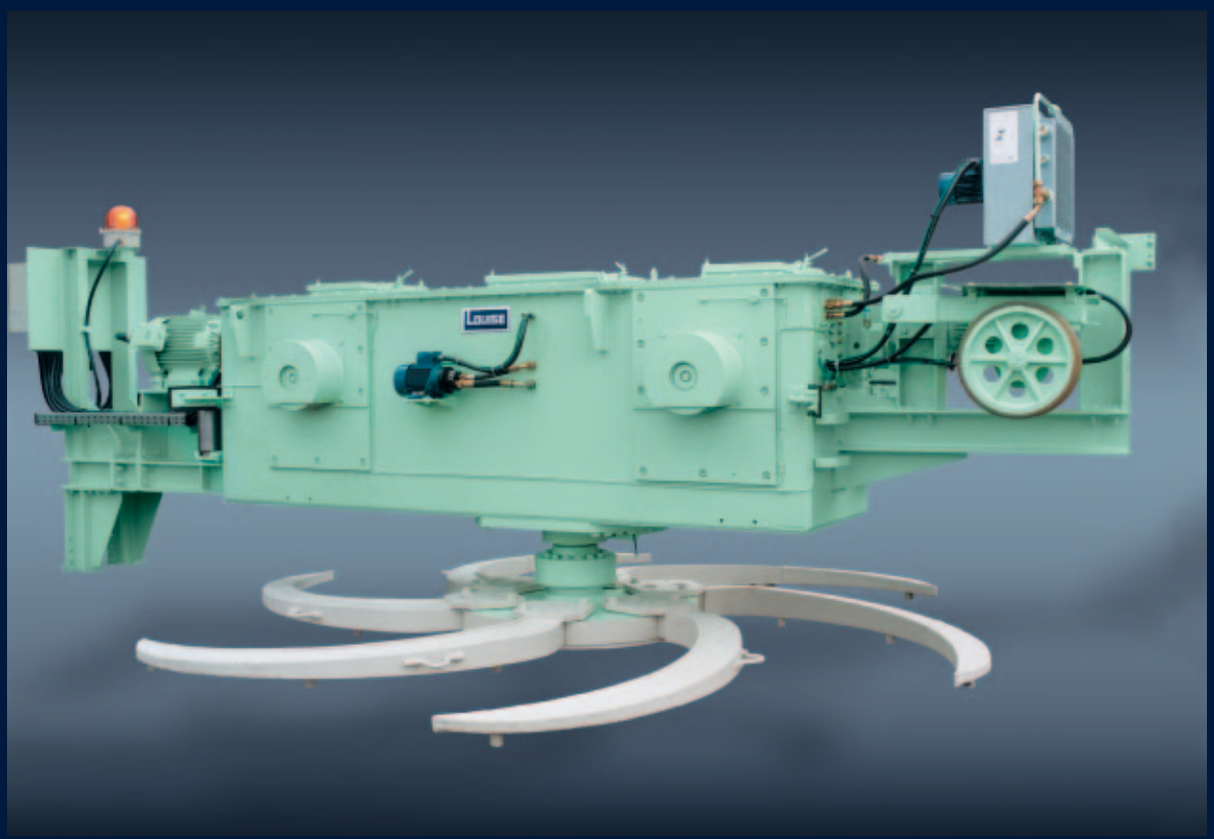
WE CONVEY QUALITY



ROTARY DISCHARGE MACHINE

AUMUND

CONTENTS

ROTARY DISCHARGE MACHINES

For a variety of applications wherever difficult bulk material needs to be discharged from

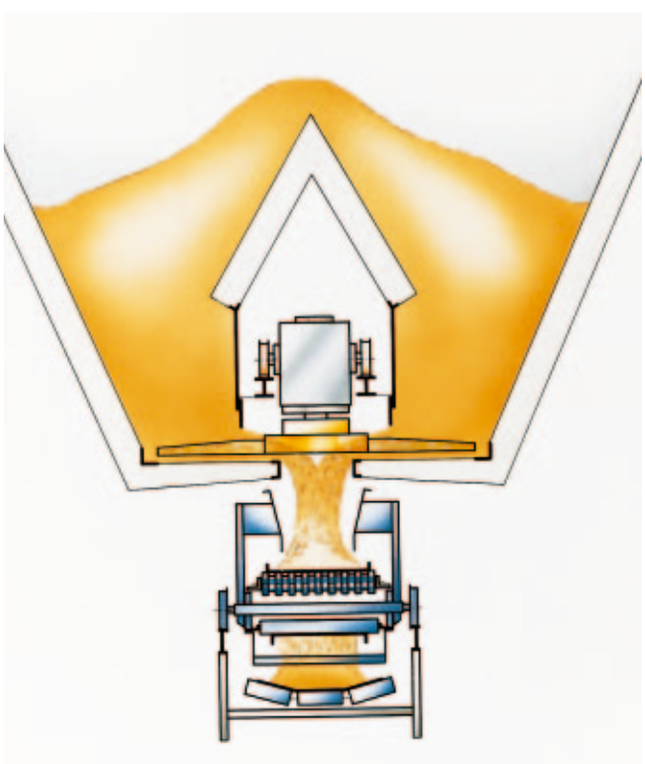
- **Rectangular hoppers**
- **Open stockpiles**
- **Large cylindrical silos**

All LOUISE Rotary Discharge Machines feature the logarithmically shaped discharge arms and automatic operation including reverse travel.

