WE CONVEY QUALITY

PAN CONVEYORS

AUMUND

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AUMUND Pan Conveyors

Technology with proven quality, strength and reliability

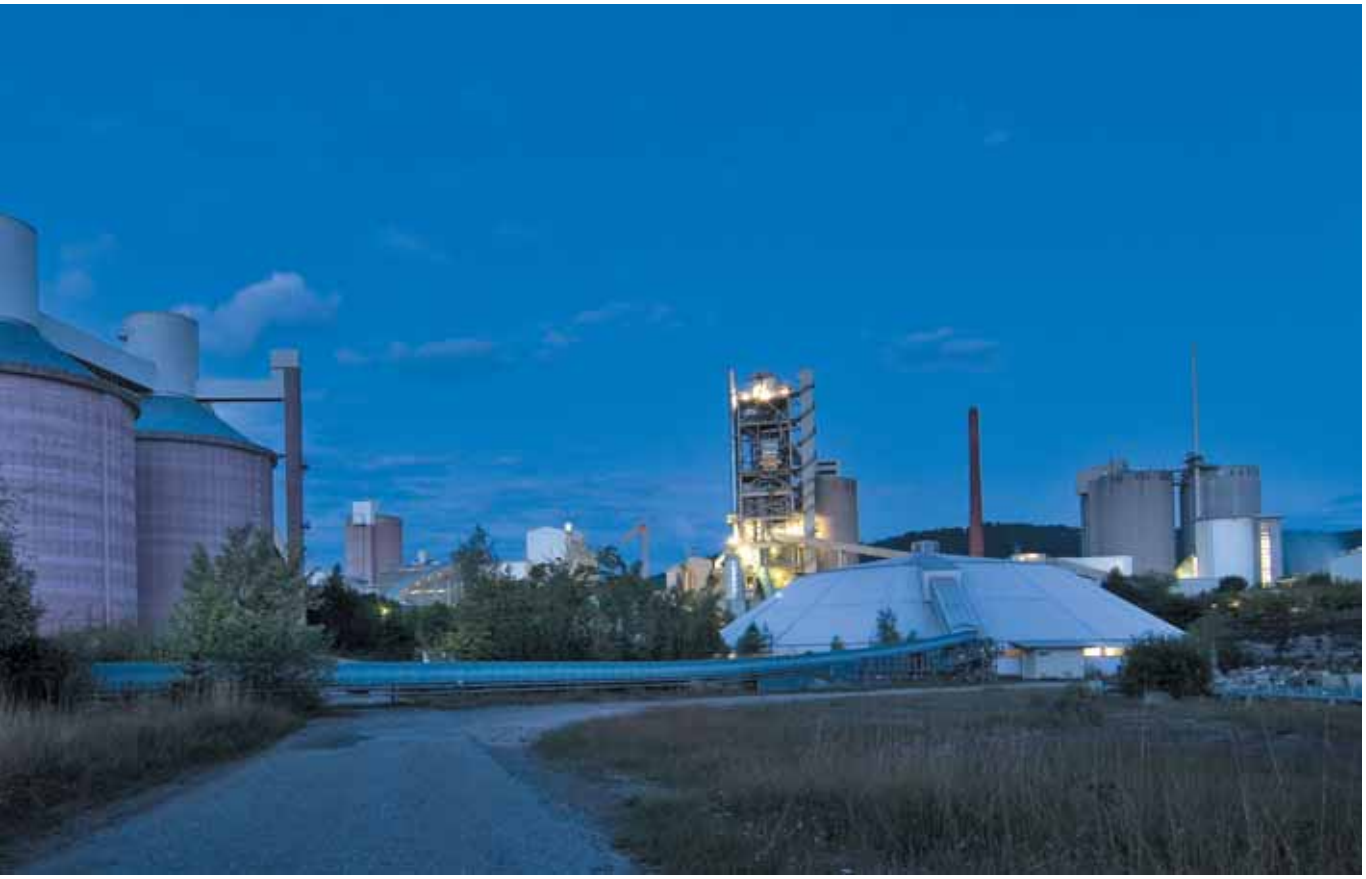
AUMUND Pan Conveyors are designed to suit efficiency driven process technologies and to ensure system performance.

At AUMUND we know that trouble-free operation of the conveying equipment is vital for the productivity and profitability of the whole plant. Keeping in mind this objective we are committed to our high quality standards which are reflected in the exceptional service life of the AUMUND Pan Conveyor.

Our focus is to satisfy specific requirements with creative, cost-effective solutions for the transport of the whole range of bulk materials in cement production from limestone, cement and additives to hot and abrasive cement clinker.

With 85 years in industrial engineering of conveying equipment we also assist customers worldwide with conceptual layouts and configuration. Our primary goal is to identify and provide the most efficient and economic conveying routes.

