control computer system as it is today is found to be both reliable and easy to work with.

**AUTOMATION SYSTEM AND INTEGRATED
CONTROLS USED AT DAVENPORT CEMENT COMPANY
BUFFALO PLANT**

ABSTRACT

The type of control system that is used to operate a modern cement plant can be obtained and installed in many different configurations.

This paper will describe the automation system with its integrated controls presently in use at the Buffalo plant of Davenport Cement Company. Following a brief description of the plant itself, the focus of the following discussion will be to describe the hardware and software control strategies being used.

The conclusion will indicate the success obtained at the Buffalo plant by using the main distributed control system, in combination with programmable controllers, to control every aspect of the cement manufacturing operation.

INTRODUCTION

There are many computer based control systems available on the market today. During the design of a new facility or the upgrading of an older one, selection of the control system is of utmost importance.

Some of the major criteria during consideration of a control system should be:

1. System reliability and performance history.
2. Control philosophy to be utilized at the facility.
3. System Master/Reserve fail-over capability.
4. Type of operator interface.
5. Ease of system programming, with flexibility to make changes while on line.
6. Equipment environmental considerations.
7. Training and vendor support.

After conquering some initial hardware and software problems, the distributed control computer system as it exists today was found to be both reliable and easy to work with.

A. Plant Overview

The existing Davenport Cement Company plant located at Buffalo Iowa, had its origins in a plant that was built in the 1920's. At that time it was called Dewey Portland Cement Company.

The preliminary engineering for a new facility was started in 1978 (figure 1). Construction was also started in that same year, with an estimated project completion by late 1981. The primary crusher was run in April of 1981 and the first clinker was produced on December 28, 1981. The facility (which is a preheater, precalciner plant) was designed to produce 850,000 TPY of finished cement using the following major equipment:

Primary Crusher

The limestone and clay raw materials are crushed in a 1750 hp impactor type crusher rated at 1300 TPH of minus 3 1/2" diameter rock.

Raw Grinding

The crushed rock is then ground using a 1500 hp roller mill that has a capacity of 230 tons per hour.

Kiln And Preheater

The kiln measures 197 ft by 13 ft. It is fed from a four stage preheater/precalciner that rises to a height of 320 ft.

Finish Mill

Finish grinding is accomplished by means of a 51 ft long, 15 ft diameter two compartment ball mill. The 7000 hp mill has a capacity of approximately 150 tons per hour.

Automation And Control System

The main process control system is a L&N CODIL VI distributed control system.

The balance of this paper will outline and discuss the distributed control concept presently in use at our manufacturing facility.