Three basic alternatives:
- **Block Model type BEW-BL**
- **Low Profile Model type BEW-FL**
- **Rotating Model type BEW-K**

Materials which can be handled:

- **FGD-gypsum**
- **Coal**
- **Gypsum**
- **Limestone**
- **Lignite**
- **Clay**
- **Marl**
- **Petcoke**



ROTARY DISCHARGE MACHINE TYPE BEW-BL

Double side discharge for rectangular hoppers

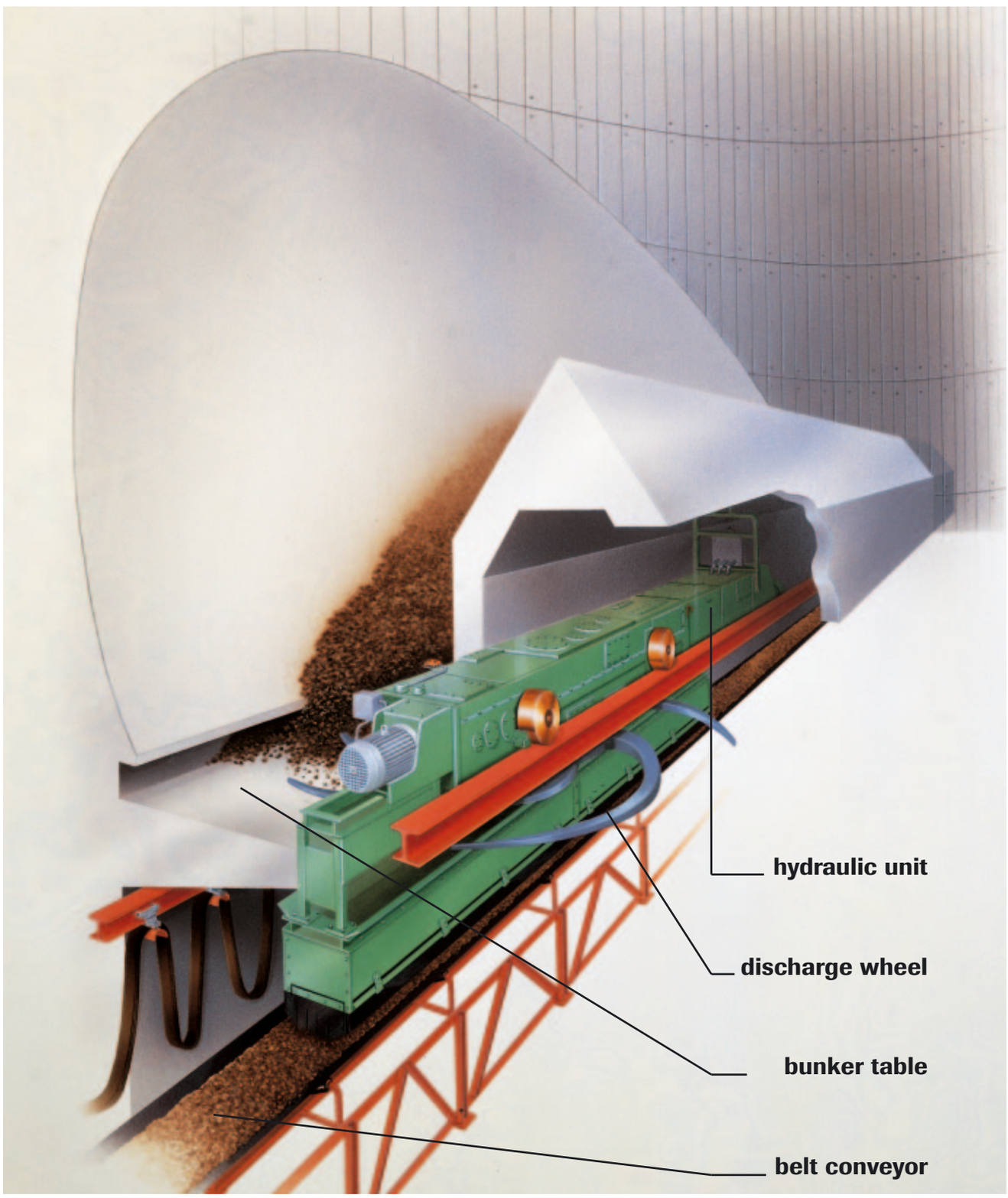
The block-type Rotary Discharge Machine is designed for double side discharge.

All drive components are located in a solid casing.

The machine moves inside a tunnel and reclaims the product from both sides.

The hydraulic unit or the frequency controller allows to adjust the reclaim capacity.

ROTARY DISCHARGE MACHINE TYPE BEW-BL

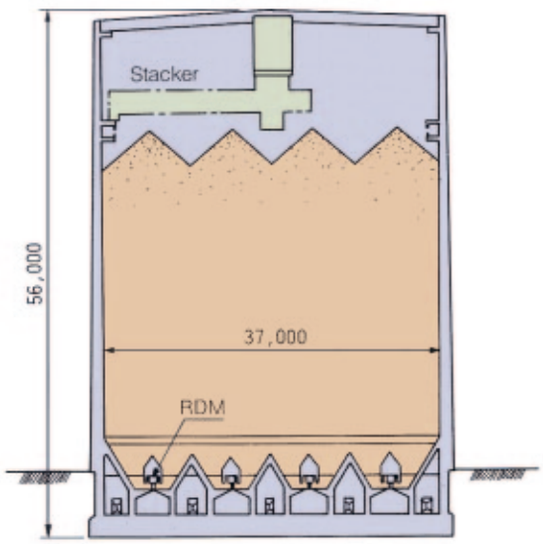


Coal storage and reclaim

The Ishikawa power plant, Okinawa - Japan, features four silos with a storage volume of 50,000 m³. These silos, ranging among the largest worldwide, were built by Mitsui Construction Co. Ltd.

The coal is discharged by four Rotary Discharge Machines arranged parallel to each other. Each discharge machine travels on rails installed in a concrete tunnel covering the whole length of the silos. This arrangement allows each individual machine to discharge from either one of the four silos. The travel distance exceeds 200 m.

The block-type discharge machine is designed in such a way that the coal is reclaimed from both-sides of the shelf. Each machine has a reclaim capacity of 40 t/h – 400 t/h and both the discharge wheel and the travel mechanism are hydraulically driven and adjustable. The discharge wheel's diameter of 4 m allows to cut deeply into the material column, an important feature to prevent bridging of the stored product. A material guide installed on the BEW serves as dust cover and guides the product onto the belt conveyor located underneath the Rotary Discharge Machine.