- **For the whole range of bulk materials in cement production**
- **Engineered to suit plant and operator needs**
- **High quality standards**
- **Outstanding service life**
- **Efficient and economic conveying routes**



Conveying route with Pan Conveyor KZB

PAN CONVEYOR WITH DEEP DRAWN PANS TYPE KZB

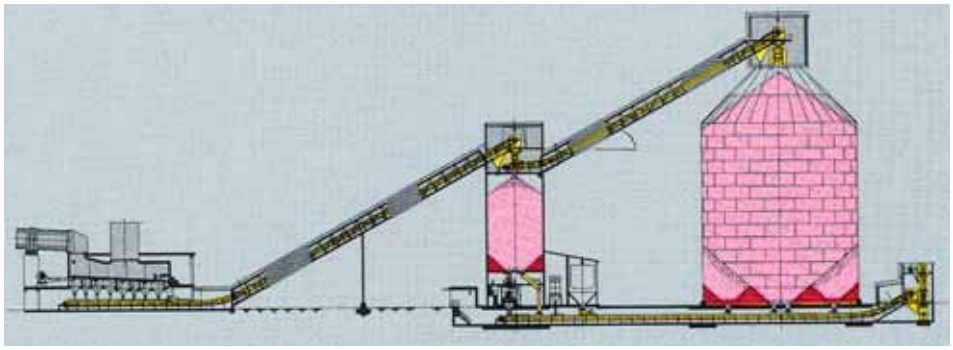
The Pan Conveyor with deep drawn pans type KZB is designed to suit slopes matching the angle of repose of the conveyed bulk material.

For clinker handling the Pan Conveyor type KZB suits conveying routes with an inclination up to 30°.

This Pan Conveyor type is the ideal direct connection between cooler and clinker stock especially for applications with grate coolers. The design allows the Pan Conveyor to be arranged underneath the whole cooler length and to collect the fines from the dust collecting hoppers same as the clinker from the crusher.

Installed underneath the clinker stock in combination with the AUMUND Silo Discharge Gate, the Pan Conveyor with deep drawn pans Type KZB allows for dust-controlled clinker reclaim.

- **Designed for conveying routes with up to 30° inclination**
- **Conveying heights exceeding 75 m**
- **Conveying capacities exceeding 1,000 t/h**
- **Chains with 290 to 3,000 kN breaking load per strand**



Deep Drawn Pan Conveyor under Clinker Cooler

FEATURES

- Accepts temperatures to 700°C
- Designed as a modular structure with standard components
- Profiled pans for high rigidity
- Minimum spillage
- Highly wear resistant chains with high yield strength
- High quality standards on all components

BENEFITS

- Efficient and reliable operation
- Reduced installation time
- Low operating costs
- Minimum and easy maintenance
- Low power consumption
- Low overall investment cost
- Outstanding service life

Pan Conveyor with Deep Drawn Pans Type KZB

Pan Conveyor type KZB - Detail

Deep-Drawn Pan Conveyor - Detail

The characteristic profile of the pans with their contact-free overlapping offers high rigidity with large pan widths and a closed surface in the return stations. Stiffeners pressed into the side plates combined with a sealing edge of special design provide the tight fitting to avoid spillage.

The range of AUMUND conveyor chains covers a large range of applications, from small capacities and horizontal conveying routes to high capacities and lifts.

The chain - for single or double strand application – is chosen to suit the actual traction force while the roller size is chosen in accordance with the weight of the pan conveyor itself and the conveyed material.

The drive units feature bevel spur gears either foot mounted with flexible coupling or shaft-mounted. For inclined conveying, the gear box is fitted with a back stop or, alternatively, a flexible coupling with brake is arranged between gear box and motor.

The coupling between motor and gear box can be hydraulic or flexible for soft start-up. Frequency converters adapt the conveying speed to the actual conveying capacity.

Conveying Capacities - Pan Conveyor Type KZB

The capacities indicated correspond to a brimfull filling (water filling) =100 %

Conveyor section type KZB			Theoretical conveying capacity m³ /h							
Width	Side wall	Plate thickness	Conveyor speed m /s							Permissible
mm	height mm	mm	0.10	0.15	0.20	0.25	0.30	0.35	0.40	filling degree
400	100	4	12	17	23	29	35	40	46	80 %
400	150	4	19	28	37	47	56	66	75	80 %
400	200	4	26	39	52	65	78	91	104	80 %
400	250	4	33	50	66	83	99	116	132	80 %
400	300	4	40	60	81	101	121	141	161	80 %
600	150	4	28	42	56	70	84	98	112	80 %
600	200	4	39	58	78	97	117	136	156	80 %
600	250	4	50	75	99	124	149	174	199	80 %
600	300	4	60	91	121	151	181	212	242	80 %
600	350	4	71	107	143	178	214	249	285	80 %
800	200	4	52	78	104	130	156	181	207	90 %
800	250	4	66	99	132	166	199	232	265	90 %
800	300	4	81	121	161	202	242	282	232	90 %
800	350	4	95	143	190	238	285	333	380	90 %
800	400	4	109	164	219	274	328	383	438	90 %
1.000	200	4	65	97	130	162	194	227	259	100 %
1.000	250	4	83	124	166	207	248	290	331	100 %
1.000	300	4	101	151	202	252	302	353	403	100 %
1.000	350	4	119	178	238	297	356	416	475	100 %
1.000	400	4	137	205	274	342	410	479	547	100 %
1.200	200	5	78	117	156	194	233	272	311	100 %
1.200	250	5	99	149	199	248	298	348	397	100 %
1.200	300	5	121	181	242	302	363	423	484	100 %
1.200	350	5	143	214	285	356	428	499	570	100 %
1.200	400	5	164	246	328	410	492	575	657	100 %
1.400	250	5	116	174	232	290	348	406	464	100 %
1.400	300	5	141	212	282	353	423	494	564	100 %
1.400	350	5	166	249	333	416	499	582	665	100 %
1.400	400	5	192	287	383	479	575	670	766	100 %
1.400	450	5	217	325	433	542	650	759	867	100 %
1.600	250	6	132	199	265	331	397	464	530	110 %
1.600	300	6	161	242	323	403	484	564	645	110 %
1.600	350	6	190	285	380	475	570	665	760	110 %
1.600	400	6	219	328	438	547	657	766	876	110 %
1.600	450	6	248	372	495	619	743	867	991	110 %
1.800	250	6	149	224	298	373	447	522	596	110 %
1.800	300	6	181	272	363	454	544	635	726	110 %
1.800	350	6	214	321	428	535	642	748	855	110 %
1.800	400	6	246	369	492	616	739	862	985	110 %
1.800	450	6	279	418	557	697	836	975	1.115	110 %
2.000	250	6	166	248	331	414	497	580	662	120 %
2.000	300	6	202	302	403	504	605	706	806	120 %
2.000	350	6	238	356	475	594	713	832	950	120 %
2.000	400	6	274	410	547	684	821	958	1.094	120 %
2.000	450	6	310	464	619	774	929	1.084	1.238	120 %
2.200	250	6	182	273	364	455	546	638	729	120 %
2.200	300	6	222	333	444	554	665	776	887	120 %
2.200	350	6	261	392	523	653	784	915	1.045	120 %
2.200	400	6	301	451	602	752	903	1.053	1.204	120 %
2.200	450	6	341	511	681	851	1.022	1.192	1.362	120 %
2.400	250	6	199	298	397	497	596	696	795	120 %
2.400	300	6	242	363	484	605	726	847	968	120 %
2.400	350	6	285	428	570	713	855	998	1.140	120 %
2.400	400	6	328	492	657	821	985	1.149	1.313	120 %
2.400	450	6	372	557	743	929	1.115	1.300	1.486	120 %