Cross section of Okinawa coal silo

Storage capacity of the 4 silos	50.000 m³
Diameter of each silo	37 m
Height of each silo	56 m
Discharge capacity of each discharge machine	adjustable from 40 t/h to 400 t/h
Installed power	37 kW
Travel speed	0.92 to 3.72 m/min
Diameter of discharge wheel	4.000 mm

Denpatsu coal-fired

At the **Denpatsu coal-fired power plant** of Electric Power Development Co. Ltd., the coal storage silos feature 8 Rotary Discharge Machines each reclaiming 1,000 t/h coal from two rows of 4 silos each.

Shikoku plant

At the **Shikoku plant**, 8 Rotary Discharge Machines reclaim from 2 rows of 2 silos each.

ROTARY DISCHARGE MACHINE TYPE BEW-BL

Coal Handling - American Superior Midwest Energy Terminal, Wisconsin - USA

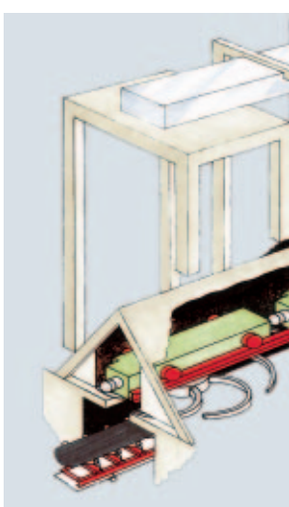
The coal extracted in open-cast mining is stored on an open stockpile during the winter season when shipping service is interrupted due to low temperatures. 6.5 million tons of coal can be stored on this open stockpile until the end of the winter season.

A total of 9 Rotary Discharge Machines reclaim the coal from this stockpile. Three machines each work in one unit and achieve a total reclaim capacity of 10,000 t/h. With this capacity and a discharge wheel diameter of 4 m, they range among the best performing reclaimers worldwide.

The discharge machines travel on rails inside a tunnel with a cone-shaped roof, continuously discharging the coal onto a belt conveyor also installed in the tunnel. When travelling back and forth, the discharge arms dig deeply into the coal through slots arranged in the tunnel. Each rotary discharge machine is driven by a 2.2 kW motor and travels the distance of 360 m with a velocity of 0.9 m/min.

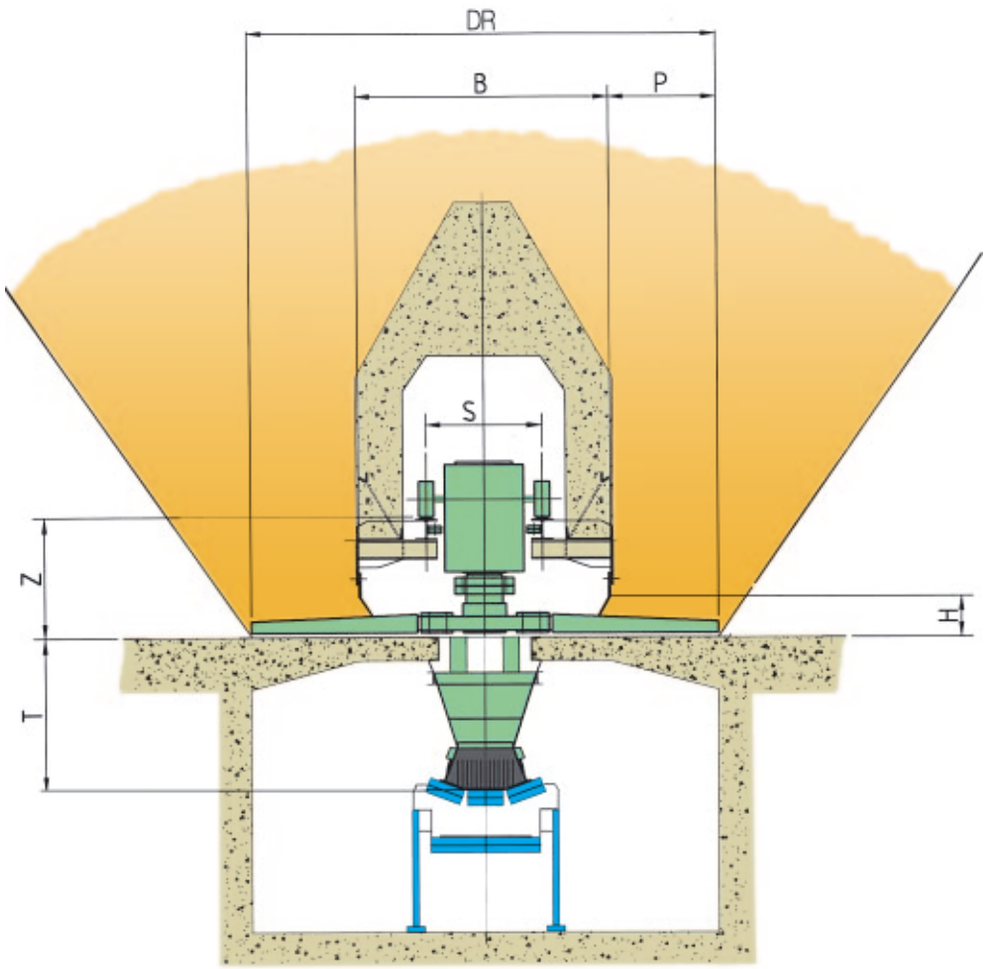
In order to achieve a high torque with only 1 to 10 rpm, the discharge wheels are actuated by hydraulic units with 110 kW electric motor. If the discharge machines encounter high resistance due to the frozen status of the coal, the pressure sensors actuate the reverse mode and restart the machine. The drive unit is installed inside a compact casing with easy access.

The machines are in operation since 1976 and demonstrate the high availability of the LOUISE Rotary Discharge Machines.