Pan Conveyor KZB-Q connecting cooler and silo

PAN CONVEYOR WITH DEEP DRAWN PANS AND BAFFLES TYPE KZB-Q

- **Designed for conveying routes with up to 45° inclination**
- **Conveying heights to 78 m**
- **Conveying capacities to 700 t/h**
- **Chains with 290 to 3,000 kN breaking load per strand**

KZB-Q inclined at 45 degrees

For slopes exceeding 30 degrees retainer baffles are fitted to the deep drawn pans. These baffles are welded to the bottom plate and held in a loose fitting by cams which are pressed into the upper part of the side boards. The loose fitting allows the baffles to bend in case foreign bodies get onto the conveyor.

All further parts of the KZB-Q are interchangeable with the KZB. These standardized components constitute the AUMUND modular system for easy field assembly and inter-changeability, an important asset for spare parts administration.

Deep Drawn Pans with Baffles

Conveying Capacities - Pan Conveyor Type KZB-Q

The capacities indicated correspond to a brimfull filling (water filling) =100 %

Conveyor section type KZB-Q			Theoretical conveying capacity m³ /h							
Width	Side wall	Plate thickness	Conveyor speed m /s							Permissible
mm	height mm	mm	0.10	0.15	0.20	0.25	0.30	0.35	0.40	filling degree
400	250	4	33	50	66	83	99	116	132	80 %
400	300	4	40	60	81	101	121	141	161	80 %
400	350	4	48	71	95	119	143	166	190	80 %
400	400	4	55	82	109	137	164	192	219	80 %
600	250	4	50	75	99	124	149	174	199	80 %
600	300	4	60	91	121	151	181	212	242	80 %
600	350	4	71	107	143	178	214	249	285	80 %
600	400	4	82	123	164	205	246	287	328	80 %
800	250	4	66	99	132	166	199	232	265	90 %
800	300	4	81	121	161	202	242	282	323	90 %
800	350	4	95	143	190	238	285	333	380	90 %
800	400	4	109	164	219	274	328	383	438	90 %
800	450	4	124	186	248	310	372	433	495	90 %
1.000	250	4	83	124	166	207	248	290	331	95 %
1.000	300	4	101	151	202	252	302	353	403	95 %
1.000	350	4	119	178	238	297	356	416	475	95 %
1.000	400	4	137	205	274	342	410	479	547	95 %
1.000	450	4	155	232	310	387	464	542	619	95 %
1.200	250	5	99	149	199	248	298	348	397	95 %
1.200	300	5	121	181	242	302	363	423	484	95 %
1.200	350	5	143	214	285	356	428	499	570	95 %
1.200	400	5	164	246	328	410	492	575	657	95 %
1.200	450	5	186	279	372	464	557	650	743	95 %
1.400	250	5	116	174	232	290	348	406	464	95 %
1.400	300	5	141	212	282	353	423	494	564	95 %
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1.400	400	5	192	287	383	479	575	670	766	95 %
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1.600	350	6	190	285	380	475	570	665	760	95 %
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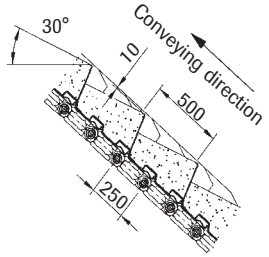
2.200	300	6	222	333	444	554	665	776	887	95 %
2.200	350	6	261	392	523	653	784	915	1.045	95 %
2.200	400	6	301	451	602	752	903	1.053	1.204	95 %
2.200	450	6	341	511	681	851	1.022	1.192	1.362	95 %
2.400	300	6	242	363	484	605	726	847	968	95 %
2.400	350	6	285	428	570	713	855	998	1.140	95 %
2.400	400	6	328	492	657	821	985	1.149	1.313	95 %
2.400	450	6	372	557	743	929	1.115	1.300	1.486	95 %