Storage capacity	open stockpile, 6.5 million tons
Stockpile length	360 m
Discharge capacity of each discharge machine	3.300 t/h
Installed power	150 kW
Rotating speed of discharge wheels	adjustable from 1 to 10 rpm
Diameter of discharge wheels	4.000 mm
Travel speed	0.9 m/min

DATA SHEET



Rotary Discharge Machine type BEW-BL

discharge wheel diameter	discharge opening height	penetration depth	cone-shaped tunnel width	rail to hopper shelf height	hopper shelf to belt feeder height	theoretical capacity Q (m^3/h) both-sided discharge with wheel speed n (rpm) range 1:10 circular speed at wheel tip		max. admissible travel speed
DR (mm)	**H** (mm)	**P** (mm)	**B** (mm)	**Z** (mm)	**T** (mm)	**U = 0,3** m/s m/h (m/s)	**U = 0,3** m/s m/h (m/s)	**V** (m/min)
2000	200	350	1300	600	1000	94 (2,90)	940 (29,0)	6,35
2500	250	450	1600	775	1100	138 (2,28)	1380 (22,8)	6,35
3000	300	700	1600	775	1100	225 (1,91)	2250 (19,1)	6,35
4000	400	1000	2000	1030	1200	410 (1,43)	4100 (14,3)	6,35
5000	500	1150	2700	1030	1200	580 (1,14)	5800 (11,4)	6,35

Standard dimensions and capacity. Further dimensions and capacities on request.

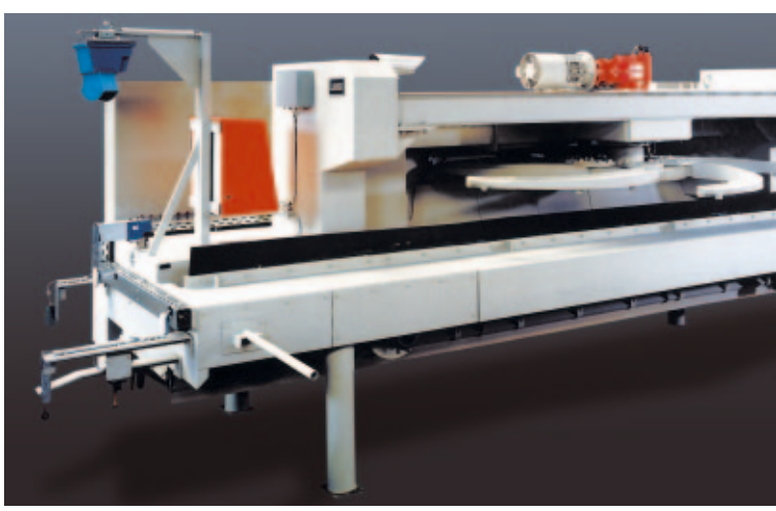
BEW with single-side discharge

Discharge wheel with six arms, each with wear resistant front plate and armoured tip.

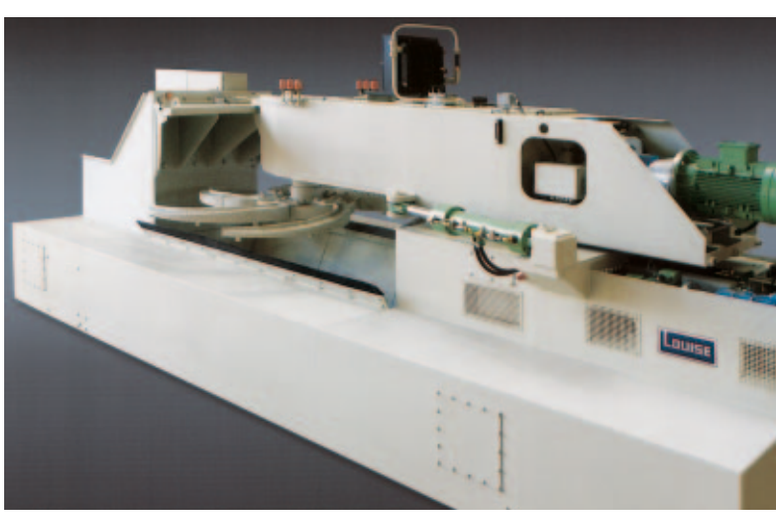
View onto discharge wheel

BEW with single side discharge

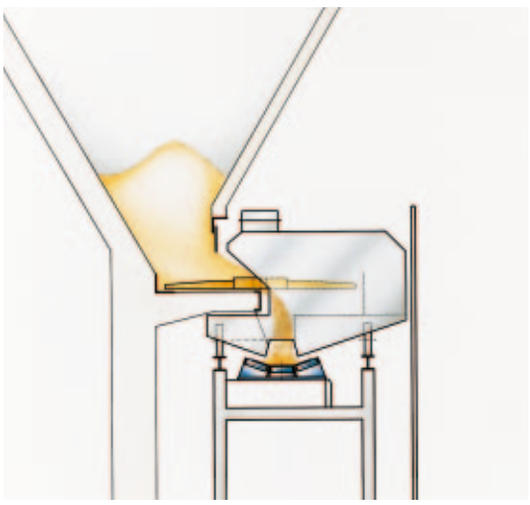
- Festoon towing arm
- Safety limit switch
- Anti-collision sensor
- Travel distance sensor
- Travel distance limit switch
- Local control box
- Discharge wheel dust cover



BEW with single-side discharge



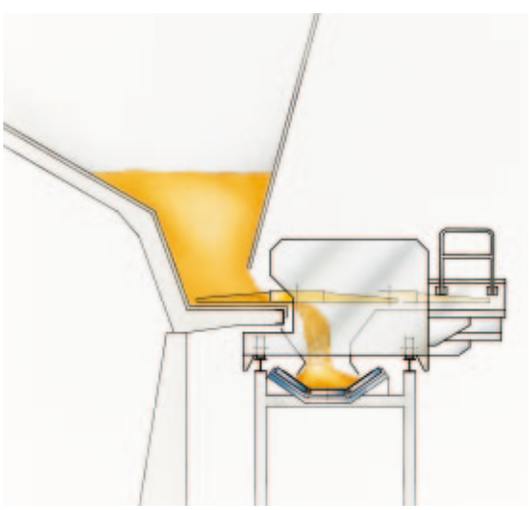
BEW with single side discharge and double swivel mechanism



ROTARY DISCHARGE MACHINE TYPE BEW-FL

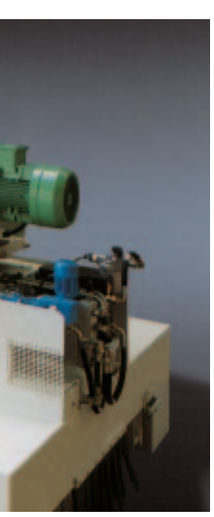
BEW with single-side discharge

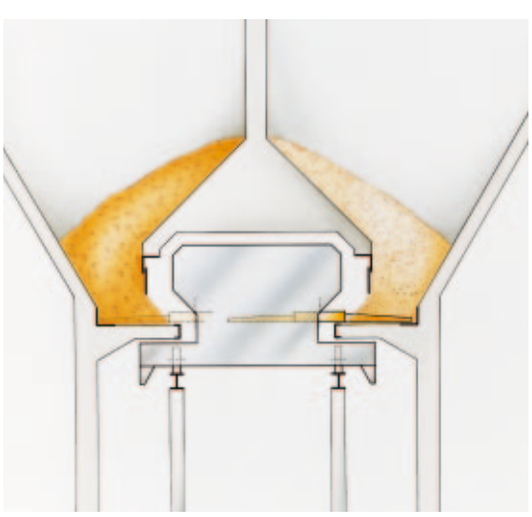
Installed on the belt conveyor supporting structure, the Rotary Discharge Machine moves along the hopper shelf and reclaims the bulk material. The drive unit and electrical package are safely stored inside the dust-tight casing of the machine.



BEW with single swivel drive for single-side discharge

Installed on the belt conveyor supporting structure, the Rotary Discharge Machine travels to defined areas of the hopper where it reclaims the bulk material. A high speed mode in the travel drive allows to reach these areas quickly. The main drive with all its components forms a swivel unit installed on the trolley.





BEW with double swivel drive for single side discharge on both sides

Installed on the belt conveyor supporting structure, the Rotary Discharge Machine travels to defined areas of the hopper. The discharge wheel swivels between the shelfs on both sides of the hopper. A high speed mode in the travel drive allows to reach these areas quickly. The main drive with all its components forms a swivel unit installed on the trolley.

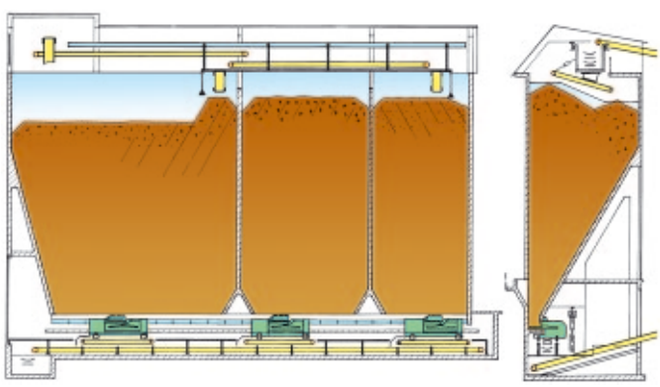
ROTARY DISCHARGE MACHINE TYPE BEW-FL WITH WEIGH FEEDER

Raw material handling in a Cement Plant

Three Rotary Discharge Machines are installed underneath a row of hoppers storing a total of 9,000 t of limestone, marl and dolomite. In order to obtain the required mixture directly when reclaiming the different raw materials from the hoppers for subsequent mill feeding, the reclaim capacity of the three discharge machines is controlled by a Weigh Belt Feeder forming part of the mobile discharge machine.

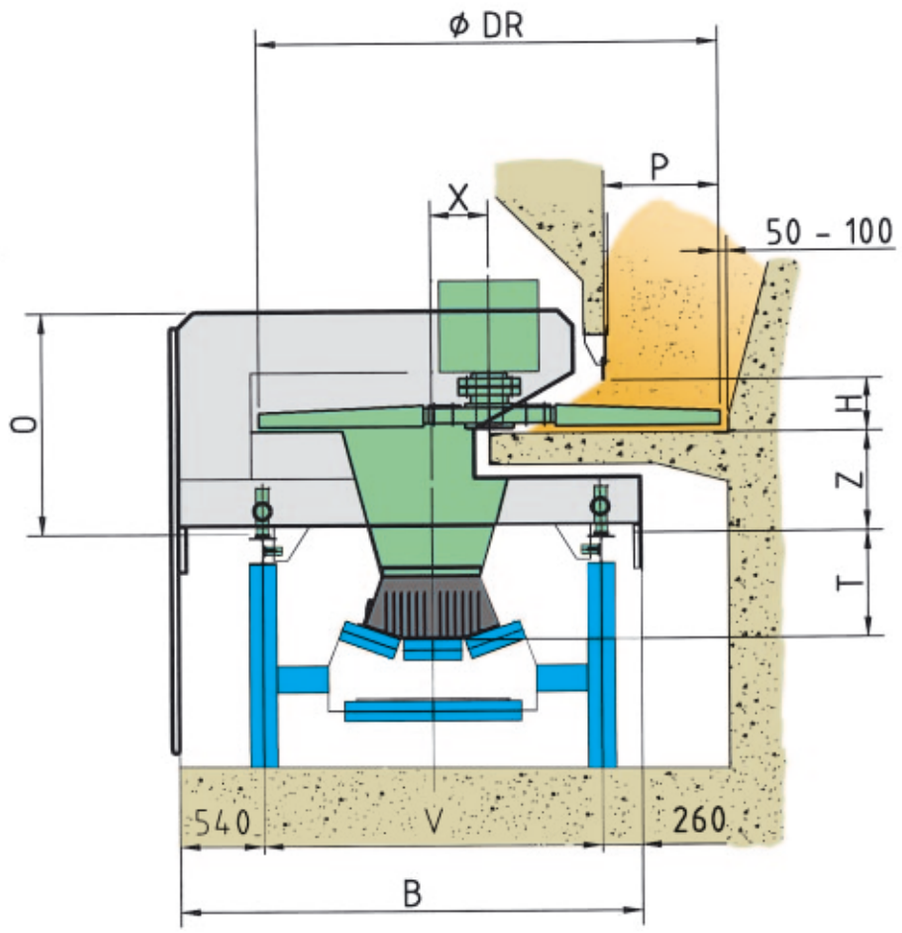
The actual volume to be reclaimed by the discharge machine from the three hoppers is determined in the laboratory. Adequate adjustment of the total reclaim capacity is made in the mill control room. The mixture ratio remains unchanged.