Reduced output factor

Side wall height	Reduced output factor up to angle of inclination of			
mm	30°	35°	40°	45°
250	0.949	0.822	0.701	0.589
300	0.960	0.863	0.769	0.682
350	0.968	0.888	0.812	0.741
400	0.973	0.905	0.841	0.782
450	0.976	0.918	0.863	0.811



Feeding of covered stockpile

PAN CONVEYOR WITH BUCKETS TYPE BZB

- **Designed for conveying routes with up to 60° inclination**
- **Conveying heights to 96 m**
- **Conveying capacities to 500 t/h**
- **Chains with 290 to 3,000 kN breaking load per strand**

Wherever conveying of clinker with a high content of fines is required, the Bucket Conveyor type BZB is the most appropriate choice. The bucket design with either forward or backward overlapping is designed to suit this particular application and minimizes spillage and cleaning.

Designed for conveying at an inclination up to 60 degrees, the Bucket Conveyor fits into layouts combining high elevation with restricted space. The narrow curve radius is a further feature to suit these applications where only limited space is available, a considerable advantage for modernization projects or conversion in existing plants.

Uniform bucket filling and even material distribution over the whole bucket width is ensured by expert planning of the feed chute system - a pre-requisite for trouble-free operation with minimum dust generation.

Bucket Apron Conveyor

Feeding of mill hoppers

Clinker Transport with Conveyor type BZB

Bucket Apron Conveyor type BZB Detail

Conveying Capacities - Bucket Conveyor Type BZB

The capacities indicated correspond to a filling of 100 % and an angle of repose of 25°.

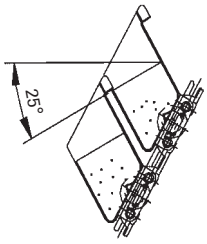
Bucket		Theoretical conveying capacity m³ /h					
Bucket	Side wall height	Conveyor speed m / s					
mm	mm	0,10	0.15	0.20	0.25	0.30	0.35
400	200	24	35	47	59	71	83
400	250	30	45	59	74	89	104
600	200	35	53	71	89	106	124
600	250	44	67	89	111	133	156
600	300	53	80	107	134	160	187
800	200	47	71	95	118	142	165
800	250	59	89	119	148	178	207
800	300	71	107	143	178	214	249
800	350	83	125	167	208	250	291
800	400	95	143	191	238	286	334
1.000	300	89	134	178	223	267	312
1.000	350	104	156	208	260	312	364
1.000	400	119	179	238	298	357	417
1.200	350	125	187	250	312	375	437
1.200	400	143	214	286	357	429	500
1.400	350	146	219	291	364	437	510
1.400	400	167	250	334	417	500	584
1.600	350	167	250	333	416	500	583
1.600	400	191	286	381	476	572	667

Permissible filling degree

70-80 % of the theoretical conveying capacity

Reduced output factor

Side wall height	Reduced output factor up to angle of inclination of						
mm	30°	35°	40°	45°	50°	55°	60°
250	0.949	0.822	0.701	0.589	0.589	0.589	0.589
300	0.960	0.863	0.769	0.682	0.682	0.682	0.682
350	0.968	0.888	0.812	0.741	0.741	0.741	0.741
400	0.973	0.905	0.841	0.782	0.782	0.782	0.782
450	0.976	0.918	0.863	0.811	0.811	0.811	0.811



Recommended inclination max. 45°

The bucket - standard widths to 1,600 mm - feature a built-in stiffener for high solidity.

Depending on the case of application the overlapping of the buckets is either forward or backward. With the tight bucket arrangement the BZB meets the criteria for proper feeding with minimum spillage.

The modular system also applies for the AUMUND Bucket Conveyor, ensuring interchangeability and combination with components like those used with the Deep Drawn Pan Conveyor.

Features

- **Ideal for conveying of clinker with a high content of fines**
- **Narrow curve radius, down to 10 m**
- **Expert design of the feed chute system**
- **Designed as a modular structure with standard components**
- **Minimum spillage**
- **Highly wear resistant chains with high yield strength**
- **High quality standards on all components**

Benefits

- **Efficient and reliable operation**
- **Suits applications with limited space**
- **Low operating costs**
- **Minimum and easy maintenance**
- **Outstanding service life**

Feeding two silos in line

PIVOTING PAN CONVEYOR TYPE SPB

For bulk material distribution into a series of silos or hoppers, the Pivoting Pan Conveyor offers the most versatile arrangements.