On account of the homogeneous volumetric reclaim through the hopper openings, an accuracy of +/- 1% can be achieved with the Weigh Feeders.



Storage capacity	9.000 t
Material	limestone and marl of 0 – 60 mm
Humidity	max. 14%
Capacity of each discharge machine	30 - 180 t/h
Installed power	20 kW
Rotating speed of discharge wheels	adjustable from 0.5 to 5 rpm
Travel speed	1 and/or 0.45 m/min
Weigh belt feeder width	800 mm

DATA SHEET



Rotary Discharge Machine – Low Profile Model

discharge wheel diameter	discharge opening height	penetration depth	overall width	overall height	track	hopper shelf to rail height	rail to belt feeder height	theoretical capacity Q (m^3/h) single-side discharge with wheel speed n (rpm) range 1:10 circular speed at wheel tip		max. admissible travel speed
DR (mm)	**H** (mm)	**P** (mm)	**B** (mm)	**O** (mm)	**V** (mm)	**Z** (mm)	**T** (mm)	**U = 0,3** m/s m/h (m/s)	**U = 0,3** m/s m/h (m/s)	**V** (m/min)
2000	200	400	2300	1450	1500	600	500	47 (2,90)	470 (29, 0)	6,35
2500	250	450	2650	1500	1850	650	550	69 (2,28)	690 (22,8)	6,35
3000	300	700	3000	1600	2200	650	700	112 (1,91)	1120 (19,1)	6,35
3500	350	800	3300	1700	2500	700	750	151 (1,63)	1510 (16,3)	6,35
4000	400	1000	3600	1850	2800	750	800	205 (1,43)	2050 (14,3)	6,35

Standard dimensions and capacity. Further dimensions and capacities on request.

ROTATING ROTARY DISCHARGE MACHINE TYPE BEW-K

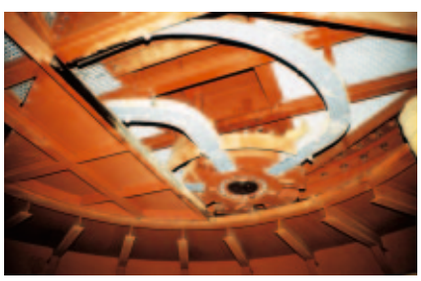
For large silos with a 5 m to 12 m diameter

The discharge wheel undercuts the material column and guides the material to the central outlet chute.

- **First in / First out**
- **Proportional reclaim**
- **Simultaneous feeding and discharge**
- **Easy access**

ROTATING ROTARY DISCHARGE MACHINE

Culley Power Station, Indiana – USA

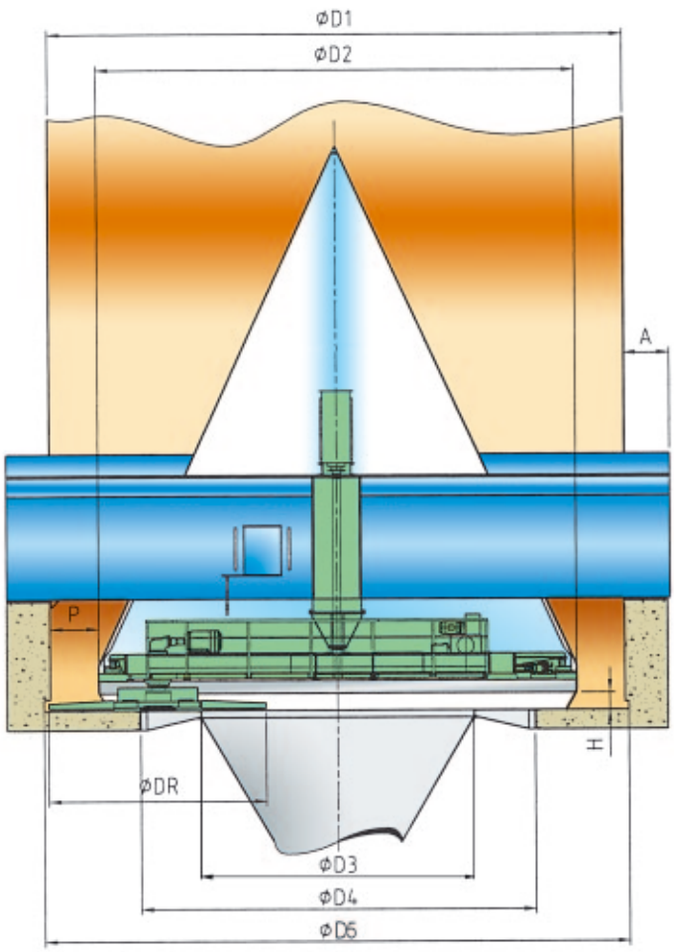


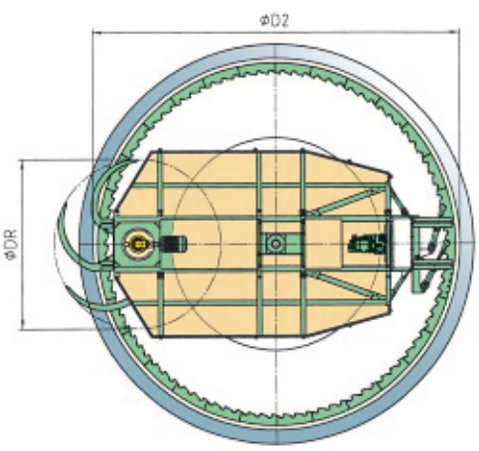
In the coal-fired plant in Indiana the FGD-gypsum, a by-product of the flue gas desulphurisation process, is stored in concrete silos. With an average humidity of 8 – 10%, sometimes even 15%, the FGD-gypsum is a heavy and sticky material with poor flow characteristics. The exact data of this material were determined by tests carried out in the LOUISE laboratory and the reclaim of each silo is now performed with a rotating rotary discharge machine designed to suite the specific characteristics revealed by these tests.