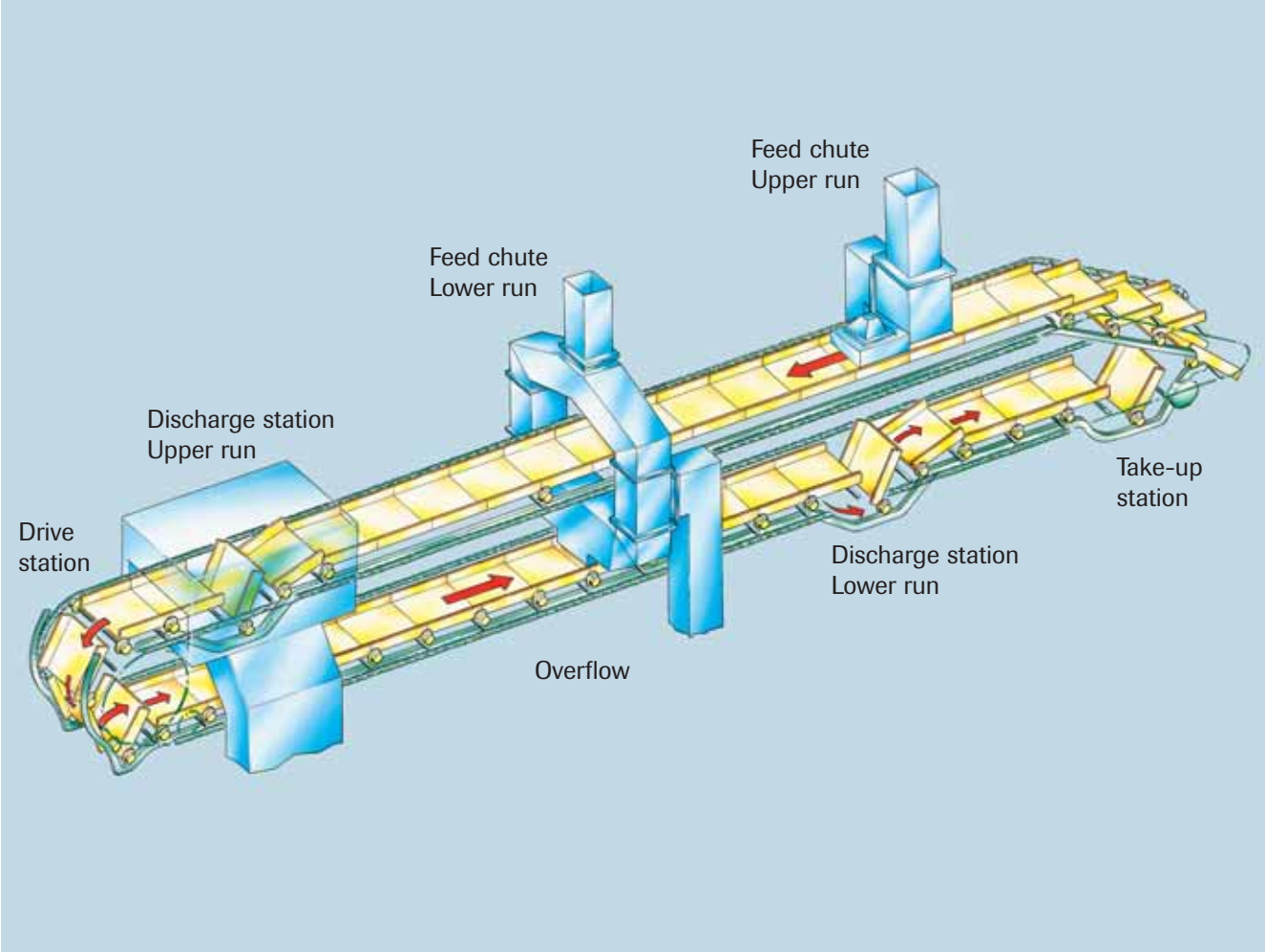
The Pivoting Pan Conveyor ensures PLC controlled multiple distribution of various materials with just one conveyor.

- **Pan reversing system for simultaneous conveying on the upper and lower run**
- **Intermediate discharge stations placed at any given position**
- **Upper and lower run feeding**
- **Specific feeding and discharge features**

Feeding onto the upper run is performed with a standard feed chute whilst a two-way chute leads the bulk material to the lower run. Equipped with an overflow system the feed chutes also ensure direct discharge of the bulk material into the silo or hopper.

Intermediate discharge stations may be positioned where required and permit remote controlled switching from one discharge station to the other.

Bulk material directed onto the upper run can subsequently be transferred to the lower run through an intermediate discharge station located on the upper run. The material may then be distributed into clinker silos or mill hoppers through discharge stations on the lower run.

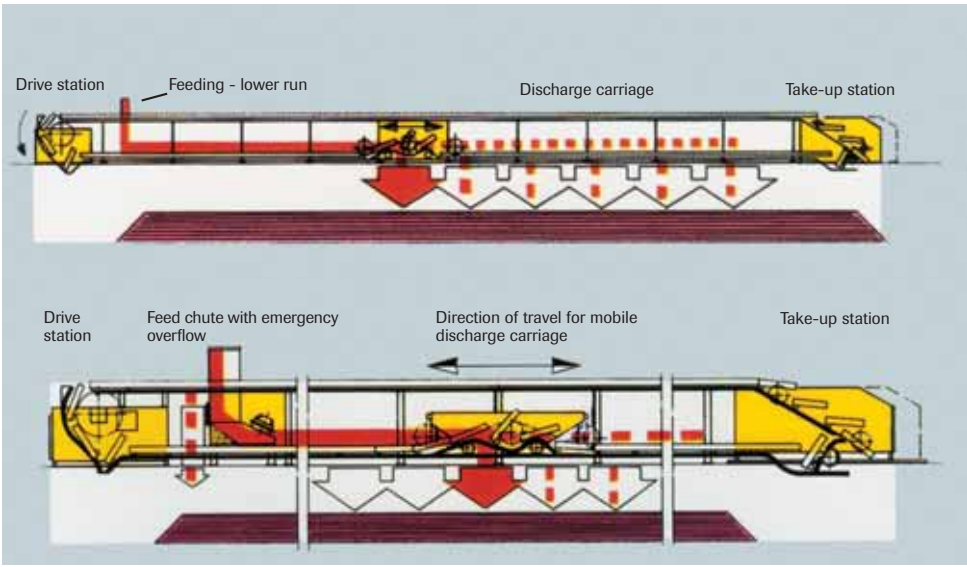


Upper and lower run feeding and discharge

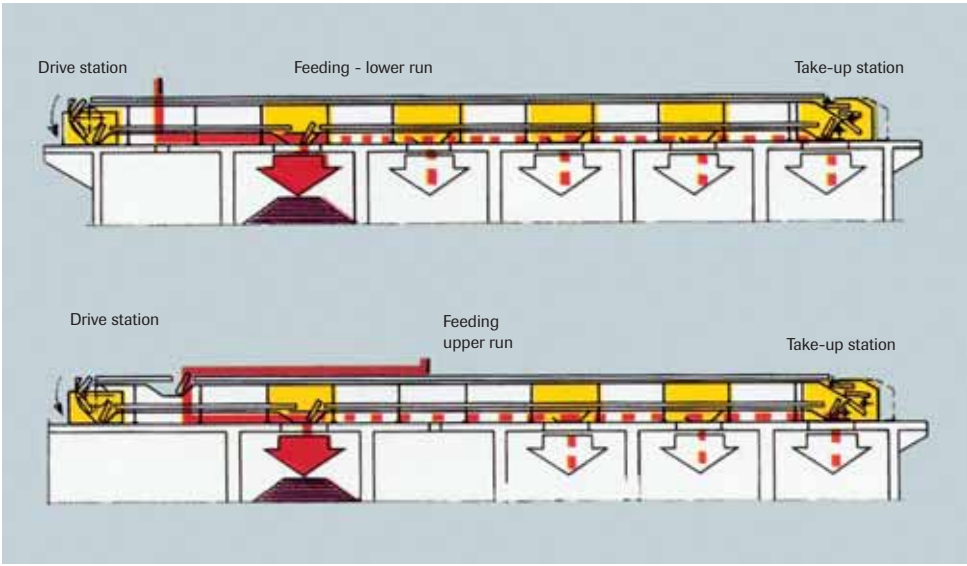
Simultaneous conveying on the upper and the lower run is a further alternative. A hopper can thus be loaded with cement clinker by way of the lower run whilst for example gypsum is conveyed on the upper run.

Mill hopper feeding

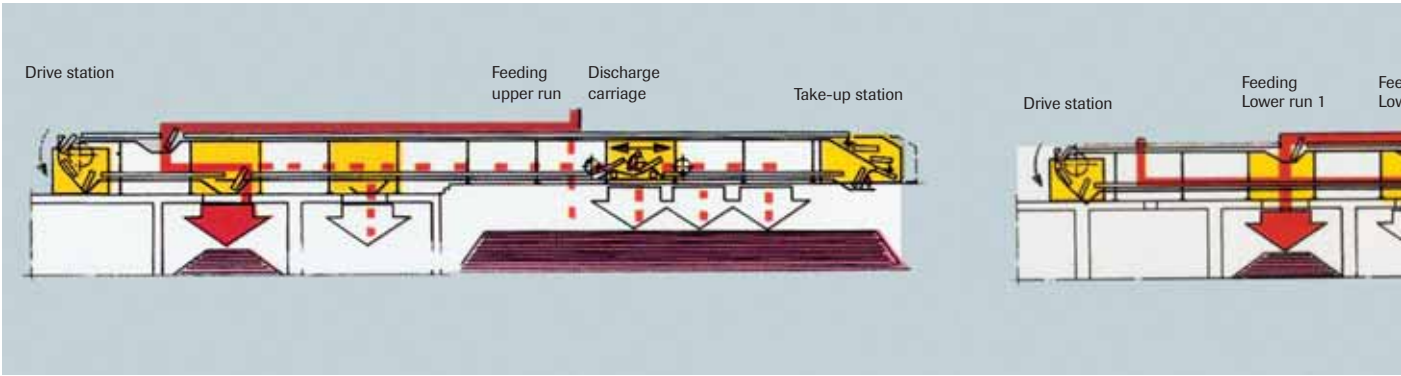
Bulk Material Distribution into Storage Halls

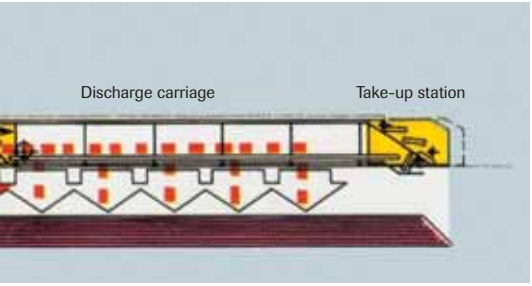


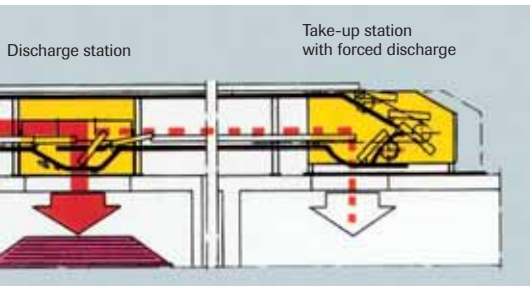
Bulk Material Distribution into a Series of Silos