Each machine reclaims a total of 500 t/h, a capacity reached within 15 seconds, and loads onto 20 ton trucks. With normal loading conditions, the material volume of each silo is unloaded within 8 hours. In order to provide easy access, the discharge machine bottom and outlet chute are fitted directly underneath the discharge arms. The bottom rotates with the discharge wheel and the machine may be entered from the side opposite to the discharge arms.

Storage capacity	2 silos of 1.000 m^3 each
Diameter of each silo	8 m
Height of each silo	20 m
Discharge capacity of each discharge machine	500 t/h
Installed power	75 kW
Rotating speed of discharge wheel	adjustable from 0.3 to 3 rpm
Diameter of discharge wheel	4.500 mm

ROTATING ROTARY DISCHARGE MACHINE TYPE BEW-K





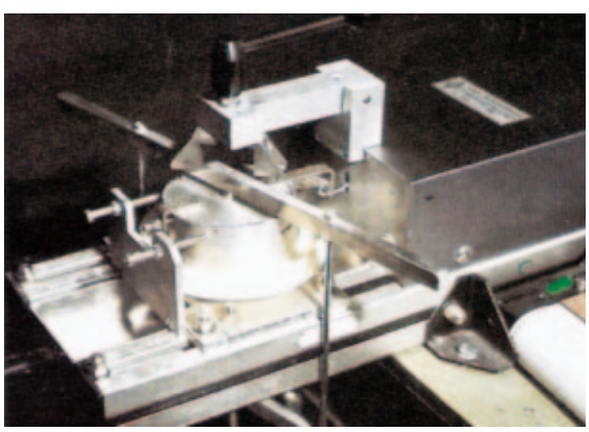
Rotating Rotary Discharge Machine type BEW-K

diameter silo	diameter discharge wheel	diameter cone	diameter floor ring opening	diameter concrete floor opening	diameter incl. undercut	max. protrusion of cone girder	discharge opening height	penetration depth	theoretical capacity Q (m³/h) with wheel speed n (rpm) range 1:10 circular speed at wheel tip	
D1 (mm)	**DR** (mm)	**D2** (mm)	**D3** (mm)	**D4** (mm)	**D5** (mm)	**A** (mm)	**H** (mm)	**P** (mm)	**u = 0,3** (m/s)	**u = 3,0** (m/s)
5000	3000	3600	1200	1950	5140	600	300	700	112 (1,91)	1120 (19,1)
6000	3600	4400	1300	2350	6140	700	350	800	155 (1,67)	1550 (16,7)
8000	4500	6000	2200	4750	8140	900	450	1000	247 (1,27)	2470 (12,7)
10000	4500	8000	3700	6250	10140	900	450	1000	247 (1,27)	2470 (12,7)
12000	4500	10000	5700	8250	12140	900	450	1000	247 (1,27)	2470 (12,7)

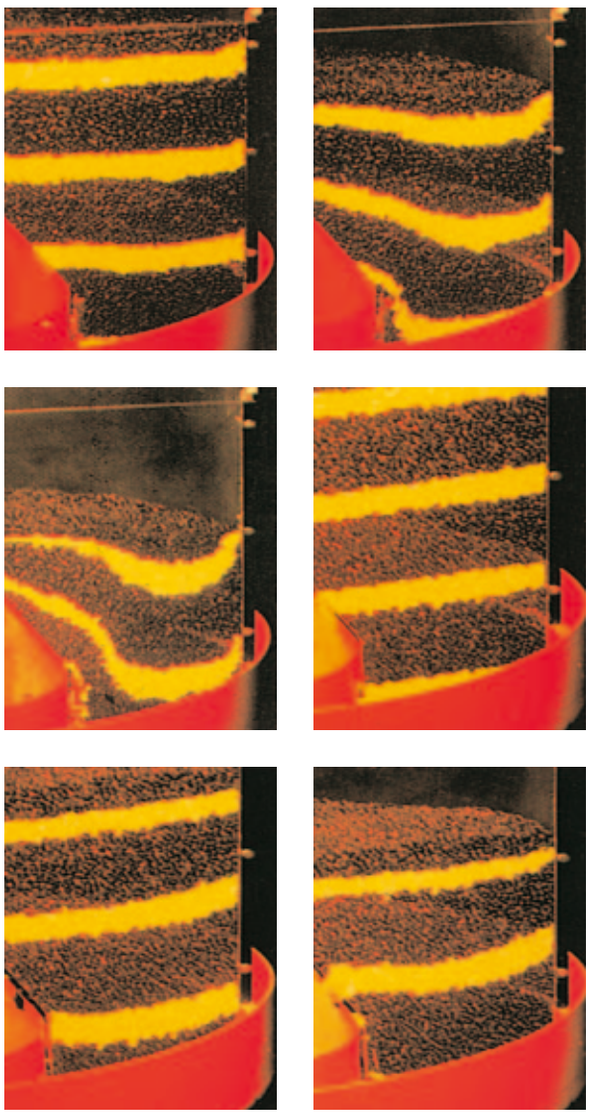
Standard dimension and capacity. Further dimensions and capacities on request.

BULK MATERIAL TESTING IN OUR LABORATORY

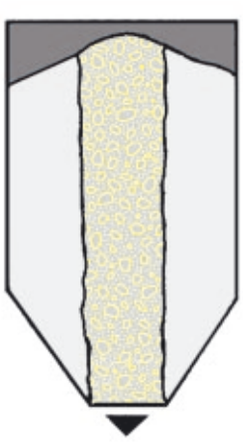
To determine the physical and mechanical properties and behaviour of specific bulk materials, our laboratory incorporates a large variety of testing equipment. Various test methods allow to determine the correct application of our products, e.g. shear testing.



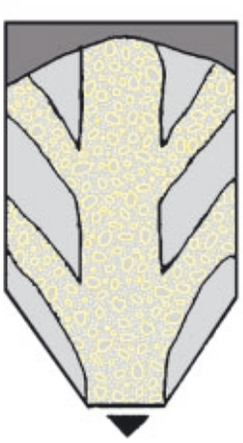
Jennicke shear cell



Bulk material tests

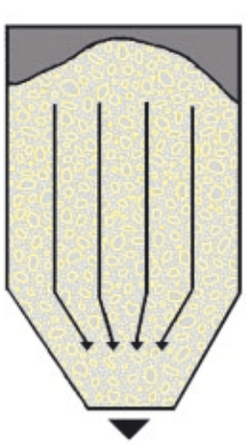


Ratholing



Core flow

Bridging



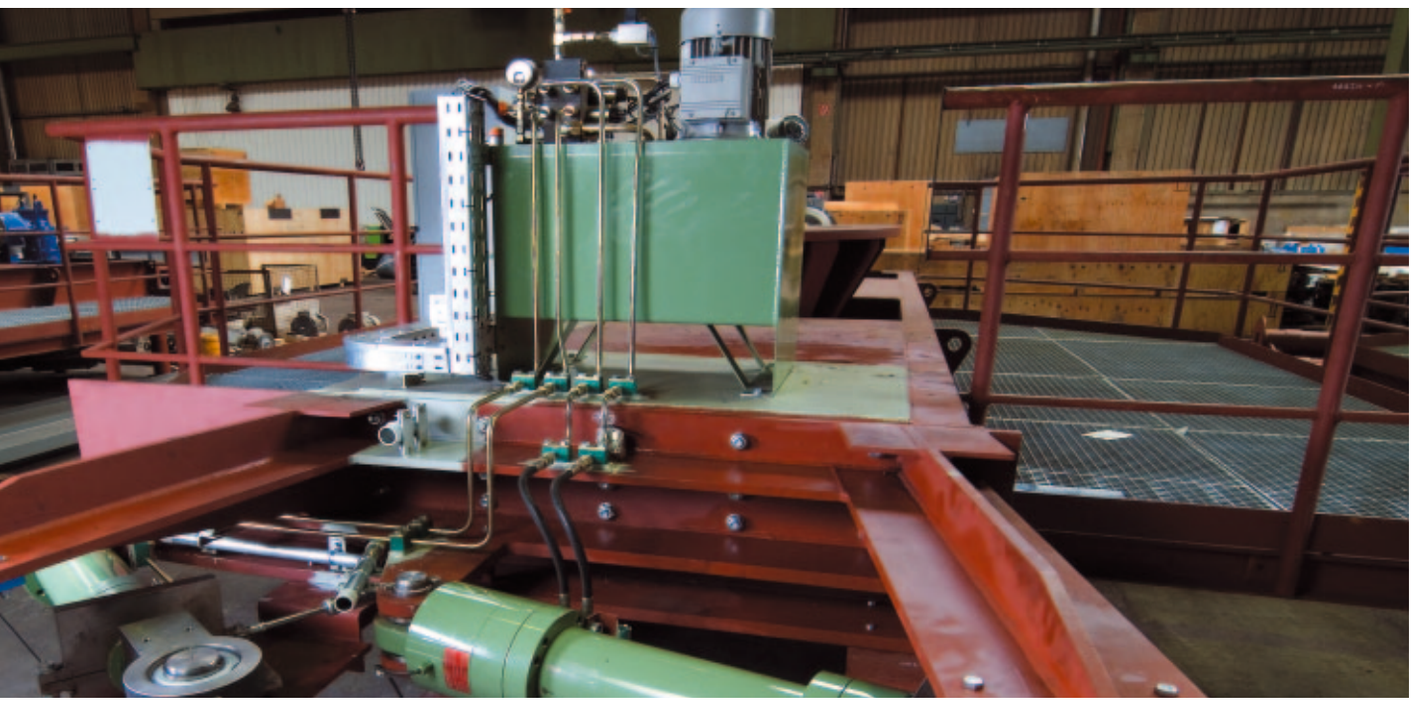
Mass flow

COMPONENTS

5 BEW-K's 10,000/4,500 during assembly in the workshop

Block gear units for BEW-BL

BEW-K discharge wheel, Ø 4,500 mm



Chassis of BEW-K, view onto hydraulic cylinders for rotation

Installation of new bucket strand

CONVERSIONS AND REFURBISHMENTS

- **Upgrading of existing plant components**
- **Targeting increased efficiency**
- **Higher output**
- **Improved availability**

With our expert team of engineers planning selective modernisation measures, we pay special attention to the upgrading of existing plant components, targeting increased efficiency, higher output rates and improved availability.

Upgrading of your materials handling and storage equipment to state-of-the-art technology is achieved through a tailor-made refurbishment process under optimum utilisation of time and budget.

Most of the existing components are re-used in the refurbishment process to save cost.

Engineered conversions and refurbishments for increased efficiency and output are performed on AUMUND equipment as well as on the equipment of other manufacturers.

Pre-assembly of chain strands

AFTER-SALES SERVICES

- **Customer Proximity around the World**

At AUMUND, service does not end at the sale of the equipment. It's the beginning of a long-term partnership. AUMUND offers you a full range of services – from commissioning to the delivery of quality spare and wear parts to customized preventive maintenance programs and equipment upgradings. The benefits for you: Maximum equipment efficiency at lower operating costs.

- **Commissioning and Field Service**

Today, presence "on the spot" is an absolute "must". Therefore, our commissioning and service engineers operate from support centers on all continents to guarantee immediate and competent support.

- **Spare and Wear Parts**

A comprehensive range of genuine spare parts is available for our entire product range from stocks in Germany, Great Britain and the USA. Our product specialists provide assistance and respond instantly.

- **Retrofits**

Aged and worn equipment? Capacity improvement needed? Too high operating costs? Aumund "just as new" retrofits are economical and tailor-made solutions for improving your existing equipment at reasonable cost.

- **Preventive Maintenance**

Knowing beforehand that service will be needed allows you to schedule downtime and save money with timely repairs. Repairs or retrofits can be accurately anticipated allowing for the downtime to be at the most convenient times and at the lowest possible cost.

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