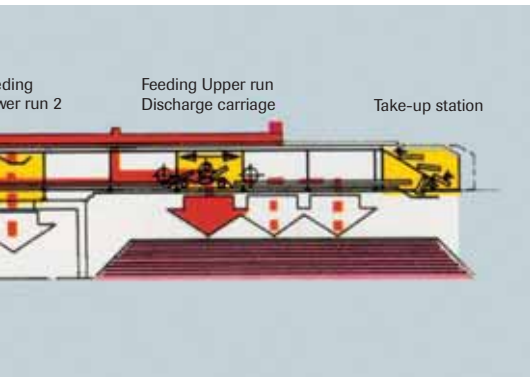


Bulk Material Distribution into Silos and Storage Hall





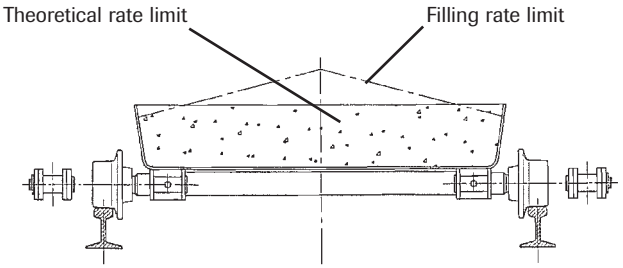




Conveying capacity - Pivoting Pan Conveyor Type SPB

The capacities indicated correspond to a brimfull filling (water filling) =100 %

Conveyor section		Theoretical conveying capacity m³/h					
Pan width	Side wall height	Conveyor speed m /s					Filling rate limit
Plw mm	mm	0.10	0.15	0.20	0.25	0.30	
400	150	22	32	43	54	65	115%
400	200	29	43	58	72	86	105%
600	150	32	49	65	81	97	120%
600	200	43	65	86	108	130	110%
800	150	43	65	86	108	130	125%
800	200	58	86	115	144	173	115%
1.000	150	54	81	108	135	162	130%
1.000	200	72	108	144	180	216	120%
1.200	150	65	97	130	162	194	135%
1.200	200	86	130	173	216	259	125%
1.400	150	76	113	151	189	227	140%
1.400	200	101	151	202	252	302	130%
1.600	150	86	130	173	216	259	140%
1.600	200	115	173	230	288	346	130%



Feeding of long clinker storage halls requires continuous shifting of the discharge point. A mobile discharge carriage which can be moved to any given position above the hall is used with this particular application. The clinker is continuously distributed over the whole travel length of the carriage.

Sensors on the conveyor supports monitor the position of the travelling carriage. Level indicators control automatic shifting of the carriage as soon as a maximum filling level is reached inside the storage hall.

- **Automated feeding of clinker silos, mill hoppers and clinker halls**
- **Simultaneous conveying of different bulk materials**
- **PLC-controlled operation**
- **Automated material distribution controlled by level sensors**
- **Customized layout and planning**
- **Standardized components**

Clinker Silos 2 x 60,000 t

REVERSIBLE DEEP-DRAWN PAN CONVEYOR TYPE KZB-R

For applications where conveying in both directions is required, the Deep Drawn Pan Conveyor may be converted into a reversible conveyor. Alternate feeding of two silos with just one conveyor is made possible by simply changing the conveying direction.

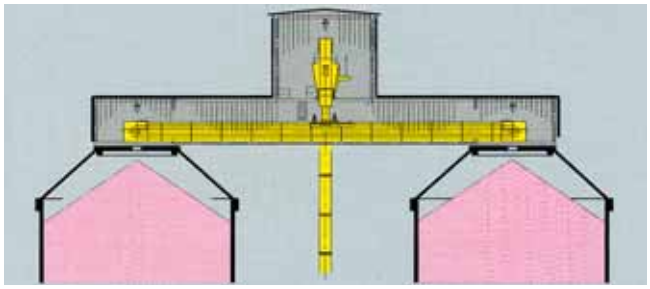
This conveyor of special design suits horizontal arrangements. The illustration shows a plant where feeding of two clinker silos is performed with one Bucket Elevator and one Reversible Conveyor. The Bucket Elevator unloads the clinker in the centre of the subsequent Reversible Conveyor which then feeds the clinker to either one of the silos.

Operation of the Reversible Conveyor is PLC controlled from the central control room ensuring that the pans are cleared before shifting from one direction to reverse conveying.

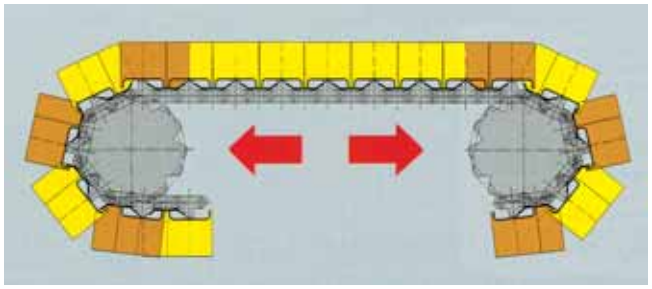
To achieve this type of operation the pans are arranged such that the pan overlapping always points into the chosen conveying direction.

If required with a long centre distance, both conveyor ends are fitted with a drive unit.

- **Alternate feeding of two silos with one conveyor**
- **Conveying in both directions by simply shifting to reverse conveying**



Clinker silo feeding with reversible pan conveyor



Reversible pan conveyor - functional principle

Silo Discharge with Remote Control

SILO DISCHARGE TYPE SAK

For clinker silo discharge with low dust emission, for proportional addition of low-burnt or imported clinker AUMUND's product range includes the Gravity Discharge Unit operating in combination with the Deep Drawn Pan Conveyor. The height of the material layer on the pan conveyor determines the discharge rate and the feeding capacity onto the subsequent conveying equipment. Preset during commissioning, it is adjusted to the specific requirements of the plant.

With its built-in motorized shell gate the Gravity Discharge Unit prevents the clinker from falling in an uncontrolled manner onto the pan conveyor. It reclaims the clinker at low speed and minimizes dust generation.

Where adequate, the Gravity Discharge Unit may also be manually operated.

For uniform discharge of the stored volume, a multitude of motorized Gravity Discharge Units are installed underneath the clinker silo. Switching between discharge points is made by remote control assisted by ultrasonic sensors detecting lack of clinker on the conveyor.

COMPONENTS

AUMUND Pan Conveyors feature standardized components forming part of the modular system. Components of different pan conveyor types are interchangeable, a major advantage for spare parts management.

- Bogie-type rails ranging from size S14 to S30, chosen to suit the pan conveyor size
- Roller guide-rails in the curve area
- Standard roller design with tempered running surface and multiple sealing and life lubrication
- Drive and tail shaft sprockets with exchangeable toothed segments for easy replacement
- Sprockets with double tooth pitch meshing with the sprocket teeth only after each second turn for increase of lifetime
- Chains with breaking loads ranging from 290 kN to 3,000 kN

Type	for conveyor type	breaking load kN
AU3032.1 BAU3032.1	KZB BZB	290
AU4540.1 BAU4540.1	KZB BZB	510
AU5544.1 BAU5544.1	KZB BZB	700
AU6052.1 BAU6052.1	KZB BZB	900
AU6060.1 BAU6060.1	KZB BZB	1200
AU8076.1 BAU8076.1	KZB BZB	1900
AU9085.1 BAU9085.1	KZB BZB	2350
AU10090.1 BAU10090.1	KZB BZB	3000

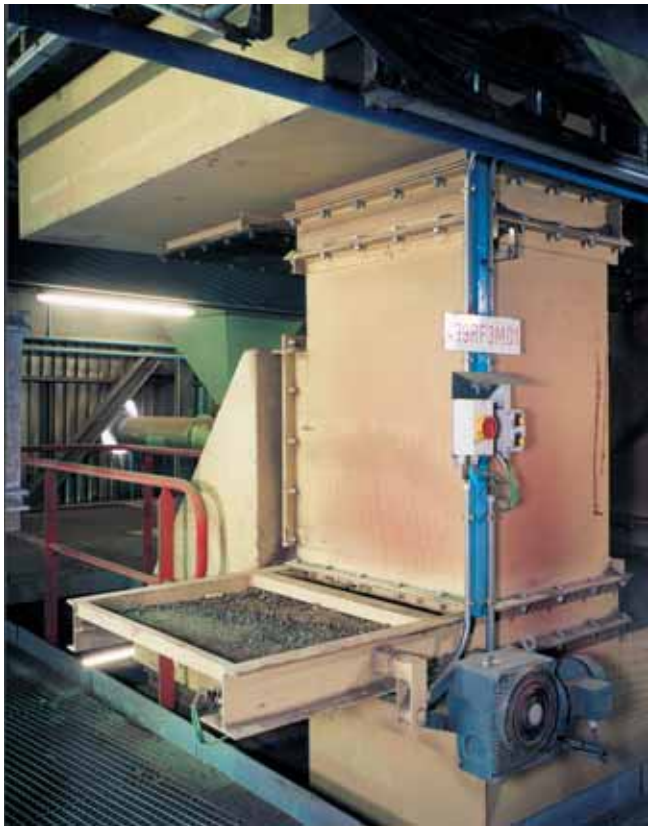
Chain pitch 250mm

CHAIN TECHNOLOGY

- **High precision manufacturing technology**
- **Special, wear-resistant steel**
- **High yield strength**

AUMUND chains for Pan Conveyors are fabricated from special steel suitable for accurate laser cutting. The high precision manufacturing technology combines high yield strength with perfect distribution of forces.

The chain features a divided chain locking link, so field assembly is simplified.



ACCESSORIES

- **Two way distribution chute**
- **Three way distribution chute**
- **Motorized flat gate**
- **Maintenance trolley for conveyor bridge**

Remote control of downstream conveying directions is performed with the AUMUND two or three-way distribution chute. The chutes are fitted with shell gates actuated either by a gear motor or a hydraulic / pneumatic cylinder. Casing and shell gates are of wear-resistant design for a long service life. Motorized flat gates of sturdy design complete the range of accessory equipment for material distribution.

In addition, AUMUND offers maintenance trolleys with rack and pinion drive to be installed inside conveyor bridges for transportation of heavy tools, oil bins or equipment components to the top of high clinker silos. The maintenance trolleys are designed to suit any angle of inclination.

The range of accessory equipment is completed by truck and ship loading systems with low dust generation and electronic control for easy loading operations.

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 increase needed? Too high operating cost? 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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AUMUND GROUP

Your partner for all requirements regarding material handling and storage.
We design, engineer, manufacture, erect and service reliable equipment.
Reputation and competence proven by more than 10,000 installations in over 100 countries.

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